

Model Calculation

Supply Chain Simulation

SCS

		Period 1	Period 2	Period 3	Period 4	Period 5	Period 6	Period 7	Period 8	Period 9	Period 10
Delivery reliability	act.	1									
	plan										
Throughput time	act.										
	plan										
Capacity utilization	act.	3									
	plan										
Store value	act.	2									
	plan										
Production costs	act.										
	plan										
Operating profit	act.										
	plan										

	Sales Orders	Forecasts			
Period Product	1	2	3	4	
P 1 Children's bicycle	200	150	150	150	
P 2 Lady's bicycle	150	100	100	50	
P 3 Men's bicycle	100	100	50	50	
Total	450	350	300	250	

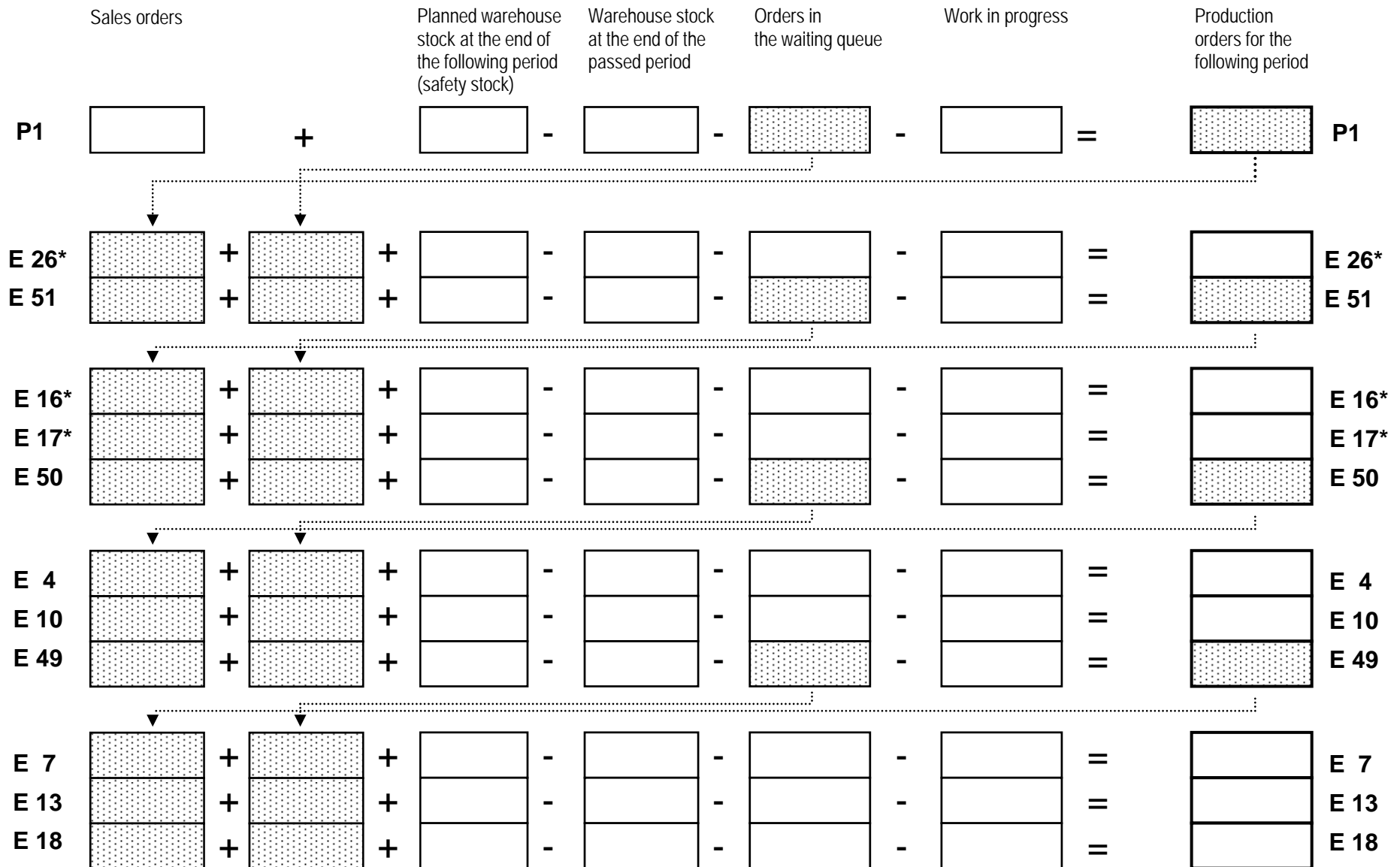
Item No.	Description	Where used	Item value [€]	Stock quantity [pieces]
P 1	Children's bicycle		156,13	100
P 2	Ladies bicycle		163,33	100
P 3	Men's bicycle		165,08	100
E 4	Rear wheel group	C	40,85	100
E 5	Rear wheel group	L	39,85	100
E 6	Rear wheel group	M	40,85	100
E 7	Front wheel group	C	35,85	100
E 8	Front wheel group	L	35,85	100
E 9	Front wheel group	M	35,85	100
E 10	Mudguard rear	C	12,40	100
E 11	Mudguard rear	L	14,65	100
E 12	Mudguard rear	M	14,65	100
E 13	Mudguard front	C	12,40	100
E 14	Mudguard front	L	14,65	100
E 15	Mudguard front	M	14,65	100
E 16	Handle complete	CLM	7,02	300
E 17	Saddle complete	CLM	7,16	300
E 18	Frame	C	13,15	100
E 19	Frame	L	14,35	100
E 20	Frame	M	15,55	100
E 26	Pedal complete	CLM	10,50	300
E 29	Front wheel compl.	M	69,29	100
E 30	Frame and wheels	M	127,53	100
E 31	Bicycle w/o pedals	M	144,42	100
E 49	Front wheel compl.	C	64,64	100
E 50	Frame and wheels	C	120,63	100
E 51	Bicycle w/o pedals	C	137,47	100
E 54	Front wheel compl.	L	68,09	100
E 55	Frame and wheels	L	125,33	100
E 56	Bicycle w/o pedals	L	142,67	100

E = In-house manufactured part and component

C = Used in children's bicycle L = Used in ladies bicycle M = Used in men's bicycle

Item Master Data: Unfinished and Finished Products at the Beginning of the First Period

	Sales orders	Forecasts			
Period Product	1	2	3	4	
P 1 Children's bicycle	200	150	150	150	
P 2 Lady's bicycle	150/100	100	100/150	50	
P 3 Men's bicycle	100/50	100	50	50/100	
Total	450/350	350	300/350	250/300	

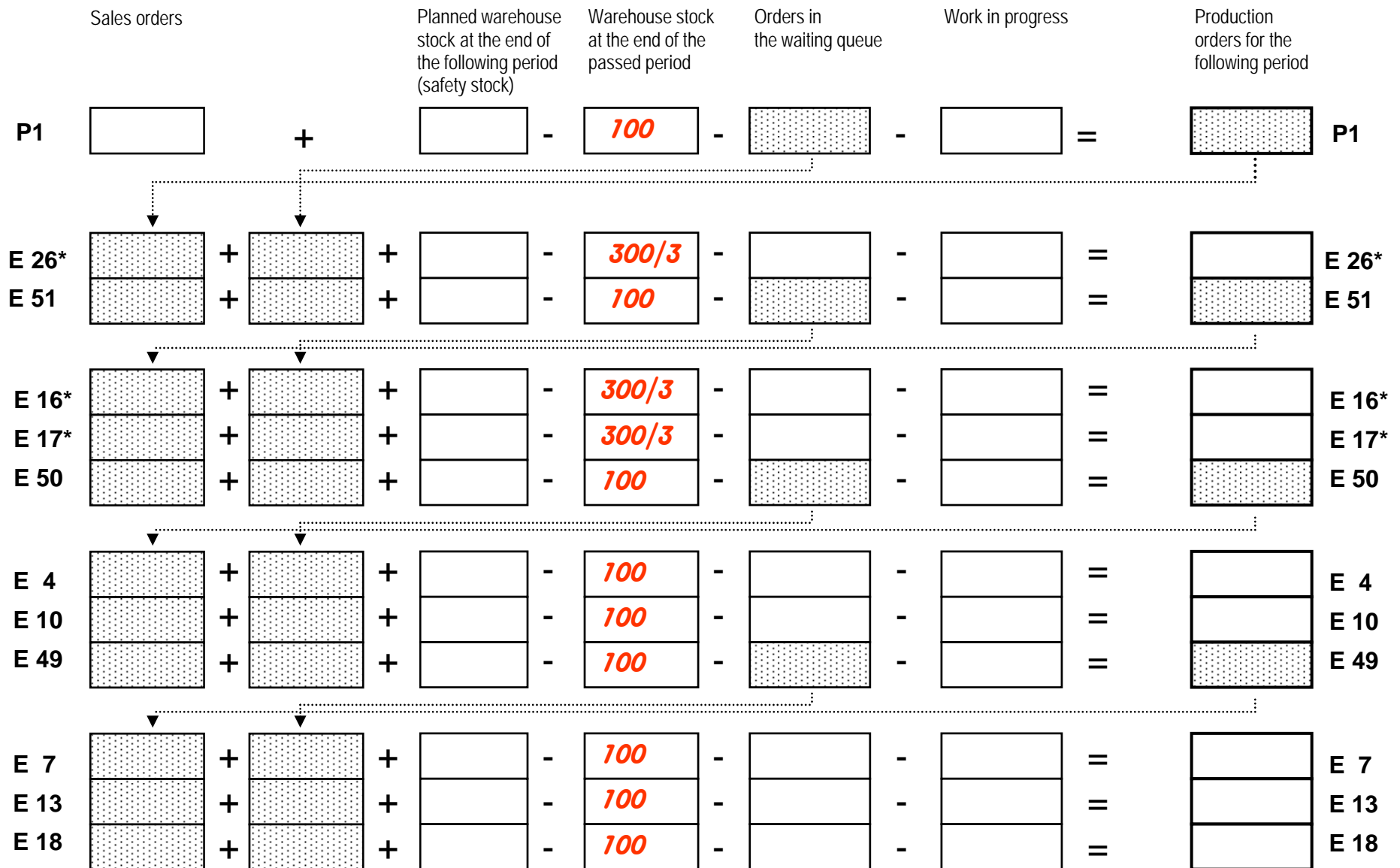


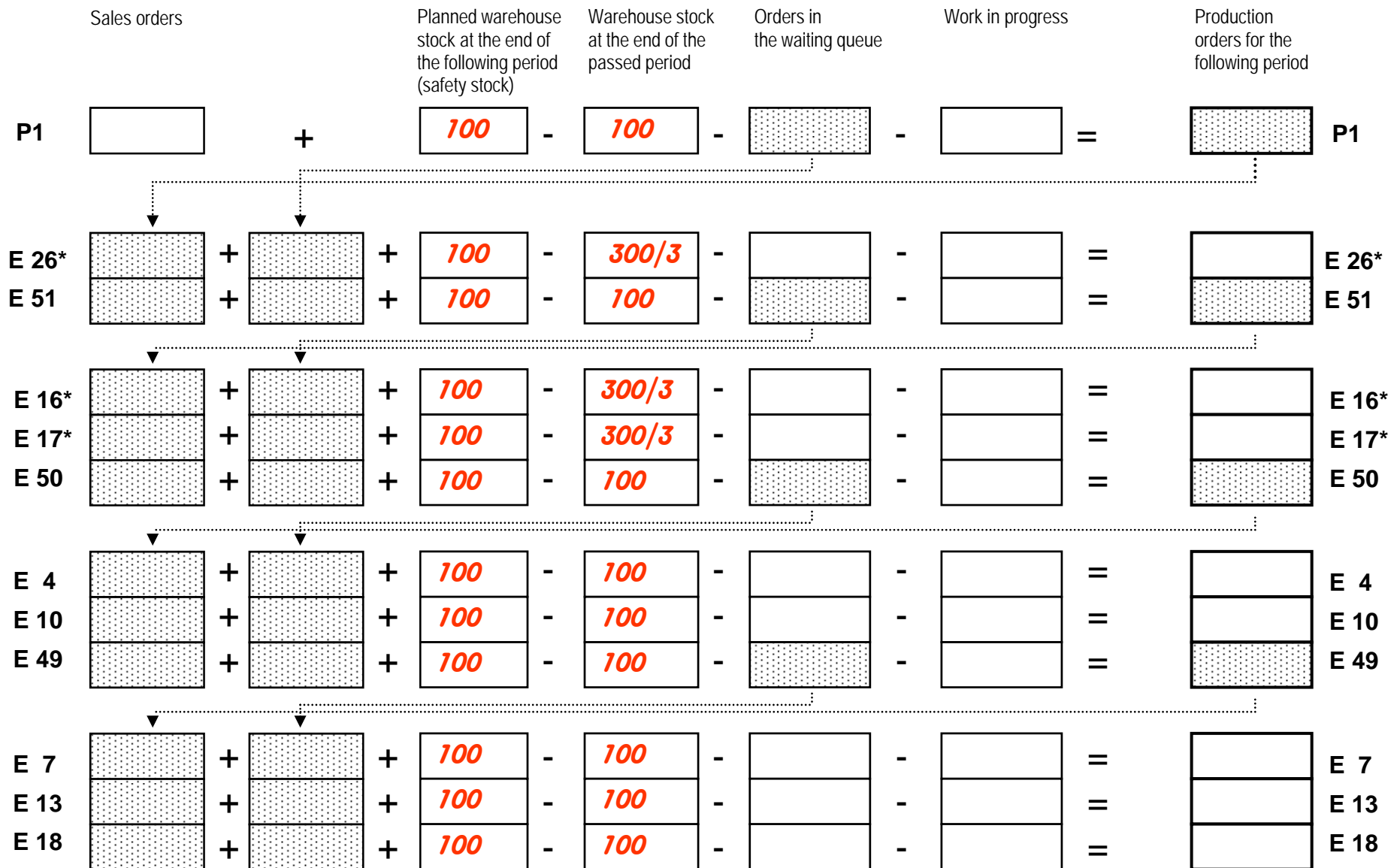
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P 2	Ladies bicycle		163,33	100
P 3	Men's bicycle		165,08	100
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E 8	Front wheel group	L	35,85	100
E 9	Front wheel group	M	35,85	100
E 10	Mudguard rear	C	12,40	100
E 11	Mudguard rear	L	14,65	100
E 12	Mudguard rear	M	14,65	100
E 13	Mudguard front	C	12,40	100
E 14	Mudguard front	L	14,65	100
E 15	Mudguard front	M	14,65	100
E 16	Handle complete	CLM	7,02	300
E 17	Saddle complete	CLM	7,16	300
E 18	Frame	C	13,15	100
E 19	Frame	L	14,35	100
E 20	Frame	M	15,55	100
E 26	Pedal complete	CLM	10,50	300
E 29	Front wheel compl.	M	69,29	100
E 30	Frame and wheels	M	127,53	100
E 31	Bicycle w/o pedals	M	144,42	100
E 49	Front wheel compl.	C	64,64	100
E 50	Frame and wheels	C	120,63	100
E 51	Bicycle w/o pedals	C	137,47	100
E 54	Front wheel compl.	L	68,09	100
E 55	Frame and wheels	L	125,33	100
E 56	Bicycle w/o pedals	L	142,67	100

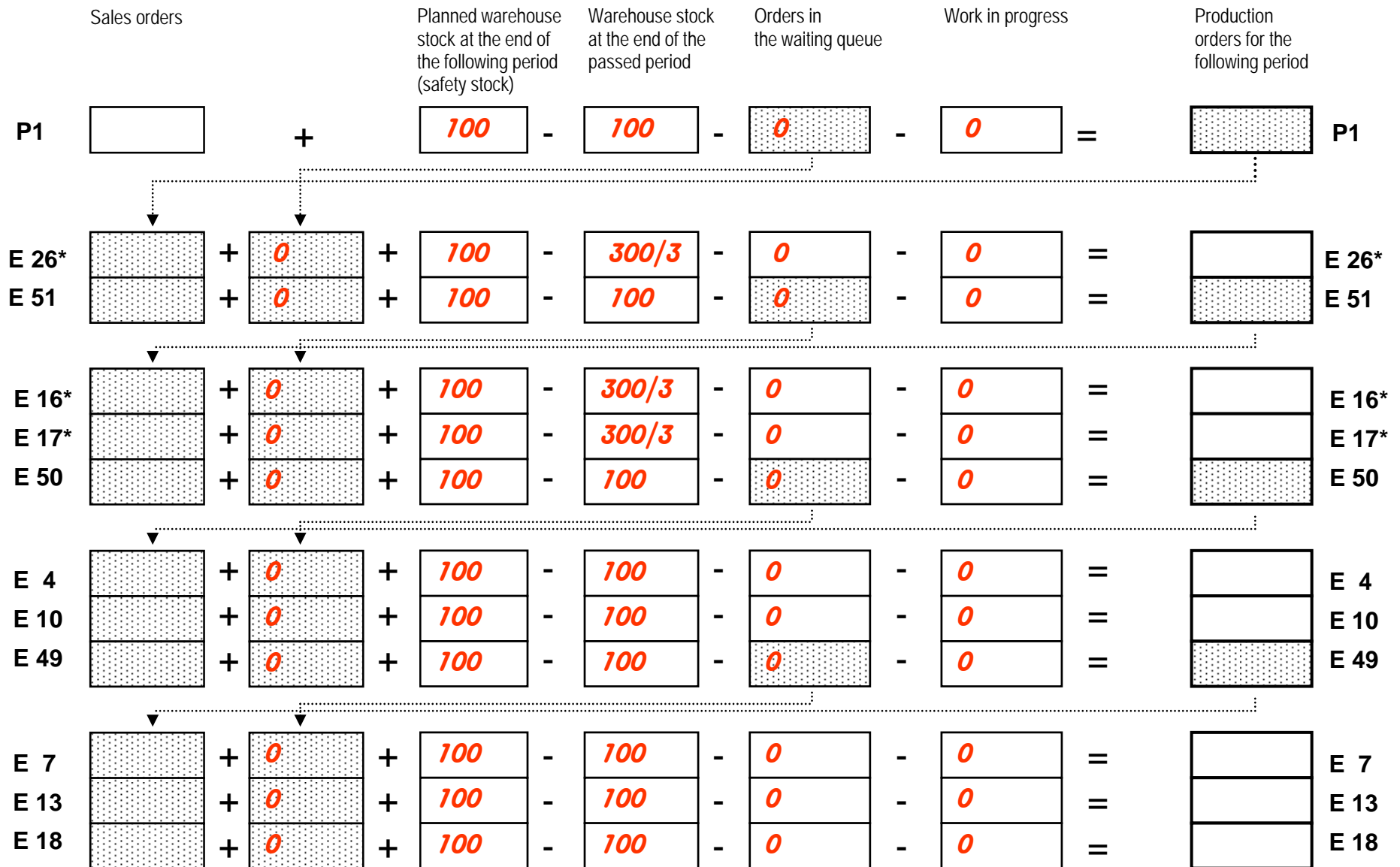
E = In-house manufactured part and component

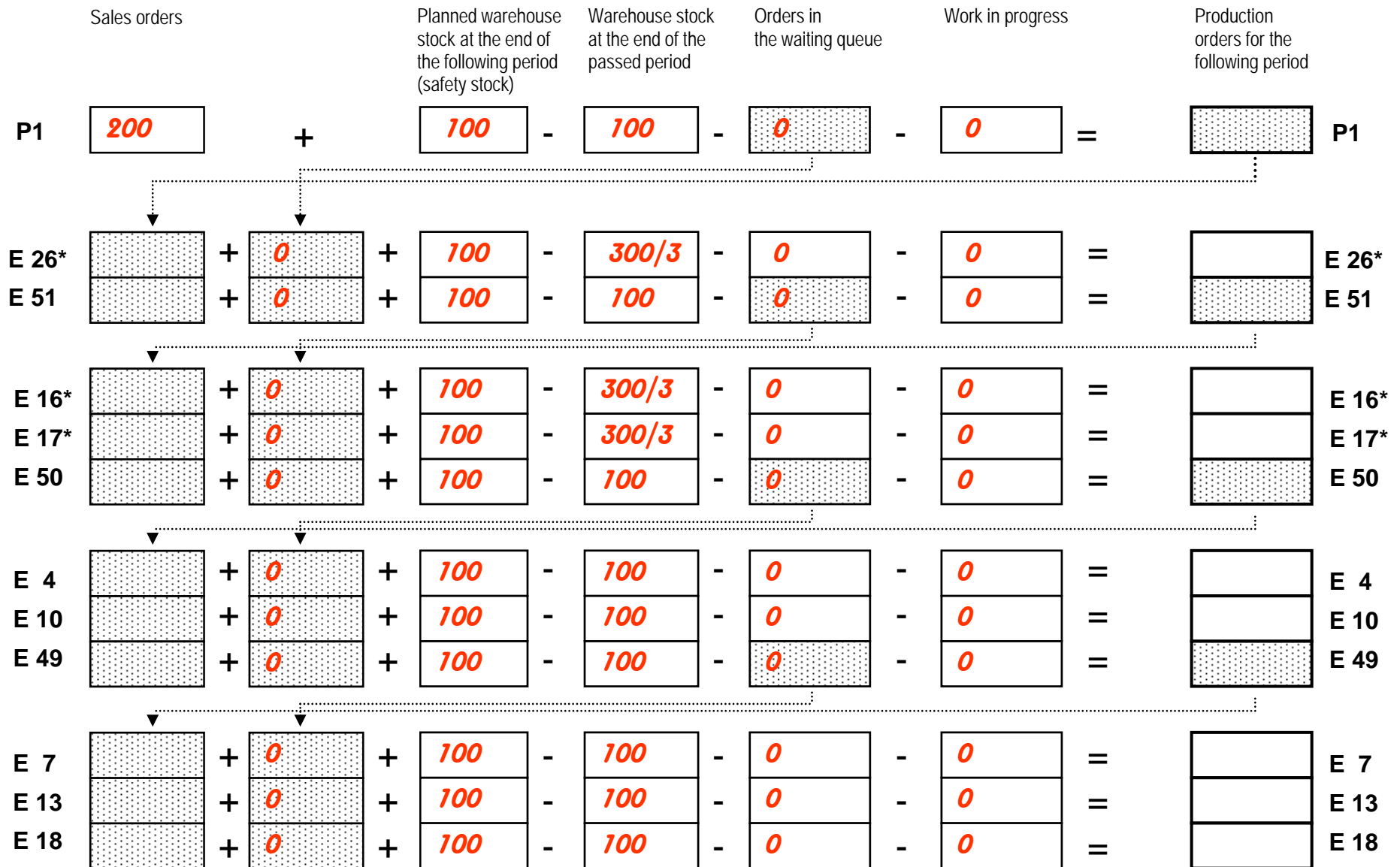
C = Used in children's bicycle L = Used in ladies bicycle M = Used in men's bicycle

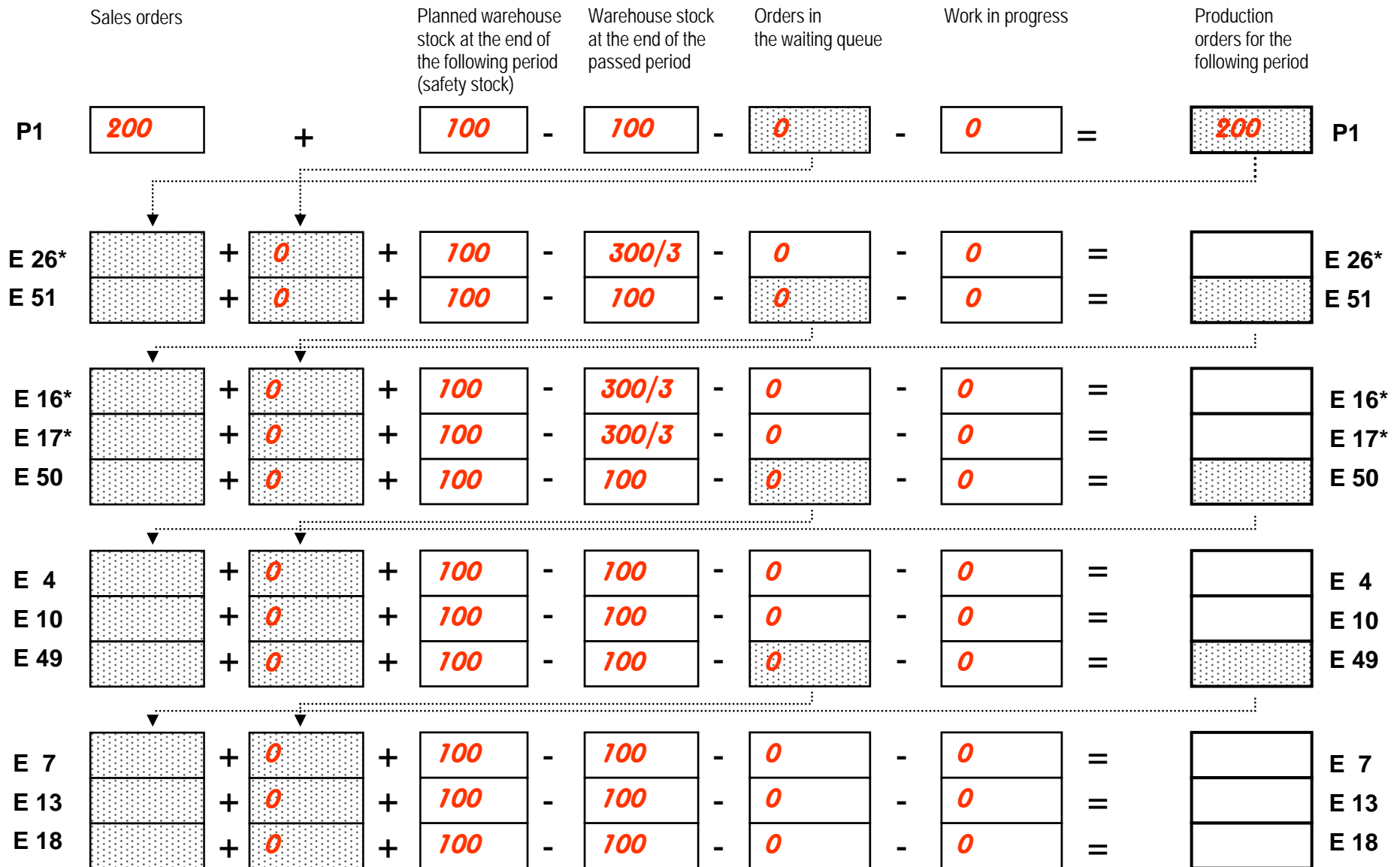
Item Master Data: Unfinished and Finished Products at the Beginning of the First Period

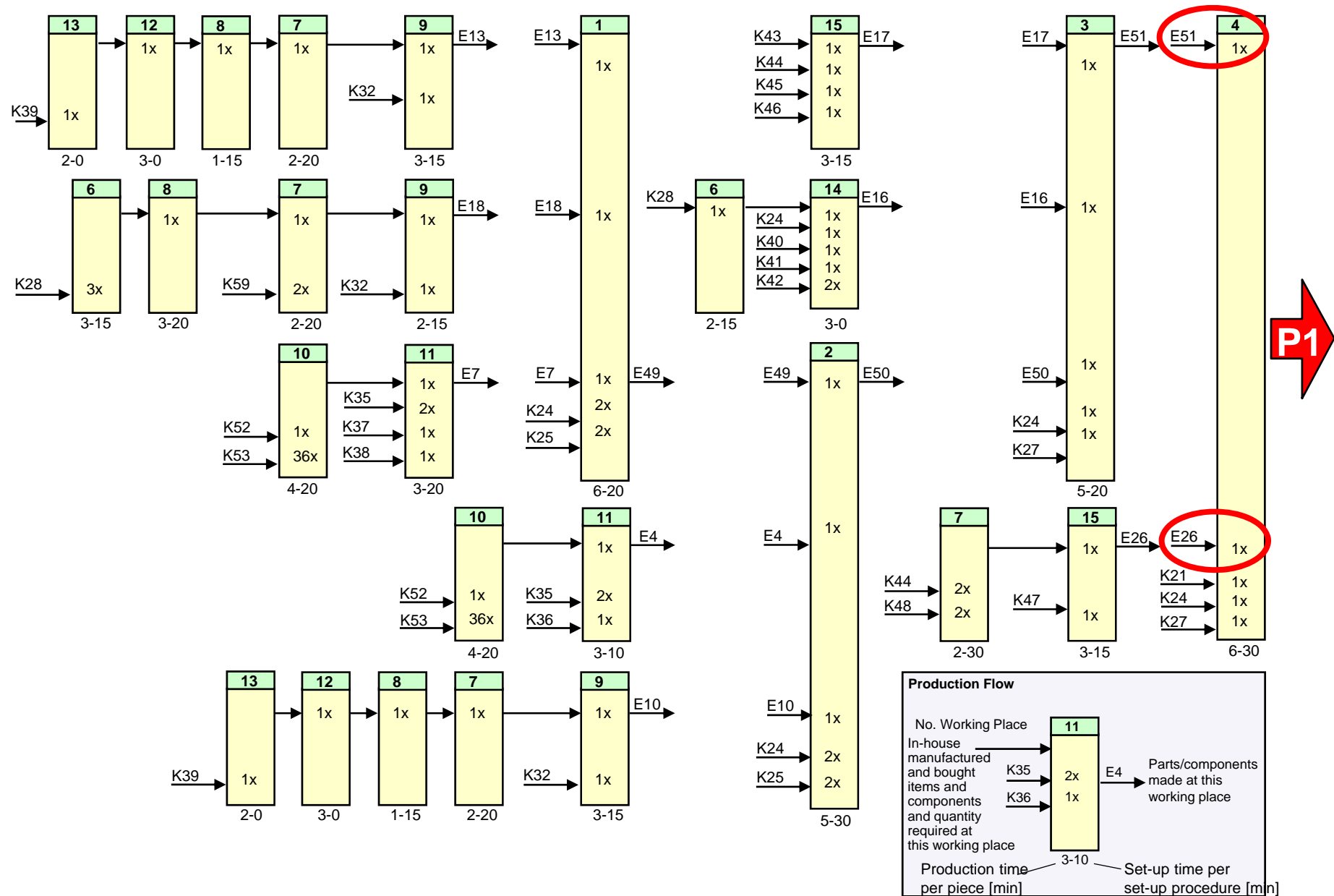






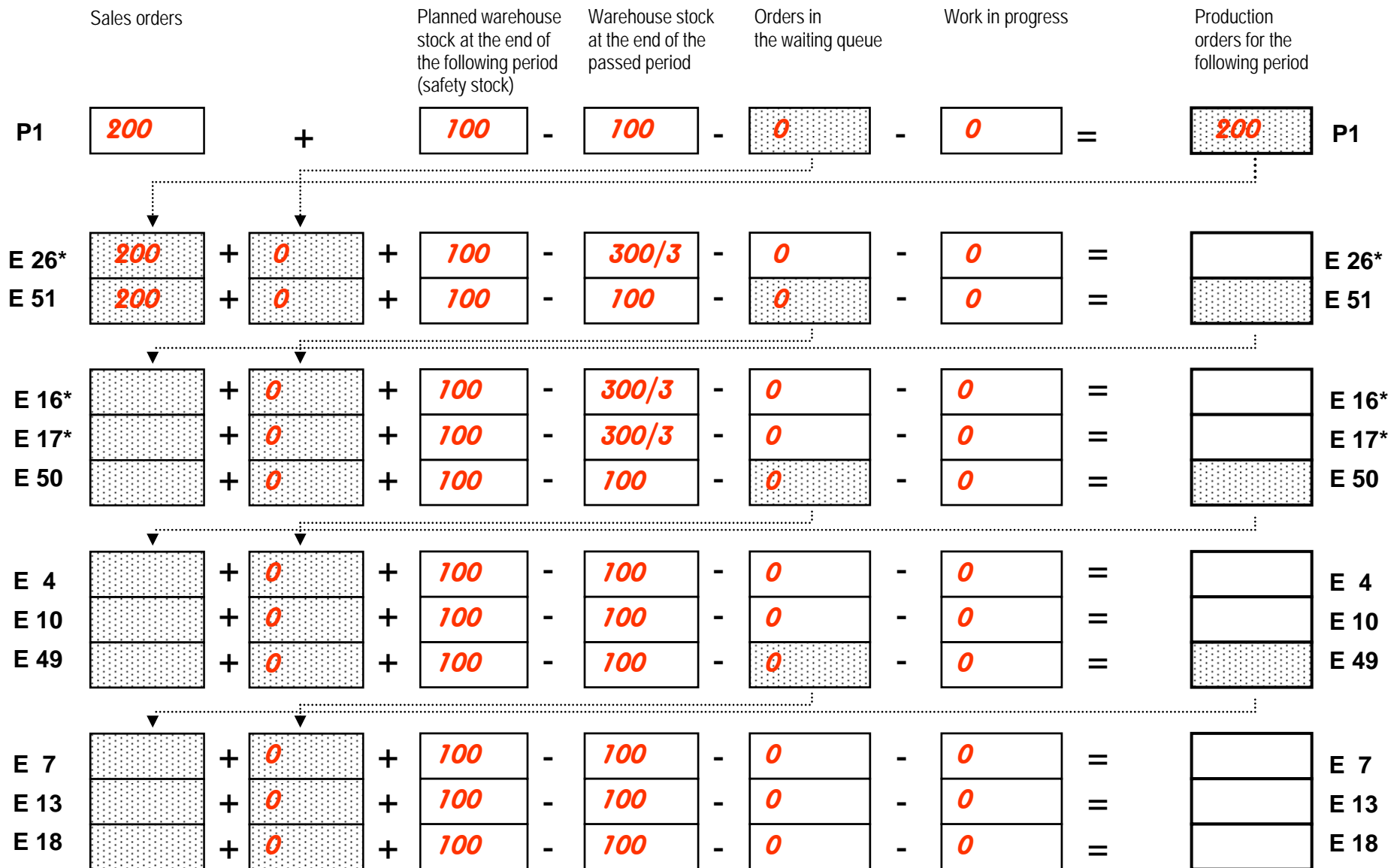






Bill of material for P1 (Children's bicycle)

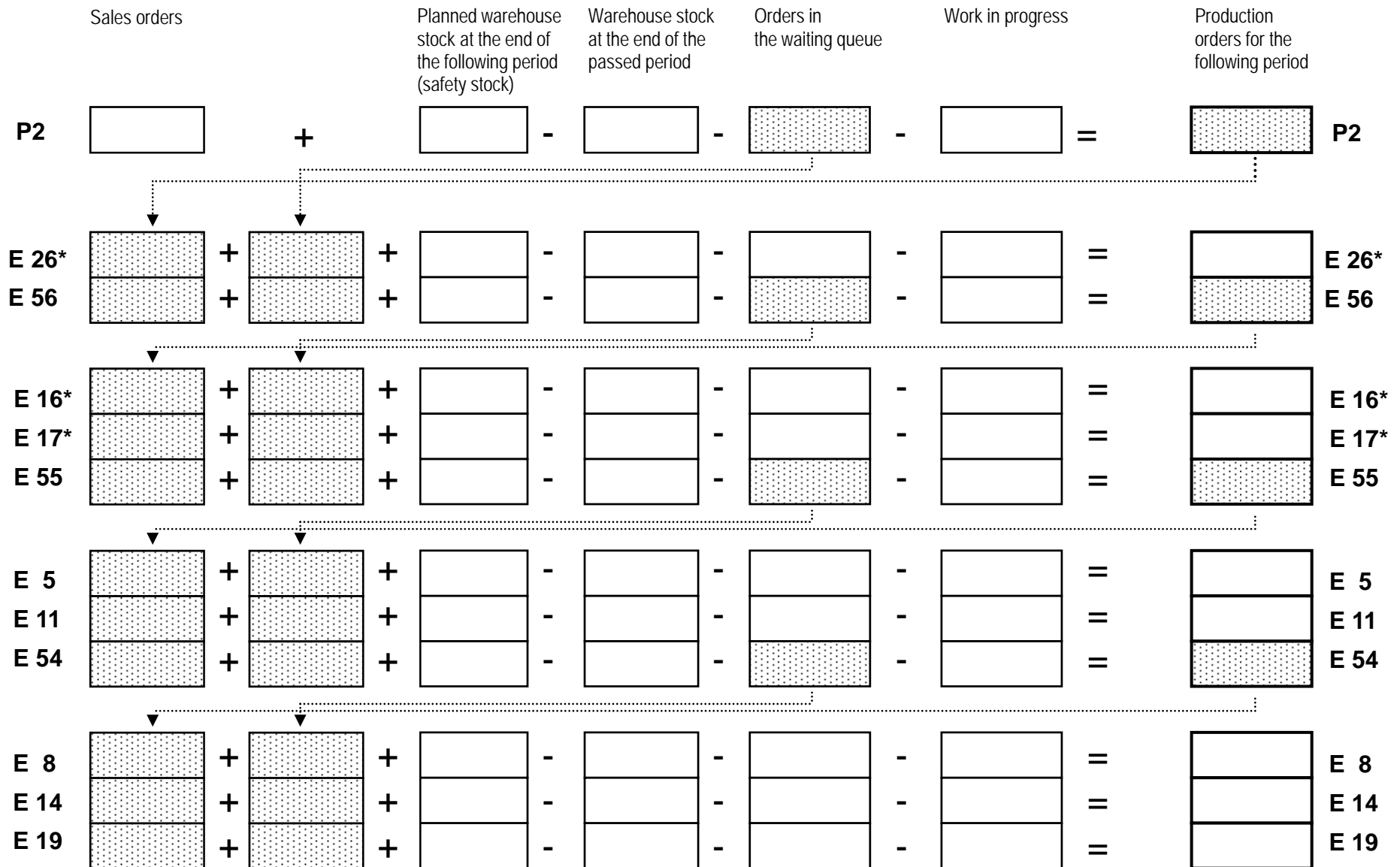
P1				1			
	K 21			1			
	K 24			1			
	K 27			1			
	E 26				1		
		K 44			2		
		K 47			1		
		K 48			2		
	E 51				1		
		K 24			1		
		K 27			1		
		E 16				1	
			K 24			1	
			K 28			1	
			K 40			1	
			K 41			1	
			K 42			2	
		E 17				1	
			K 43			1	
			K 44			1	
			K 45			1	
			K 46			1	
		E 50				1	
			K 24			2	
			K 25			2	
			E 4				1
				K 35			2
				K 36			1
				K 52			1
	K 53					36	
			■				
			■				
		■					



*) Attention! Parts are used in all finished Products

	Sales orders		Planned warehouse stock at the end of the following period (safety stock)	Warehouse stock at the end of the passed period	Orders in the waiting queue	Work in progress		Production orders for the following period	
P1	200	+	100	- 100	- 0	- 0	=	200	P1
E 26*	200	+	0	+	100	- 300/3	- 0	=	200
E 51	200	+	0	+	100	- 100	- 0	=	200
E 16*	200	+	0	+	100	- 300/3	- 0	=	200
E 17*	200	+	0	+	100	- 300/3	- 0	=	200
E 50	200	+	0	+	100	- 100	- 0	=	200
E 4	200	+	0	+	100	- 100	- 0	=	200
E 10	200	+	0	+	100	- 100	- 0	=	200
E 49	200	+	0	+	100	- 100	- 0	=	200
E 7	200	+	0	+	100	- 100	- 0	=	200
E 13	200	+	0	+	100	- 100	- 0	=	200
E 18	200	+	0	+	100	- 100	- 0	=	200

*) Attention! Parts are used in all finished Products

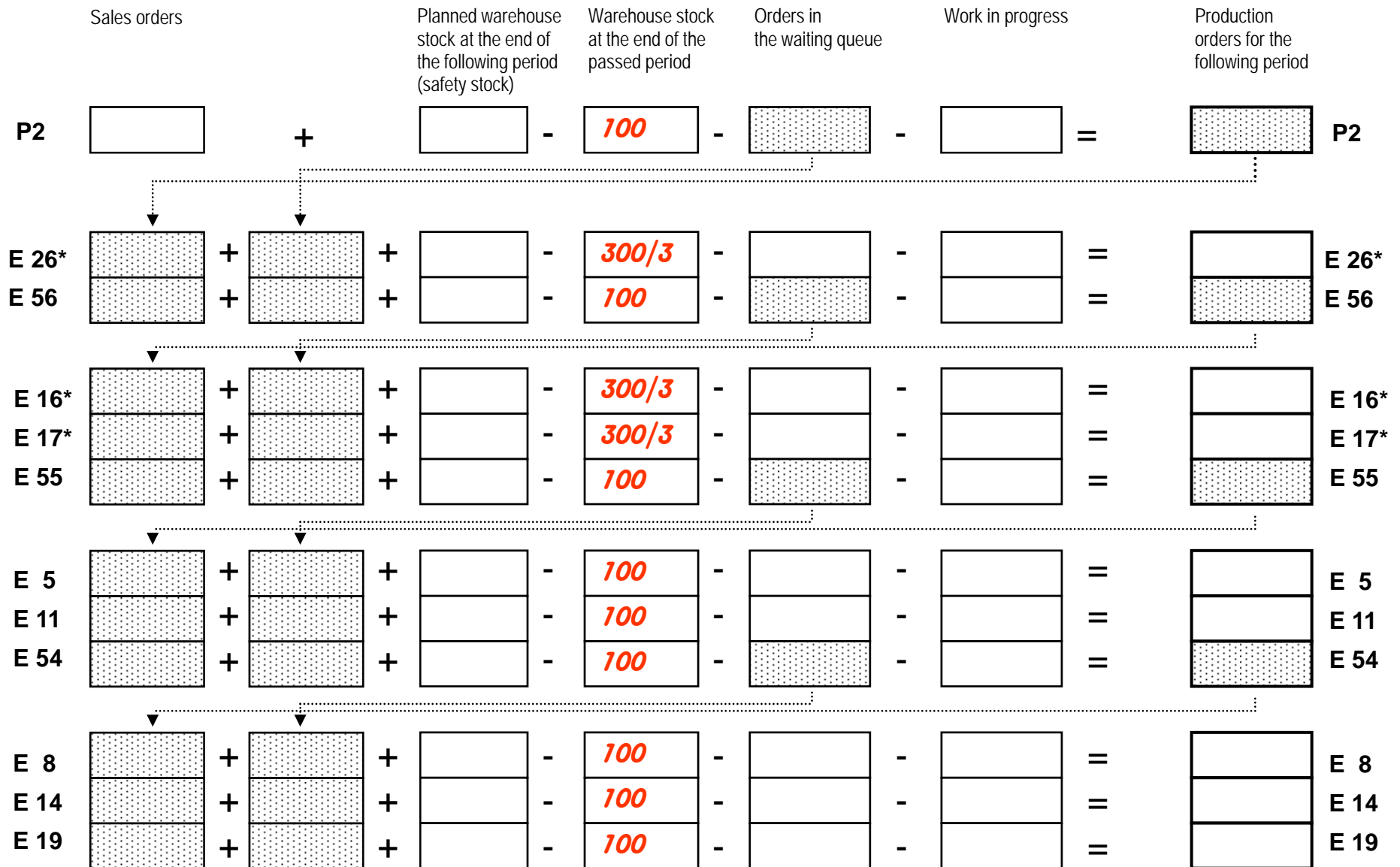


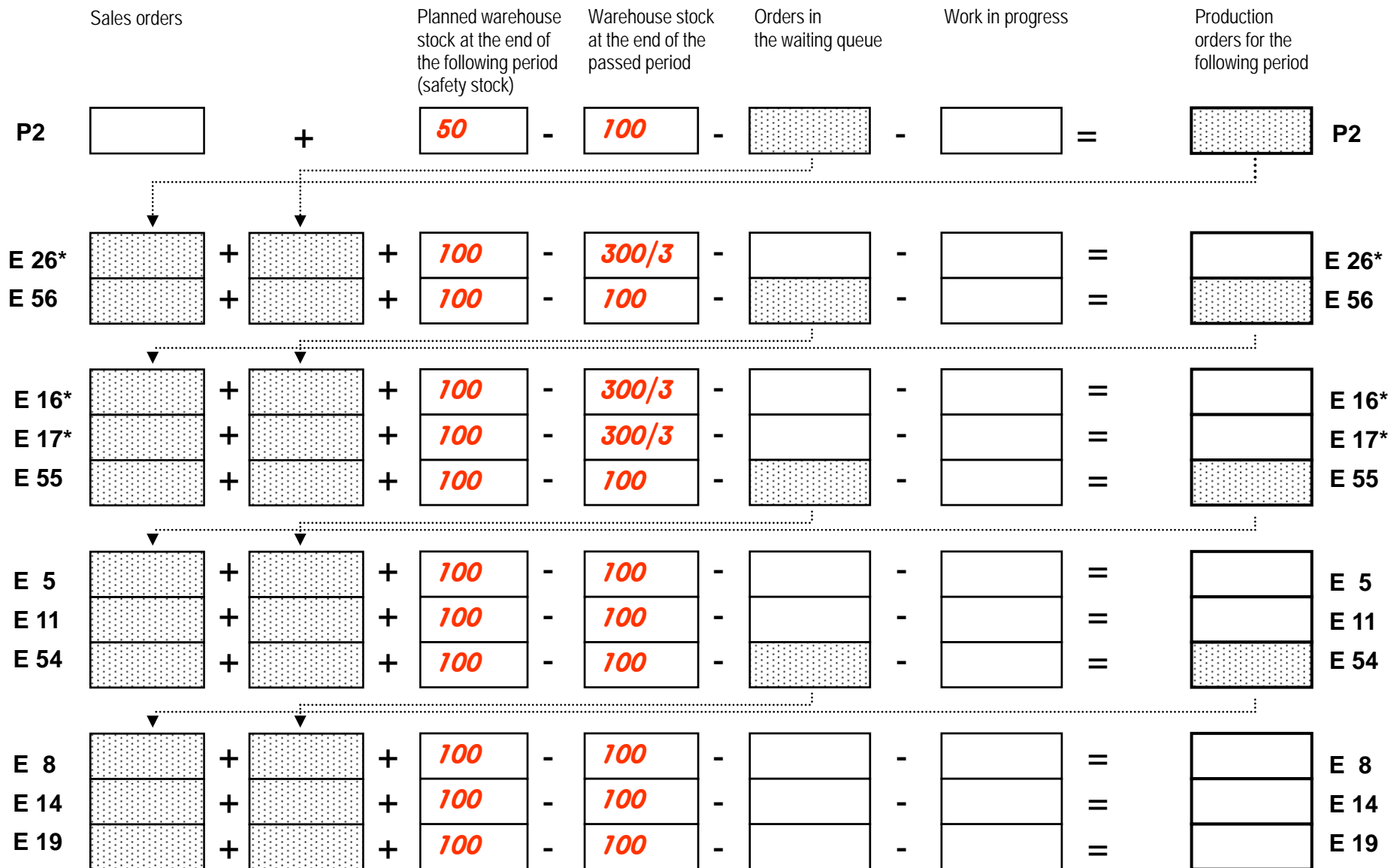
*) Attention! Parts are used in all finished Products

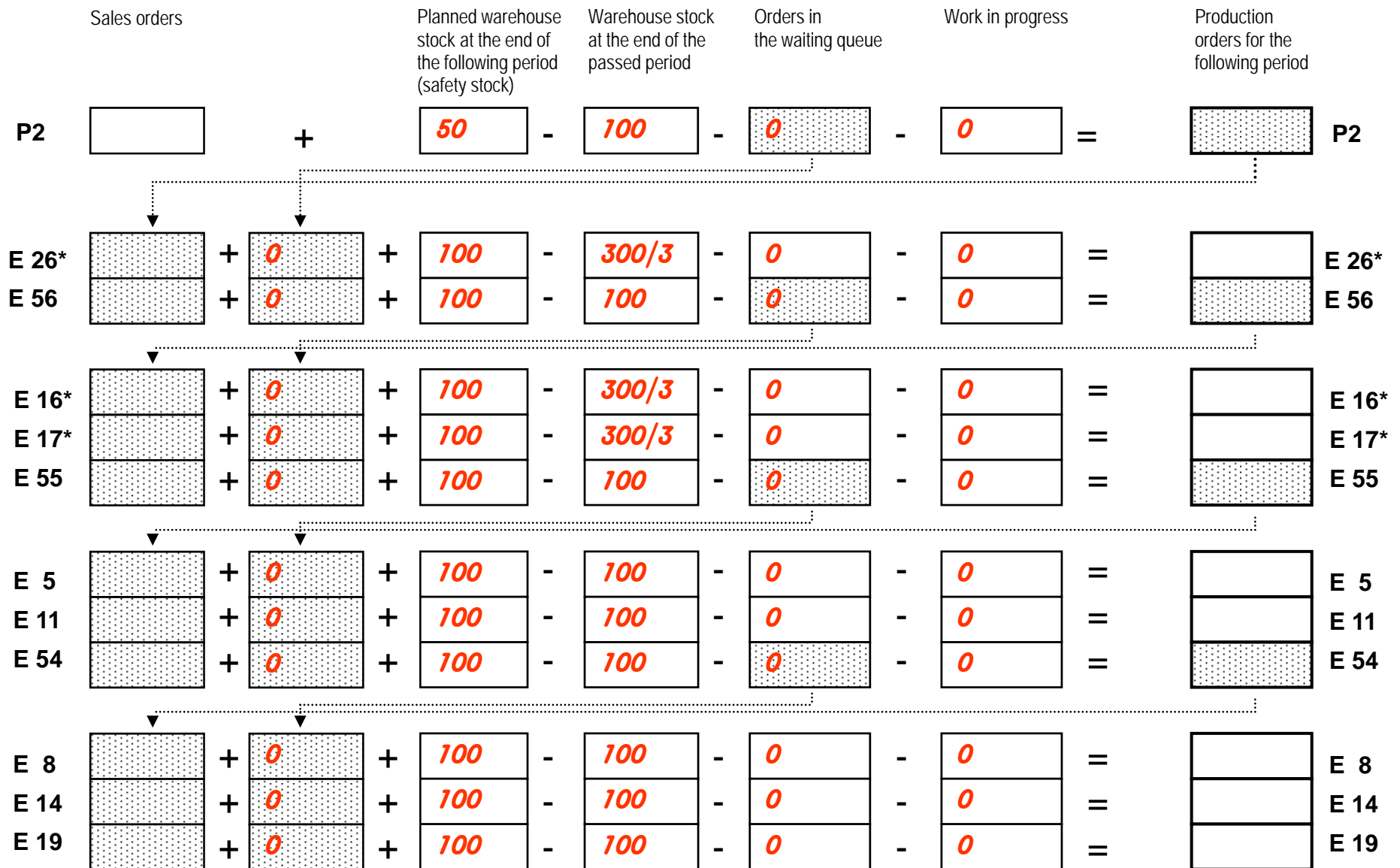
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E 5	Rear wheel group	L	39,85	100
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E 7	Front wheel group	C	35,85	100
E 8	Front wheel group	L	35,85	100
E 9	Front wheel group	M	35,85	100
E 10	Mudguard rear	C	12,40	100
E 11	Mudguard rear	L	14,65	100
E 12	Mudguard rear	M	14,65	100
E 13	Mudguard front	C	12,40	100
E 14	Mudguard front	L	14,65	100
E 15	Mudguard front	M	14,65	100
E 16	Handle complete	CLM	7,02	300
E 17	Saddle complete	CLM	7,16	300
E 18	Frame	C	13,15	100
E 19	Frame	L	14,35	100
E 20	Frame	M	15,55	100
E 26	Pedal complete	CLM	10,50	300
E 29	Front wheel compl.	M	69,29	100
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E 31	Bicycle w/o pedals	M	144,42	100
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E 51	Bicycle w/o pedals	C	137,47	100
E 54	Front wheel compl.	L	68,09	100
E 55	Frame and wheels	L	125,33	100
E 56	Bicycle w/o pedals	L	142,67	100

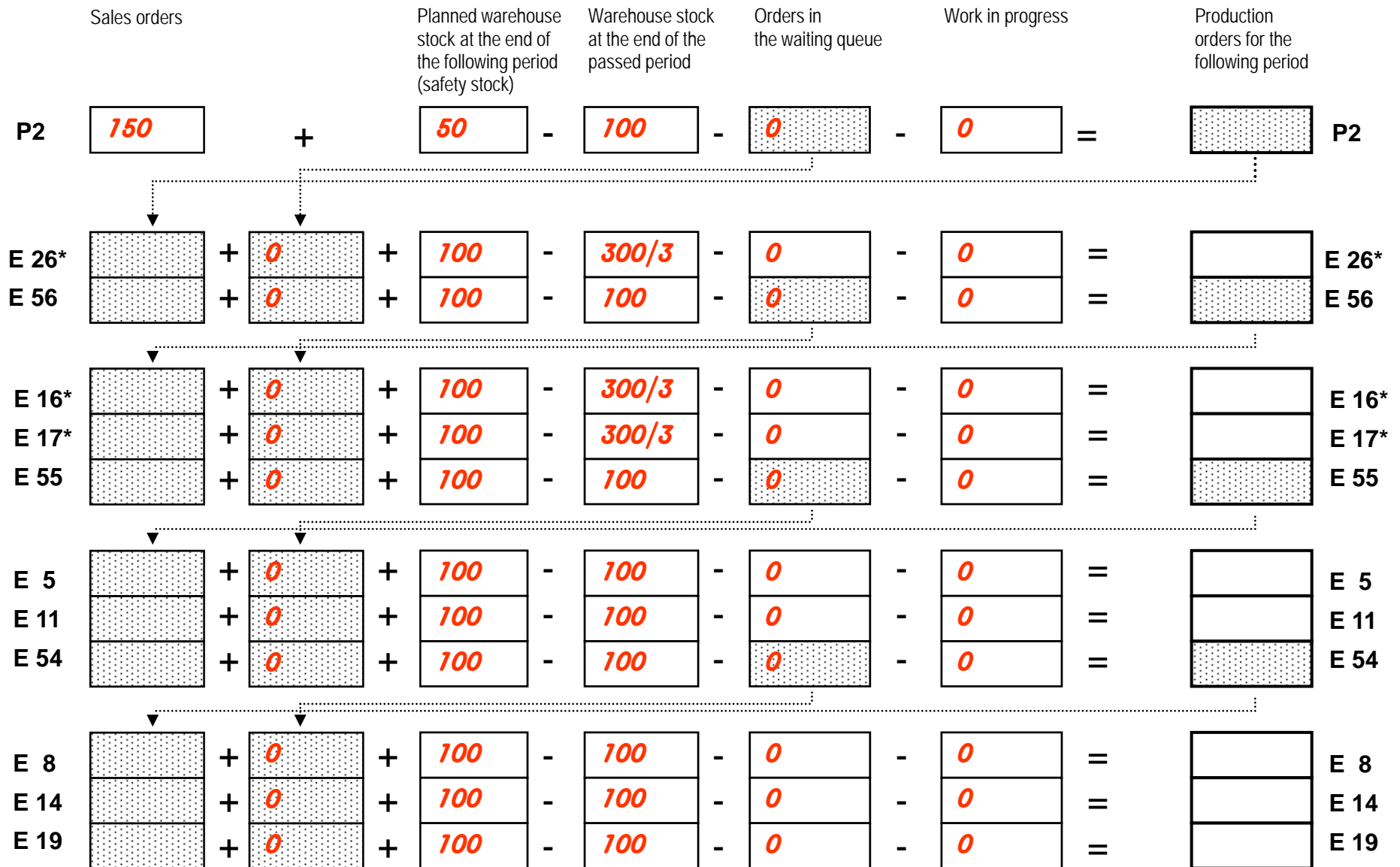
E = In-house manufactured part and component

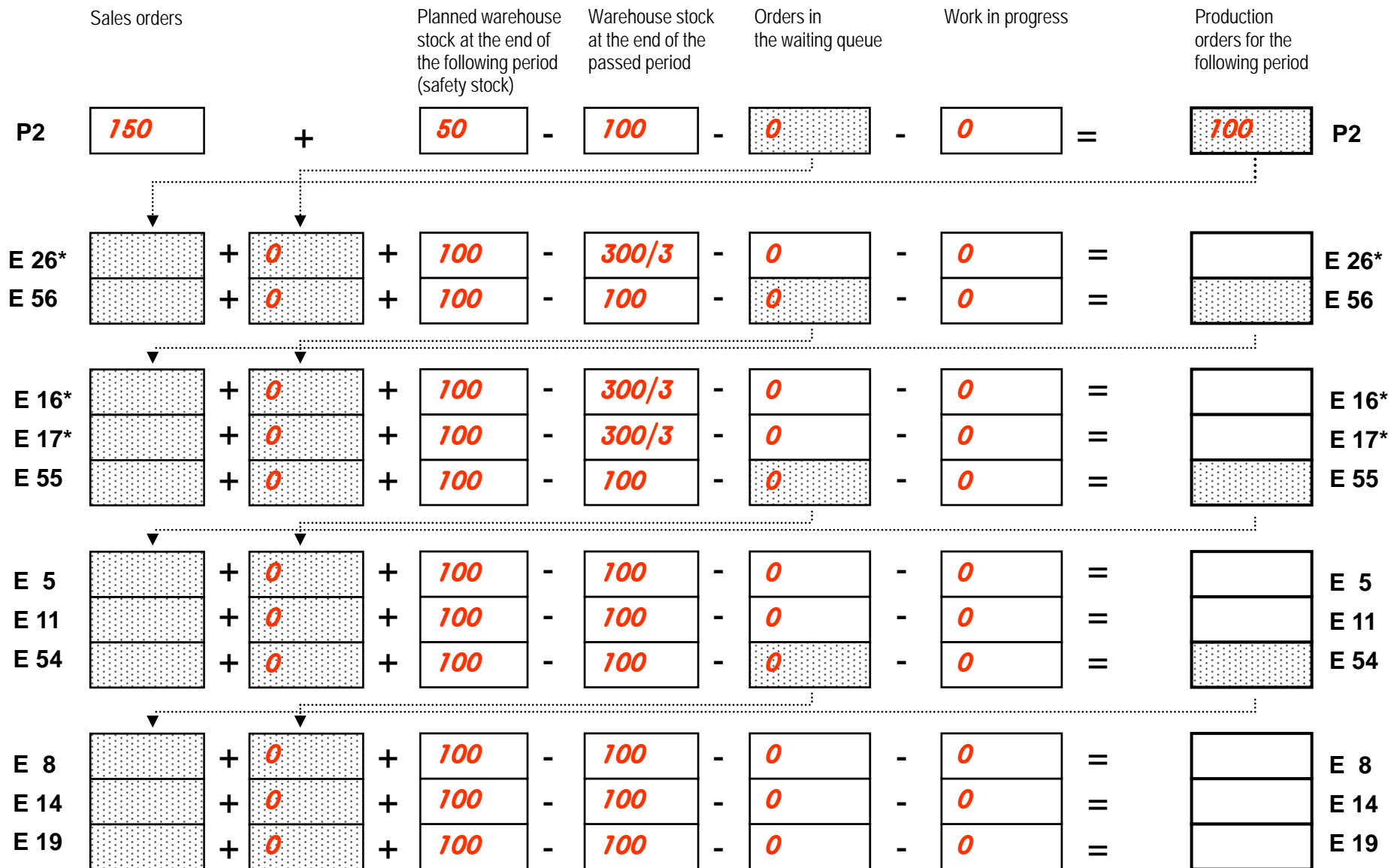
C = Used in children's bicycle L = Used in ladies bicycle M = Used in men's bicycle

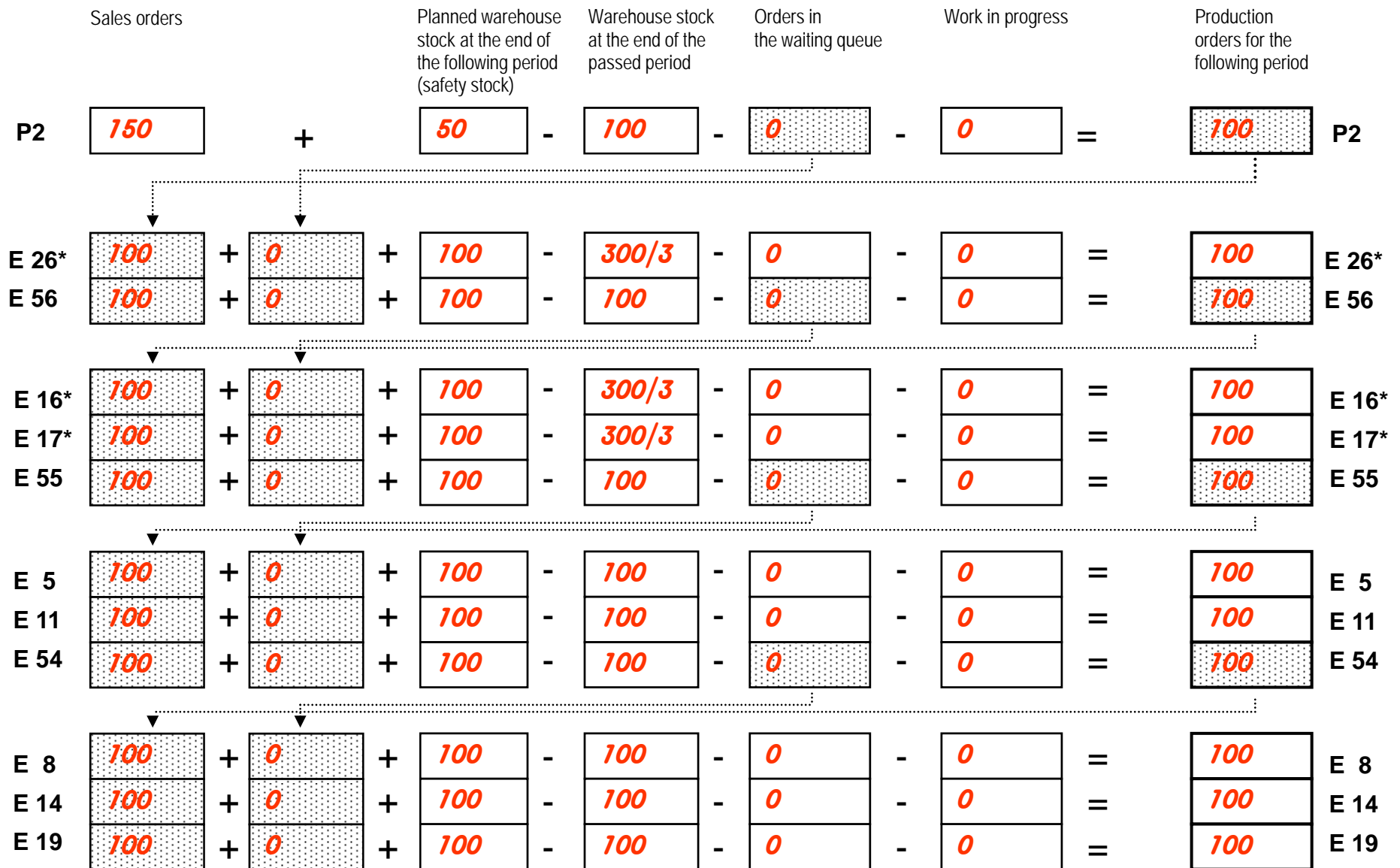


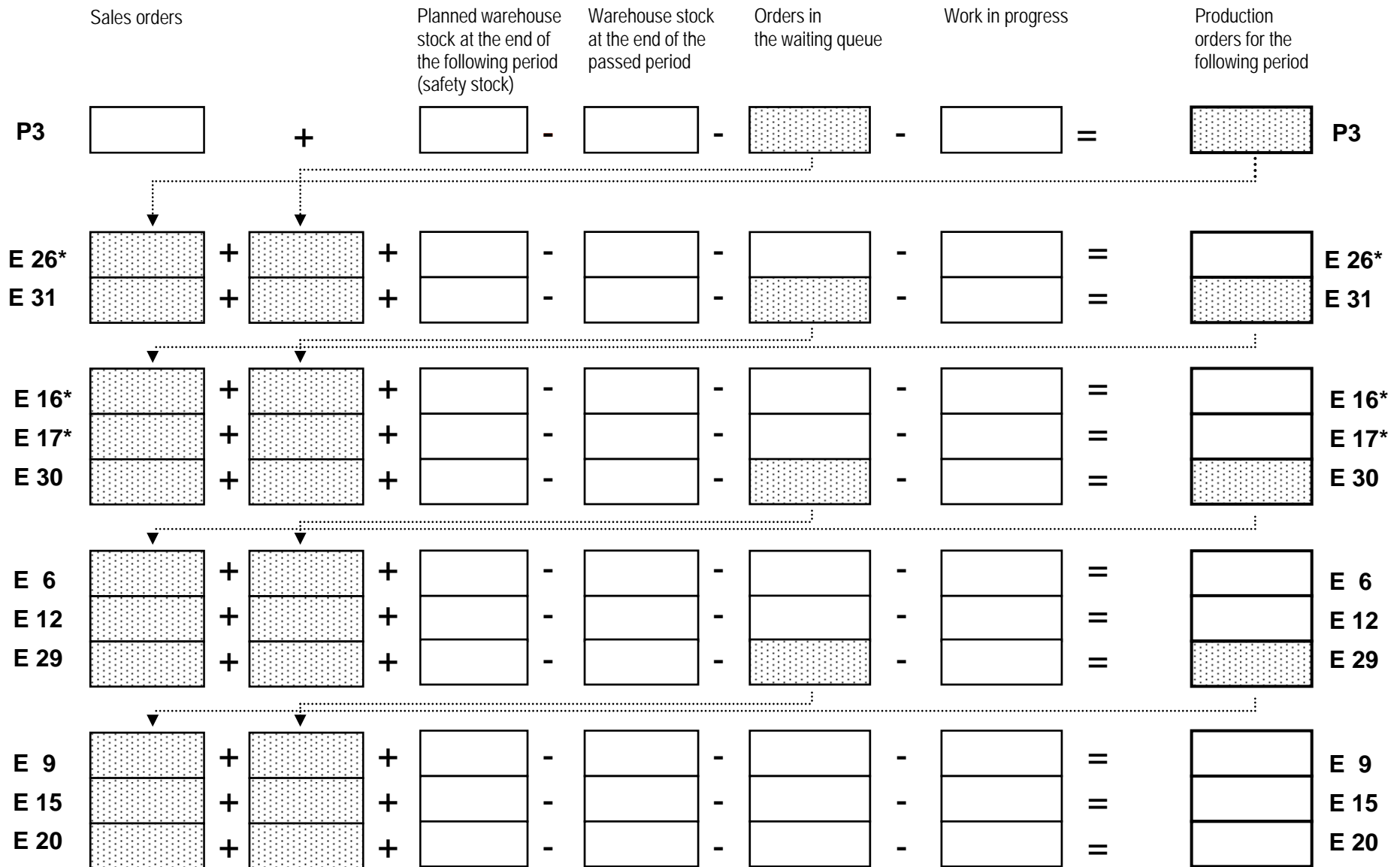












	Sales orders		Planned warehouse stock at the end of the following period (safety stock)	Warehouse stock at the end of the passed period	Orders in the waiting queue	Work in progress		Production orders for the following period	
P3	100	+	50	100	0	0	=	50	P3
									⋮
E 26*	50	+	0	300/3	0	0	=	50	E 26*
E 31	50	+	0	100	0	0	=	50	E 31
E 16*	50	+	0	300/3	0	0	=	50	E 16*
E 17*	50	+	0	300/3	0	0	=	50	E 17*
E 30	50	+	0	100	0	0	=	50	E 30
E 6	50	+	0	100	0	0	=	50	E 6
E 12	50	+	0	100	0	0	=	50	E 12
E 29	50	+	0	100	0	0	=	50	E 29
E 9	50	+	0	100	0	0	=	50	E 9
E 15	50	+	0	100	0	0	=	50	E 15
E 20	50	+	0	100	0	0	=	50	E 20

*) Attention! Parts are used in all finished Products

Period...	Item No.	Order-quantity	Workplace														
			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Rear wheel	C E4											4	3				
	L E5											4	3				
	M E6											4	3				
Front wheel	C E7											4	3				
	L E8											4	3				
	M E9											4	3				
Mudguard rear	C E10								2	1	3			3	2		
	L E11								2	2	3			3	2		
	M E12								2	2	3			3	2		
Mudguard front	C E13								2	1	3			3	2		
	L E14								2	2	3			3	2		
	M E15								2	2	3			3	2		
Handle bar	CLM E16							2								3	
Seat	CLM E17																3
Frame	C E18							3	2	3	2						
	L E19							3	2	3	2						
	M E20							3	2	3	2						
Pedal	CLM E26								2								3
Front wheel complete _(cpl)	C E49		6														
	L E54		6														
	M E29		6														
Frame and wheels	C E50			5													
	L E55			5													
	M E30			5													
Bicycle w/o pedal	C E51				5												
	L E56				6												
	M E31				6												
Bicycle complete _(cpl)	C P1				6												
	L P2				7												
	M P3				7												
Capacity requirements (new)																	
Setup time (new)																	
Cap.req. (backlog prev. periods)																	
Setup time (backlog prev. periods)																	
Total capacity requirements ¹⁾																	
Shifts and Overtime ²⁾																	

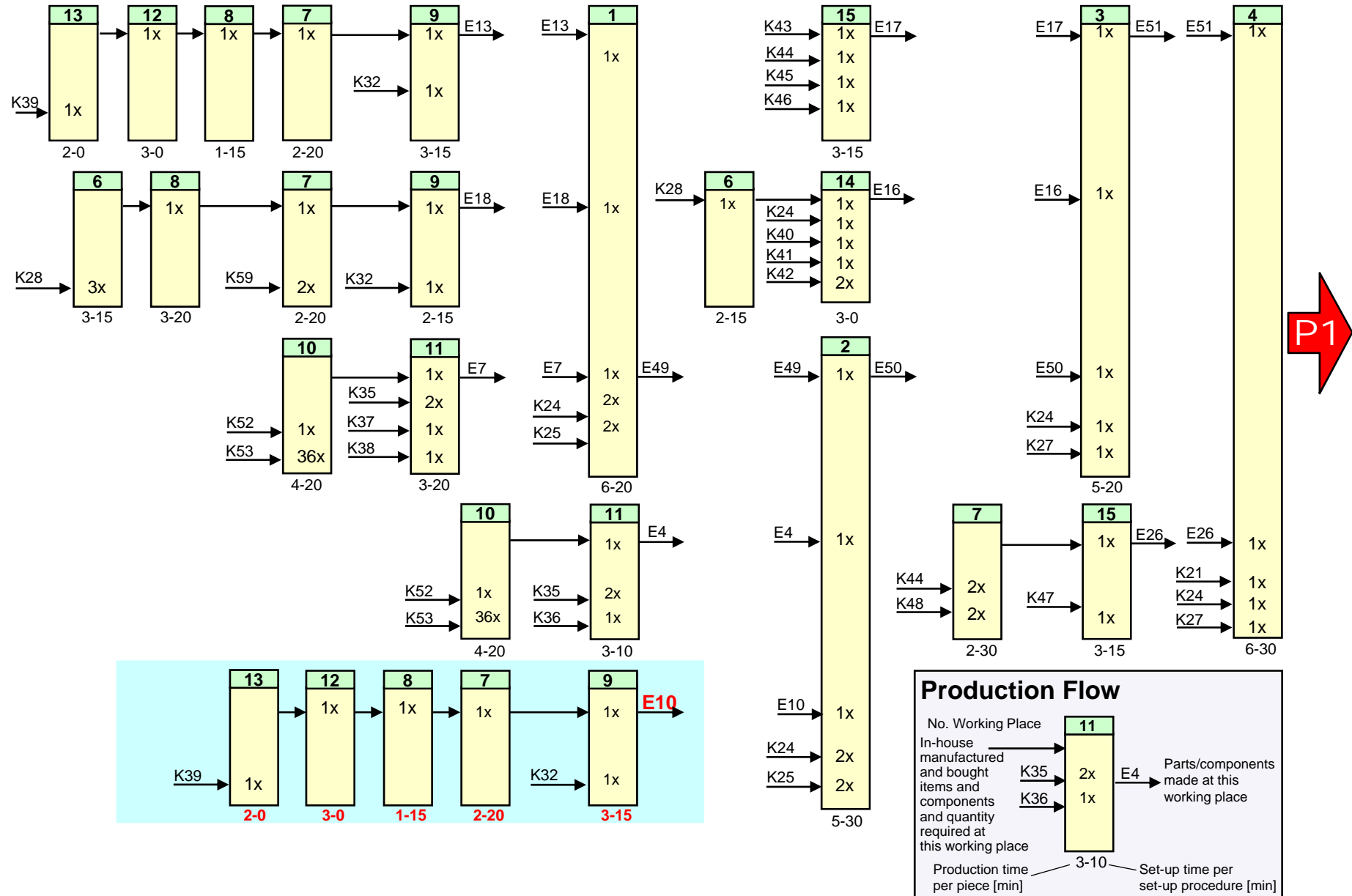
¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Period...	Description	Item No.	Order-quantity	Workplace														
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Rear wheel	C	E4	200										4	3				
	L	E5	100										4	3				
	M	E6	50										4	3				
Front wheel	C	E7	200										4	3				
	L	E8	100										4	3				
	M	E9	50										4	3				
Mudguard rear	C	E10	200						2		1	3			3	2		
	L	E11	100						2		2	3			3	2		
	M	E12	50						2		2	3			3	2		
Mudguard front	C	E13	200						2		1	3			3	2		
	L	E14	100						2		2	3			3	2		
	M	E15	50						2		2	3			3	2		
Handle bar	CLM	E16	350						2								3	
Seat	CLM	E17	350															3
Frame	C	E18	200						3		2	3	2					
	L	E19	100						3		2	3	2					
	M	E20	50						3		2	3	2					
Pedal	CLM	E26	350							2								3
Front wheel complete _(cpl)	C	E49	200	6														
	L	E54	100	6														
	M	E29	50	6														
Frame and wheels	C	E50	200		5													
	L	E55	100		5													
	M	E30	50		5													
Bicycle w/o pedal	C	E51	200			5												
	L	E56	100			6												
	M	E31	50			6												
Bicycle complete _(cpl)	C	P1	200				6											
	L	P2	100				7											
	M	P3	50				7											
Capacity requirements (new)																		
Setup time (new)																		
Cap.req. (backlog prev. periods)																		
Setup time (backlog prev. periods)																		
Total capacity requirements ¹⁾																		
Shifts and Overtime ²⁾																		

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²⁾ Shifts 1, 2, 3 - overtime in minutes per day



Period...	Description	Item No.	Order-quantity	Workplace														
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Rear wheel	C	E4	200										4	3				
	L	E5	100										4	3				
	M	E6	50										4	3				
Front wheel	C	E7	200										4	3				
	L	E8	100										4	3				
	M	E9	50										4	3				
Mudguard rear	C	E10	200							2	400	1	200	3	600			
	L	E11	100							2		2		3				
	M	E12	50							2		2		3				
Mudguard front	C	E13	200							2		1		3				
	L	E14	100							2		2		3				
	M	E15	50							2		2		3				
Handle bar	CLM	E16	350						2								3	
Seat	CLM	E17	350															3
Frame	C	E18	200						3		2		3		2			
	L	E19	100						3		2		3		2			
	M	E20	50						3		2		3		2			
Pedal	CLM	E26	350							2								3
Front wheel complete _(cpl)	C	E49	200	6														
	L	E54	100	6														
	M	E29	50	6														
Frame and wheels	C	E50	200		5													
	L	E55	100		5													
	M	E30	50		5													
Bicycle w/o pedal	C	E51	200			5												
	L	E56	100			6												
	M	E31	50			6												
Bicycle complete _(cpl)	C	P1	200				6											
	L	P2	100				7											
	M	P3	50				7											
Capacity requirements (new)																		
Setup time (new)																		
Cap.req. (backlog prev. periods)																		
Setup time (backlog prev. periods)																		
Total capacity requirements ¹⁾																		
Shifts and Overtime ²⁾																		

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²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Period...	Description	Item No.	Order-quantity	Workplace														
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Rear wheel	C	E4	200										4	800	3	600		
	L	E5	100										4	400	3	300		
	M	E6	50										4	200	3	150		
Front wheel	C	E7	200										4	800	3	600		
	L	E8	100										4	400	3	300		
	M	E9	50										4	200	3	150		
Mudguard rear	C	E10	200							2	400	1	200	3	300			
	L	E11	100							2	200	2	200	3	300			
	M	E12	50							2	100	2	100	3	150			
Mudguard front	C	E13	200							2	400	1	200	3	600			
	L	E14	100							2	300	2	200	3	300			
	M	E15	50							2	100	2	100	3	150			
Handle bar	CLM	E16	350							2	700						3	1050
Seat	CLM	E17	350															3 1050
Frame	C	E18	200							3	600	2	200	3	600	2	400	
	L	E19	100							3	300	2	200	3	300	2	200	
	M	E20	50							3	150	2	100	3	150	2	100	
Pedal	CLM	E26	350							2	700							3 1050
Front wheel complete _(cpl)	C	E49	200	6	1200													
	L	E54	100	6	600													
	M	E29	50	6	300													
Frame and wheels	C	E50	200		5	1000												
	L	E55	100		5	500												
	M	E30	50		5	250												
Bicycle w/o pedal	C	E51	200			5	1000											
	L	E56	100			6	600											
	M	E31	50			6	300											
Bicycle complete _(cpl)	C	P1	200			6	1200											
	L	P2	100			7	700											
	M	P3	50			7	350											
Capacity requirements (new)																		
Setup time (new)																		
Cap.req. (backlog prev. periods)																		
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Period...	Item No.	Order-quantity	Workplace																	
Description			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15			
Rear wheel	C	E4	200									4	800	3	600					
	L	E5	100									4	400	3	300					
	M	E6	50									4	200	3	150					
Front wheel	C	E7	200									4	800	3	600					
	L	E8	100									4	400	3	300					
	M	E9	50									4	200	3	150					
Mudguard rear	C	E10	200						2	400	1	200	3	300		3	600	2	400	
	L	E11	100						2	200	2	200	3	300		3	300	2	200	
	M	E12	50						2	100	2	100	3	150		3	150	2	100	
Mudguard front	C	E13	200						2	400	1	200	3	600		3	600	2	400	
	L	E14	100						2	300	2	200	3	300		3	300	2	200	
	M	E15	50						2	100	2	100	3	150		3	150	2	100	
Handle bar	CLM	E16	350						2	700								3	1050	
Seat	CLM	E17	350																3	1050
Frame	C	E18	200						3	600	2	200	3	600	2	400				
	L	E19	100						3	300	2	200	3	300	2	200				
	M	E20	50						3	150	2	100	3	150	2	100				
Pedal	CLM	E26	350						2	700									3	1050
Front wheel complete _(cpl)	C	E49	200	6	1200															
	L	E54	100	6	600															
	M	E29	50	6	300															
Frame and wheels	C	E50	200		5	1000														
	L	E55	100		5	500														
	M	E30	50		5	250														
Bicycle w/o pedal	C	E51	200			5	1000													
	L	E56	100			6	600													
	M	E31	50			6	300													
Bicycle complete _(cpl)	C	P1	200				6	1200												
	L	P2	100				7	700												
	M	P3	50				7	350												
Capacity requirements (new)				2100	1750	1900	2250		1750	2700	2050	2500	2800	2100	2100	1450	105	2100		
Setup time (new)																				
Cap.req. (backlog prev. periods)																				
Setup time (backlog prev. periods)																				
Total capacity requirements ¹⁾																				
Shifts and Overtime ²⁾																				

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Period...		Item No.	Order-quantity	Workplace																
Description				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15		
Rear wheel	C	E4	200										4	800	3	600				
	L	E5	100										4	400	3	300				
	M	E6	50										4	200	3	150				
Front wheel	C	E7	200										4	800	3	600				
	L	E8	100										4	400	3	300				
	M	E9	50										4	200	3	150				
Mudguard rear	C	E10	200							2	400	1	200	3	300		3	600	2	400
	L	E11	100							2	200	2	200	3	300		3	300	2	200
	M	E12	50							2	100	2	100	3	150		3	150	2	150
Mudguard front	C	E13	200							2	400	1	200	3	600		3	600	2	400
	L	E14	100							2	300	2	200	3	300		3	300	2	200
	M	E15	50							2	100	2	100	3	150		3	150	2	100
Handle bar	CLM	E16	350						2	700								3	1050	
Seat	CLM	E17	350																3	1050
Frame	C	E18	200						3	600	2	200	3	600	2	400				
	L	E19	100						3	300	2	200	3	300	2	200				
	M	E20	50						3	150	2	100	3	150	2	100				
Pedal	CLM	E26	350							2	700								3	1050
Front wheel complete _(cpl)	C	E49	200	6	1200															
	L	E54	100	6	600															
	M	E29	50	6	300															
Frame and wheels	C	E50	200		5	1000														
	L	E55	100		5	500														
	M	E30	50		5	250														
Bicycle w/o pedal	C	E51	200			5	1000													
	L	E56	100			6	600													
	M	E31	50			6	300													
Bicycle complete _(cpl)	C	P1	200				6	1200												
	L	P2	100				7	700												
	M	P3	50				7	350												
Capacity requirements (new)				2100	1750	1900	2250		1750	2700	2050	2500	2800	2100	2100	1450	105	2100		
Setup time (new)				60	80	60	80		60	200	155	140	120	130	0	0	0	30		
Cap.req. (backlog prev. periods)																				
Setup time (backlog prev. periods)																				
Total capacity requirements ¹⁾																				
Shifts and Overtime ²⁾																				

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Period...		Item No.	Order-quantity	Workplace																
Description				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15		
Rear wheel	C	E4	200										4	800	3	600				
	L	E5	100										4	400	3	300				
	M	E6	50										4	200	3	150				
Front wheel	C	E7	200										4	800	3	600				
	L	E8	100										4	400	3	300				
	M	E9	50										4	200	3	150				
Mudguard rear	C	E10	200							2	400	1	200	3	300		3	600	2	400
	L	E11	100							2	200	2	200	3	300		3	300	2	200
	M	E12	50							2	100	2	100	3	150		3	150	2	100
Mudguard front	C	E13	200							2	400	1	200	3	600		3	600	2	400
	L	E14	100							2	300	2	200	3	300		3	300	2	200
	M	E15	50							2	100	2	100	3	150		3	150	2	100
Handle bar	CLM	E16	350						2	700								3	1050	
Seat	CLM	E17	350																3	1050
Frame	C	E18	200						3	600	2	200	3	600	2	400				
	L	E19	100						3	300	2	200	3	300	2	200				
	M	E20	50						3	150	2	100	3	150	2	100				
Pedal	CLM	E26	350							2	700								3	1050
Front wheel complete _(cpl)	C	E49	200	6	1200															
	L	E54	100	6	600															
	M	E29	50	6	300															
Frame and wheels	C	E50	200		5	1000														
	L	E55	100		5	500														
	M	E30	50		5	250														
Bicycle w/o pedal	C	E51	200			5	1000													
	L	E56	100			6	600													
	M	E31	50			6	300													
Bicycle complete _(cpl)	C	P1	200				6	1200												
	L	P2	100				7	700												
	M	P3	50				7	350												
Capacity requirements (new)				2100	1750	1900	2250		1750	2700	2050	2500	2800	2100	2100	1450	1050	2100		
Setup time (new)				60	80	60	80		60	200	155	140	120	130	0	0	0	0	30	
Cap.req. (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0		
Setup time (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0		
Total capacity requirements ¹⁾																				
Shifts and Overtime ²⁾																				

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Period...		Item No.	Order-quantity	Workplace																	
Description				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15			
Rear wheel	C	E4	200										4	800	3	600					
	L	E5	100										4	400	3	300					
	M	E6	50										4	200	3	150					
Front wheel	C	E7	200										4	800	3	600					
	L	E8	100										4	400	3	300					
	M	E9	50										4	200	3	150					
Mudguard rear	C	E10	200							2	400	1	200	3	300		3	600	2	400	
	L	E11	100							2	200	2	200	3	300		3	300	2	200	
	M	E12	50							2	100	2	100	3	150		3	150	2	100	
Mudguard front	C	E13	200							2	400	1	200	3	600		3	600	2	400	
	L	E14	100							2	300	2	200	3	300		3	300	2	200	
	M	E15	50							2	100	2	100	3	150		3	150	2	100	
Handle bar	CLM	E16	350						2	700								3	1050		
Seat	CLM	E17	350																3	1050	
Frame	C	E18	200						3	600	2	200	3	600	2	400					
	L	E19	100						3	300	2	200	3	300	2	200					
	M	E20	50						3	150	2	100	3	150	2	100					
Pedal	CLM	E26	350							2	700								3	1050	
Front wheel complete _(cpl)	C	E49	200	6	1200																
	L	E54	100	6	600																
	M	E29	50	6	300																
Frame and wheels	C	E50	200		5	1000															
	L	E55	100		5	500															
	M	E30	50		5	250															
Bicycle w/o pedal	C	E51	200			5	1000														
	L	E56	100			6	600														
	M	E31	50			6	300														
Bicycle complete _(cpl)	C	P1	200				6	1200													
	L	P2	100				7	700													
	M	P3	50				7	350													
Capacity requirements (new)				2100	1750	1900	2250		1750	2700	2050	2500	2800	2100	2100	1450	1050	2100			
Setup time (new)				60	80	60	80		60	200	155	140	120	130	0	0	0	0	30		
Cap.req. (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0			
Setup time (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0			
Total capacity requirements ¹⁾				2160	1830	1960	2310		1810	2900	2205	2640	2920	2230	2100	1450	1050	2130			
Shifts and Overtime ²⁾																					

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Period...	Item No.	Order-quantity	Workplace																		
Description			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15				
Rear wheel	C	E4	200									4	800	3	600						
	L	E5	100									4	400	3	300						
	M	E6	50									4	200	3	150						
Front wheel	C	E7	200									4	800	3	600						
	L	E8	100									4	400	3	300						
	M	E9	50									4	200	3	150						
Mudguard rear	C	E10	200						2	400	1	200	3	300			3	600	2	400	
	L	E11	100						2	200	2	200	3	300			3	300	2	200	
	M	E12	50						2	100	2	100	3	150			3	150	2	150	
Mudguard front	C	E13	200						2	400	1	200	3	600			3	600	2	400	
	L	E14	100						2	300	2	200	3	300			3	300	2	200	
	M	E15	50						2	100	2	100	3	150			3	150	2	100	
Handle bar	CLM	E16	350						2	700									3	1050	
Seat	CLM	E17	350																	3	1050
Frame	C	E18	200						3	600	2	200	3	600	2	400					
	L	E19	100						3	300	2	200	3	300	2	200					
	M	E20	50						3	150	2	100	3	150	2	100					
Pedal	CLM	E26	350							2	700									3	1050
Front wheel complete _(cpl)	C	E49	200	6	1200																
	L	E54	100	6	600																
	M	E29	50	6	300																
Frame and wheels	C	E50	200			5	1000														
	L	E55	100			5	500														
	M	E30	50			5	250														
Bicycle w/o pedal	C	E51	200				5	1000													
	L	E56	100				6	600													
	M	E31	50				6	300													
Bicycle complete _(cpl)	C	P1	200					6	1200												
	L	P2	100					7	700												
	M	P3	50					7	350												
Capacity requirements (new)				2100	1750	1900	2250		1750	2700	2050	2500	2800	2100	2100	1450	1050	2100			
Setup time (new)				60	80	60	80		60	200	155	140	120	130	0	0	0	0	30		
Cap.req. (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0	0		
Setup time (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0	0		
Total capacity requirements ¹⁾				2160	1830	1960	2310		1810	2900	2205	2640	2920	2230	2100	1450	1050	2130			
Shifts and Overtime ²⁾										500/5 =100		240/5 = 50	520/5 = 105								

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

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Capacity Planning - calculation of extra shifts and/or overtime

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Item No.	Description	Where used	Item value [€]	Stock quantity [piece]	Discount quantity [piece]	Order costs [€]	Procure lead-time [Period]	Deviation +/- [Period]
21 K	Chain	C	5,00	300	300	50,00	1,8	0,4
22 K	Chain	L	6,50	300	300	50,00	1,7	0,4
23 K	Chain	M	6,50	300	300	50,00	1,2	0,2
24 K	Nut 3/8"	CLM	0,06	6.100	6.100	100,00	3,2	0,3
25 K	Washer 3/8"	CLM	0,06	3.600	3.600	50,00	0,9	0,2
27 K	Screw 3/8"	CLM	0,10	1.800	1.800	75,00	0,9	0,2
28 K	Tube 3/4"	CLM	1,20	4.500	4.500	50,00	1,7	0,4
32 K	Paint	CLM	0,75	2.700	2.700	50,00	2,1	0,5
33 K	Rim compl.	M	22,00	900	900	75,00	1,9	0,5
34 K	Spoke	M	0,10	22.000	22.000	50,00	1,6	0,3
35 K	Taper sleeve	CLM	1,00	3.600	3.600	75,00	2,2	0,4
36 K	Free wheel	CLM	8,00	900	900	100,00	1,2	0,1
37 K	Fork	CLM	1,50	900	900	50,00	1,5	0,3
38 K	Axle	CLM	1,50	300	300	50,00	1,7	0,4
39 K	Sheet	CLM	1,50	900	1.800	75,00	1,5	0,3
40 K	Handle bar	CLM	2,50	900	900	50,00	1,7	0,2
41 K	Nut 3/4"	CLM	0,06	900	900	50,00	0,9	0,2
42 K	Handle grip	CLM	0,10	1.800	1.800	50,00	1,2	0,3
43 K	Saddle	CLM	5,00	1.900	2.700	75,00	2,0	0,5
44 K	Bar 1/2"	CLM	0,50	2.700	900	50,00	1,0	0,2
45 K	Nut 1/4"	CLM	0,06	900	900	50,00	1,7	0,3
46 K	Screw 1/4"	CLM	0,10	900	900	50,00	0,9	0,3
47 K	Sprocket	CLM	3,50	900	900	50,00	1,1	0,1
48 K	Pedal	CLM	1,50	1.800	1.800	75,00	1,0	0,2
52 K	Rim compl.	C	22,00	600	600	50,00	1,6	0,4
53 K	Spoke	C	0,10	22.000	22.000	50,00	1,6	0,2
57 K	Rim compl.	L	22,00	600	600	50,00	1,7	0,3
58 K	Spoke	L	0,10	22.000	22.000	50,00	1,6	0,5
59 K	Welding wires	CLM	0,15	1.800	1.800	50,00	0,7	0,2

K = Bought item

C = Used in children's bicycle L = Used in ladies bicycle M = Used in men's bicycle

Item Master Data: Purchased Parts at the Beginning of the First Period

Production program				
Period	1	2	3	4
P1				
P2				
P3				

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300											
22	1,7	0,4		1 x		300											
23	1,2	0,2			1 x	300											
24	3,2	0,3	7 x	7 x	7 x	6100											
25	0,9	0,2	4 x	4 x	4 x	3600											
27	0,9	0,2	2 x	2 x	2 x	1800											
28	1,7	0,4	4 x	5 x	6 x	4500											
32	2,1	0,5	3 x	3 x	3 x	2700											
33	1,9	0,5			2 x	900											
34	1,6	0,3			72 x	22000											
35	2,2	0,4	4 x	4 x	4 x	3600											
36	1,2	0,1	1 x	1 x	1 x	900											
37	1,5	0,3	1 x	1 x	1 x	900											
38	1,7	0,4	1 x	1 x	1 x	300											
39	1,5	0,3	2 x	2 x	2 x	1800											
40	1,7	0,2	1 x	1 x	1 x	900											
41	0,9	0,2	1 x	1 x	1 x	900											
42	1,2	0,3	2 x	2 x	2 x	1800											
43	2,0	0,5	1 x	1 x	1 x	2700											
44	1,0	0,2	3 x	3 x	3 x	900											
45	1,7	0,3	1 x	1 x	1 x	900											
46	0,9	0,3	1 x	1 x	1 x	900											
47	1,1	0,1	1 x	1 x	1 x	900											
48	1,0	0,2	2 x	2 x	2 x	1800											
52	1,6	0,4	2 x			600											
53	1,6	0,2	72 x			22000											
57	1,7	0,3		2 x		600											
58	1,6	0,5		72 x		22000											
59	0,7	0,2	2 x	2 x	2 x	1800											

Production program				
Period	n	n+1	n+2	n+3
P1				
P2				
P3				

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order N=normal F=fast Quantity	Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4		2	3	4	5
21	1,8	0,4	1 x			300	300									
22	1,7	0,4		1 x		300	300									
23	1,2	0,2			1 x	300	300									
24	3,2	0,3	7 x	7 x	7 x	6100	6100									
25	0,9	0,2	4 x	4 x	4 x	3600	3600									
27	0,9	0,2	2 x	2 x	2 x	1800	1800									
28	1,7	0,4	4 x	5 x	6 x	4500	4500									
32	2,1	0,5	3 x	3 x	3 x	2700	2700									
33	1,9	0,5			2 x	900	900									
34	1,6	0,3			72 x	22000	22000									
35	2,2	0,4	4 x	4 x	4 x	3600	3600									
36	1,2	0,1	1 x	1 x	1 x	900	900									
37	1,5	0,3	1 x	1 x	1 x	900	900									
38	1,7	0,4	1 x	1 x	1 x	300	300									
39	1,5	0,3	2 x	2 x	2 x	1800	900									
40	1,7	0,2	1 x	1 x	1 x	900	900									
41	0,9	0,2	1 x	1 x	1 x	900	900									
42	1,2	0,3	2 x	2 x	2 x	1800	1800									
43	2,0	0,5	1 x	1 x	1 x	2700	1900									
44	1,0	0,2	3 x	3 x	3 x	900	2700									
45	1,7	0,3	1 x	1 x	1 x	900	900									
46	0,9	0,3	1 x	1 x	1 x	900	900									
47	1,1	0,1	1 x	1 x	1 x	900	900									
48	1,0	0,2	2 x	2 x	2 x	1800	1800									
52	1,6	0,4	2 x			600	600									
53	1,6	0,2	72 x			22000	22000									
57	1,7	0,3		2 x		600	600									
58	1,6	0,5		72 x		22000	22000									
59	0,7	0,2	2 x	2 x	2 x	1800	1800									

	Sales orders	Forecasts			
Period Product	1	2	3	4	
P 1 Children's bicycle	200	150	150	150	
P 2 Lady's bicycle	150/100	100	100/150	50	
P 3 Men's bicycle	100/50	100	50	50/100	
Total	450/350	350	300/350	250/300	

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300										
22	1,7	0,4		1 x		300	300										
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200									
22	1,7	0,4		1 x		300	300										
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150						
22	1,7	0,4		1 x		300	300										
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300					
22	1,7	0,4		1 x		300	300										
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300										
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300	100	100	150	50						
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300	100	100	150	50	300	N				
23	1,2	0,2			1 x	300	300										
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300	100	100	150	50	300	N				
23	1,2	0,2			1 x	300	300	50	100	50	100						
24	3,2	0,3	7 x	7 x	7 x	6100	6100										
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300	100	100	150	50	300	N				
23	1,2	0,2			1 x	300	300	50	100	50	100						
24	3,2	0,3	7 x	7 x	7 x	6100	6100	2450	2450	2450	2100	6100	F				
25	0,9	0,2	4 x	4 x	4 x	3600	3600										
27	0,9	0,2	2 x	2 x	2 x	1800	1800										
28	1,7	0,4	4 x	5 x	6 x	4500	4500										
32	2,1	0,5	3 x	3 x	3 x	2700	2700										
33	1,9	0,5			2 x	900	900										
34	1,6	0,3			72 x	22000	22000										
35	2,2	0,4	4 x	4 x	4 x	3600	3600										
36	1,2	0,1	1 x	1 x	1 x	900	900										
37	1,5	0,3	1 x	1 x	1 x	900	900										
38	1,7	0,4	1 x	1 x	1 x	300	300										
39	1,5	0,3	2 x	2 x	2 x	1800	900										
40	1,7	0,2	1 x	1 x	1 x	900	900										
41	0,9	0,2	1 x	1 x	1 x	900	900										
42	1,2	0,3	2 x	2 x	2 x	1800	1800										
43	2,0	0,5	1 x	1 x	1 x	2700	1900										
44	1,0	0,2	3 x	3 x	3 x	900	2700										
45	1,7	0,3	1 x	1 x	1 x	900	900										
46	0,9	0,3	1 x	1 x	1 x	900	900										
47	1,1	0,1	1 x	1 x	1 x	900	900										
48	1,0	0,2	2 x	2 x	2 x	1800	1800										
52	1,6	0,4	2 x			600	600										
53	1,6	0,2	72 x			22000	22000										
57	1,7	0,3		2 x		600	600										
58	1,6	0,5		72 x		22000	22000										
59	0,7	0,2	2 x	2 x	2 x	1800	1800										

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300	100	100	150	50	300	N				
23	1,2	0,2			1 x	300	300	50	100	50	100						
24	3,2	0,3	7 x	7 x	7 x	6100	6100	2450	2450	2450	2100	6100	F				
25	0,9	0,2	4 x	4 x	4 x	3600	3600	1400	1400	1400	1200						
27	0,9	0,2	2 x	2 x	2 x	1800	1800	700	700	700	600						
28	1,7	0,4	4 x	5 x	6 x	4500	4500	1600	1700	1650	1450						
32	2,1	0,5	3 x	3 x	3 x	2700	2700	1050	1050	1050	900						
33	1,9	0,5			2 x	900	900	100	200	100	200						
34	1,6	0,3			72 x	22000	22000	3600	7200	3600	7200						
35	2,2	0,4	4 x	4 x	4 x	3600	3600	1400	1400	1400	1200						
36	1,2	0,1	1 x	1 x	1 x	900	900	350	350	350	300						
37	1,5	0,3	1 x	1 x	1 x	900	900	350	350	350	350						
38	1,7	0,4	1 x	1 x	1 x	300	300	350	350	350	300	600	F				
39	1,5	0,3	2 x	2 x	2 x	1800	900	700	700	700	600	1800	N				
40	1,7	0,2	1 x	1 x	1 x	900	900	350	350	350	300						
41	0,9	0,2	1 x	1 x	1 x	900	900	350	350	350	300						
42	1,2	0,3	2 x	2 x	2 x	1800	1800	700	700	700	600						
43	2,0	0,5	1 x	1 x	1 x	2700	1900	350	350	350	300						
44	1,0	0,2	3 x	3 x	3 x	900	2700	1050	1050	1050	900						
45	1,7	0,3	1 x	1 x	1 x	900	900	350	350	350	300						
46	0,9	0,3	1 x	1 x	1 x	900	900	350	350	350	300						
47	1,1	0,1	1 x	1 x	1 x	900	900	350	350	350	300						
48	1,0	0,2	2 x	2 x	2 x	1800	1800	700	700	700	600						
52	1,6	0,4	2 x			600	600	400	300	300	300	600	N				
53	1,6	0,2	72 x			22000	22000	14400	10800	10800	10800	22000	F				
57	1,7	0,3		2 x		600	600	200	200	300	100						
58	1,6	0,5		72 x		22000	22000	7200	7200	10800	3600	22000	N				
59	0,7	0,2	2 x	2 x	2 x	1800	1800	700	700	700	600						

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Period...	Description	Item No.	Order-quantity	Workplace														
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
Rear wheel	C	E4	200										4	3				
	L	E5	100										4	3				
	M	E6	50										4	3				
Front wheel	C	E7	200										4	3				
	L	E8	100										4	3				
	M	E9	50										4	3				
Mudguard rear	C	E10	200						2		1	3			3	2		
	L	E11	100						2		2	3			3	2		
	M	E12	50						2		2	3			3	2		
Mudguard front	C	E13	200						2		1	3			3	2		
	L	E14	100						2		2	3			3	2		
	M	E15	50						2		2	3			3	2		
Handle bar	CLM	E16	350						2								3	
Seat	CLM	E17	350															3
Frame	C	E18	200						3		2	3	2					
	L	E19	100						3		2	3	2					
	M	E20	50						3		2	3	2					
Pedal	CLM	E26	350						2									3
Front wheel complete _(cpl)	C	E49	200	6														
	L	E54	100	6														
	M	E29	50	6														
Frame and wheels	C	E50	200		5													
	L	E55	100		5													
	M	E30	50		5													
Bicycle w/o pedal	C	E51	200			5												
	L	E56	100			6												
	M	E31	50			6												
Bicycle complete _(cpl)	C	P1	200				6											
	L	P2	100				7											
	M	P3	50				7											
Capacity requirements (new)																		
Setup time (new)																		
Cap.req. (backlog prev. periods)																		
Setup time (backlog prev. periods)																		
Total capacity requirements ¹⁾																		
Shifts and Overtime ²⁾																		

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

Direct Sales (2)		Purchase orders N = normal; F = fast (3)						Production orders (4)						Capacity requirements (5)					
Item No.	Quantity	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	Item No.	Quantity	Item No.	Quantity	Working place	Shifts (1, 2, 3)	Overtime [Min/Tag]
											4	200	50	200					
											5	100	55	100					
											6	50	30	50					
											7	200	51	200					
											8	100	56	100					
											9	50	31	50					
											10	200	1	200					
											11	100	2	100					
											12	50	3	50					
											13	200							
											14	100							
											15	50							
											16	350							
											17	350							
											18	200							
											19	100							
											20	50							
											26	350							
											49	200							
											54	100							
											29	50							

Attention! Don't forget the production orders for the final assembly of P1, P2 und P3 at working place 4.

Sales Orders (1)		
P1	P2	P3

Production program				
Period	n	n+1	n+2	n+3
P1	200	150	150	150
P2	100	100	150	50
P3	50	100	50	100

Item No.	Delivery time	Deviation	Used in			Discount quantity	Initial stock in Per n	Gross requirements according the prod.progr.				Order		Stock after intended goods receipt			
			P1	P2	P3			1	2	3	4	Quantity	N=normal F=fast	2	3	4	5
21	1,8	0,4	1 x			300	300	200	150	150	150	300	N				
22	1,7	0,4		1 x		300	300	100	100	150	50	300	N				
23	1,2	0,2			1 x	300	300	50	100	50	100						
24	3,2	0,3	7 x	7 x	7 x	6100	6100	2450	2450	2450	2100	6100	F				
25	0,9	0,2	4 x	4 x	4 x	3600	3600	1400	1400	1400	1200						
27	0,9	0,2	2 x	2 x	2 x	1800	1800	700	700	700	600						
28	1,7	0,4	4 x	5 x	6 x	4500	4500	1600	1700	1650	1450						
32	2,1	0,5	3 x	3 x	3 x	2700	2700	1050	1050	1050	900						
33	1,9	0,5			2 x	900	900	100	200	100	200						
34	1,6	0,3			72 x	22000	22000	3600	7200	3600	7200						
35	2,2	0,4	4 x	4 x	4 x	3600	3600	1400	1400	1400	1200						
36	1,2	0,1	1 x	1 x	1 x	900	900	350	350	350	300						
37	1,5	0,3	1 x	1 x	1 x	900	900	350	350	350	350						
38	1,7	0,4	1 x	1 x	1 x	300	300	350	350	350	300	600	F				
39	1,5	0,3	2 x	2 x	2 x	1800	900	700	700	700	600	1800	N				
40	1,7	0,2	1 x	1 x	1 x	900	900	350	350	350	300						
41	0,9	0,2	1 x	1 x	1 x	900	900	350	350	350	300						
42	1,2	0,3	2 x	2 x	2 x	1800	1800	700	700	700	600						
43	2,0	0,5	1 x	1 x	1 x	2700	1900	350	350	350	300						
44	1,0	0,2	3 x	3 x	3 x	900	2700	1050	1050	1050	900						
45	1,7	0,3	1 x	1 x	1 x	900	900	350	350	350	300						
46	0,9	0,3	1 x	1 x	1 x	900	900	350	350	350	300						
47	1,1	0,1	1 x	1 x	1 x	900	900	350	350	350	300						
48	1,0	0,2	2 x	2 x	2 x	1800	1800	700	700	700	600						
52	1,6	0,4	2 x			600	600	400	300	300	300	600	N				
53	1,6	0,2	72 x			22000	22000	14400	10800	10800	10800	22000	F				
57	1,7	0,3		2 x		600	600	200	200	300	100						
58	1,6	0,5		72 x		22000	22000	7200	7200	10800	3600	22000	N				
59	0,7	0,2	2 x	2 x	2 x	1800	1800	700	700	700	600						

Material planning Purchased Items - the purchased orders

Direct Sales (2)		Purchase orders N = normal; F = fast (3)						Production orders (4)						Capacity requirements (5)			
Item No.	Quantity	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	Item No.	Quantity	Working place	Shifts (1, 2, 3)	Overtime [Min/Tag]
		21	300	N							4	200	50	200			
		22	300	N							5	100	55	100			
		24	6100	F							6	50	30	50			
		38	600	F							7	200	51	200			
		39	1800	N							8	100	56	100			
		52	600	N							9	50	31	50			
		53	22000	F							10	200	1	200			
		58	22000	N							11	100	2	100			
											12	50	3	50			
											13	200					
											14	100					
											15	50					
											16	350					
											17	350					
											18	200					
											19	100					
											20	50					
											26	350					
											49	200					
											54	100					
											29	50					

**Sales Orders
(1)**

P1	P2	P3

Attention! Don't forget the production orders for the final assembly of P1, P2 und P3 at working place 4.

Period...	Item No.	Order-quantity	Workplace																		
Description			1	2	3	4	5	6	7	8	9	10	11	12	13	14	15				
Rear wheel	C	E4	200									4	800	3	600						
	L	E5	100									4	400	3	300						
	M	E6	50									4	200	3	150						
Front wheel	C	E7	200									4	800	3	600						
	L	E8	100									4	400	3	300						
	M	E9	50									4	200	3	150						
Mudguard rear	C	E10	200						2	400	1	200	3	300			3	600	2	400	
	L	E11	100						2	200	2	200	3	300			3	300	2	200	
	M	E12	50						2	100	2	100	3	150			3	150	2	150	
Mudguard front	C	E13	200						2	400	1	200	3	600			3	600	2	400	
	L	E14	100						2	300	2	200	3	300			3	300	2	200	
	M	E15	50						2	100	2	100	3	150			3	150	2	100	
Handle bar	CLM	E16	350						2	700									3	1050	
Seat	CLM	E17	350																	3	1050
Frame	C	E18	200						3	600	2	200	3	600	2	400					
	L	E19	100						3	300	2	200	3	300	2	200					
	M	E20	50						3	150	2	100	3	150	2	100					
Pedal	CLM	E26	350							2	700									3	1050
Front wheel complete _(cpl)	C	E49	200	6	1200																
	L	E54	100	6	600																
	M	E29	50	6	300																
Frame and wheels	C	E50	200		5	1000															
	L	E55	100		5	500															
	M	E30	50		5	250															
Bicycle w/o pedal	C	E51	200			5	1000														
	L	E56	100			6	600														
	M	E31	50			6	300														
Bicycle complete _(cpl)	C	P1	200				6	1200													
	L	P2	100				7	700													
	M	P3	50				7	350													
Capacity requirements (new)				2100	1750	1900	2250		1750	2700	2050	2500	2800	2100	2100	1450	1050	2100			
Setup time (new)				60	80	60	80		60	200	155	140	120	130	0	0	0	0	30		
Cap.req. (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0	0		
Setup time (backlog prev. periods)				0	0	0	0		0	0	0	0	0	0	0	0	0	0	0		
Total capacity requirements ¹⁾				2160	1830	1960	2310		1810	2900	2205	2640	2920	2230	2100	1450	1050	2130			
Shifts and Overtime ²⁾										500/5 =100		240/5 = 50	520/5 = 105								

¹⁾ Total capacity requirements = capacity requirements (new) + capacity requirements (backlog previous periods) + setup time (backlog previous periods) [Minutes]

²⁾ Shifts 1, 2, 3 - overtime in minutes per day

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Capacity Planning - extra shifts and/or overtime

0149202

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Direct Sales (2)		Purchase orders N = normal; F = fast (3)					Production orders (4)						Capacity requirements (5)				
Item No.	Quantity	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	Item No.	Quantity	Working place	Shifts (1, 2, 3)	Overtime [Min/Tag]
		21	300	N							4	200	50	200	1	1	
		22	300	N							5	100	55	100	2	1	
		24	6100	F							6	50	30	50	3	1	
		38	600	F							7	200	51	200	4	1	
		39	1800	N							8	100	56	100	6	1	
		52	600	N							9	50	31	50	7	1	100
		53	22000	F							10	200	1	200	8	1	
		58	22000	N							11	100	2	100	9	1	50
											12	50	3	50	10	1	105
											13	200			11	1	
											14	100			12	1	
											15	50			13	1	
											16	350			14	1	
											17	350			15	1	
											18	200					
											19	100					
											20	50					
											26	350					
											49	200					
											54	100					
											29	50					

Attention! Don't forget the production orders for the final assembly of P1, P2 und P3 at working place 4.

Sales Orders (1)		
P1	P2	P3

	Sales Orders	Forecasts			
Period Product	1	2	3	4	
P 1 Children's bicycle	200	150	150	150	
P 2 Lady's bicycle	150	100	100	50	
P 3 Men's bicycle	100	100	50	50	
Total	450	350	300	250	

Direct Sales (2)		Purchase orders N = normal; F = fast (3)					Production orders (4)						Capacity requirements (5)				
Item No.	Quantity	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	N F	Item No.	Quantity	Item No.	Quantity	Working place	Shifts (1, 2, 3)	Overtime [Min/Day]
		21	300	N							4	200	50	200	1	1	
		22	300	N							5	100	55	100	2	1	
		24	6100	F							6	50	30	50	3	1	
		38	600	F							7	200	51	200	4	1	
		39	1800	N							8	100	56	100	6	1	
		52	600	N							9	50	31	50	7	1	100
		53	22000	F							10	200	1	200	8	1	
		58	22000	N							11	100	2	100	9	1	50
											12	50	3	50	10	1	105
											13	200			11	1	
											14	100			12	1	
											15	50			13	1	
											16	350			14	1	
											17	350			15	1	
											18	200					
											19	100					
											20	50					
											26	350					
											49	200					
											54	100					
											29	50					
											Attention! Don't forget the production orders for the final assembly of P1, P2 und P3 at working place 4.						
															Sales Orders (1)		
															P1	P2	P3
															200	150	100

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Sales & Direct sales

Sales		Direct sales		
P(rodect)1	200	Quantity	Price	Contract penalty
P(rodect)2	150	P(rodect)1	0	0.0
P(rodect)3	100	P(rodect)2	0	0.0
		P(rodect)3	0	0.0

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? Article Quantity Mode Article Quantity Mode Article Quantity Mode

21	300	normal(5)	0	0	normal(5)	0	0	normal(5)
22	300	normal(5)	0	0	normal(5)	0	0	normal(5)
24	6100	fast(4)	0	0	normal(5)	0	0	normal(5)
38	600	fast(4)	0	0	normal(5)	0	0	normal(5)
39	1800	normal(5)	0	0	normal(5)	0	0	normal(5)
52	600	normal(5)	0	0	normal(5)	0	0	normal(5)
53	22000	fast(4)	0	0	normal(5)	0	0	normal(5)
58	22000	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)
0	0	normal(5)	0	0	normal(5)	0	0	normal(5)

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Production releases

?

Article	Quantity	Article	Quantity	Article	Quantity	Article	Quantity
4	200	19	100	0	0	0	0
5	100	20	50	0	0	0	0
6	50	26	350	0	0	0	0
7	200	49	200	0	0	0	0
8	100	54	100	0	0	0	0
9	50	29	50	0	0	0	0
10	200	50	200	0	0	0	0
11	100	55	100	0	0	0	0
12	50	30	50	0	0	0	0
13	200	51	200	0	0	0	0
14	100	56	100	0	0	0	0
15	50	31	50	0	0	0	0
16	350	1	200	0	0	0	0
17	350	2	100	0	0	0	0
18	200	3	50	0	0	0	0

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Work schedule



	Shift	Overtime (min/day)
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15	<input type="text" value="1"/>	<input type="text" value="0"/>

* workingplace 5 does not exist

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