# Production Planning

## Lesson 9 : Repetitive Manufacturing

# Lesson Objectives

- Objectives -On successful completion of this training module, you should have:

- Understood the basics of Repetitive Manufacturing
- Master data  required for Repetitive Manufacturing
- Process flow diagram
- Basic terminology of repetitive manufacturing & their definitions

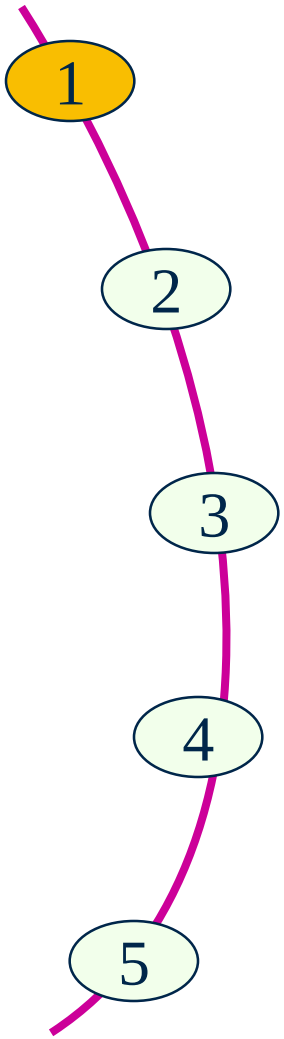
# Training Agenda

- What is Repetitive Manufacturing?
- master data  required for Repetitive Manufacturing
- Process flow diagram
- Repetitive manufacturing Profile
- Basic terminology of repetitive manufacturing & their definitions

# Training Agenda

- Price release-CK24
- Single Item-Multi Level MRP Run – MD02
- Repetitive manufacturing Back flush
- Stock Overview – MMBE
- Frequently Used Transactions for REM

# Repetitive Manufacturing

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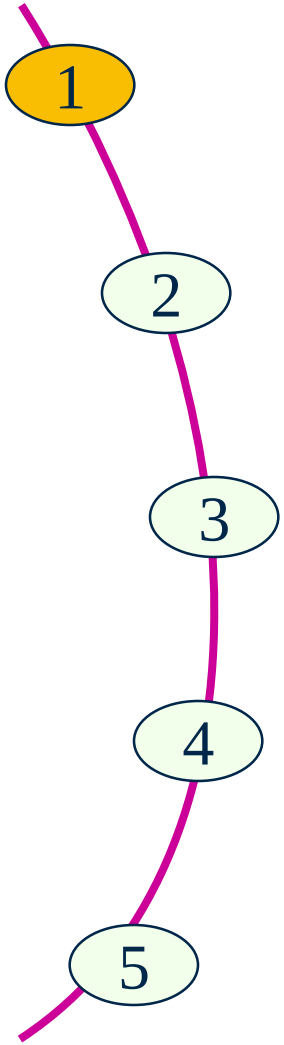
# Repetitive Manufacturing

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# Introduction

- Repetitive Manufacturing is commonly used when a production process meets the following criteria:
  - The same or similar products are produced over a lengthy period of time.
  - The products produced are not manufactured in individually defined lots. Instead, a total quantity is produced over a certain period at a certain rate per part-period.
  - The products produced always follow the same sequence through the machines and work centers in production.
  - Routings tend to be simple and do not vary much

# Master Data

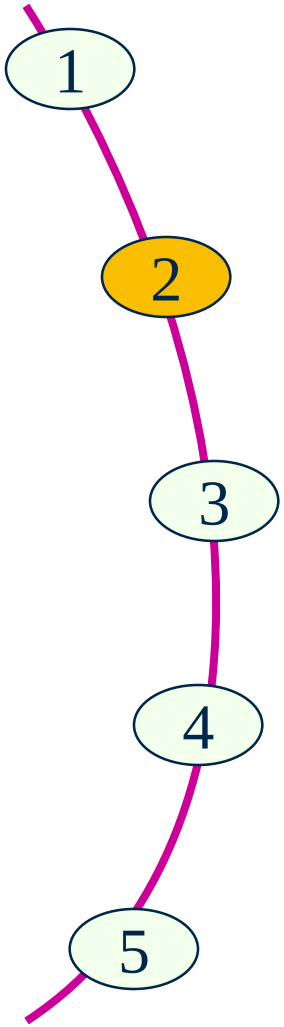
- The following master data  required for REM:

- REM Profile
- Production Version
- Rate Routing/Routing
- Product Cost Collector
- Standard Cost Estimate

# Key Process Steps

- Creating Planned Independent Requirements
- Material Requirements Planning at Plant Level
- In-House Production
- Confirming Assembly Activities

# Repetitive Manufacturing

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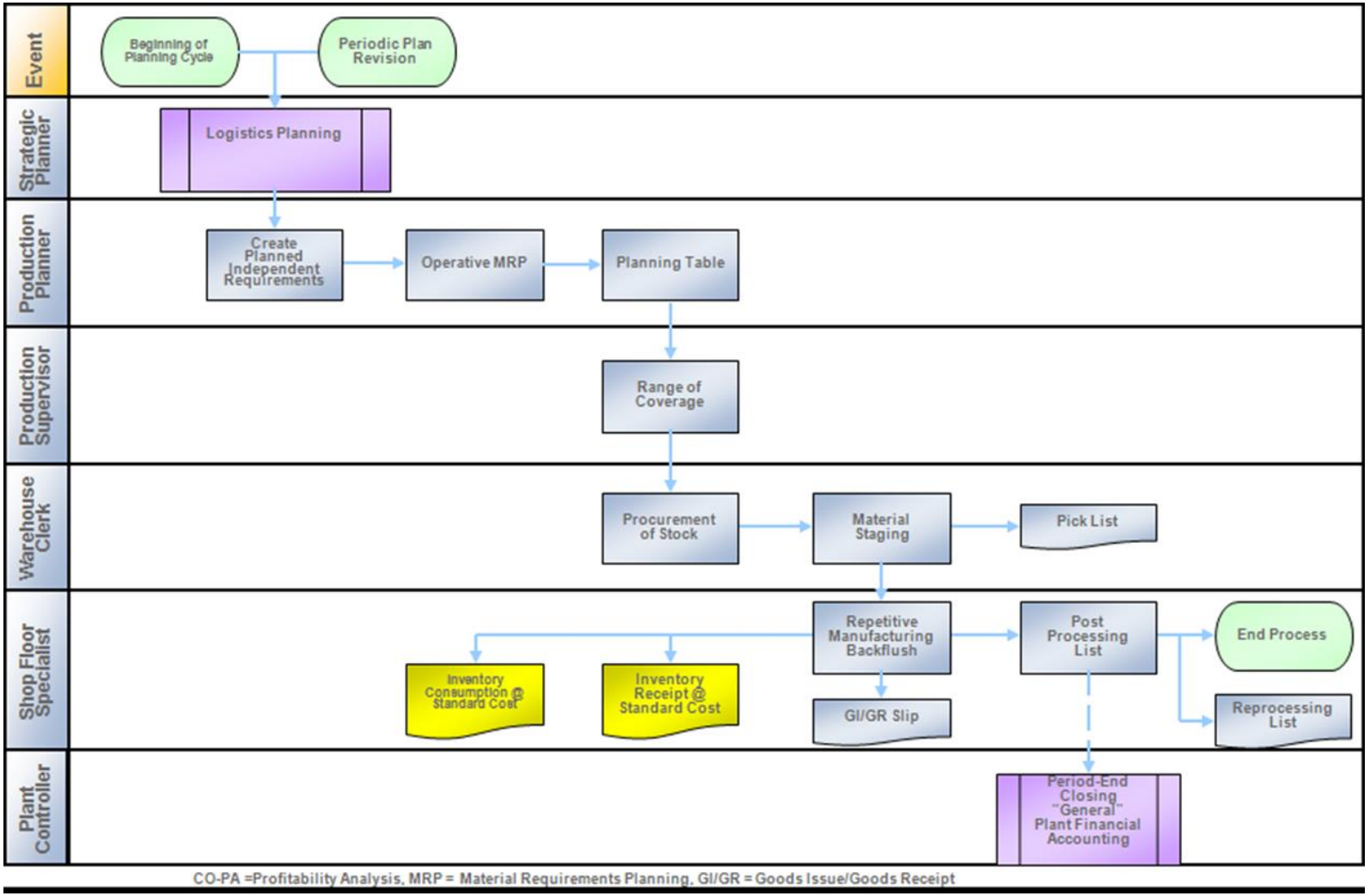
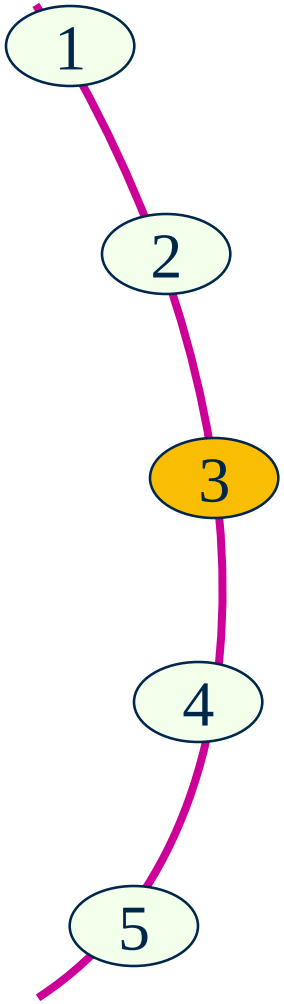
# Process Flow Diagram



# Process flow

- 1. First, you must make certain settings in the material master data and Configuration.
- 2.Create Planned Independent Requirement.
- 3. Carry out MRP run.
- 4. Production will start and when the product is finished, you carry out the back flush. Back flushing includes posting the
- goods receipt for the product, the goods issue for the components.
- 5. At the end of a settlement period, you carry out a period-end closing

# Repetitive Manufacturing

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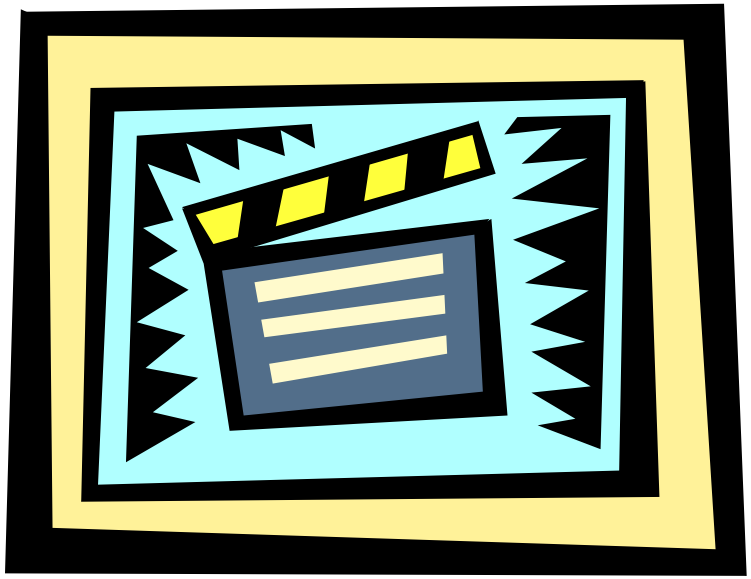
# Show Me….

- Environment
- Prerequisites of REM
- Basic Terminologies used in REM & their Definitions
- Master Data and Customizing
- Process



# Show Me….

## Environment

The Environment in which REM runs is SAP R/3 under PP module.

# Prerequisites of REM

Prerequisites of REM

- System Configuration

- Master data like
  - a. REM Profile
  - b. Product Cost Collector
  - c. Material With production Version

# Basic Terminology used in REM & their Definitions

**Basic Terminology used in REM & their Definitions**

- Planning table
- Sequencing
- Pull list
- Back flushing
- Cost Object Controlling

# Planning table

- **Planning table**

Within the framework of repetitive manufacturing, planning and control is carried out on the basis of time buckets. Starting from the existing requirements situation, you can plan production quantities based on periods. The scheduling data for products and product groups is thus broken down into a series of time buckets, the user being presented with period views for the purposes of checking and revision.

# Sequencing

- **Sequencing**

- You can use Sequencing to carry out task-based scheduling which determines the sequence in which planned orders are produced on the production line. Sequencing simplifies the dispatching process, especially for high order volumes, and enables you to display them in a graphic.

# Pull List

- **Pull List**

- You can use the pull list to control in-house material flow, supplying production with materials. The pull list checks the stock situation at the production line, calculates the missing parts for the components and triggers replenishment for these missing parts.

# Back Flushing & Cost object controlling

Back flushing:

Production completion confirmations are simplified and are made with reference to the material being produced. The completion confirmation usually includes the back flushing of components and the posting of production costs.

Cost Object Controlling

In REM, you usually determine costs per material or per production version via a product cost collector (product cost per period).

# Master Data & Configuration

Master Data and Configuration

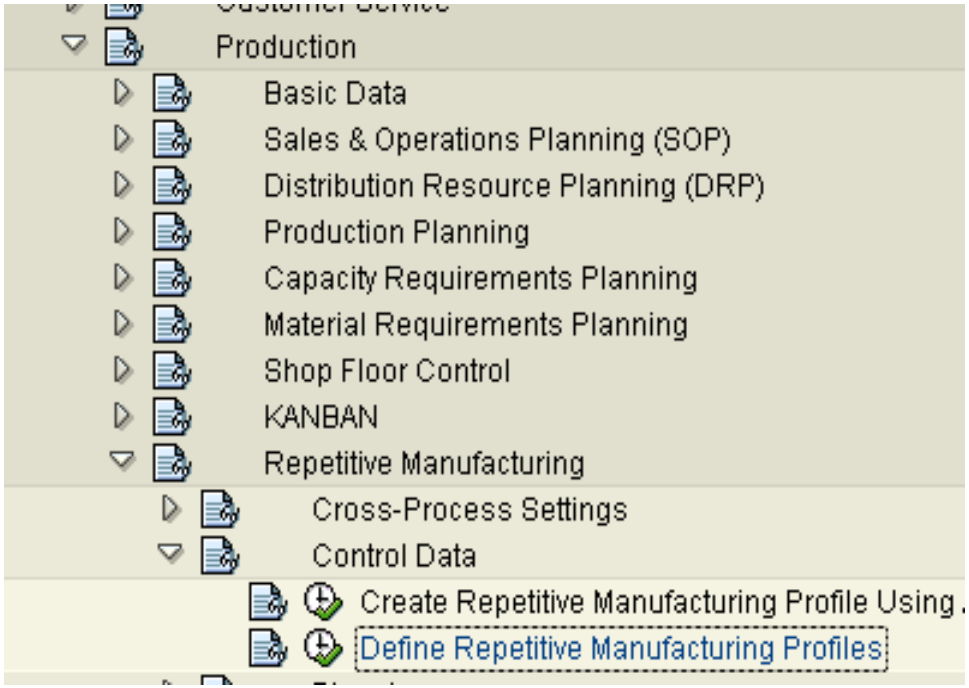
1. REM Profile (Configuration )
2. Material Master
3. Production Version
4. Product Cost Collector

# REM profile

REM Profile

T Code- OSP2

Menu Path: Logistics → Production →Repetitive Manufacturing→ Control Data → Define Repetitive Manufacturing Profile



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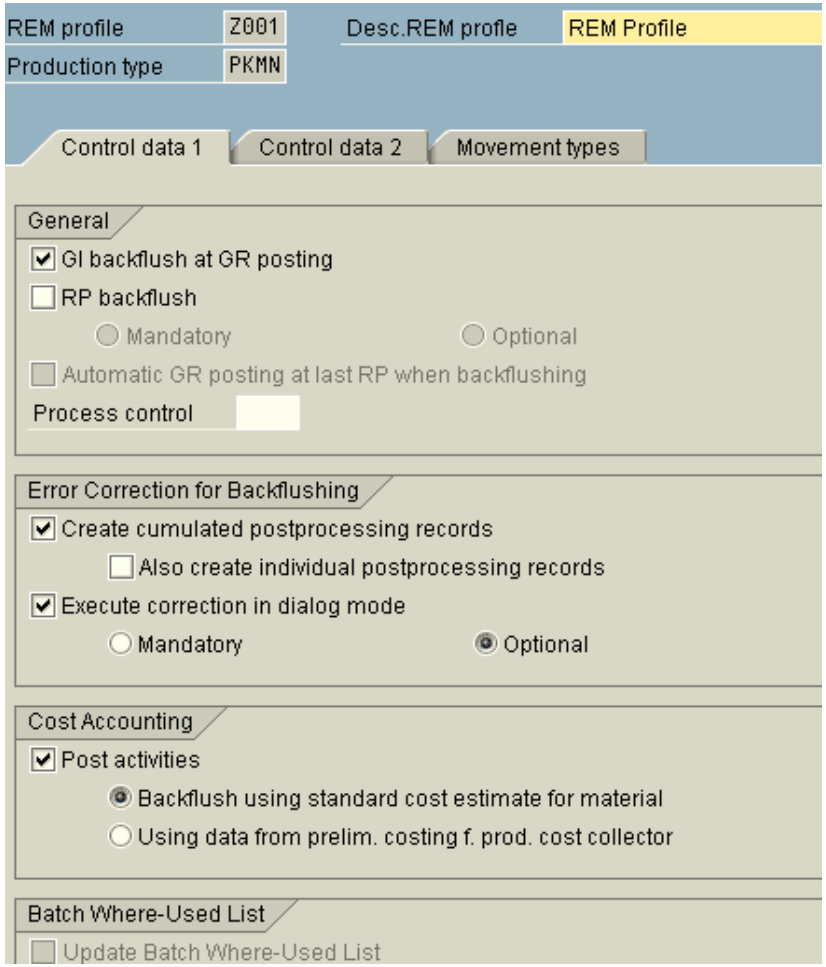


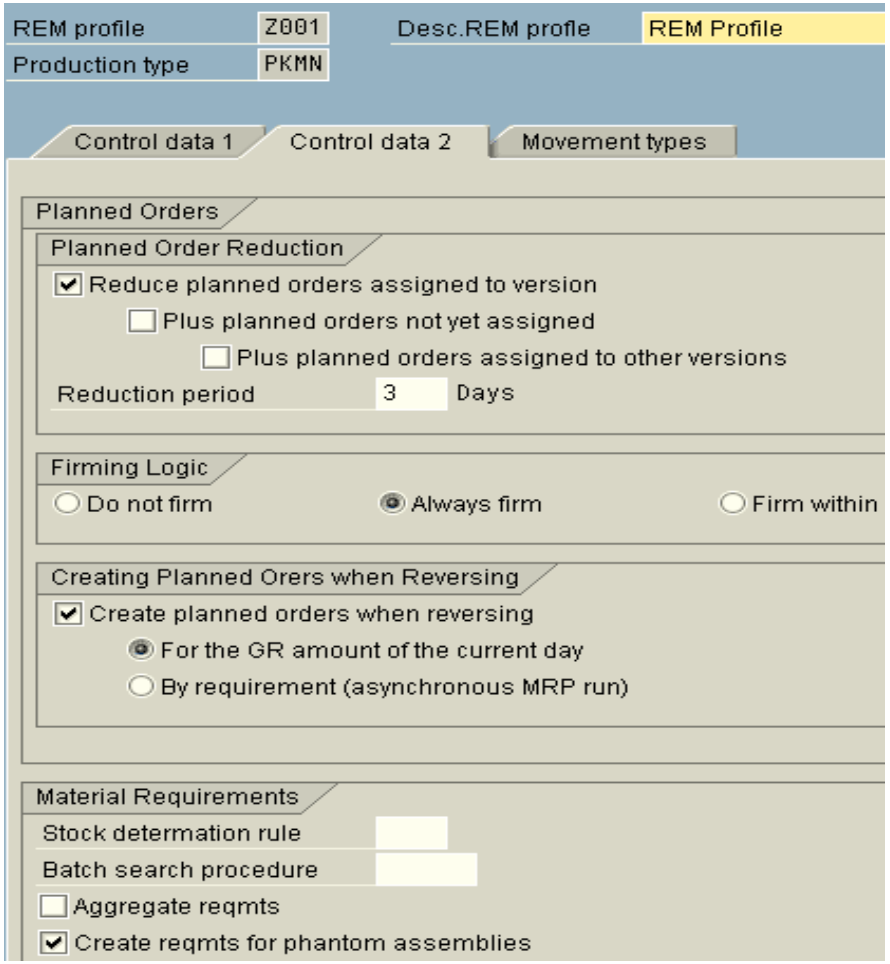

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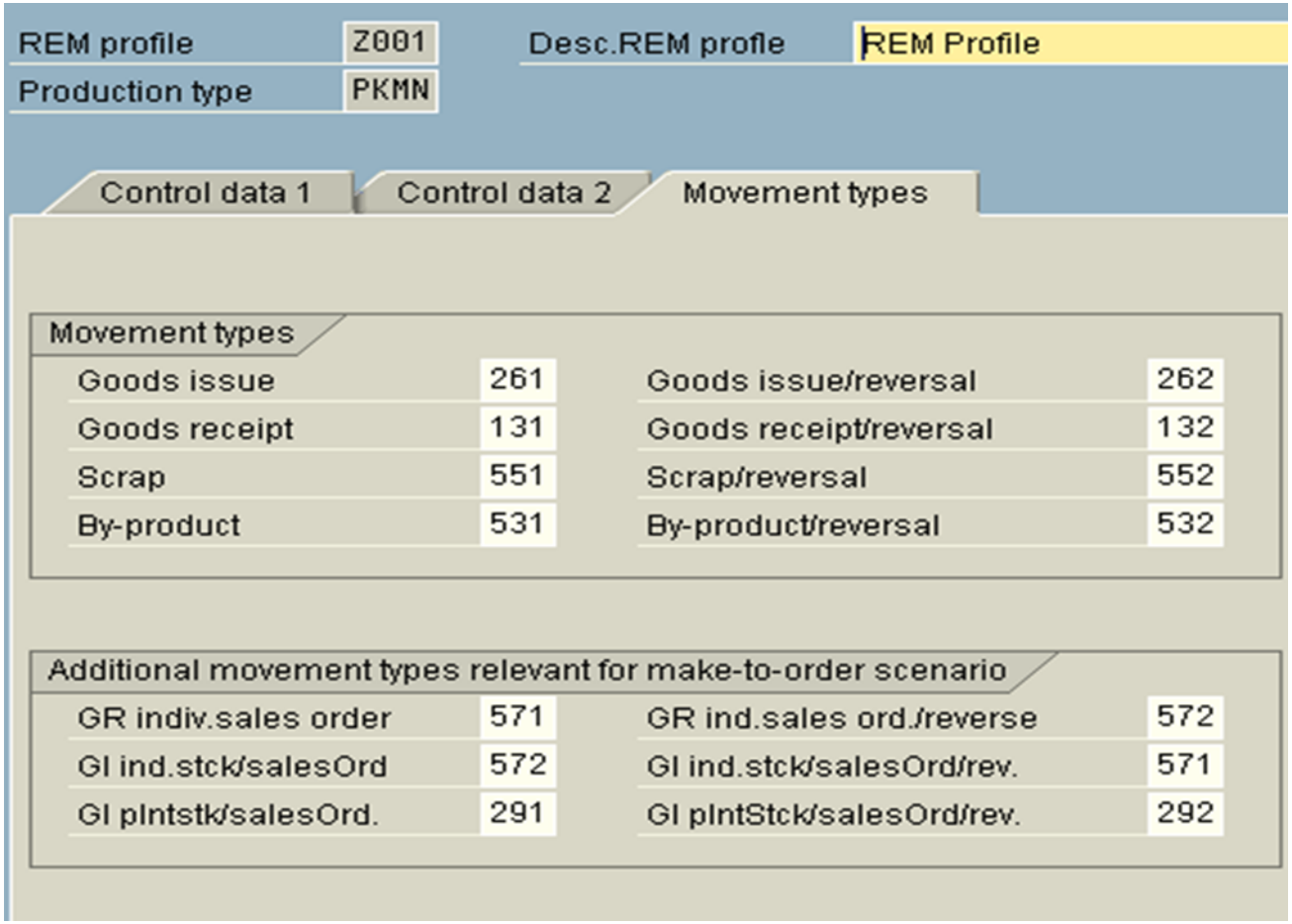
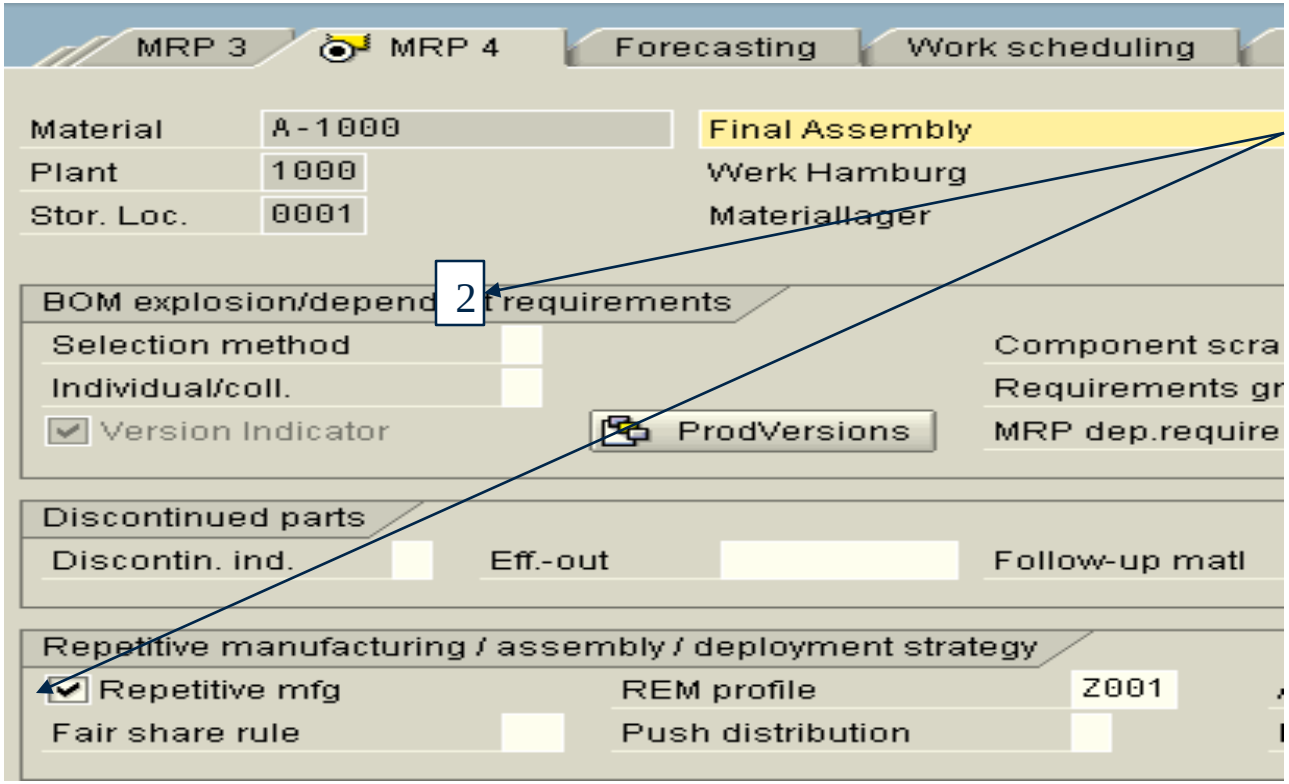


# Material Master – MM01

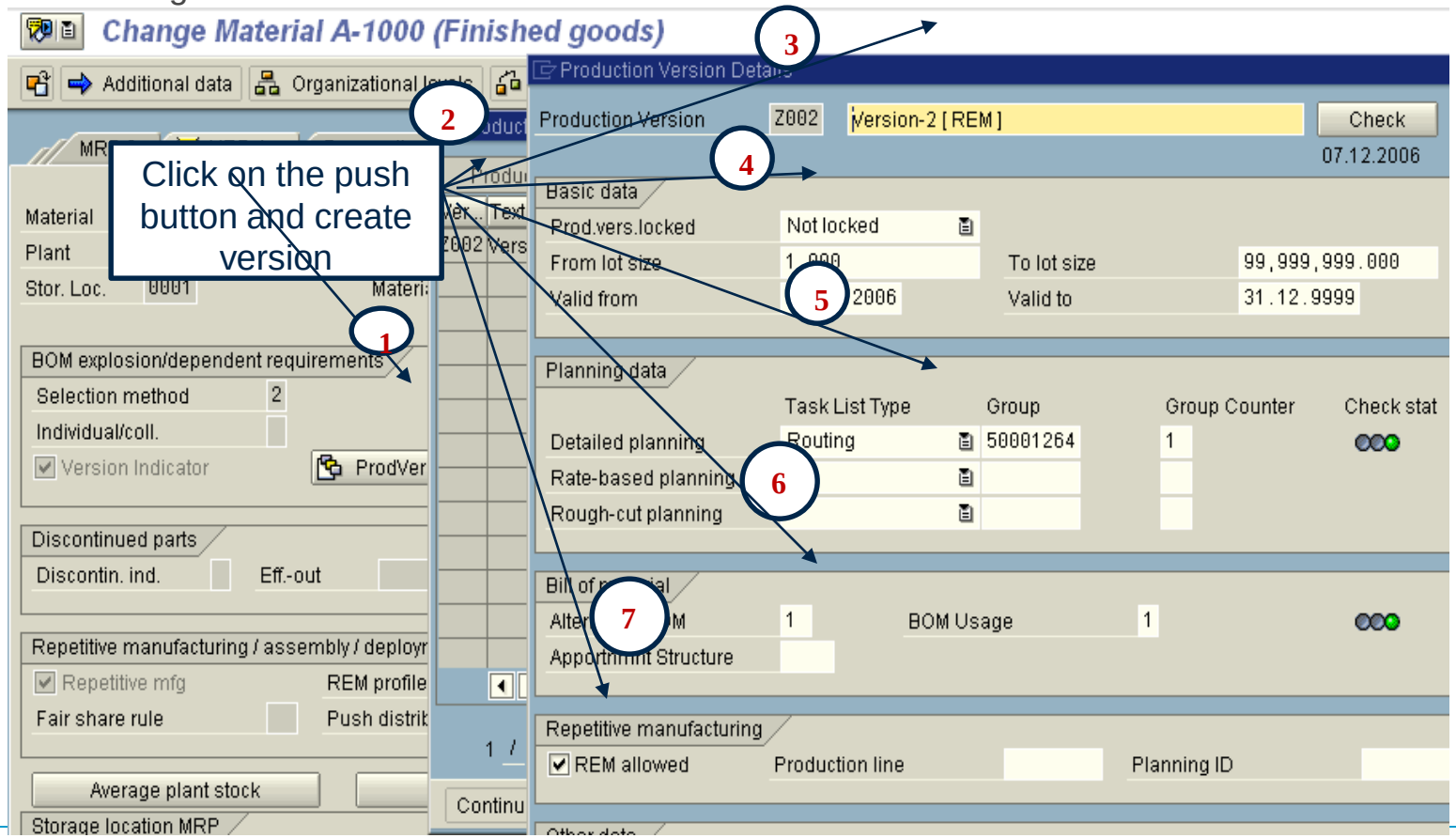
- ***Material Master***

- T. Code- MM01
- **Menu Path**: Logistics → Production → Repetitive Manufacturing →Master Data → Material→ Create (General)



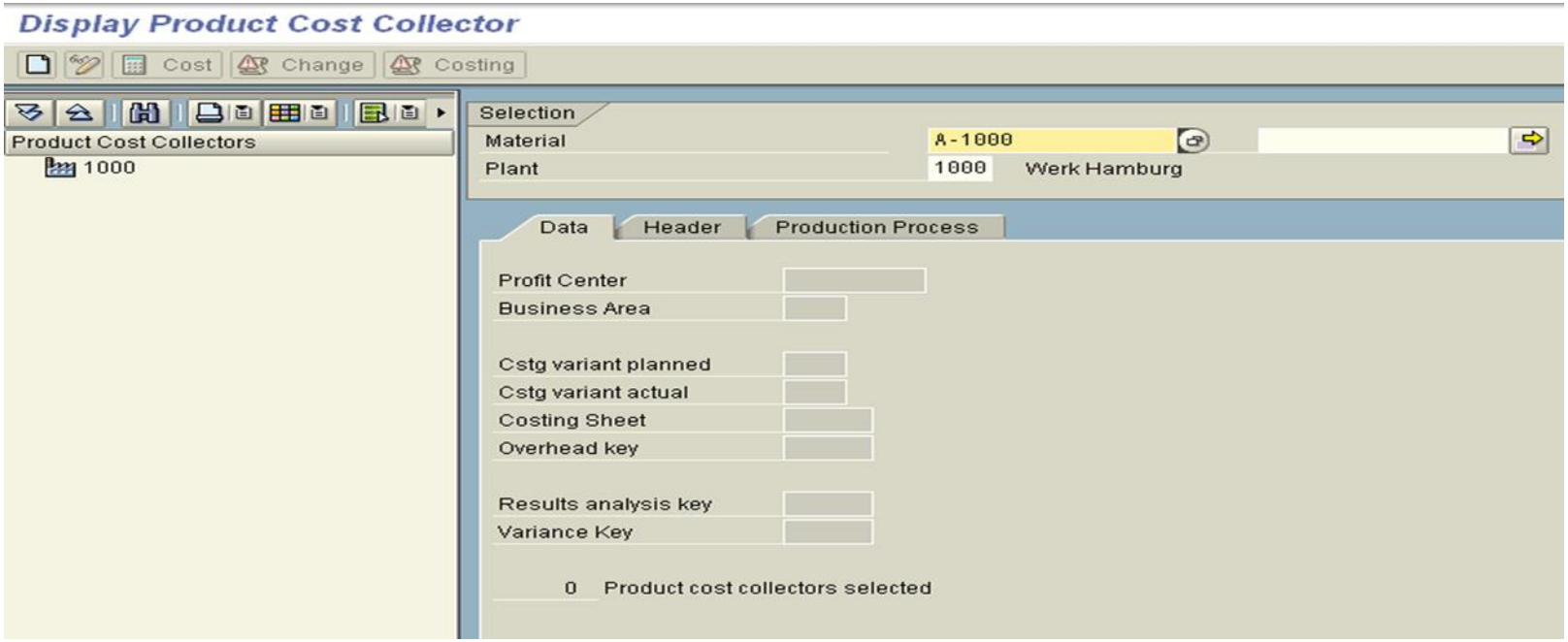
# Production Version- MM02

- *Production Version*
- T. Code- MM02
- Menu Path: Logistics → Production →Repetitive Manufacturing→ Master Data → Material→ Change



# Product cost collector-KKF6N

- Product Cost Collector
- T. Code- KKF6N
- Menu Path: Logistics → Production →Repetitive Manufacturing→ Master Data →Product Cost Collector



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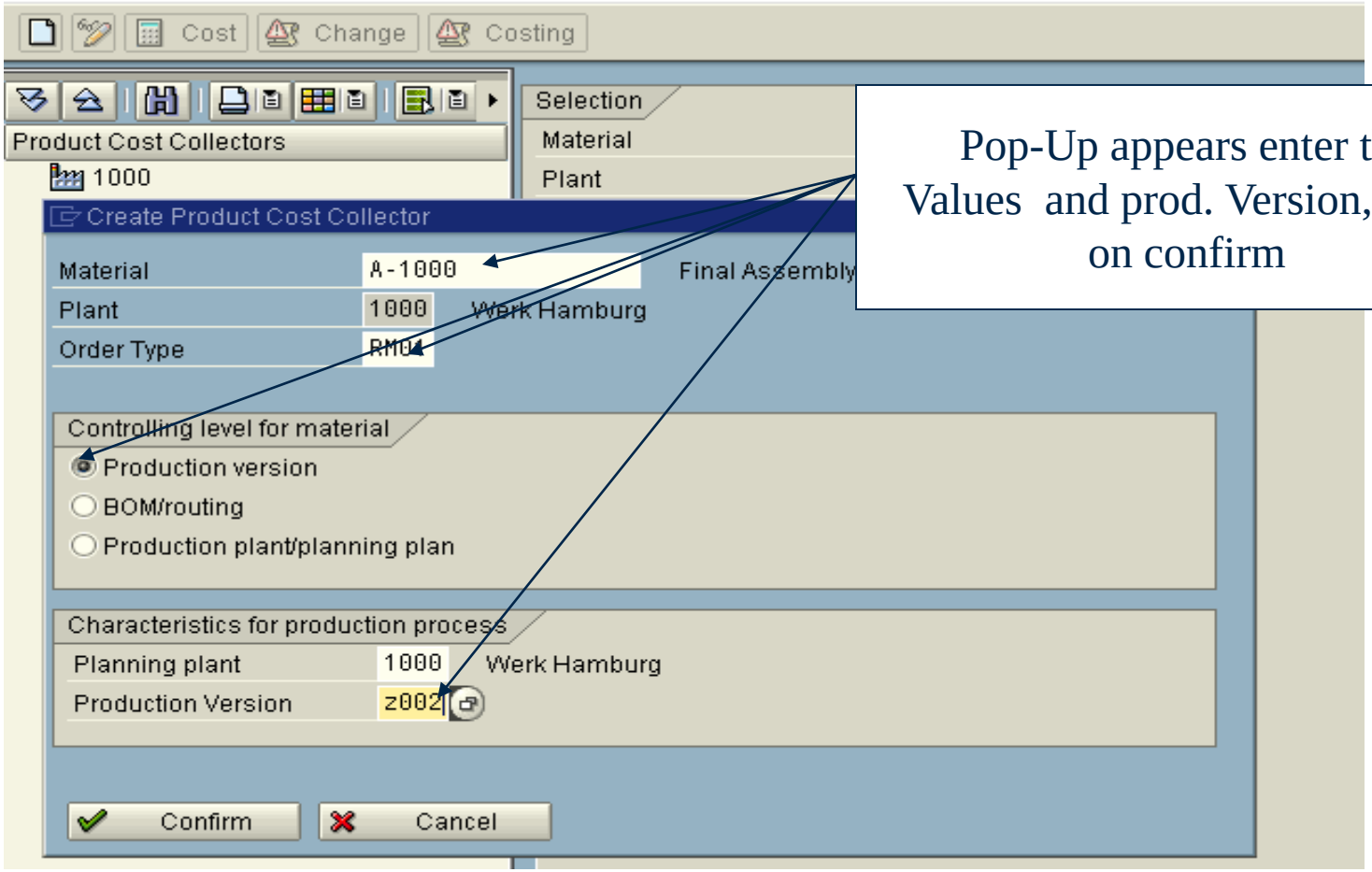


Pop-Up appears enter the Values and prod. Version, click on confirm

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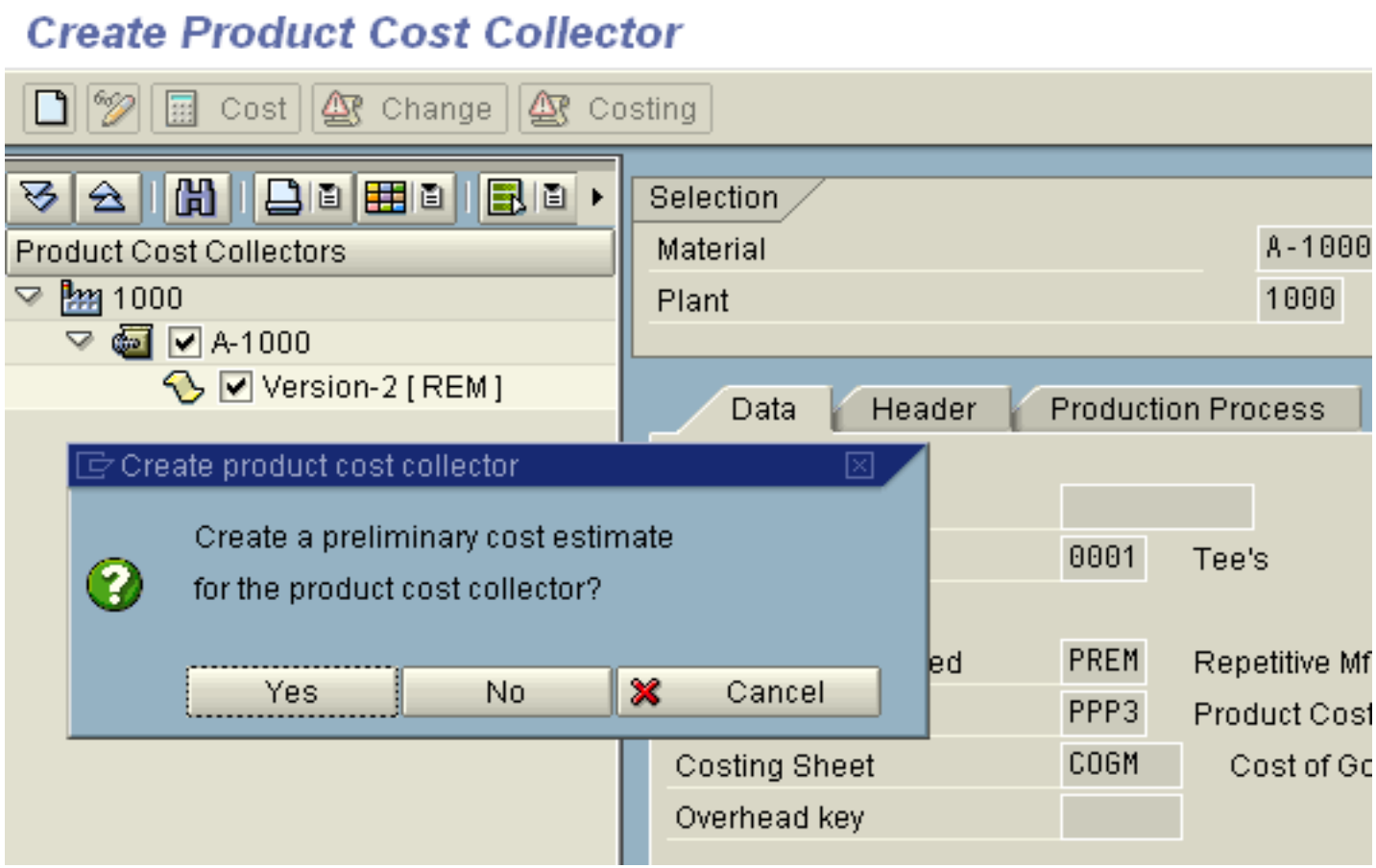
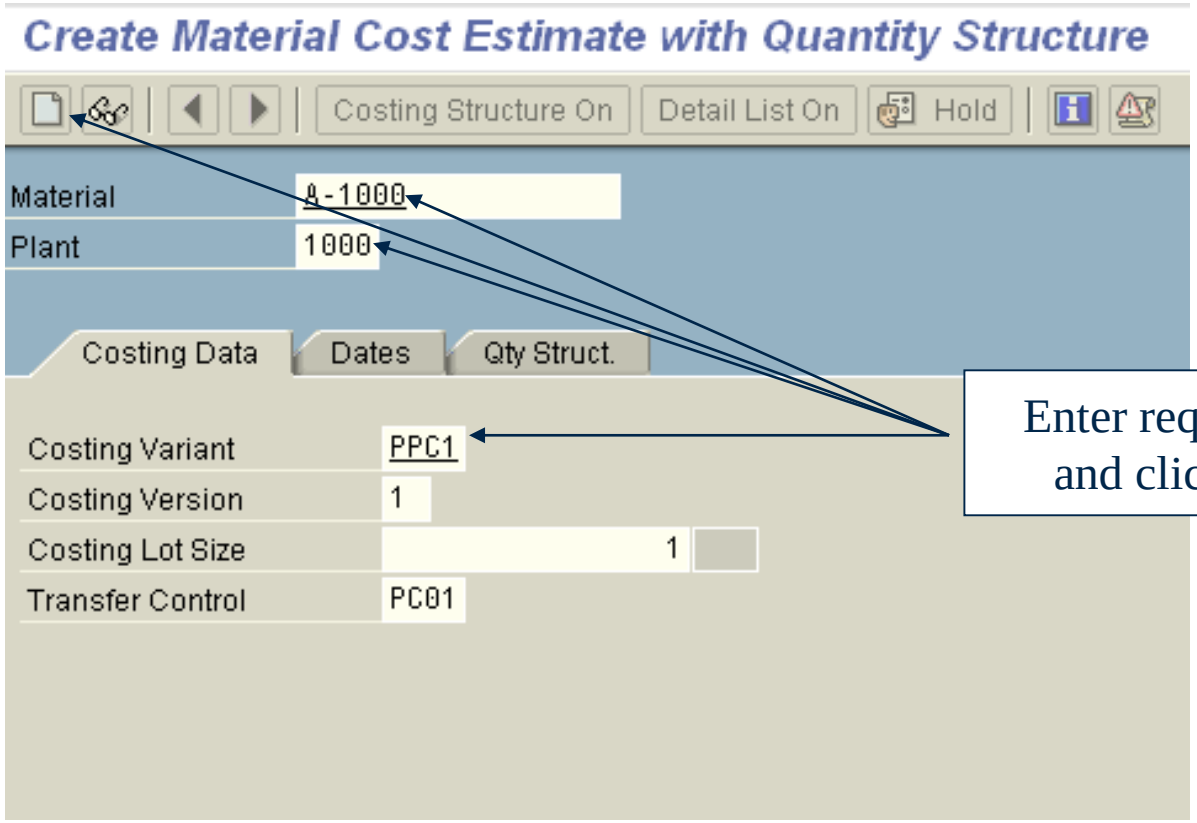


# Create Preliminary Cost Estimate – CK11N

- ***Process***
- Create Preliminary Cost Estimate – CK11N



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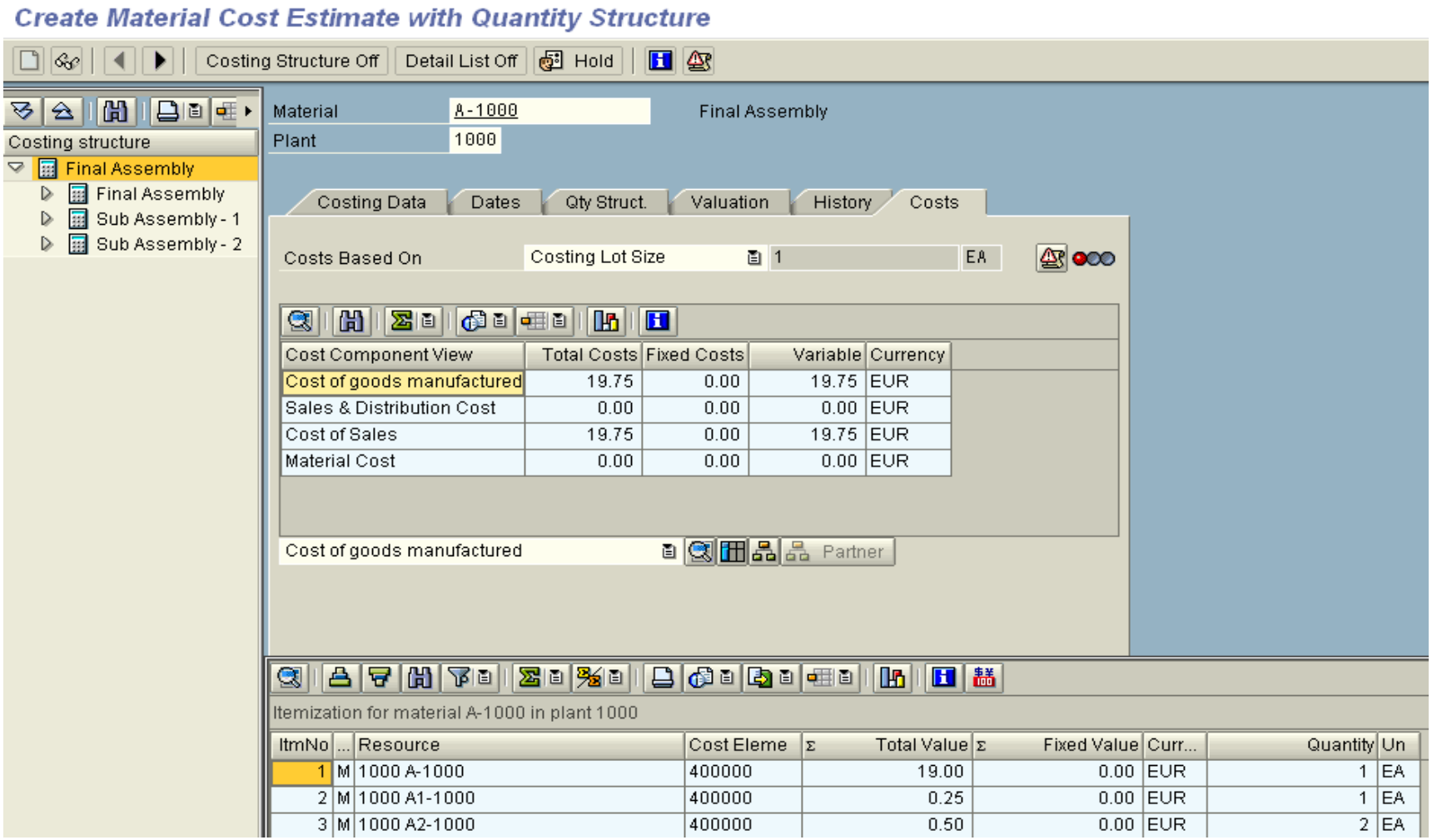
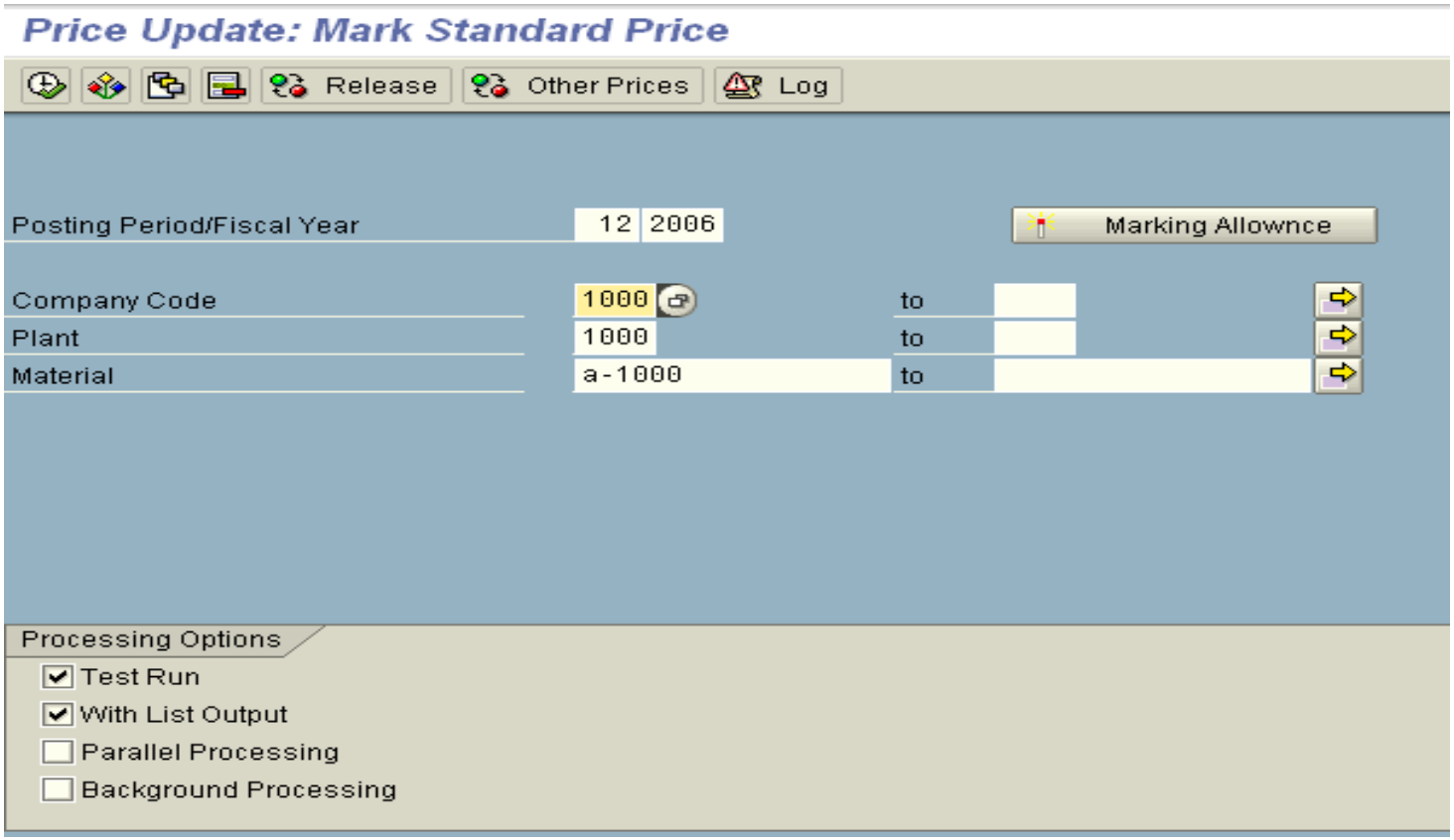


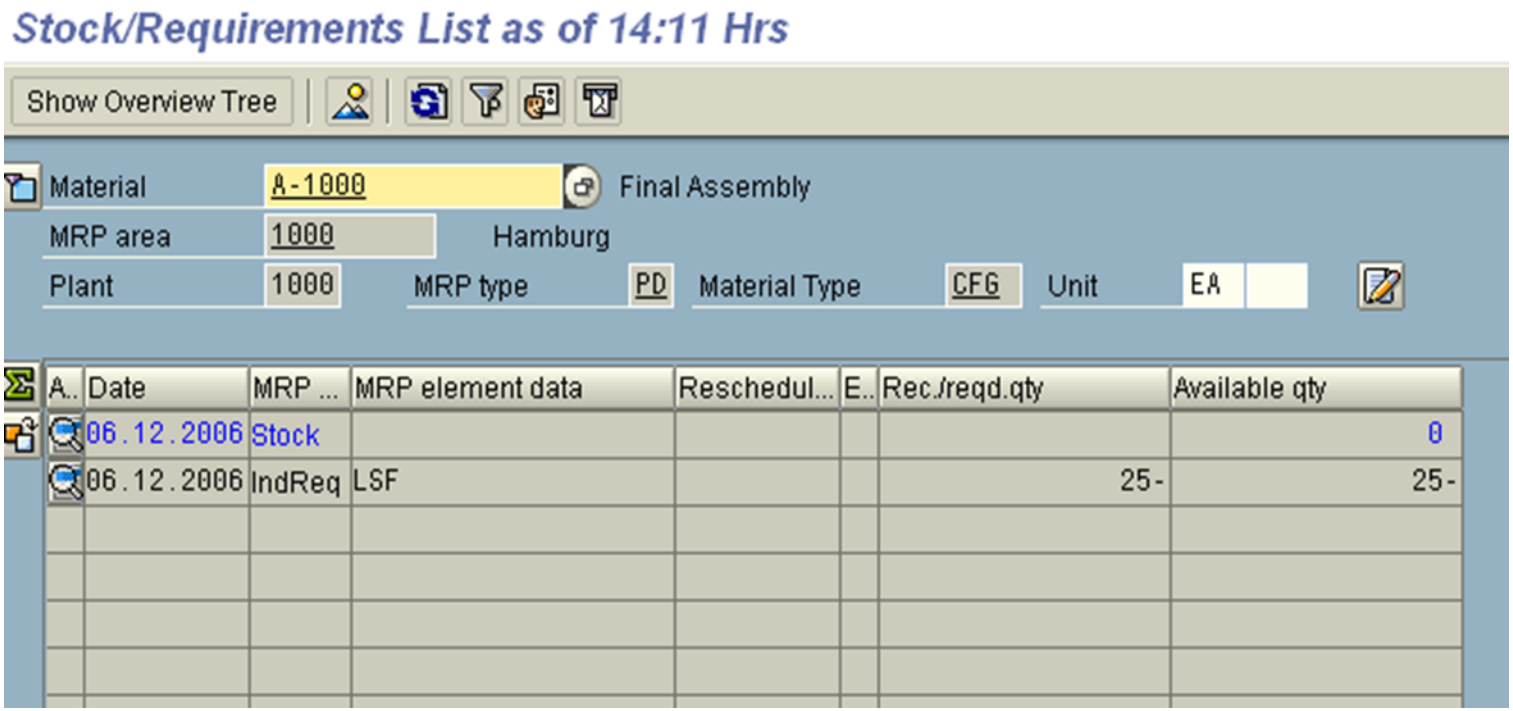
# Price Release-CK24

- Price Release – CK24



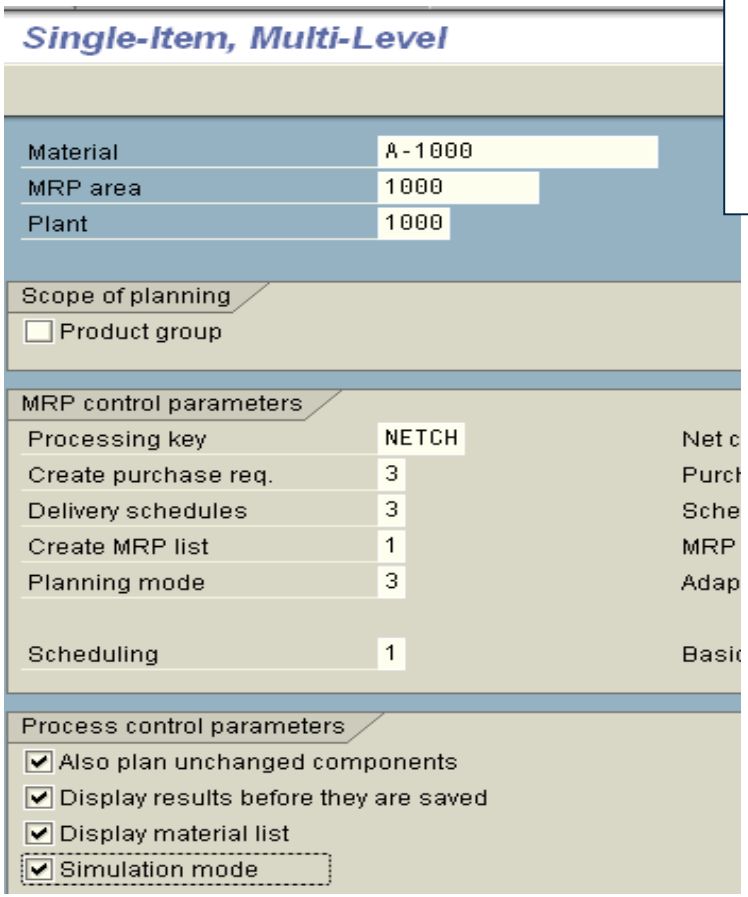
# Display stock/Requirement list-MD04

- Display Stock/Requirement List – MD04

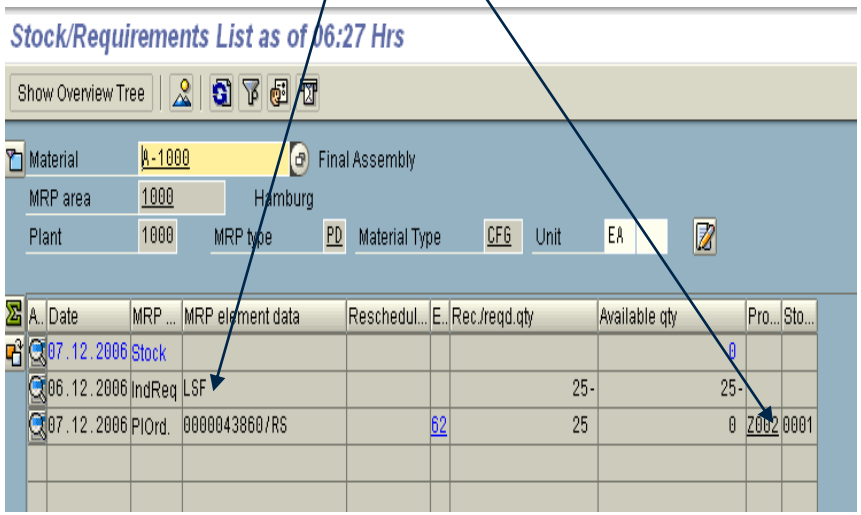


# Single item-Multi level MRP run-MD02

## Single Item-Multi Level MRP Run – MD02

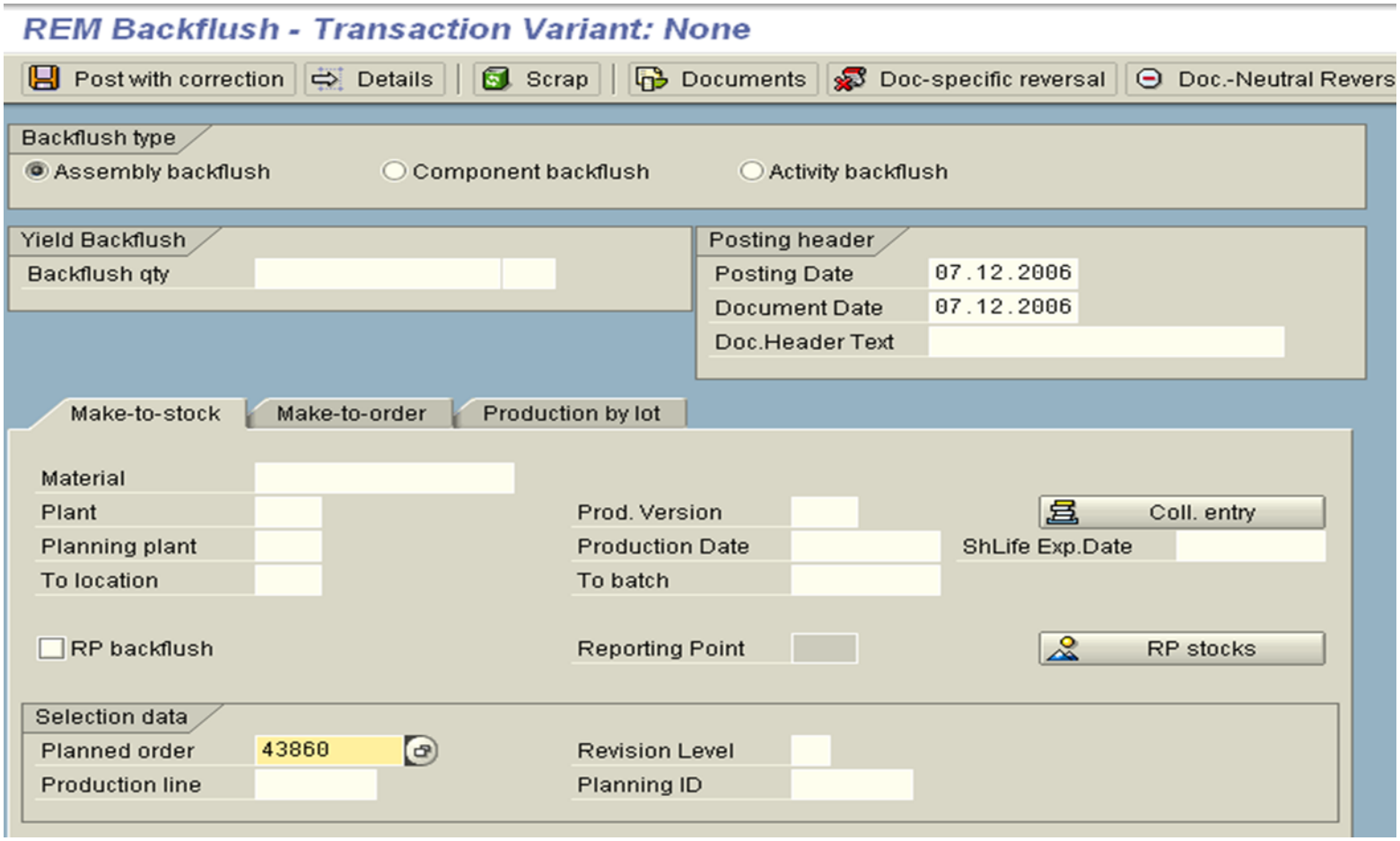



Stock Req. List after MRP Run, Planned order have been created by system with relevant Prod Version



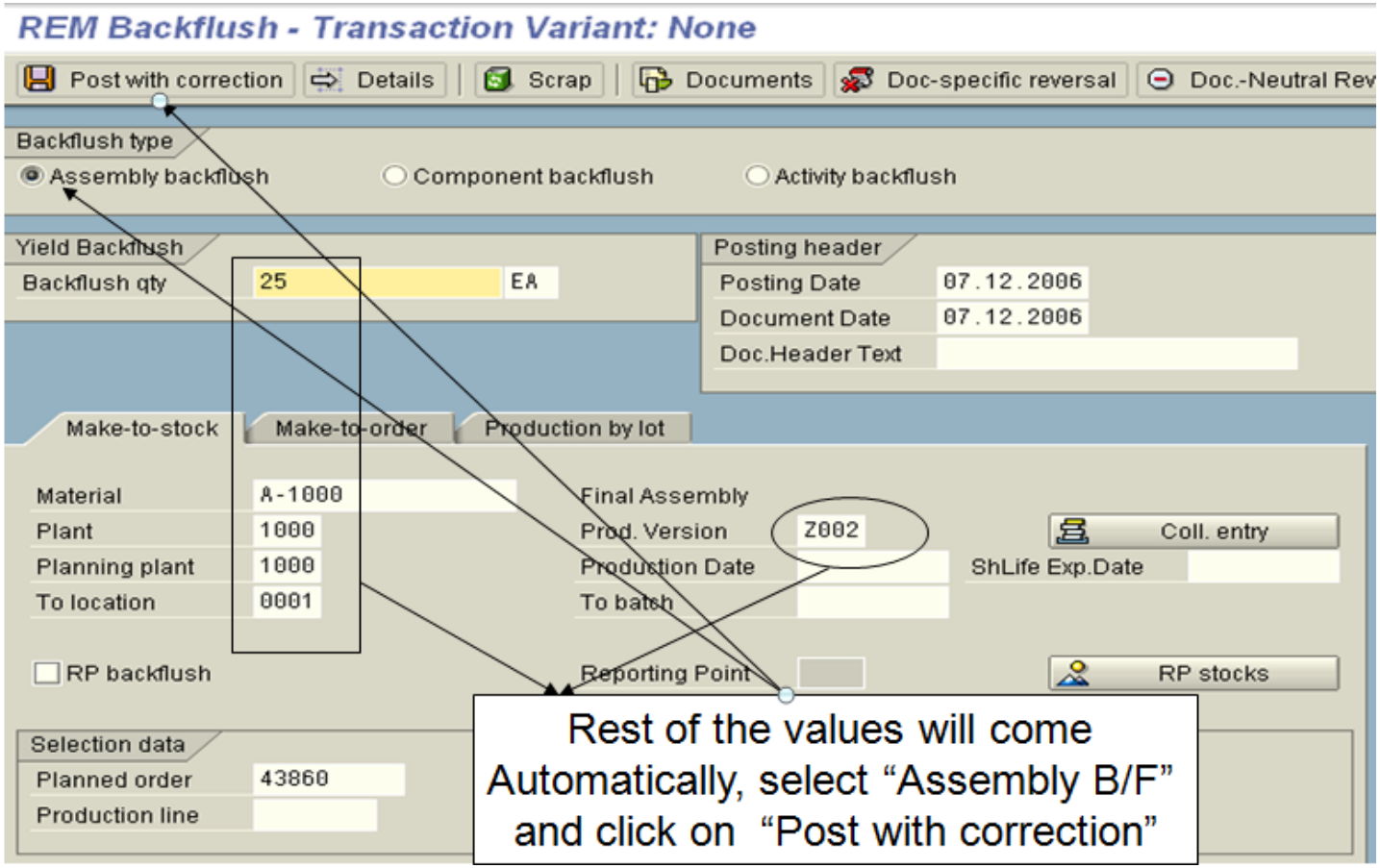
# Back flush

- REM Back flush – MFBF



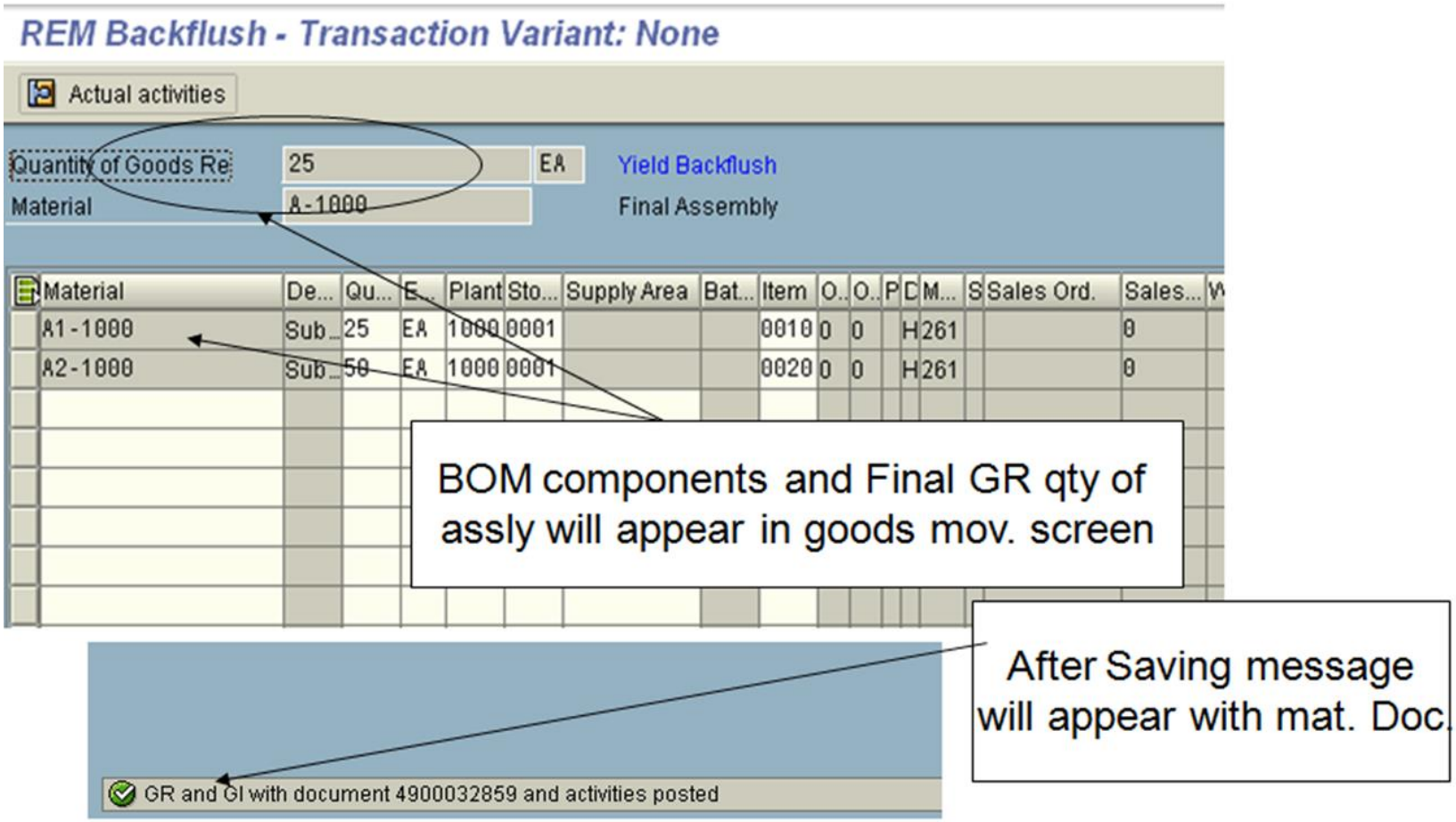
# Show Me….

- REM Backflush….



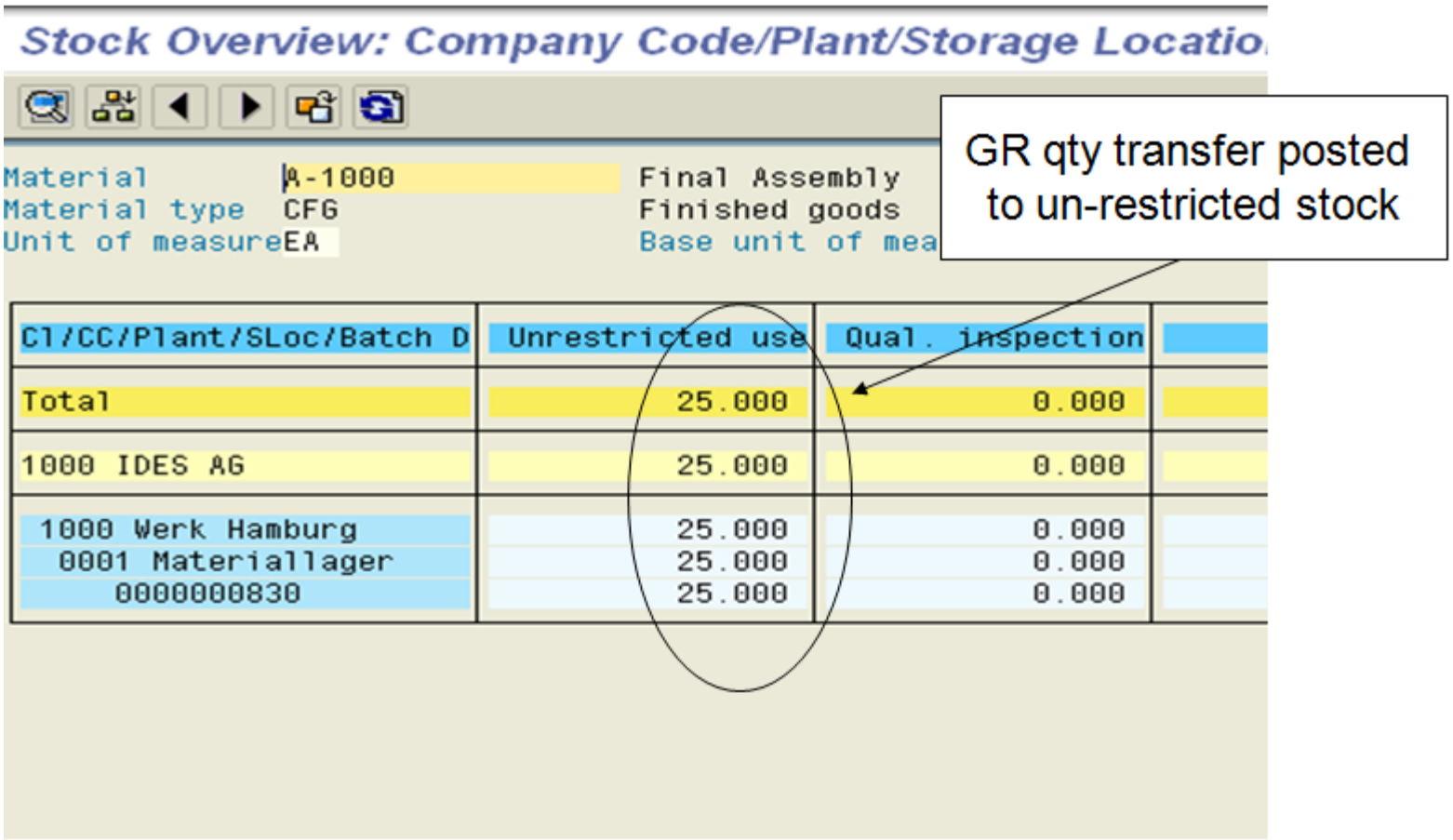
# Show Me….

## REM Backflush

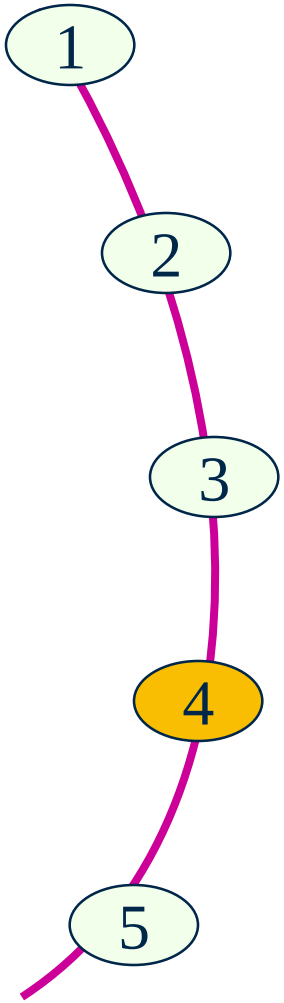


# Stock overview

- Stock Overview - MMBE



# Repetitive Manufacturing

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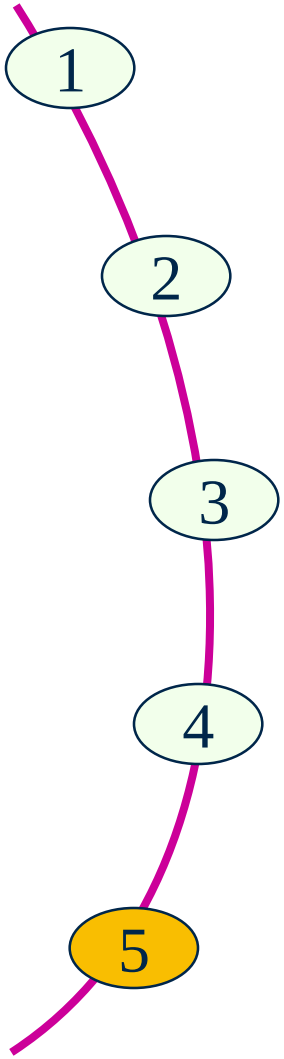
# Let Me….

- Understand the Basic Business scenario of REM
- Understand the Process of REM

# PP1012 -SOP

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# Frequently Used Transactions for REM

Practice the following transactions generally used for REM

- MM01/MM02 -Create/Change Material Master
- CS01/ CS02- Create/ Change Bill Of Material
- CR01- Create Work center
- CA21- Create Rate routing
- KKF6N- Create Product Cost Collector
- MF50/MF52- Change /Display Planning Table
- MF60- Pull List
- MFBF- REM Confirmation
- MD61- Create PIR
- MD04- Stock Requirement List
- MD02- Single item Multilevel Planning Run
- KK87- Settlement

# Summary


- Repetitive Manufacturing is commonly used when the same or similar products are produced over a lengthy period of time
- Planning table

Within the framework of repetitive manufacturing, planning and control is carried out on the basis of time buckets. Starting from the existing requirements situation, you can plan production quantities based on periods. The scheduling data for products and product groups is thus broken down into a series of time buckets, the user being presented with period views for the purposes of checking and revision.

- You can use Sequencing to carry out task-based scheduling which determines the sequence in which planned orders are produced on the production line. Sequencing simplifies the dispatching process, especially for high order volumes, and enables you to display them in a graphic.
- Cost Object Controlling

  In REM, you usually determine costs per material or per production version via a product cost collector (product cost per period).

# Review Questions

1.REM suitable for products produced always follow the same sequence through the machines and work centers in production.

a. True
b. False

2. You can use the pull list to control in-house material flow

Check whether the statement is true or false

a. True
b. False

3. In REM, you usually determine costs per material or per production version via a product cost collector (product cost per period).

a.True
b.False

# Repetitive Manufacturing

**THANK YOU**