



A GUIDE TO BASIC PRODUCTION PLANNER PROCEDURES USING SAP

© 2021 SAP SE or an SAP affiliate company. All rights reserved. No part of this publication may be reproduced or transmitted in any form or for any purpose without the express permission of SAP SE or an SAP affiliate company.

SAP and other SAP products and services mentioned herein as well as their respective logos are trademarks or registered trademarks of SAP SE (or an SAP affiliate company) in Germany and other countries. All other product and service names mentioned are the trademarks of their respective companies. Please see <http://www.sap.com/trademark> for additional trademark information and notices.

The Lam Research logo, Lam Research, Silfex, and all Lam Research product and service names used in this website are either registered trademarks or trademarks of Lam Research Corporation or its subsidiaries in the United States and/or other countries. All other marks mentioned herein are the property of their respective owners.



Introduction

Welcome to the team of Lam Research! You are now a member of the division of Lam Research called Production Control, otherwise known as PC. While the assemblers on the Manufacturing floor are working to build Lam Research's products, you will be monitoring our supplies of parts to make sure that the assemblers always have what they need to accomplish their tasks.

Your job is made much easier through the use of the enterprise resource planning (ERP) software programmed by SAP SE. This allows you to oversee the updated inventories for all the parts used by the assemblers.

The purpose of this guide is to give you an introduction to the basic procedures you will carry out as member of PC. All of the procedures described here will be very important to keeping Lam Research's Manufacturing floor running smoothly and on schedule.

Table of Contents

1	Signing In.....	1
2	Important Terms and Groups	4
3	Expediting Parts.....	6
3.1	PL / PC Parts	10
3.1.1	Check for Transit	11
3.1.2	Expediting A Pre-existing Order.....	11
3.1.3	New STO.....	15
3.1.4	Replacing	19
3.2	PN Parts	21
3.2.1	Find the Reservation	22
3.2.2	Expediting	23
3.2.3	New STO.....	26
3.2.4	Replacing	30
3.3	Freestock Parts.....	31
3.3.1	Inventory Control	31
3.3.2	Wave Orders	32
3.3.3	Spares.....	33
4	Pulling in Stock	34
4.1	Contacting Buyers.....	34
4.2	Reaching out Worldwide	36
5	Return to Stock	38
5.1	PL / PC Parts	39
5.2	PN Parts	40
6	Production Cards	46
7	Backflushing	49
	Appendix.....	55
	Glossary	57
	Index.....	Error! Bookmark not defined.

Table of Figures

Figure 1-1 The first login screen for PulseSecure VPN.	1
Figure 1-2 The second login screen.	2
Figure 1-3 The desktop icon for SAP Logon.	2
Figure 1-4 Main Logon screen for SAP.	3
Figure 1-5 SAP GUI Main Menu.	4
Figure 3-1 The main page of MD04.	7
Figure 3-2 Showing Part Inventory and Schedule.	8
Figure 3-3 Display Material; specific information is found on the tabs marked at the top.	9
Figure 3-4 In Basic Data 1, the type of part (Material Group) is marked with the red square.	10
Figure 3-5 The column marking In Transit parts is marked by the square.	11
Figure 3-6 The 2000 side of MD04 shows our warehouse inventory.	12
Figure 3-7 The marked STO has its demand marked CC. This is an STO going to 3150.	13
Figure 3-8 The STO pop up menu. EDIT STO button is marked with red.	14
Figure 3-9 STO Details. The Shipping tab is marked with red and the Delivery Priority field is marked with blue.	15
Figure 3-10 Bin Status Report. The Execute button is marked in red.	16
Figure 3-11 The Control Cycle indicates a bin's location. Marked with red.	16
Figure 3-12 This is the setup of values you absolutely want to follow on ME27.	17
Figure 3-13 The inserted values for creating a new STO.	17
Figure 3-14 Make sure the MRP Element and MRP element number fields are filled as the text specifies. The Save button is marked red.	19
Figure 3-15 Main page of ZR261.	20
Figure 3-16 Entering values to log damaged parts.	21
Figure 3-17 Use Ctrl+F to find the FCID given in the email. Highlight the full row.	22
Figure 3-18 Follow the row to find the reservation number you need.	23
Figure 3-19 The Delivery Priority and Demand buttons are marked with red.	23
Figure 3-20 Main page for ZR101.	24
Figure 3-21 This page shows the items of the reservation.	25
Figure 3-22 Main page of ZR308.	25
Figure 3-23 The Change Reservation button is marked with red.	26
Figure 3-24 The New Item button is marked with red.	27
Figure 3-25 Pop up menu for making a new part entry. Make sure the Reqmts date matches the Base date.	27
Figure 3-26 Fill out a line for a new entry as shown.	28
Figure 3-27 Make sure to fill in these lines as the text specifies.	29
Figure 3-28 Main page for Z026.	30
Figure 3-29 The given NCI information has been added to the text line.	31
Figure 3-30 Main page for ZRWAVE01.	32

Figure 3-31 The current orders in progress for this part.	33
Figure 4-1 An incoming shipment of parts is marked with red.	35
Figure 4-2 This part's buyer is marked with red.....	36
Figure 4-3 Main page of MMBE	37
Figure 4-4 This shows our stock for a specific part company-wide. The Unrestricted use column shows parts that are open for use while On-Order Stock shows parts to be delivered.	38
Figure 5-1 This Stock Overview shows all stock of this part within the 1000 facility.	40
Figure 5-2 The option you need, Reservations, is marked with red.	41
Figure 5-3 Reservations with a movement type of 311 are ones that arrive in 3150/3250.	42
Figure 5-4 The Display Reservation button is marked with red.	42
Figure 5-5 The individual parts that make up a reservation.	43
Figure 5-6 The location a part is delivered to is marked with red.....	44
Figure 5-7 Main page of MB1B	45
Figure 5-8 Fill the values of the line as shown above. Make certain that SLoc is 3149 and Iss. SLoc is 3150.....	45
Figure 5-9 This is where you fill in specifics of why this part is needed for RTS.	46
Figure 6-1 Main page for ZIPKPRINT.	47
Figure 6-2 This is a White Card with a corresponding Production Card stuck on.	48
Figure 6-3 The card on the left is a Yellow Card and is marked DEMAND. The card on the right is a White Card and just has an ID number.	49
Figure 7-1 Main page for ZR151.	51
Figure 7-2 The active cards corresponding with the Serial Number above.	51
Figure 7-3 Main page of ZR218.	52
Figure 7-4 Pay attention to the row with a WrkCtr value that matches (WC)	52
Figure 7-5 Make sure both numbers marked in red are matching when you select them.	53
Figure 7-6 The Prod Order is marked with red.	54

1 Signing In

The first thing that must be done when you begin your work day is to sign into the SAP GUI (Graphical User Interface).

NOTE: If you are working onsite at Lam Research, you can ignore the steps marked with (*). These are steps to sign into the Lam VPN. This is required if you are working outside the Lam facility.

- 1) (*) Double-click on the PulseSecure icon on your desktop.
- 2) (*) Select the Lam-Global-VPN icon and select CONNECT.

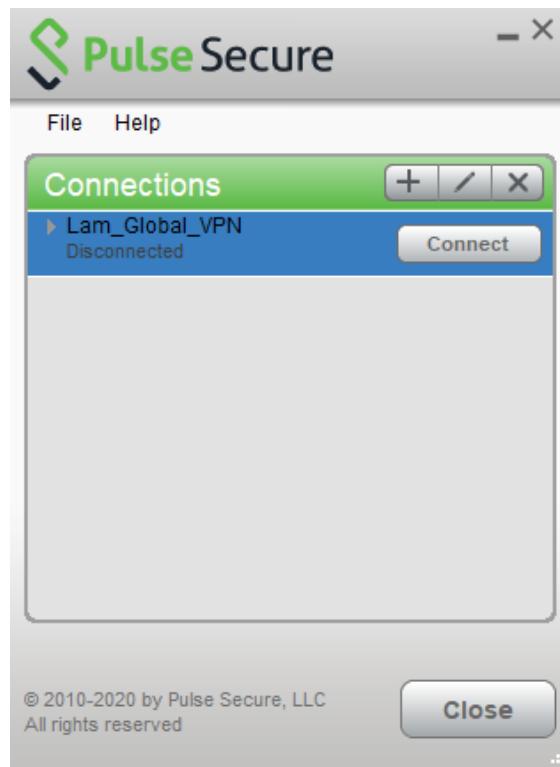


Figure 1-1 The first login screen for PulseSecure VPN.

- 3) (*) Sign in with the same login that you use for your computer. Wait for connecting to complete.



Figure 1-2 The second login screen.

- 4) Double-click on the SAP GUI icon on your desktop.



Figure 1-3 The desktop icon for SAP Logon.

- 5) When the SAP window opens, click on the list item SAP PRODUCTION (PRD) and then click LOG ON.

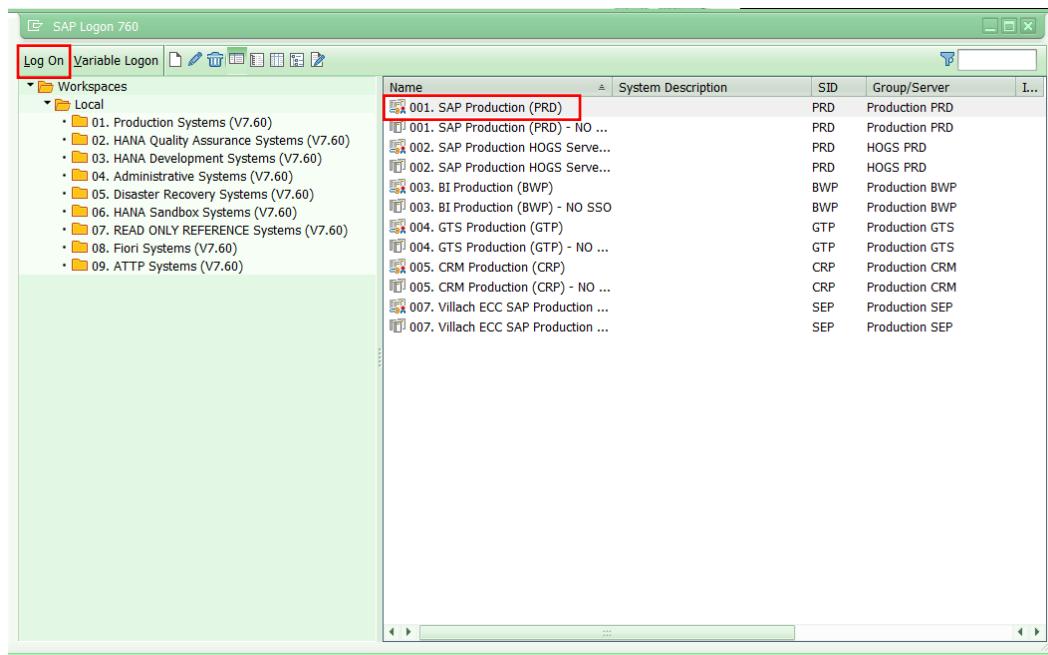


Figure 1-4 Main Logon screen for SAP.

You are now on the home page of the SAP GUI. From here you can type Transaction codes, or T-codes, into the search bar at the top left corner of the window (marked by the red square below). A list of your most used T-codes can be found at the Appendix of this document. You can also create new windows of the GUI by pressing the New Window button (marked by the blue square).

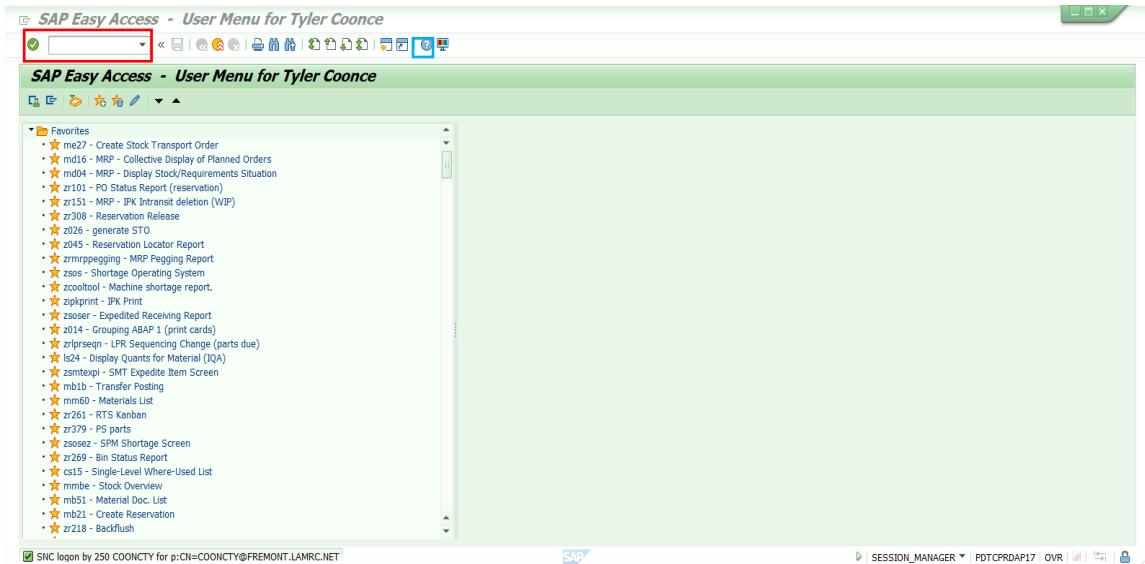


Figure 1-5 SAP GUI Main Menu.

2 Important Terms and Groups

This is a list to help familiarize you with the terms you should familiarize yourself with and groups you will be regularly interacting with over the course of a work day.

- Lam Research Manufacturing 1000 – the Lam manufacturing facility in Livermore. Consists of buildings 3150 and 3250
 - Lam Research Warehouse 2000 – the main Lam warehouse storing our parts.
 - Lam Research Spares Warehouse 2001 – a Lam warehouse storing emergency stocks for parts that are usually sent worldwide.
 - Assemblers – the employees working on the Manufacturing floor of 1000. They will be your most frequent customers.
 - DHL – the courier company that manages 2000 and transports our parts.

- DHL Receiving – the division responsible for receiving new deliveries of parts to 2000 and making sure they are properly decontaminated and ready for use. You will contact them about the status of incoming deliveries or moving parts to a pickable location.

Email: DL-DHL.LIV-LAM-RECEIVING@dhl.com

- DHL Inventory Control – the division that monitors 2000 inventory. You will contact them about moving Freestock parts from 2000 to 1000.

Email: DL-DHL.LIV-LAM-InventoryControl@dhl.com

- DHL Picking – the division responsible for loading parts onto delivery trucks and sending them to 1000. Contact them about expediting part through the loading process to arrive as soon as possible.

Email: DL-DHL.LIV-LAM-PICKING@dhl.com

- DHL Resupply – the division that receives shipments of parts into 1000 and moves them to the Manufacturing floor. Contact them about the status of recently arrived parts.

Email: DL-DHL.LIV-LAM-CA31.32RESUPPLY@dhl.com

- Hot Orders – the side of Lam that focuses on delivering parts to different facilities around the world. Contact them if you are trying to pull parts into 2000 from outside facilities.

Email: Hot.Orders@lamresearch.com

3 Expediting Parts

The most common action that PC is responsible for is expediting deliveries of parts from 2000 to 1000. When a production line on the Manufacturing floor begins to run out of a specific part, the assemblers will scan the barcode on one of the bins that hold that part. The first scan gets logged on the SAP system and the system will eventually generate a Stock Transfer Order (STO) to replenish the part. When an assembler scans this part for a second time, that will tell the system that the part is entirely depleted and an STO will generate with a faster delivery window.

Sometimes there are special circumstances that require PC to take a more active role in part procurement. Whether from misplaced stock, too many requests on the system, or simple human error, production lines on the Manufacturing floor can find themselves entirely empty of a necessary part and will enter a Line Down situation, where work on the current product builds cannot continue and progress is essentially frozen. To resolve this issue, members of PC will expedite existing STOs or create new ones.

Assemblers will send emails to PC asking for specific parts to be expedited into 1000. Emails can be found in Microsoft Outlook. When your email account is set up, you will be automatically added to the 'PC Mfg' Outlook group.

The first step of expediting parts to 1000 is to find out which part type you are currently working with. The part type determines which procedure you will use to expedite it. This information and more can be found easily on SAP.

1. The T-code you will be using the most throughout these procedures is **MD04**, which shows the scheduled uses and deliveries for a specific part. Type **MD04** into the search bar of the Main Menu and press the ENTER key or click the Green Checkmark to go to the **MD04** page.
NOTE: Pressing the ENTER key and clicking the Green Checkmark are interchangeable for this interface. Both will accomplish the same thing.
2. When you reach the first screen of **MD04**, type out the full number of the part you are searching for on the line marked MATERIAL. Assemblers on the Manufacturing floor will send you the number in an email, along with how many they will need and which location it should be sent to.

Stock/Requirements List: Initial Screen

Individual access Collective access

Material	<input checked="" type="checkbox"/>	
MRP Area	<input type="text"/>	
Plant	1000	Manufacturing Livermore

With filter

Figure 3-1 The main page of MD04.

3. When you add the part number and press ENTER, that will take you to the STOCK / REQUIREMENTS LIST page.

Stock/Requirements List as of 14:33 hrs											
Stock/Requirements List as of 14:33 hrs											
<input type="checkbox"/> Show Overview Tree <input type="button" value="Print"/> <input type="button" value="Print Preview"/> <input type="button" value="Email"/> <input type="button" value="Copy"/> <input type="button" value="Paste"/> <input type="button" value="Batch/Com.Dt."/> <input type="button" value="Del. Prty."/> <input type="button" value="Demand"/>											
<input checked="" type="checkbox"/>	Material	853-A16921-100	ASSY,ENCL,SHLD,MAG,+Z,TOP BOX	MRP Area	1000	Manufacturing Operations	COMP	Unit	EA		<input type="button" value="Display"/>
Plant	1000	MRP Type	PD	Material Type							
<input type="checkbox"/> Individual List <input type="checkbox"/> Cross-Plant View											
A...	Date	MRP ele...	Opening date	MRP element data	Rescheduling d...	Except...	Receipt/Reqmt	Available Qty	Supp...	Stor...	R...
	06/14/2021	Stock		3507033987 /00070	03/29/2021 15		5.000	8.000	2000	3150	A
	02/23/2021	STFord		3507035038 /00030	05/18/2021 15		5.000	13.000	2000	3150	A
	02/24/2021	STFord									
	03/29/2021	DepReq		848-307589-727			1.000-	12.000			A
	03/29/2021	DepReq		848-307589-727			1.000-	11.000			A
	03/29/2021	DepReq		848-307589-727			1.000-	10.000			A
	03/29/2021	DepReq		848-307589-727			1.000-	9.000			A
	03/29/2021	DepReq		848-307589-727			1.000-	8.000			A
	03/29/2021	DepReq		848-307589-727			1.000-	7.000			A
	05/06/2021	OrdRes		1A-FLKXPREP-001			1.000-	6.000	0290		A
	05/18/2021	DepReq		848-339666-427			1.000-	5.000	3150		A
	05/18/2021	DepReq		848-339666-427			1.000-	4.000	3150		A
	05/21/2021	DepReq		848-307589-427			1.000-	3.000	3150		A
	05/21/2021	DepReq		848-307589-427			1.000-	2.000	3150		A
	05/21/2021	DepReq		848-307589-427			1.000-	1.000	3150		A
	05/21/2021	DepReq		848-307589-427			1.000-	0.000	3150		A
	05/21/2021	DepReq		848-307589-427			1.000-	1.000-	3150		A

Figure 3-2 Showing Part Inventory and Schedule.

4. To find the part type you are working with, double-click on the part number marked by the square above. This will take you to the DISPLAY MATERIAL page.

Display Material 853-A16921-100 (Component Material)

Display Material 853-A16921-100 (Component Material)

Additional Data Org. Levels

Purchase Order Text MRP 1 MRP 2 MRP 3 MRP 4 Forecasting Work scheduling Plant da...

Material	853-A16921-100	ASSY,ENCL,SHLD,MAG,+Z, TOP BOX	<input type="button" value="I"/>
Plant	2000	Livermore Warehouse	
RevLev	A	<input type="button" value="S"/>	

General Data				
Base Unit of Measure	EA	each	MRP group	<input type="text"/>
Purchasing Group	JJ		ABC Indicator	A
Plant-sp.mati status	<input type="text"/>	Valid from <input type="text"/>		

MRP procedure			
MRP Type	PD	MRP	
Reorder Point	0.000	Planning time fence	34
Planning cycle	<input type="text"/>	MRP Controller	552

Lot size data			
Lot size	SP	Part period balancing	
Minimum Lot Size	0.000	Maximum Lot Size	0.000
Ordering costs	49.00	Maximum stock level	102.000
Assembly scrap (%)	0.00	Storage costs ind.	2
Rounding Profile	<input type="text"/>	Takt time	0
Unit of Measure Grp	<input type="text"/>	Rounding value	0.000

MRP areas			
<input type="checkbox"/> MRP area exists	MRP areas		

SAP

Figure 3-3 Display Material; specific information is found on the tabs marked at the top.

5. Move through the tabs until you reach one titled BASIC DATA 1. Click on it.

The screenshot shows the SAP Material Display interface for material 853-A16921-100. The 'Basic Data 1' tab is selected. In the 'General Data' section, the 'Material Group' field contains 'PC' and is highlighted with a red square. Other fields include 'Base Unit of Measure' (EA), 'Old material number' (empty), 'Division' (01), 'Product allocation' (P), 'Ext. Matl Group' (empty), 'Lab/Office' (005), 'Prod. Hierarchy' (0201020204), 'Valid from' (empty), and 'GenItemCatGroup' (empty). The 'Material authorization group' section shows an empty field. The 'Dimensions/EANs' section includes fields for Gross Weight (33.350), Net Weight (33.350), Volume (0.000), Weight Unit (LB), Volume Unit (empty), Size/dimensions (empty), and EAN/UPC (empty). The 'Packaging material data' section shows 'Matl Grp Pack.Matlis' as 0. The 'Basic Data Texts' section shows 'Languages Maintained' as 0, with a button for 'Basic Data Text' and a dropdown for 'Language'. The SAP logo is visible at the bottom right.

Figure 3-4 In Basic Data 1, the type of part (Material Group) is marked with the red square.

If the MATERIAL GROUP is listed as PL or PC, you will proceed to Section 3.1.

If it is PN, you will proceed to Section 3.2.

Finally, if it is F, you will proceed to Section 3.3.

3.1 PL / PC Parts

PL and PC parts are the easiest to replace. These are smaller and cheaper parts of which the Manufacturing floor receives regular shipments. New shipments are requested by scanning the production line bins these parts are kept in. If no shipments have been generated, however, you can create a new one as needed.

3.1.1 Check for Transit

When you get a new request for parts, the first thing to check is to see if there is any stock already in transit to the Manufacturing floor. If there are parts in transit, you will see a new column on the STOCK / REQUIREMENTS LIST page marked TRANSIT. Most of the cells in this column will be marked with **0.000**, but there will be at least one cell that has a number in it.

A...	Date	MRP ele...	Opening date	MRP element data	Rescheduling d...	Except...	Receipt/Rqmt	Available Qty	Stck in transit	Supp...	Stor...	R...
	07/01/2021	Stock						14.000	0.000			
	02/22/2021	STFord		3507093484/00030	06/10/2021	15		18.000	32.000	18.000	2000	3150 B
	02/26/2021	STFord		3507093493/00020	06/11/2021	15		24.000	56.000	24.000	2000	3150 B
	03/29/2021	Delv.		0804091704/000130/0...				1.000-	55.000	0.000	6049	
	05/25/2021	DepReq		857-010949-483				1.000-	54.000	0.000	3150 B	
	05/25/2021	DepReq		857-010949-483				1.000-	53.000	0.000	3150 B	
	05/25/2021	DepReq		857-010949-483				1.000-	52.000	0.000	3150 B	
	05/25/2021	DepReq		857-010949-483				1.000-	51.000	0.000	3150 B	
	05/25/2021	DepReq		857-010949-483				1.000-	50.000	0.000	3150 B	
	05/25/2021	DepReq		857-010949-483				1.000-	49.000	0.000	3150 B	
	06/08/2021	DepReq		857-010949-465				1.000-	48.000	0.000	3150 B	

Figure 3-5 The column marking In Transit parts is marked by the square.

If the Storage Location (SLoc) column is labeled with either **3150** or **3250**, then those parts are meant for us. You can then reply to the assembler to let them know that their parts are already on the way.

3.1.2 Expediting A Pre-existing Order

- 1) Change the number on the MRP AREA line from **1000** to **2000**. This will take you to the Lam inventory in the Fremont warehouse. All of our part deliveries come through this facility.

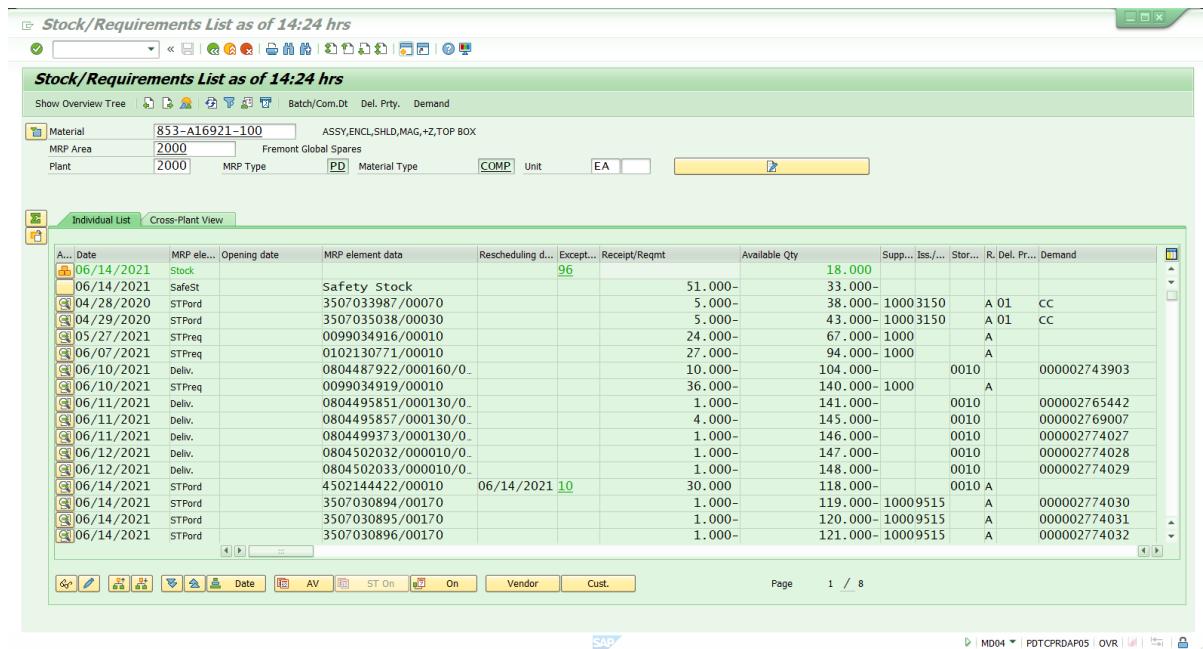


Figure 3-6 The 2000 side of MD04 shows our warehouse inventory.

- 2) When looking through the various Stock Transfer Orders (STO) on the schedule, make note of any that are marked with one of the number designations listed below.

 - a. **35-** — This indicates a delivery scheduled to leave the warehouse to our facility.
 - b. **080-** — Indicates a delivery that is in the stage of being moved to a loading area of the warehouse. At this point, the delivery should be in transit shortly.
 - c. **45-** — Indicates an upcoming shipment of parts to the warehouse from our suppliers.

3) Pressing the Delivery and Demand buttons on the top of the screen will reveal more columns on the STO in question. STOs that are going to the

Manufacturing floor will all have the **35-** designation and will also have **CC** in the demand column.

- 4) If there is an STO that fulfills the above criteria, that is a delivery already scheduled to arrive on the line.

The screenshot shows a software interface titled "Stock/Requirements List as of 14:24 hrs". The table displays various items with their details such as Date, MRP element data, Available Qty, and Demand status (A01 CC). One specific row is highlighted with a red box around the demand column, indicating it has been expedited.

A...	Date	MRP ele...	Opening date	MRP element data	Rescheduling d...	Except...	Receipt/Reqmt	Available Qty	Supp...	Iss./...	Stor...	R. Del. Pr...	Demand
	06/14/2021	Stock		Safety Stock	96			51.000-	33.000-			A01	CC
	06/14/2021	SafeSt		3507033987/00070				5.000-	38.000-	10003150			
	04/28/2020	STFord		3507035038/00030				5.000-	43.000-	10003150	A01		CC
	04/29/2020	STFord		0099034916/00010				24.000-	67.000-	1000	A		
	05/27/2021	STFreq		0102130771/00010				27.000-	94.000-	1000	A		
	06/07/2021	STFreq		0804487922/000160/0-				10.000-	104.000-	0010			000002743903
	06/10/2021	STFreq		0099034919/00010				36.000-	140.000-	1000	A		
	06/11/2021	Deliv.		0804495851/000130/0-				1.000-	141.000-	0010			000002765442
	06/11/2021	Deliv.		0804495857/000130/0-				4.000-	145.000-	0010			000002769007
	06/11/2021	Deliv.		0804499373/000130/0-				1.000-	146.000-	0010			000002774027
	06/12/2021	Deliv.		0804502032/000010/0-				1.000-	147.000-	0010			000002774028
	06/12/2021	Deliv.		0804502033/000010/0-				1.000-	148.000-	0010			000002774029
	06/14/2021	STFord		4502144422/00010	06/14/2021	10		30.000-	118.000-	0010 A			
	06/14/2021	STFord		3507030894/00170				1.000-	119.000-	10009515	A		000002774030
	06/14/2021	STFord		3507030895/00170				1.000-	120.000-	10009515	A		000002774031
	06/14/2021	STFord		3507030896/00170				1.000-	121.000-	10009515	A		000002774032

Figure 3-7 The marked STO has its demand marked CC. This is an STO going to 3150.

- 5) The next step is to expedite the STO. Double-click on this row to pull up a detail window. Click on the EDIT button to move to a new screen.

Stock/Requirements List as of 07:07 hrs

Material: 714-035203-005 COV,ENCL,DBLCNTN
 MRP Area: 1000 Manufacturing Operations
 Plant: 1000 MRP Type: PD Material Type: COMP Unit: EA

Additional Data for MRP Element

Purchasing Doc.	3507093484	30	1	Scheduled Qty	24.000 EA
Delivery date	02/19/2021	Delivered			6.000 EA
Net Price	0.00 / 1 EA	Target Quantity			0.000 EA
Supplying Plant	2000 Livermore Warehouse				
Exception	15 = Reschedule out (06/10/21/06/09/21)				
	07 = Finish date in the past				

Available Qty

Line	Available Qty
1	14.000
2	18.000
3	24.000
4	1.000-
5	1.000-
6	1.000-
7	1.000-
8	1.000-
9	1.000-
10	1.000-
11	1.000-
12	1.000-
13	1.000-
14	1.000-
15	1.000-
16	1.000-
17	1.000-
18	1.000-
19	1.000-
20	1.000-
21	1.000-
22	1.000-
23	1.000-
24	1.000-
25	1.000-
26	1.000-
27	1.000-
28	1.000-
29	1.000-
30	1.000-
31	1.000-
32	1.000-
33	1.000-
34	1.000-
35	1.000-
36	1.000-
37	1.000-
38	1.000-
39	1.000-
40	1.000-
41	1.000-
42	1.000-
43	1.000-
44	1.000-
45	1.000-
46	1.000-
47	1.000-
48	1.000-
49	1.000-
50	1.000-
51	1.000-
52	1.000-
53	1.000-
54	1.000-
55	1.000-
56	1.000-
57	1.000-
58	1.000-
59	1.000-
60	1.000-
61	1.000-
62	1.000-
63	1.000-
64	1.000-
65	1.000-
66	1.000-
67	1.000-
68	1.000-
69	1.000-
70	1.000-
71	1.000-
72	1.000-
73	1.000-
74	1.000-
75	1.000-
76	1.000-
77	1.000-
78	1.000-
79	1.000-
80	1.000-
81	1.000-
82	1.000-
83	1.000-
84	1.000-
85	1.000-
86	1.000-
87	1.000-
88	1.000-
89	1.000-
90	1.000-
91	1.000-
92	1.000-
93	1.000-
94	1.000-
95	1.000-
96	1.000-
97	1.000-
98	1.000-
99	1.000-
100	1.000-
101	1.000-
102	1.000-
103	1.000-
104	1.000-
105	1.000-
106	1.000-
107	1.000-
108	1.000-
109	1.000-
110	1.000-
111	1.000-
112	1.000-
113	1.000-
114	1.000-
115	1.000-
116	1.000-
117	1.000-
118	1.000-
119	1.000-
120	1.000-
121	1.000-
122	1.000-
123	1.000-
124	1.000-
125	1.000-
126	1.000-
127	1.000-
128	1.000-
129	1.000-
130	1.000-
131	1.000-
132	1.000-
133	1.000-
134	1.000-
135	1.000-
136	1.000-
137	1.000-
138	1.000-
139	1.000-
140	1.000-
141	1.000-
142	1.000-
143	1.000-
144	1.000-
145	1.000-
146	1.000-
147	1.000-
148	1.000-
149	1.000-
150	1.000-
151	1.000-
152	1.000-
153	1.000-
154	1.000-
155	1.000-
156	1.000-
157	1.000-
158	1.000-
159	1.000-
160	1.000-
161	1.000-
162	1.000-
163	1.000-
164	1.000-
165	1.000-
166	1.000-
167	1.000-
168	1.000-
169	1.000-
170	1.000-
171	1.000-
172	1.000-
173	1.000-
174	1.000-
175	1.000-
176	1.000-
177	1.000-
178	1.000-
179	1.000-
180	1.000-
181	1.000-
182	1.000-
183	1.000-
184	1.000-
185	1.000-
186	1.000-
187	1.000-
188	1.000-
189	1.000-
190	1.000-
191	1.000-
192	1.000-
193	1.000-
194	1.000-
195	1.000-
196	1.000-
197	1.000-
198	1.000-
199	1.000-
200	1.000-
201	1.000-
202	1.000-
203	1.000-
204	1.000-
205	1.000-
206	1.000-
207	1.000-
208	1.000-
209	1.000-
210	1.000-
211	1.000-
212	1.000-
213	1.000-
214	1.000-
215	1.000-
216	1.000-
217	1.000-
218	1.000-
219	1.000-
220	1.000-
221	1.000-
222	1.000-
223	1.000-
224	1.000-
225	1.000-
226	1.000-
227	1.000-
228	1.000-
229	1.000-
230	1.000-
231	1.000-
232	1.000-
233	1.000-
234	1.000-
235	1.000-
236	1.000-
237	1.000-
238	1.000-
239	1.000-
240	1.000-
241	1.000-
242	1.000-
243	1.000-
244	1.000-
245	1.000-
246	1.000-
247	1.000-
248	1.000-
249	1.000-
250	1.000-
251	1.000-
252	1.000-
253	1.000-
254	1.000-
255	1.000-
256	1.000-
257	1.000-
258	1.000-
259	1.000-
260	1.000-
261	1.000-
262	1.000-
263	1.000-
264	1.000-
265	1.000-
266	1.000-
267	1.000-
268	1.000-
269	1.000-
270	1.000-
271	1.000-
272	1.000-
273	1.000-
274	1.000-
275	1.000-
276	1.000-
277	1.000-
278	1.000-
279	1.000-
280	1.000-
281	1.000-
282	1.000-
283	1.000-
284	1.000-
285	1.000-
286	1.000-
287	1.000-
288	1.000-
289	1.000-
290	1.000-
291	1.000-
292	1.000-
293	1.000-
294	1.000-
295	1.000-
296	1.000-
297	1.000-
298	1.000-
299	1.000-
300	1.000-
301	1.000-
302	1.000-
303	1.000-
304	1.000-
305	1.000-
306	1.000-
307	1.000-
308	1.000-
309	1.000-
310	1.000-
311	1.000-
312	1.000-
313	1.000-
314	1.000-
315	1.000-
316	1.000-
317	1.000-
318	1.000-
319	1.000-
320	1.000-
321	1.000-
322	1.000-
323	1.000-
324	1.000-
325	1.000-
326	1.000-
327	1.000-
328	1.000-
329	1.000-
330	1.000-
331	1.000-
332	1.000-
333	1.000-
334	1.000-
335	1.000-
336	1.000-
337	1.000-
338	1.000-
339	1.000-
340	1.000-
341	1.000-
342	1.000-
343	1.000-
344	1.000-
345	1.000-
346	1.000-
347	1.000-
348	1.000-
349	1.000-
350	1.000-
351	1.000-
352	1.000-
353	1.000-
354	1.000-
355	1.000-
356	1.000-
357	1.000-
358	1.000-
359	1.000-
360	1.000-
361	1.000-
362	1.000-
363	1.000-
364	1.000-
365	1.000-
366	1.000-
367	1.000-
368	1.000-
369	1.000-
370	1.000-
371	1.000-
372	1.000-
373	1.000-
374	1.000-
375	1.000-
376	1.000-
377	1.000-
378	1.000-
379	1.000-
380	1.000-
381	1.000-
382	1.000-
383	1.000-
384	1.000-
385	1.000-
386	1.000-
387	1.000-
388	1.000-
389	1.000-
390	1.000-
391	1.000-
392	1.000-
393	1.000-
394	1.000-
395	1.000-
396	1.000-
397	1.000-
398	1.000-
399	1.000-
400	1.000-
401	1.000-
402	1.000-
403	1.000-
404	1.000-
405	1.000-
406	1.000-
407	1.000-
408	1.000-
409	1.000-
410	1.000-
411	1.000-
412	1.000-
413	1.000-
414	1.000-
415	1.000-
416	1.000-
417	1.000-
418	1.000-
419	1.000-
420	1.000-
421	1.000-
422	1.000-
423	1.000-
424	1.000-
425	1.000-
426	1.000-
427	1.000-
428	1.000-
429	1.000-
430	1.000-
431	1.000-
432	1.000-
433	1.000-
434	1.000-
435	1.000-
436	1.000-
437	1.000-
438	1.000-
439	1.000-
440	1.000-
441	1.000-
442	1.000-
443	1.000-
444	1.000-
445	1.000-
446	1.000-
447	1.000-
448	1.000-
449	1.000-
450	1.000-
451	1.000-
452	1.000-
453	1.000-
454	1.000-
455	1.000-
456	1.000-
457	1.000-
458	1.000-
459	1.000-
460	1.000-
461	1.000-
462	1.000-
463	1.000-
464	1.000-
465	1.000-
466	1.000-
467	1.000-
468	1.000-
469	1.000-
470	1.000-
471	1.000-
472	1.000-
473	1.000-
474	1.000-
475	1.000-
476	1.000-
477	1.000-
478	1.000-
479	1.000-
480	1.000

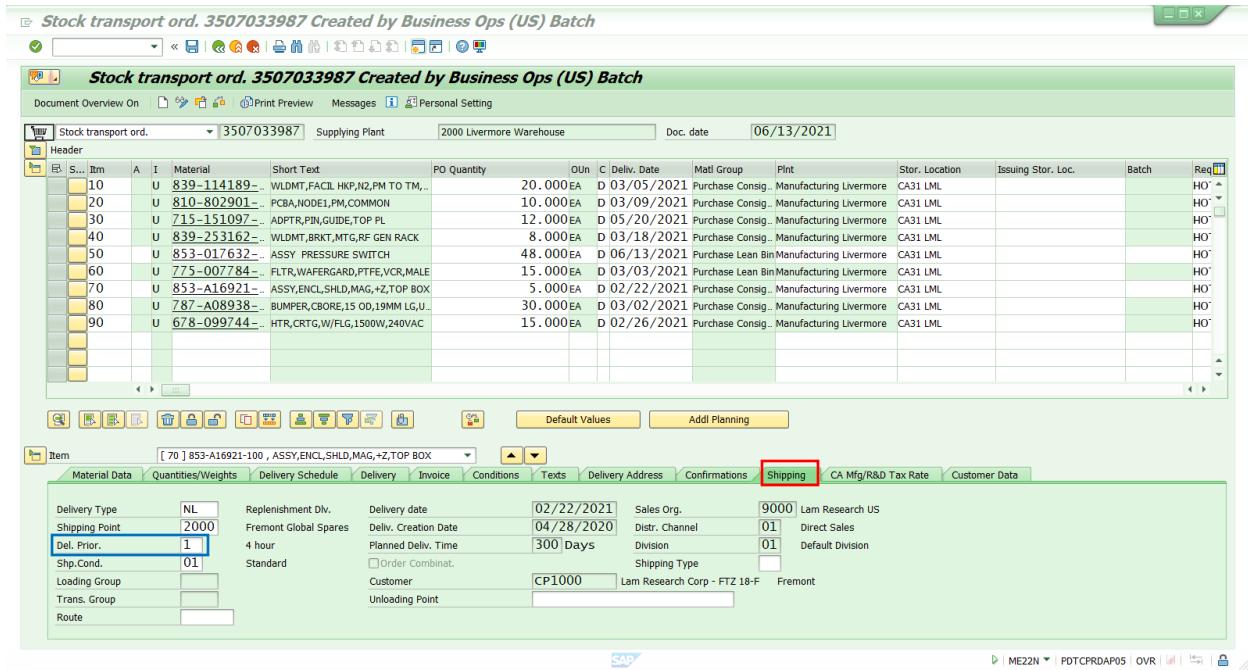


Figure 3-9 STO Details. The Shipping tab is marked with red and the Delivery Priority field is marked with blue.

The STO is now expedited and should arrive at our facility sometime within the next four hours. Your task is now complete.

3.1.3 New STO

When an STO does not currently exist for this card, the next step is to create a brand new one.

- 1) Keeping the **MD04** page open, create a new window and type in the T-code **ZR269**. Put the part number on the appropriate line and press the **F8** button or click the EXECUTE ICON at the top of the screen.

Bin Status Report

Plant: 1000

Selection option:

- By Material
Material: 853-A16921-100 to []
- By Control Cycle
Control cycle: [] to []
- By Storage Location
Storage Location: []

Figure 3-10 Bin Status Report. The Execute button is marked in red.

NOTE: The **F8** button and the EXECUTE button are interchangeable and both accomplish the same action.

- 2) You are now on the BIN STATUS REPORT page, which shows the information on the bins for this part. The number you need off this page is the number marked CNTCYCLE. Copy the number that is connected to the bin you are sending these parts to.

Material	CntrCycle	# Sleep Kanbans	Supp Area	Storing Position	DemandQty(Hrznl)	DemandQty(Hrznl2)	CC SLocQty	KanbanQty	QtyToPutaway	Resup Qty	ZAIMPICKqty	STPOqty
853-A16921-100	128140	0	02102	RACK:07 SHELF:01	237.000	249.000	2.000	2.000	0.000	0.000	0.000	10.000

Figure 3-11 The Control Cycle indicates a bin's location. Marked with red.

- 3) Create a new window and use the T-code **ME27**. Paste in the provided information in the way shown below. Press ENTER when you are done.

Create Purchase Order : Initial Screen

Supplying Plant: 2000
Order Type: UB
Purchase Order Date: 06/14/2021
Purchase order:

Organizational Data
Purch. Organization: 1000
Purchasing Group: ZZ

Default Data for Items
Item Category: U Stock transfer
Act Assignment Cat.
Delivery Date: T
Plant: 1000
Storage Location: 3150
Req. Tracking Number: 0000128140
Promotion:
 Acknowledgment Rqrd

Figure 3-12 This is the setup of values you absolutely want to follow on ME27.

- 4) You'll be taken to the CREATE PURCHASE ORDER screen. In the first row of the table, input the part number and the quantity you want to order. Input today's date in the DELIV DATE cell. Double-click on the part number. Three prompts will appear, but press ENTER for all of them.

Create Purchase Order : Item Overview

Purchase order: [] Order Type: UB PO Date: 06/14/2021
Vendor: []
Supplying Plant: 2000 Livermore Warehouse

PO Items

Item	I	A	Material	Short Text	PO Quantity	OUn	C	Deliv. Date	Mat. Grp	PInt	SLoc	D	R	S	L	Total Value of Servs	Exp. Value	Overall Lim
10	U		853-A16921-100		5	D	X-XX-20XX		1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00
20	U					D			1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00
30	U					D			1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00
40	U					D			1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00
50	U					D			1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00
60	U					D			1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00
70	U					D			1000 3150	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	0.00	0.00	0.00	0.00	0.00

Figure 3-13 The inserted values for creating a new STO.

- 5) When the smaller window pops up, press the GENERATE NEW STO button to move to the next screen.
- 6) When you come to the NEXT page, copy the TRACKING number along with one of the leading 0's and paste it onto the line marked MRP ELEMENT NUMBER. Next, type **CC** on the MRP ELEMENT line. When you are finished, click the SAVE icon at the top of the window.

Create Purchase Order : Item 00010

Figure 3-14 Make sure the MRP Element and MRP element number fields are filled as the text specifies. The Save button is marked red.

- 7) A new STO has been generated and you can go back to **MD04** to expedite it by the steps listed in Section 3.1.2.

3.1.4 Replacing

The step for replacing missing or damaged parts is slightly different than creating a normal STO. If parts must be replaced, the assembler contacting you will add provide an NCI number for their request.

1. Similar to the start of Section 3.1.3, go to the **ZR269** page and copy the COUNTER number for the part.
2. Make a new window and use the T-code **ZR261**. Paste the copied COUNTER number on the line and press the button marked NCR.

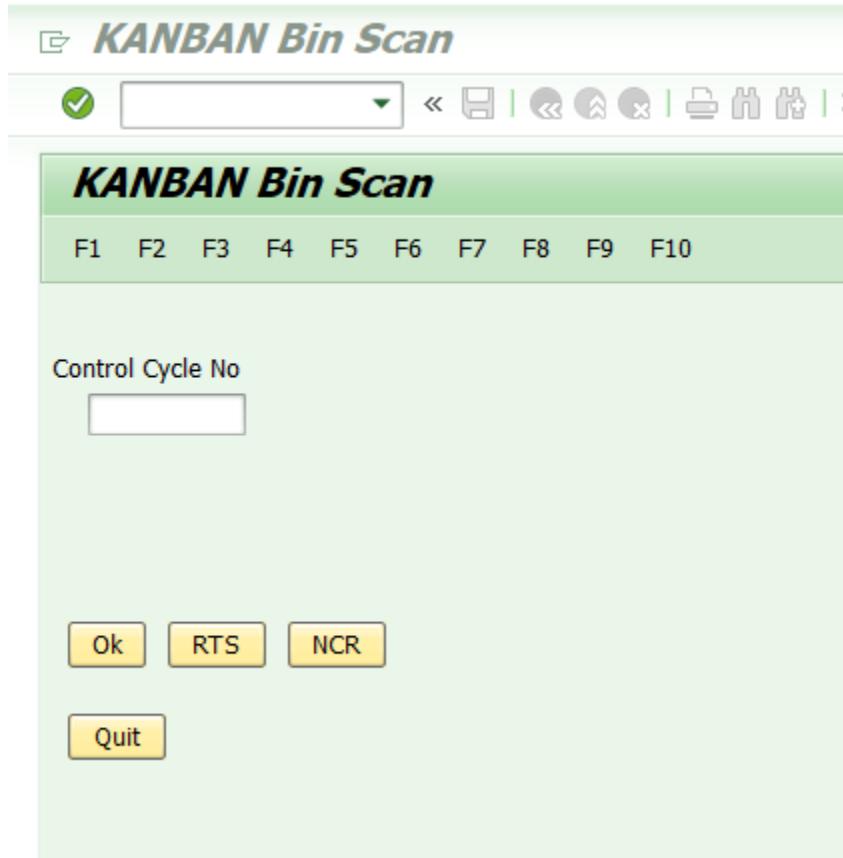


Figure 3-15 Main page of ZR261.

3. Type in the quantity that are missing and the NCI number on the corresponding lines. When you are done, press ENTER.

NCR									
F1	F2	F3	F4	F5	F6	F7	F8	F9	F10
Qty withdrawn									
<input type="text" value="2"/>									
NCR Number									
<input type="text" value="131624"/>									
<input type="button" value="Ok"/>					<input type="button" value="Quit"/>				

Figure 3-16 Entering values to log damaged parts.

4. When the pop-up window appears, specify whether the bin is empty or not. The assembler will let you know if it is empty. After choosing YES or NO, the request will be complete. The system will generate a new STO to replace the missing parts.

3.2 PN Parts

In contrast to PL and PC parts, PN parts are more expensive and are harder to order. The system typically only orders these parts on an as-needed basis. This is done by linking that part to a unique reservation number, which connects all PN parts to a specific product. When an assembler requests an expedite of PN parts, they will need to provide a Functional Configuration Identification (FCID) that specifies the type of product being built. This FCID is used in the **PC Release Schedule spreadsheets**,

which you should have access to through the PC group SharePoint, and can be used to find the reservations you will be working with for this expedite.

3.2.1 Find the Reservation

1. Open the PC Release Schedule in Excel and press **CTRL+F**. Paste the FCID into the search bar and press ENTER. If the FCID is present in the spreadsheet, your cursor will snap to it.

	B	C	D	E	F	G	H	I	
1		06-28-2021							Dynamic List Display
2									
3		Module Report; POM: ETCH - CA31 - VOLUME MFG - US - LIVERMOR							
4	Cell Fusion	Mis- M			FCID				
5	CF/DJANC	Mis- M	SD Doc.	Item No	FCID	LPR Customer Fab	Serial No	Description	
556	CFDL	CLOSED	D2669	180	213834	SAMSUNG - M PROJEC	FHXPL-1771	23FLEXHX_PLUS	
557	CFDL	CLOSED	D5791	250	217036	LAM - ETCH/REM	KFXE-3129	23KiyoFXE	
558	CFDL	CLOSED	D5791	250	217036	LAM - ETCH/REM	KFXE-3130	23KiyoFXE	Not okay to group
559	CFDL	CLOSED	D5791	250	217036	LAM - ETCH/REM	KFXE-3131	23KiyoFXE	Waiting for Misr
560	CFDL	CLOSED	D2555	400	213252	SAMSUNG - P II LINE S	FXM-259	23KiyoFXM	Partial Chamber
561	CFDL	CLOSED	D2555	400	213252	SAMSUNG - P II LINE S	FXM-260	23KiyoFXM	715-800331-006
562	CFDL	CLOSED	D2555	400	213252	SAMSUNG - P II LINE S	FXM-261	23KiyoFXM	
563	CFDL	CLOSED	D2555	400	213252	SAMSUNG - P II LINE S	FXM-262	23KiyoFXM	
564	CFDL	CLOSED	D4310	120	210323	WUHAN XINXIN SEMI	N 23SNC-242	SyndionC	Partial Chamber
565	CFDL	CLOSED	D4310	120	210323	WUHAN XINXIN SEMI	N 23SNC-241	SyndionC	

Figure 3-17 Use **Ctrl+F** to find the FCID given in the email. Highlight the full row.

2. Follow along that same row to find the reservation numbers connected to the FCID. If you are sending a part to 3150, you will concentrate on the PM LINE reservation. If instead you are sending to 3250, the BIAS LINE number is the one you want.

	O	P	Q	R	S	T	U	V	W
1			*						
2			>						
3			<						
4				Pump Line	Prep Line	PM Line	Bias Line	Bias Test	Comments
5	Pln Group	Pln Launch	Act Launch	Pump Line	Prep Line	PM Line	Bias Line	Bias Test	Comments
656	6/22/2021	6/29/2021				17446899*	17446900*		
657	6/22/2021	6/29/2021			17455626	17455627	17455628		
658	6/22/2021	6/29/2021			17455626	17455627	17455628		
659	6/22/2021	6/29/2021			17455626	17455627	17455628		
660	6/22/2021	6/29/2021			17446901*	17446902*	17446903*		
661	6/22/2021	6/29/2021			17446901*	17446902*	17446903*		
662	6/22/2021	6/29/2021			17446901*	17446902*	17446903*		
663	6/22/2021	6/29/2021			17446901*	17446902*	17446903*		
664	6/22/2021	6/29/2021		17446906*	17446907*	17446908*	17446909*	17446910*	17446911*
665	6/22/2021	6/29/2021		17446906*	17446907*	17446908*	17446909*	17446910*	17446911*

Figure 3-18 Follow the row to find the reservation number you need.

Make note of this reservation number.

3.2.2 Expediting

1. Similar to Section 3.1.2, you want to search if there are any already active STOs when you first receive an expedite request. Go to the **2000** side of **MD04**.
 2. Click on the DEL PRTY and DEMAND buttons near the top of the screen to see what reservations the active STOs are connected to.

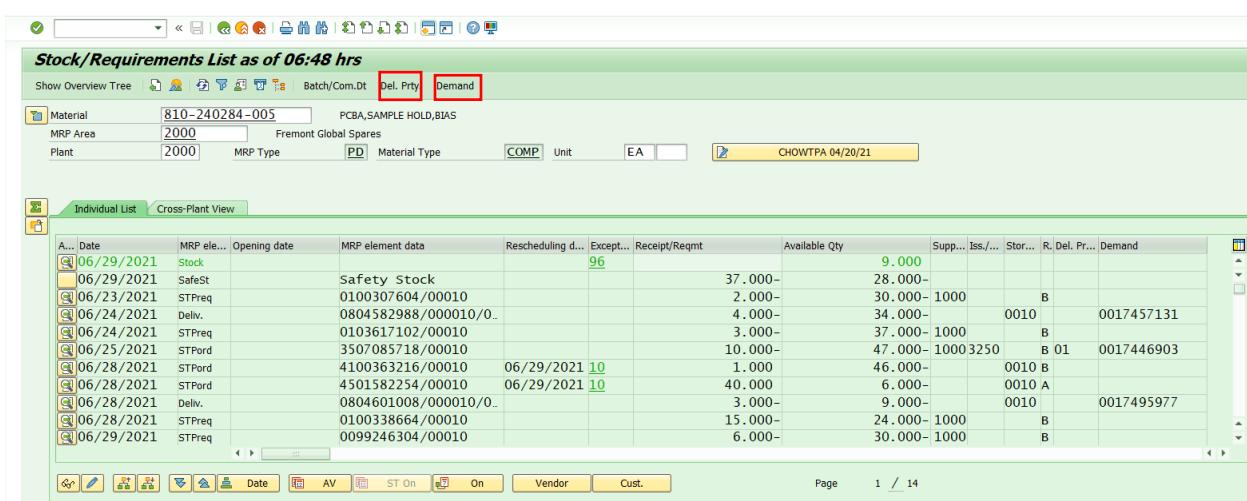


Figure 3-19 The Delivery Priority and Demand buttons are marked with red.

3. If you do not see this part's reservation number in **MD04**, you can ignore the rest of this section and move on to Section 3.2.3. Otherwise, we first need to make sure that this reservation has been properly released for transit. Create a new window using T-code **ZR101**. Fill in the bubble marked NR/ENG REPORT and paste your reservation number onto the line. Click EXECUTE.

The screenshot shows the SAP ZR101 main page titled "PO Status report". It features three radio button options: "PO Status Report" (unchecked), "NR/ENG Report" (checked), and "Production Order Report" (unchecked). The "NR/ENG Report" section contains a "Reservation" field with the value "17446903". There are also "Purchase Order" and "Order no." fields, both of which are currently empty.

Figure 3-20 Main page for ZR101.

4. When you see this reservation's RESERVATION ITEM STATUS, check the top line. If the line has any sort of text on it, this reservation has been released. If the line is blank, then this is not the case. Consult with your supervisor at this point.

Reservation Item Status										
Display Res.		Change Res.	Stk/Reqmts (MFG)	Stk/Reqmts (WHS)	MRP Controller	Status Log	O			
Reservation Item Status										
Reservation : 0017380385				Req By	Req Date					
Status :					00/00/0000 00:00:00					
Item	Material	Descriptn	SLoc	MGr	Reqd	Issd	ZMAKE	ZQty		
0001	575-013640-438	CONFIG, RF CAR	9520	MN	6.00					
0002	575-043960-438	CONFIG, CHAMBE	9520	MN	6.00					
0003	575-800096-438	CONFIG, ASSY,	9520	MN	6.00					
0004	575-800325-348	CONFIG, BIAS A	9520	MN	6.00					
0005	853-802259-421	ASSY, COLLIMAT	9520	MN	6.00					

Figure 3-21 This page shows the items of the reservation.

5. If your supervisor approves releasing this reservation, create a new window and use the T-code **ZR308**.

Reservation Release								
Reservation	17380385	to						
Additional filter data								
Sales Order								
Item								
Line								
Op								
Parent Assembly								

Figure 3-22 Main page of ZR308.

6. Paste the reservation number on the line a click EXECUTE.

7. When the next window comes up, click the bubble next to the reservation you want and press the RELEASE RESERVATION button.
8. Now the reservation has been released for transit. Return to **MD04** and expedite the STO as you have done in Section 3.1.2.

3.2.3 New STO

1. If there is no current STO, you will have to create a new one. Use the reservation number and make a new window for **ZR101**.
2. If the reservation is released, press the CHANGE RES button at the top. It has a pen icon.

Reservation Item Status								
Display Res.		Change Res.	Stk/Reqmts (MFG)	Stk/Reqmts (WHS)	MRP Controller	Status Log	O	
Reservation Item Status								
Reservation : 0017380385			Req By		Req Date			
Status :					00/00/0000 00:00:00			
Item	Material	Descriptn	SLoc	MGr	Reqd	Issd	ZMAKE	ZQty
0001	575-013640-438	CONFIG,RF CAR	9520	MN	6.00			
0002	575-043960-438	CONFIG,CHAMBE	9520	MN	6.00			
0003	575-800096-438	CONFIG, ASSY,	9520	MN	6.00			
0004	575-800325-348	CONFIG,BIAS A	9520	MN	6.00			
0005	853-802259-421	ASSY,COLLIMAT	9520	MN	6.00			

Figure 3-23 The Change Reservation button is marked with red.

3. Press the button at the top that has the icon of a blank page. This will let you create a new item for the reservation.

Change Reservation 0017314931 : Collective Processing

 Details fm item

Movement type	311 TF tfr. within plant	Goods recipient								
Rcvg SLoc	3250									
Positionen										
Item	Material	Quantity	UnE	Plnt	SLOC	Batch	M	FIS	PO Crea	D
1	684-084547-111	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2	684-084547-112	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3	684-084547-113	6.000	EA	1000	3250		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
4	684-084547-114	6.000	EA	1000	3250		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
5	713-083420-014	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
6	713-112956-437	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
7	713-136118-006	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
8	713-155260-025	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Figure 3-24 The New Item button is marked with red.

4. A small window will pop up asking for the REQUIREMENT DATE for this new delivery. Copy the BASE DATE onto that line and write **1000** for the PLANT.

Change Reservation 0017314931 : Collective Processing

 Details fm item

Movement type	311 TF tfr. within plant	Goods recipient								
Positionen										
Item	Material	Quantity	UnE	Plnt	SLOC	Batch	M	FIS	PO Crea	D
1	684-084547-111	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2	684-084547-112	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3	684-084547-113	6.000	EA	1000	3250		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
4	684-084547-114	6.000	EA	1000	3250		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
5	713-083420-014	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
6	713-112956-437	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
7	713-136118-006	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
8	713-155260-025	6.000	EA	1000	9520		<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

Default Values

Header information	
Base date	06/18/2021
Suggestion for new items	
Reqmts date	06/18/2021
Plant	1000

Figure 3-25 Pop up menu for making a new part entry. Make sure the Reqmts date matches the Base date.

5. You can now create a new reservation item. Fill in the first row of the new page, adding the part number, quantity, and whether this part is going to 3150 or 3250. All of this information should be present in the email. Double click on the part number after you have added the information.

Change Reservation 0017314931 : New Items

Details fm item

Movement type	311	TF tfr. within plant								
Goods recipient										
Rcvg SLoc	3250									
Positionen										
Item	Material	Quantity	UnE	Plnt	SLOC	Batch	M	FIs	PO Crea	D
28	839-800328-229	1		1000	3250		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
29				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
30				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
31				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
32				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
33				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
34				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
35				1000			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Figure 3-26 Fill out a line for a new entry as shown.

6. The item you have created will be at the very end of the reservation. Hold SHIFT+F7 to move through the reservation items until you reach the very end. Copy the RECIPIENT and TEXT lines from previous entries and paste them on the appropriate lines. Add the UNLOAD PT that this part must be delivered to, with the first three digits being the production line and the last two digits being the workstation as shown below. Press the SAVE button at the top of the screen.

Change Reservation 0017314931 : Details 0028 / 0028

◀ ▶ New item

Movement type	311	TF tfr. within plant
Plant	1000	Manufacturing Livermore
Material	839-800328-229	ESC,ITER, BTM, 300MM
Stor. location	3250 CA32 LML	
Quantity in		
Unit of entry	1.000	EA <input type="checkbox"/> Qty. is fixed
Stockkeepg.unit	1.000	EA
Further information		
Reqmts date	06/18/2021	<input type="checkbox"/> Final issue <input checked="" type="checkbox"/> Mvt allowed
Recipient	C9669/MULTI	Unload.pt. <input type="checkbox"/> 03112
Text	571-800096-478	

Figure 3-27 Make sure to fill in these lines as the text specifies.

7. Create a new window and use the T-code **Z026**. Make sure PLANT is **1000** and that the RESERVATION NUMBER option is bubbled. Paste the number onto the line and click EXECUTE. This will generate a new STO for the reservation item you just created.

Grouping ABAP 2

The screenshot shows the SAP Z026 main page with the following interface elements:

- Plant:** A dropdown menu with icons for plant selection.
- Reservation number:** An input field containing "1000".
- Production order number:** An input field containing "17314931" with a "to" field and a search icon.
- Business area:** An input field with a dropdown arrow.
- Storage location:** An input field with a search icon.

Figure 3-28 Main page for Z026.

- Close all previous windows and go back to **MD04**. Find the new STO you have just generated and expedite it as you did in Section 3.1.2. Email the assembler and let them know that you have expedited the part.

3.2.4 Replacing

Like making a replacement STO for PL or PC parts, replacing a PN part will require use of an NCI number. Fortunately, the procedure for making such an STO is almost exactly the same as the procedure in Section 3.2.3. Go through the instructions of the previous section like normal, but just make an addition to the TEXT line with “NCI #” and the NCI number the assembler gave you. Then just finish the steps listed above in Section 3.2.3.

Change Reservation 0017446903 : Details 0002 / 0002

Movement type	311	TF tfr. within plant
Plant	1000	Manufacturing Livermore
Material	810-240284-005	PCBA,SAMPLE HOLD,BIAS
Stor. location	3250 CA32 LML	
Quantity in		
Unit of entry	10.000	EA
Stockkeepg.unit	10.000	EA
<input type="checkbox"/> Qty. is fixed		
Further information		
Reqmts date	06/30/2021	<input type="checkbox"/> Final issue
<input checked="" type="checkbox"/> Mvt allowed	<input type="checkbox"/> Item deleted	
Recipient	D2555/MULTI	Unload.pt.
Text	571-800096-820 NCI # 1359612	

Figure 3-29 The given NCI information has been added to the text line.

3.3 Freestock Parts

Freestock parts are the final type of parts you will regularly work with. They are frequently those that are small and numerous, such as screws and caps for rivets. The challenge of these parts is they do not officially exist within the system and an STO cannot be made for them. There are three methods of pulling Freestock parts and it is recommended to try them in this sequence.

3.3.1 Inventory Control

1. On some occasions, the warehouse will be carrying the Freestock parts you are looking for. This can be confirmed by going to the warehouse **2000** side of **MD04**. Check with the procedure mentioned previously in Section 3.1.2.

- If there turns out to be stock for this part in the warehouse, write an email to DHL Inventory Control and ask them to transfer the necessary quantity of the part to the location specified by the original email.

3.3.2 Wave Orders

- If no stock can be found in **2000**, you will need to try a new approach.

Create a new window and use the T-code **ZRWAVE01**. Fill in PLANT as **1000** and paste the part number on the MATERIAL NUMBER line.

Figure 3-30 Main page for ZRWAVE01.

- The WAVE REPORT page shows all the incoming deliveries bound for **3150** and **3250**. Scroll down the ORDER until you find row items that have an order number starting with **993-**. Find one or more of these orders that provide the required quantity of Freestock parts and copy the order numbers.



The screenshot shows a software application window titled "Wave Report for Manufacturing". The main area displays a table of current orders. The columns include: Warehouse, Wave, Pick_Id, Order, Operation, Ord Item, Material, Type, TO Item, Pick Qty, Dif Container, Bin, Cart ID, Created By, CreateDate, CreateTime, Confirmed By, ConfirmDate, ConfirmTime, Consolidated By, and ConsolDate. There are four rows of data in the table:

Warehouse	Wave	Pick_Id	Order	Operation	Ord Item	Material	Type	TO Item	Pick Qty	Dif Container	Bin	Cart ID	Created By	CreateDate	CreateTime	Confirmed By	ConfirmDate	ConfirmTime	Consolidated By	ConsolDate
101	1385796	30577509	993120210530		67	720-056626-020	CC	3120210530	67	100.000	C77000479	JLCONS1202	CAMARRI	05/30/2021	20:01:23	OP_US_BATCH	05/31/2021	01:03:19	SALVAJO2	05/31/2021
101	1388137	30656096	993120210606		131	720-056626-020	CC	3120210606	131	100.000	C77000427	JLCONS1402	QUILAMA	06/06/2021	22:28:22	OP_US_BATCH	06/06/2021	23:13:26	SALVAJO2	06/06/2021
101	1381150	30429981	993120210517		124	720-056626-020	CC	3120210517	124	100.000	C77000679	SMRK020404	DAVISJE1	05/17/2021	20:03:40	OP_US_BATCH	05/17/2021	20:23:18	PHILJO	05/17/2021
101	1380015	30399824	993120210514		26	720-056626-020	CC	3120210514	26	100.000	C77000169	SMRK010103	CHOPRSO	05/14/2021	11:10:29	OP_US_BATCH	05/14/2021	13:13:48	WILLITA1	05/14/2021

Figure 3-31 The current orders in progress for this part.

- Send an email to DHL Picking asking for them to pull in the specified wave orders as soon as they can.

3.3.3 Spares

If neither of the above methods are successful, it is time to see if there is stock for this part in Spares.

- Go back to the **MD04** page and change the MRP AREA value to **2001**.

This will show stock in the Fremont Spares Warehouse.

- If there is stock for this Freestock part in 2001, write an email to Hot

Orders asking that they transfer the required stock from 2001 to 2000.

Parts will be sent and you can then communicate with the warehouse using the procedure found in Section 3.3.1.

If all three methods have been attempted and there is no available stock for this part, consult your supervisor on possible next steps.

4 Pulling in Stock

Expediting parts is normally a simple process, but sometimes you will find that there are none of this part available in 2000 and our Manufacturing lines are desperately asking for them. In situations like this, you will need to try other ways of finding the parts you need. This can be done by either reaching out to buyers or by contacting other Lam facilities.

4.1 Contacting Buyers

After checking the 2000 inventory for a specific part and finding it empty, the first thing you want to do is try to communicate with the buyer. The buyer is the link between Lam and our part suppliers and order shipments of parts as we need them. If you inform them of the current predicament, they may be able to pull a shipment of parts into 2000 sooner than they would have arrived on their own.

1. First you want to look through the STOCK REQUIREMENTS LIST and find the next shipment of parts. As mentioned in Section 3.1.2, they will always be denoted by a number code beginning with **45-**. Copy this number for later use.

Stock Requirements List as of 11:07 hrs											
Show Overview Tree Batch/Corn.Dt Del. Ptry. Demand											
Material	715-101136-051		CLIP,CAM,SHAFT,INNER ELCTD								
MRP Area	2000		Fremont Global Spares								
Plant	2000		MRP Type	PD	Material Type	COMP	Unit	EA		KRAYNRI	10/31/13
Individual List											
A... Date	MRP ele...	Opening date	MRP element data	Rescheduling d...	Except...	Receipt/Reqmt	Available Qty	Supp...	Iss./...	Stor...	R. Del. Pr... Demand
06/15/2021	Stock		Safety Stock		96		0.000				
06/15/2021	SafeSt		3506819128/00080		10	260.000-	260.000-				
03/29/2021	STFord		3507010551/00020			8.000	252.000-	10006049 0010 B			
05/17/2021	STFord		3507024372/00070			33.000-	285.000-	10003250 B 02 CC			
06/09/2021	STFord		4500893952/00010			40.000-	325.000-	10003250 B 02 CC			
06/25/2021	STFord		4500893952/00010	06/15/2021	10	50.000	275.000-		0010 B		
06/30/2021	STFord		4500893952/00010	06/15/2021	10	100.000	175.000-		0010 B		
07/02/2021	STPreq		0097662746/00010			172.000-	347.000-	1000 B			
07/07/2021	STFord		4500893952/00010	06/15/2021	10	100.000	247.000-		0010 B		
07/09/2021	STPreq		0105899948/00010			96.000-	343.000-	1000 B			
07/14/2021	STFord		4500893952/00010	06/15/2021	10	200.000	143.000-		0010 B		
07/16/2021	STPreq		0103395314/00010			240.000-	383.000-	1000 B			
07/21/2021	STFord		4500893952/00010	07/02/2021	10	240.000	143.000-		0010 B		
07/28/2021	STFord		4500893952/00010	07/16/2021	10	100.000	43.000-		0010 B		
08/04/2021	STFord		4500893952/00010	07/16/2021	10	100.000	57.000		0010 B		

Figure 4-1 An incoming shipment of parts is marked with red.

2. Next to the PART line at the top of the screen there is a file icon. It is marked in the image above with a blue square. Click on it to extend a pull-down menu showing additional information on this part. Click on the tab marked OVERVIEW OF PART DATA. The person listed as PURCHASING GROUP is the buyer for this part.

The screenshot shows the SAP Stock/Requirements List interface. At the top, there's a toolbar with various icons and a date field 'KRAYNRI 10/31/13'. Below the toolbar, a header row displays material information: Material '715-101136-051', MRP Area '2000', Plant '2000', MRP Type 'PD', Material Type 'COMP', Unit 'EA', and a yellow status bar. The main area has tabs for 'Overview of material data', 'Procurement and scheduling', 'Stocks/coverage', 'Statistic 1', and 'In-house production data'. A sub-section titled 'Purchasing Group' highlights 'W10 Abdul Shahid' in red. Below this, there's a table with columns like MRP Controller, Purchasing Group, Procurement Type, Planning time fence, ABC Indicator, MRP group, Strategy Group, Special procurement, Availability check, and a checkbox for 'B401 Active'. The bottom section shows a table of procurement history with columns: A..., Date, MRP ele..., Opening date, MRP element data, Rescheduling d..., Except..., Receipt/Reqmt, Available Qty, Suppl..., Iss./..., Stor..., R. Del., Pr..., and Demand. The table lists several entries, including a row for 'Safety Stock' with a quantity of 0.000.

Figure 4-2 This part's buyer is marked with red.

3. Write an email to this buyer and ask if it is possible to expedite the upcoming shipment of parts. They will reply when they are able about the status of the shipment.

4.2 Reaching out Worldwide

If parts cannot be found in the way marked above, then you will need to borrow some from other Lam facilities.

1. After copying the part number, create a new window and use the T-code **MMBE**. When the page appears, copy the number onto the PART line and click EXECUTE. **Make sure all other lines in the DATABASE SELECTIONS area are empty.**

Stock Overview: Company Code/Plant/Storage Location/Batch

The screenshot shows the SAP Stock Overview interface. At the top, there are several icons for navigating through the system. Below the header, the title "Stock Overview: Company Code/Plant/Storage Location/Batch" is displayed. The main area is divided into several sections:

- Database selections:** This section contains input fields for "Material" (719-101612-887), "Plant" (with a dropdown menu), "Storage location" (with a dropdown menu), and "Batch" (with a dropdown menu). To the right of these fields are three small yellow buttons.
- Stock Type Selection:** This section contains two checked checkboxes: "Also Select Special Stocks" and "Also Select Stock Commitments".
- List Display:** This section contains input fields for "Special Stock Indicator" (dropdown menu), "Display version" (set to 1), "Display Unit of Measure" (dropdown menu), and two checkboxes: "No Zero Stock Lines" (checked) and "Decimal Place as per Unit" (unchecked).
- Selection of Display Levels:** This section contains four checked checkboxes: "Company Code", "Plant", "Storage Location", and "Batch".

Figure 4-3 Main page of MMBE

2. You will now find yourself on the STOCK OVERVIEW page, which shows how much of this part every other Lam facility currently has and is expected to receive. Scroll through the list until you find one or more locations that carry the quantity of part that you need.

Stock Overview: Basic List							
Selection							
Material	719-101612-887	ESC,MZ,HTD_CER,300MM,C					
Material Type	COMP	Component Material					
Unit of Measure	EA	Base Unit of Measure EA					
Stock Overview							
						
Client/Company Code/Plant/Storage Location/Batch/Special Stock		Unrestricted use	Qual. inspection	Reserved	Rcpt reservation	On-Order Stock	Consgt ord.
Full <ul style="list-style-type: none"> 2700 Lam Research Intl Sarl <ul style="list-style-type: none"> 1000 Manufacturing Livermore <ul style="list-style-type: none"> 3150 CA31 LML 106.000 97.000 97.000 184.000 3250 CA32 LML NEW 25.000 97.000 97.000 24.000 6099 IMF MRB 10.000 54.000 97.000 9520 NR Staging 43.000 9550 Make 34.000 24.000 2000 Livermore Warehouse <ul style="list-style-type: none"> Stock Provided to Vendor 1.000 0010 Main Warehouse 100.000 0020 Spares MRB 6.000 0021 Spares WR MRB 1.000 QUAR Quarantine 3.000 2001 Tracy Spares Warehouse <ul style="list-style-type: none"> 2.000 59.000 0010 Spares Main WH 2.000 46.000 QHLD Q Hold 13.000 4010 Tokyo Global Spares <ul style="list-style-type: none"> 0015 Non-Value 1.000 Sales Order Stock 4030 Lam Research GK <ul style="list-style-type: none"> 0010 Inventory 3.000 4040 Lam Research Tainan <ul style="list-style-type: none"> 0010 Inventory 2.000 							

Figure 4-4 This shows our stock for a specific part company-wide. The Unrestricted use column shows parts that are open for use while On-Order Stock shows parts to be delivered.

- Write an email to Hot Orders and ask them to transfer the quantity of part from the specified locations to the 2000 warehouse.

5 Return to Stock

While the previous chapter informed you on how to pull parts from other Lam facilities, this next chapter will inform you on what to do when other Lam facilities need to pull parts from the Manufacturing floor and transfer them to the warehouse so they can be sent out worldwide. These procedures are called Return to Stock, or RTS.

For a number of reasons, people from other Lam facilities will send emails to PC to ask to use some of the parts we have on hand. It can be to support Manufacturing in

another country or to repair a customer's damaged machine. Therefore, we need to do what we can to make sure they get the parts they need as quickly as possible. When you receive an email asking you to RTS a certain quantity of part, these emails will usually be sent by Hot Orders. They can handle the transfer of parts from the warehouse to their location, but they can't do anything about parts on the Manufacturing floor. These are steps to follow to accomplish that.

5.1 PL / PC Parts

1. When you receive the RTS email, you will need to find the supervisor of the production line the parts are found at. Make a new window and use the T-code **ZR269**. This will tell you what production line this part is located at. Your supervisor can provide you with the names of the supervisors in charge of that production line.
2. Add them to the original email and request that they check our on-hand stock for this part and advise if we can fill the RTS request. They will check our stock and respond back. Any parts we RTS are physically moved to the Material Review Board (MRB) room.
3. Go through the procedures listed in Section 3.1.4, but click on the RTS button instead of NCR.
4. Respond to the original email letting the requester know we can support their RTS. Add DHL Resupply to ask them to place these parts on a Hot Truck to the warehouse.

5.2 PN Parts

PN parts are frequently requested for RTS, but it is rare that we are able to accommodate these requests. We typically transfer PN parts to the Manufacturing floor on an as-needed basis. However, in the event we are able to support this RTS, whether because more PN parts were ordered than necessary or a production order was cancelled by a customer, follow these steps to RTS the parts.

1. Start by going to **MD04** and search for the PN part requested for RTS.
2. To find the location of this part, double-click on the total stock count on the **1000** side of **MD04** and then press the STOCK OVERVIEW button on the pop-up window. This shows the current and on-order stock for this part.

Stock Overview: Basic List							
Selection		Stock Overview					
Material	714-143334-013	BRKT,SUPPORT,CDA LINE					
Material Type	COMP	Component Material					
Unit of Measure	EA	Base Unit of Measure					
Client/Company Code/Plant/Storage Location/Batch/Special Stock							
Full		Unrestricted use	Qual. inspection	Reserved	Rcpt reservation	On-Order Stock	Cor
2700 Lam Research Intl Sarl		5.000	22.000	9.000	9.000	9.000	
1000 Manufacturing Livermore		5.000	22.000	9.000	9.000	9.000	
0290 Fremont Eng Etch		4.000	13.000				
3150 CA31 LML		1.000		9.000			
9520 NR Staging			9.000			9.000	

Figure 5-1 This Stock Overview shows all stock of this part within the 1000 facility.

3. Right-click on the stock number in 3150 / 3250 and select the RESERVATIONS option.

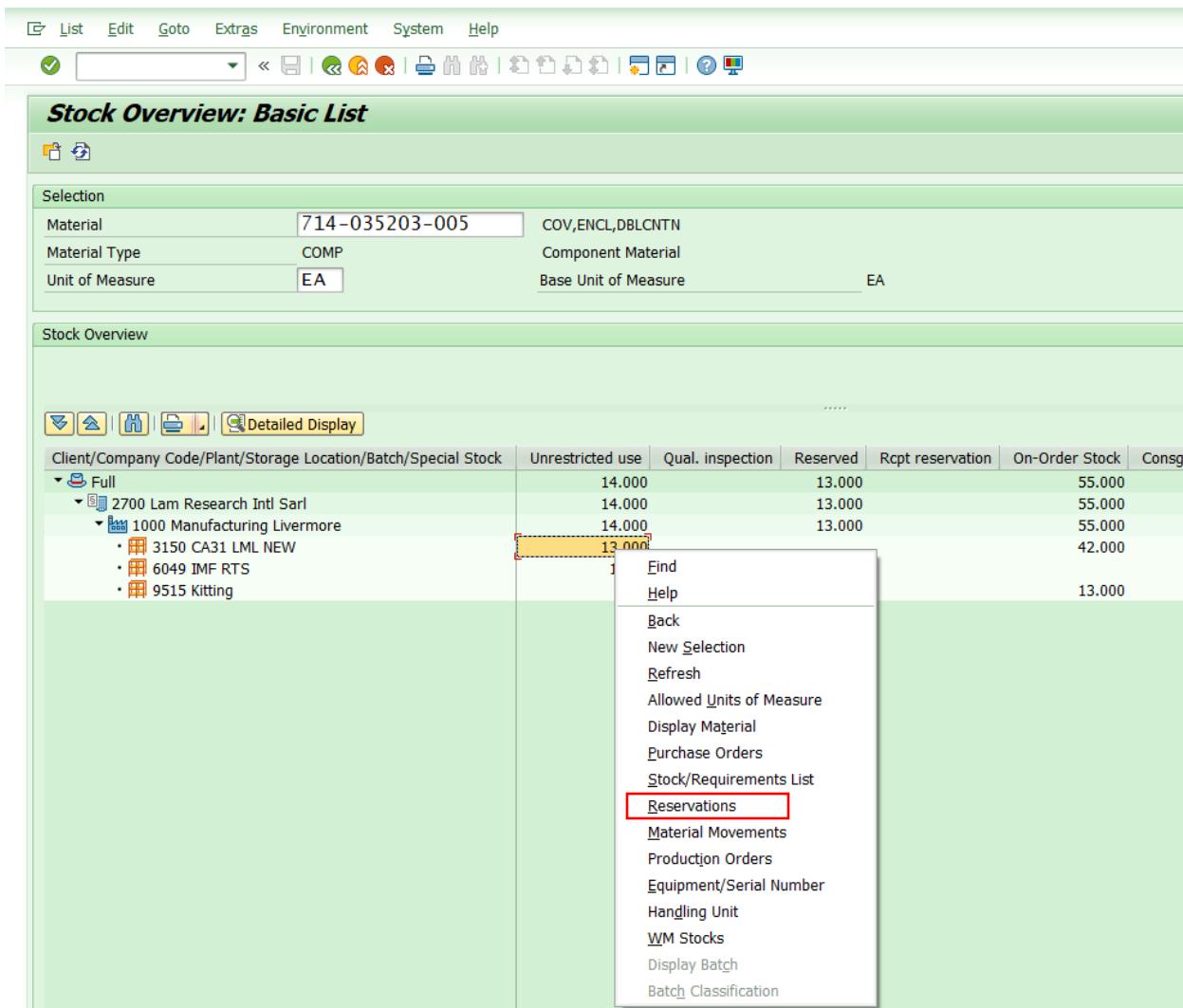


Figure 5-2 The option you need, Reservations, is marked with red.

4. This new page has all of the previous reservations that arrived for this part. Find a reservation that has the movement type (MvT) of 311 and copy the reservation number.

Reservation List Inventory Management																	
	Reserv.no.	Itm	Reqmts date	Mvt	D/C	Material	Reqmnt qty	RCa	Acct assgt	Del	RSt	Plant	SLoc	Recipient	RemovedQty	Text	Act User
	17455627	13	06/30/2021	311	H	714-143334-013	3.000	U	10003150	M	1000	9520	D5791/MULTI	0.000	571-800096-D5791B	MANTA	
	17446687	9	06/28/2021	311	H	714-143334-013	3.000	U	10003150	M	1000	9520	D2661/MULTI	0.000	571-800096-805	MANTA	
	17446431	13	06/25/2021	311	H	714-143334-013	3.000	U	10003150	M	1000	9520	D5789/MULTI	0.000	571-800096-D5789B	MANTA	
	17380512	9	06/21/2021	311	H	714-143334-013	3.000	U	10003150	M	1000	9520	D2647/MULTI	3.000	571-800096-805	MANTA	
	17380514	9		311	H	714-143334-013	3.000	U	10003150	M	1000	9520	D2653/MULTI	3.000	571-800096-805	MANTA	
	17232626	9	06/14/2021	311	H	714-143334-013	3.000	U	10003150	M	1000	9520	D2621/MULTI	3.000	571-800096-805	MANTA	
	17275033	10	06/07/2021	311	H	714-143334-013	3.000	U	10009371	M	1000	0290	SAF 000716...	3.000	RC:Del to 9371 for ...	CALIG...	
	17223355	10	06/02/2021	311	H	714-143334-013	3.000	U	10009371	M	1000	0290	SAF 000716...	3.000	RC:Del to 9371 for ...	CALIG...	
	17166698	10	05/24/2021	311	H	714-143334-013	3.000	U	10009371	M	1000	0290	SAF 71469	3.000		DERO...	
	17158172	10	05/21/2021	311	H	714-143334-013	3.000	U	10009371	M	1000	0290	SAF 000714...	3.000	RC:Del to 9371 for ...	CALIG...	
	17158182	10		311	H	714-143334-013	3.000	U	10009371	M	1000	0290	SAF 000714...	3.000	RC:Del to 9371 for ...	CALIG...	

Figure 5-3 Reservations with a movement type of 311 are ones that arrive in 3150/3250.

5. Create a new window for **ZR101** and put in the number like in Section 3.2.2.
6. This will take you to the RESERVATION ITEM STATUS page and you can now find the entry for the PN part you are searching for. Click the button marked DISPLAY RES.

Reservation Item Status										O								
<input style="border: 2px solid red; padding: 2px 10px; margin-right: 10px;" type="button" value="Display Res."/>		<input type="button" value="Change Res."/>		Stk/Reqmts (MFG)		Stk/Reqmts (WHS)		MRP Controller		<input type="button" value="Status Log"/>	O							
Reservation Item Status																		
Reservation : 0017380385			Req By			Req Date			00/00/0000 00:00:00									
Status : 																		
Item	Material	Descriptn	SLoc	MGr	Reqd	Issd	ZMAKE	ZQty										
0001	575-013640-438	CONFIG,RF CAR	9520	MN	6.00													
0002	575-043960-438	CONFIG,CHAMBE	9520	MN	6.00													
0003	575-800096-438	CONFIG, ASSY,	9520	MN	6.00													
0004	575-800325-348	CONFIG,BIAS A	9520	MN	6.00													
0005	853-802259-421	ASSY,COLLIMAT	9520	MN	6.00													

Figure 5-4 The Display Reservation button is marked with red.

7. Scroll through the list of part entries until you find the part you are searching for. Double-click the entry.

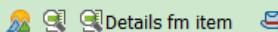
Display Reservation 0017380385 : Overview											
 Details fm item 											
Movement type		311	TF tfr. within plant								
Rcvg SLoc		3150									
Items											
Itm	Reqmnt qty	BUn	Material	PInt	SLoc	Batch	Mvt	PO Cre	Rqmnt date	FIs Del D/C	
	Qty withdrawn		Material Description								
1	6.000	EA	575-013640-438	1000	9520		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/> H	
		EA	CONFIG,RF CART ASSY,FLEX HX PLUS								
2	6.000	EA	575-043960-438	1000	9520		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/> H	
		EA	CONFIG,CHAMBER ASSY,FLEX HX PLUS								
3	6.000	EA	575-800096-438	1000	9520		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/> H	
		EA	CONFIG, ASSY,UP PL, FLEX HX PLUS								
4	6.000	EA	575-800325-348	1000	9520		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/> H	
		EA	CONFIG,BIAS ASSY, MU-METAL,FLEX HX PLUS								
5	6.000	EA	853-802259-421	1000	9520		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/> H	
		EA	ASSY,COLLIMATOR,OES,DCX LENS,ADJ GAP								

Figure 5-5 The individual parts that make up a reservation.

- Attached to the entry will be the location this part was delivered to.

Change Reservation 0017314931 : Details 0028 / 0028

◀ ▶ New item

Movement type	311	TF tfr. within plant
Plant	1000	Manufacturing Livermore
Material	839-800328-229	ESC,ITER, BTM, 300MM
Stor. location	3250 CA32 LML	
Quantity in		
Unit of entry	1.000	EA <input type="checkbox"/> Qty. is fixed
Stockkeepg.unit	1.000	EA
Further information		
Reqmts date	06/18/2021	<input type="checkbox"/> Final issue <input checked="" type="checkbox"/> Mvt allowed
Recipient	C9669/MULTI	Unload.pt. 03112
Text	571-800096-478	

Figure 5-6 The location a part is delivered to is marked with red.

9. Now that you have the location, you can contact the production line supervisor. Like in Section 5.1, ask them to check our on-hand stock for this part to see if we can support this RTS.
10. If parts are found and moved to the MRB room, create a new window and use the T-code **MB1B**.

Enter Transfer Posting: Initial Screen

New Item To Reservation... To Purchase Order... WM Parameters...

Document Date	06/24/2021	Posting Date	06/24/2021
Material Slip			
Defaults for Document Items			
Movement Type	344	Special Stock	<input type="checkbox"/>
Plant	1000	Reason for Movement	<input type="checkbox"/>
Storage Location	3149	<input type="checkbox"/> Suggest Zero Lines	
GR/GI Slip			
<input type="checkbox"/> Print	<input type="radio"/> Individual Slip <input type="radio"/> Indiv.Slip w.Inspect.Text <input checked="" type="radio"/> Collective Slip		

Figure 5-7 Main page of MB1B

11. MB1B is used when moving parts between different locations via differing movement types. In this instance, mark MOVEMENT TYPE as **344**. Write **3149** on the STORAGE LOCATION line if the specified part is found in 3150. Otherwise, write **3249** if 3250. Press ENTER.

Enter Transfer Posting: New Items

To Reservation... To Order... To Purchase Order...

Movement Type	344	TR blocked to unre.					
Iss. SLoc.	3150						
Items							
Item	Material	Quantity	UnE	SLoc	Batch	Re	Plnt
1	714-143334-013	1		3149			1000
2				3149			1000
3				3149			1000
4				3149			1000

Figure 5-8 Fill the values of the line as shown above. Make certain that SLoc is 3149 and Iss. SLoc is 3150.

12. Fill out the PART NUMBER and QUANTITY. Write **3150 / 3250** for the ISS. SLOC at the top. Double-click on the PART NUMBER.

Enter Transfer Posting: Details 0001 / 0001

◀ ▶ New Item Messages To Reservation... To Order... WM Details...

Movement Type	344	TR blocked to unre.		
Material	714-143334-013	BRKT,SUPPORT,CDA LINE		
Quantity in				
Unit of Entry	1.000	EA		
Plant	1000	Stor. Loc.	3149	
Account Assignment				
Text			Iss. SLoc.	3150

Figure 5-9 This is where you fill in specifics of why this part is needed for RTS.

13. On the TEXT line, copy and paste the subject line for the RTS request email. Press the SAVE button at the top of the page.

14. Now the part is ready for RTS. Email Resupply and ask them to put this part on a “hot truck”, which means a truck is meant to deliver the part as quickly as possible.

6 Production Cards

Printing out Production Cards is a simple procedure for PC. There are two production lines on the Manufacturing floor, lines 15 and 18, that are responsible for creating sub-assemblies that go onto the main product as a single part. When these sub-assemblies get used on the other production lines, the assemblers scan the bins as they would for other parts. Instead of creating an STO for this one sub-assembly, however, the SAP system will create STOs for the smaller parts going into the creation

of the sub-assembly and also generate a Production Card. One of the duties of PC is to print out these cards and take them down to the floor in a timely manner.

1. To print the newly generated Production Cards, use the T-code **ZIPKPRINT**. Near the top of the window, make sure cards are being printed for both **3150** and **3250**. Also write **Z500** on the line marked PRINTER. This is the printer in the PC work area. After that, click the EXECUTE button to begin printing the Production Cards.

Storage locatio/Material due Labels					
Location					
Issuing Storage Location	3150	to	3250		
Repeat print options					
<input type="checkbox"/> Re-print					
<input checked="" type="radio"/> Demand					
<input type="radio"/> Internal					
Plant	1000	to			
Material Number		to			
Sales Order		to			
Serial Number		to			
Counter		to			
Control Cycle Number		to			
Print Date		to			
Printing options					
Printer	z500				

Figure 6-1 Main page for ZIPKPRINT.

2. When the printing is complete, the Production Card stickers must be placed onto laminated cards by hand. Make note that there are likely

different types of Production Cards in a single batch. Not only will they need to be sent to different production lines, but they could be for different types of parts as well.

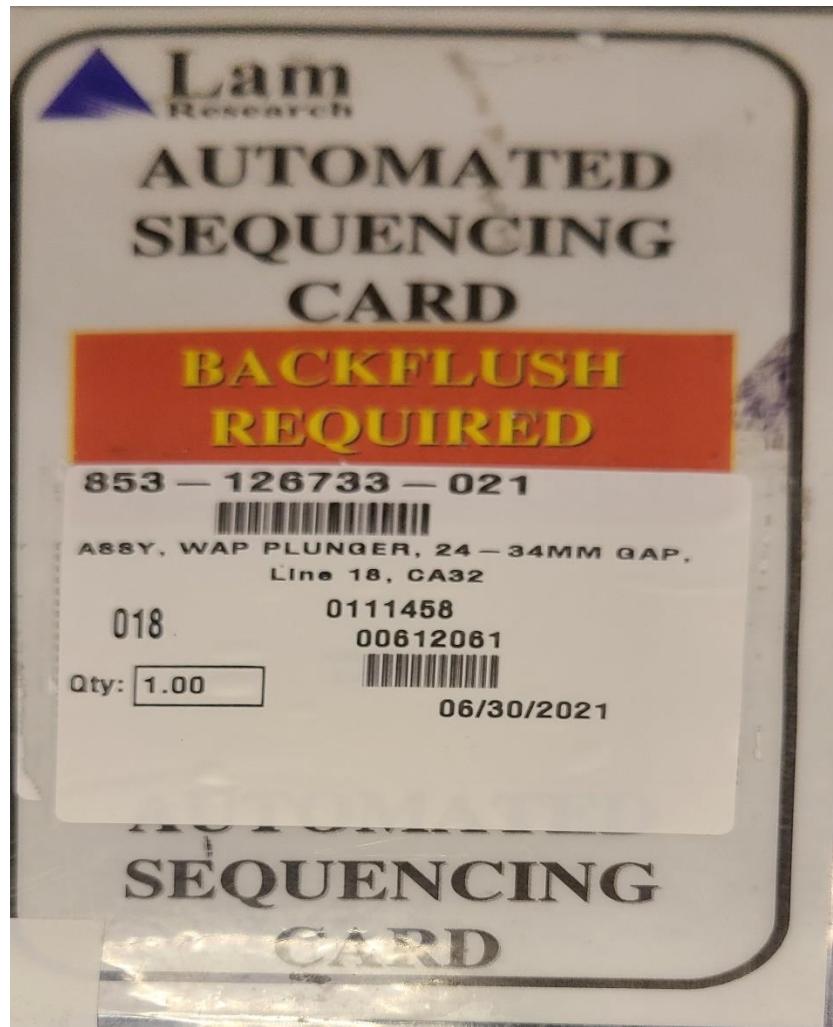


Figure 6-2 This is a White Card with a corresponding Production Card stuck on.

3. Make note of the difference between the cards below.

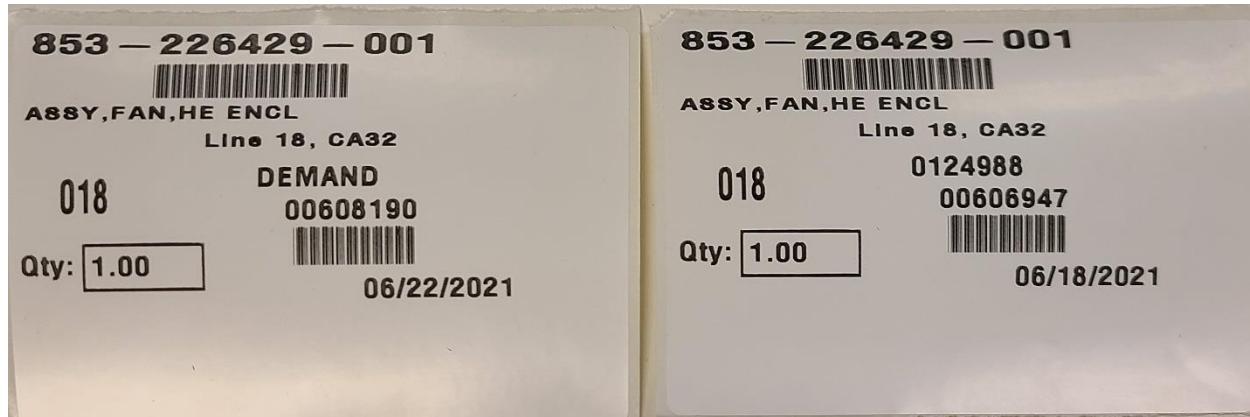


Figure 6-3 The card on the left is a Yellow Card and is marked DEMAND. The card on the right is a White Card and just has an ID number.

- A Yellow Card means the subassembly that is built will be going somewhere different than the Manufacturing floor.
 - White Cards are sub-assemblies that are used on the Manufacturing floor.
4. When all the stickers are placed on cards, contact the supervisors who are in charge of the specified lines. Make arrangements with them to meet at one of the Decontamination rooms downstairs and hand these cards over to them.

7 Backflushing

When a product is complete, it is moved off the Manufacturing floor into a Decontamination room, where it is prepared for shipping. There is one final step before it can be shipped, though. A member of the Lam team on the loading dock makes note of the product's unique serial number and emails it to the PC team to be backflushed.

Backflushing is the process where all of the parts that have gone into the assembly of this product are accounted for and deleted from the 1000 inventory. These backflushes must be done in a specific order, as shown by the table below.

Table 7-1 Work Center values and their corresponding Backflush Types

Work Center ((WC))	Backflush Type ((BT))
08	TOPPLATE
14	PUMPCRT
31	BIASELTRD
32	CHAMBER
01	MODULE

For the below steps, follow down the left column, adding the specified work center where you see **((WC))** and the corresponding backflush type where you see **((BT))**.

To give a step-by-step example, we will use the serial number **FLGL-116** as an example.

1. To start, you will need to use the T-code **ZR151**. When you get to this new page, type **1000** on the PLANT line and then copy the above serial number on the line marked SERIAL NUMBER. Press ENTER.

Delete IPK Intransit table entry

Plant: 1000 to []

Material: [] to []

Receiving location: [] to []

Sales Order: [] to []

Sales Item: [] to []

FCID: [] to []

Serial Number: FLGL-116 to []

Additional parameters

Work Center: [] to []

Print date: [] to []

Selection

All

Material Part Filter: []

Only Spares

Others

History Only

Figure 7-1 Main page for ZR151.

2. You are now showing the major assemblies that add up into a completed product.

Delete IPK Intransit table entry

	Material	Counter	ContrCyc	Qty	Plant	SLOC	RcLoc	WrkCtr	CreateBy	CreateDt	PrintDt	MtGrp	Sales Ord	Sales Item	FCID	Ser Num	Order	Supply Area	Start Date	Comp Date	Comp Time	Comp By
<input type="checkbox"/>	571-800096-433	591217	INTERNAL	1.000	1000	3150	3150	001	MANTA	05/03/2021	05/03/2021	MN D1942	170 200303	FLGL-116	00112	05/10/2021		00:00:00				
<input type="checkbox"/>	575-013640-433	591223	INTERNAL	1.000	1000	3150	3150	014	MANTA	05/03/2021	05/03/2021	MN D1942	170 200303	FLGL-116	00117	05/10/2021		00:00:00				
<input type="checkbox"/>	575-043960-433	591224	INTERNAL	1.000	1000	3150	3150	032	MANTA	05/03/2021	05/03/2021	MN D1942	170 200303	FLGL-116	00101	05/10/2021		00:00:00				
<input type="checkbox"/>	575-800096-433	591218	TRANSFER	1.000	1000	3150	3250	008	MANTA	05/03/2021	05/03/2021	MN D1942	170 200303	FLGL-116	00112	05/10/2021		00:00:00				
<input type="checkbox"/>	575-800325-445	591222	TRANSFER	1.000	1000	3150	3250	031	MANTA	05/03/2021	05/03/2021	MN D1942	170 200303	FLGL-116	00108	05/10/2021		00:00:00				

Figure 7-2 The active cards corresponding with the Serial Number above.

3. Create a new window and use the T-code **ZR218**. Type **3150** on the line labeled SLOC, but don't add anything else for the moment. You will need both this page and the previous **ZR151** to complete this task. Find the row on **ZR151** that has the number matching **((WT))** in the WRKCTR column.

One by one, copy the SALES ORD, SALES ITEM, and COUNTER from **ZR151** and paste them on the corresponding lines on **ZR218** (the COUNTER goes on the line marked CONTROL NUMBER). On the final line marked BACKFLUSH TYPE, type in **((BT))**. Click EXECUTE.

Process Production Orders from a Sales Order

Sales Order	D1942
Item	170
Planned Order	
Plant	1000
To Location	3150
Control Number	591218
Backflush Type	TOPPLATE

Figure 7-3 Main page of ZR218.

4. Scroll through the list of assembly numbers until you find the number that matches the row you were working with on **ZR151**.

Delete IPK Intransit table entry

	Material	Counter	ContrCyc	Qty	Plant	SLOC	RcLoc	WrkCtr	CreateBy	CreateDt	PrintDt	MtGrp	Sales Ord	Sales Item	FCID	Ser Num	Order	Supply Area	Start Date	Comp Date	Comp Time	Comp By
<input type="checkbox"/>	571-800096-433	591217	INTERNAL	1.000	1000	3150	3150	001	MANTA	05/03/2021	05/03/2021	MN	D1942	170	200303	FLGL-116	00112	05/10/2021	00:00:00			
<input type="checkbox"/>	575-013640-433	591223	INTERNAL	1.000	1000	3150	3150	014	MANTA	05/03/2021	05/03/2021	MN	D1942	170	200303	FLGL-116	00117	05/10/2021	00:00:00			
<input type="checkbox"/>	575-043960-433	591224	INTERNAL	1.000	1000	3150	3150	032	MANTA	05/03/2021	05/03/2021	MN	D1942	170	200303	FLGL-116	00101	05/10/2021	00:00:00			
<input checked="" type="checkbox"/>	575-800096-433	591218	TRANSFER	1.000	1000	3150	3250	008	MANTA	05/03/2021	05/03/2021	MN	D1942	170	200303	FLGL-116	00112	05/10/2021	00:00:00			
<input type="checkbox"/>	575-800325-445	591222	TRANSFER	1.000	1000	3150	3250	031	MANTA	05/03/2021	05/03/2021	MN	D1942	170	200303	FLGL-116	00108	05/10/2021	00:00:00			

Figure 7-4 Pay attention to the row with a WrkCtr value that matches **(WC)**.

MAKE ABSOLUTELY CERTAIN THEY MATCH.

Press ENTER.

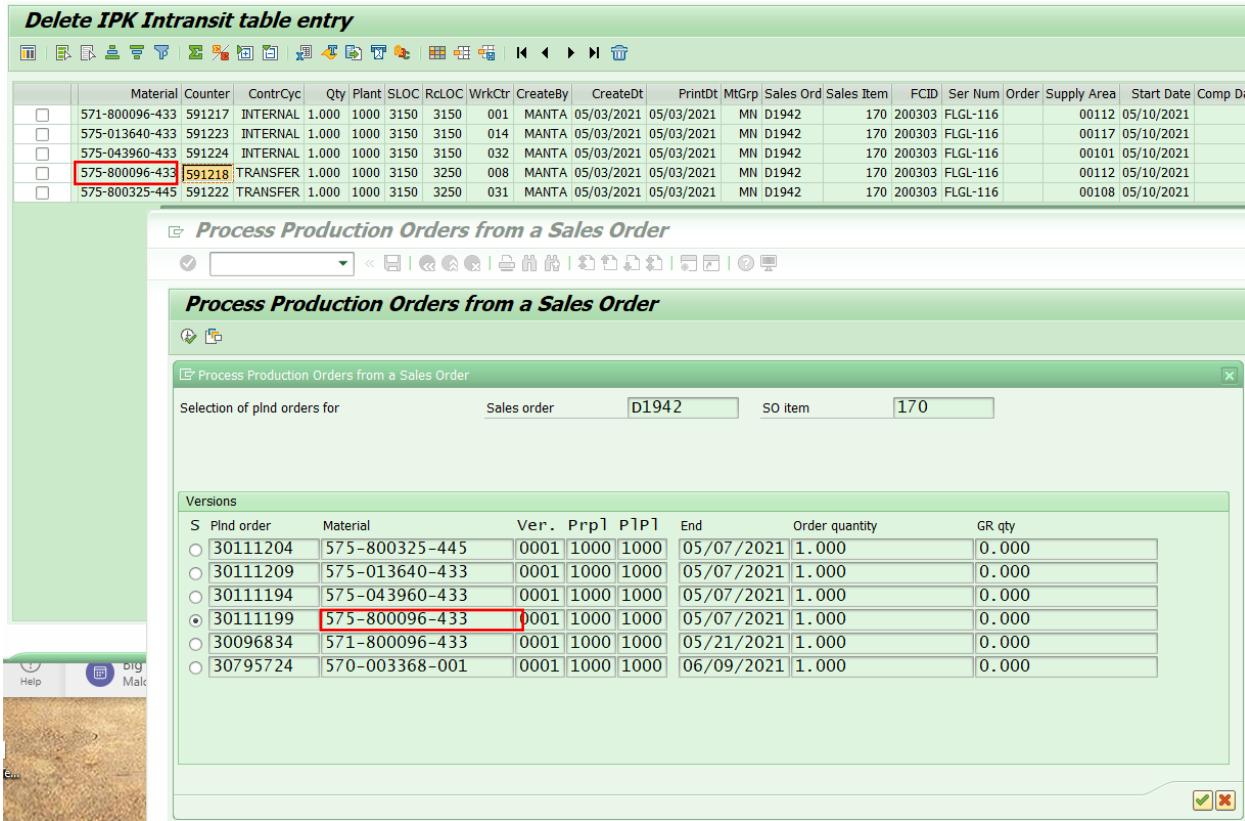


Figure 7-5 Make sure both numbers marked in red are matching when you select them.

5. When the screen changes, press the button marked PROD ORD and press YES on the window that pops up. Wait a few moments for the system to complete the action and take you back to the original **ZR218** screen.

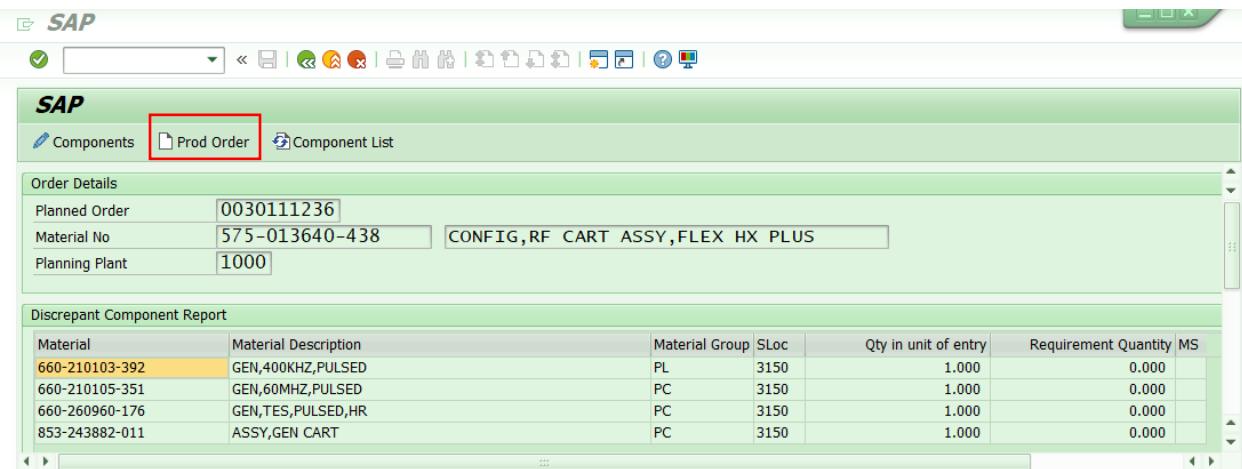


Figure 7-6 The Prod Order is marked with red.

6. Delete the information on the lines marked PLANNED ORDER, CONTROL NUMBER, and BACKFLUSH TYPE.
7. Repeat steps 4 through 7 for all items, but make certain you are performing the actions in the order shown in Table 7-1. If there are any items that do not match with this table, consult with your supervisor.

When the last item is processed, your backflush has now been completed.

Appendix

Important T-codes:

- MD04 – Stock/Requirements List
 - Used to verify part inventory and expedite upcoming STOs.
- ZR269 – Bin Status Report
 - Used to check bins and find Counter numbers.
- ME27 – Create Purchase Order
 - Used to create new STOs.
- ZR101 – PO Status Report
 - Used to check on the status of reservations and create part entries.
- Z026 – Grouping ABAP 2
 - Used to generate new STOs for parts added to reservations.
- ZRWAVE01 – Wave Report of Manufacturing
 - Used to find the status of shipments to 1000 and to expedite freestock parts.
- MMBE – Stock Overview
 - Used to check part inventory across all Lam facilities.
- ZR261 – KANBAN Bin Scan
 - Used to RTS and log replacements for PL and PC parts.
- MB1B – Enter Transfer Posting
 - Used to mark parts for transfer between facilities.

- ZIPKPRINT – Storage location/Material due Labels
 - Used to print new production cards.
- ZR151 – Delete IPK Intransit table entry
 - Used for performing backflushes.
- ZR218 – Process Production Orders from a Sales Order
 - Used for performing backflushes.

Glossary

C

Control Cycle – A number referring to the bin a specific part is stored in. Used to create new shipments.

D

DHL – The logistics and courier company that is in charge of moving our parts between facilities.

F

F Parts – Freestock parts; things like screws and caps that are cheap to replace and are delivered in large quantities.

FCID – an identifying number that refers to a specific product currently being built.

H

Hot Orders – A division of Lam Research that is responsible for transferring parts between facilities to cover demands or to repair customer machines.

I

Inventory Control – A division of DHL that keeps inventory of warehouse 2000.

M

Manufacturing floor – The main production area of Lam facility 1000.

N

NCI – An identifying number that is used when a part has been damaged and is in need of a replacement.

P

Picking

PL / PC Parts

PN Parts

Purchase Order

Production Control

Production Line

PulseSecure

R

Receiving

Reservation

Resupply

RTS

S

SAP

Spares

Stock Transfer Order (STO)

T

Transaction codes (T-codes)

W

White Card

Y

Yellow Card

Index

C

Card · 47, 48, 49, 58

D

DHL · 4, 5, 32, 33, 39, 57

E

expedited
 expedite · 6, 15, 30

F

FCID · 21, 22, 57
Freestock · 31

H

Hot Orders · 5, 33, 38, 39, 57

I

Inventory Control · 5, 31, 32, 57

M

MB1B · 44, 45, 55
MD04 · 7, 12, 15, 19, 23, 24, 26, 30, 31, 33, 40, 55
ME27 · 16, 17, 55
MMBE · 36, 37, 55

N

NCI · 19, 20, 30, 31, 57

P

PC · 6, 10, 21, 30, 38, 39, 46, 47, 49, 55, 57
Picking · 5, 33, 57
PL · 10, 21, 30, 39, 55, 57
PN · 10, 21, 30, 40, 42, 57
Production Control · ii, 58
PulseSecure · 1, 58
Purchase Order · 55, 58

R

Receiving · 5, 58
reservation · 21, 22, 23, 24, 25, 26, 28, 29, 41, 43
Reservation · 22, 26, 42, 58
Resupply · 5, 39, 46, 58
RTS · 38, 39, 40, 44, 46, 55, 58

S

SLoc · 11, 45
Spares · 4, 33, 58
STO · 6, 12, 13, 14, 15, 17, 18, 19, 21, 23, 26, 29, 30, 31, 46,
 58
STOCK / REQUIREMENTS LIST · 7, 11

T

T-code · 7, 15, 16, 20, 24, 25, 29, 32, 36, 39, 44, 47, 50, 51

Z

Z026 · 29, 30, 55
ZIPPRINT · 47, 56
ZR101 · 24, 26, 42, 55
ZR151 · 50, 51, 52, 56
ZR218 · 51, 52, 53, 56
ZR261 · 20, 55
ZR269 · 15, 20, 39, 55
ZRWAVE01 · 32, 55