



Pilot Plant

MES PLANNING TOOL / PO BUILDING

HOW TO SCHEDULE Production Orders?

Schedule

PO

Insp

Start

08/28/2018

End

08/31/2018

Select → Date Ranges (mm/dd/yyyy)

≡ Schedule ≡

PO Template

flavored string nuggets_1

Version

1

INSPLot

20415

INSPLVersion

PO Material

100002947

Insp Material

100402508

#1 Select → ProductionOrder

#2 Select → InspectionLot

ProductionOrder	Material	QTY	POID	Insp	SP	SPDesc	PO
Olivers string_1	100002947	100 0000000000	1206	20415TEST_5	100402508	BASE CHZ PILOT PLAN1	20415
flavored string nuggets_1	100002947	100 0000000000	1205	20415_4	100402508	BASE CHZ PILOT PLAN1	20415
flavored string nuggets_1	100002947	100 0000000000	1204	20415_3	100402508	BASE CHZ PILOT PLAN1	20415
PH w- Starch blend_1	100402508	100 0000000000	1203	20415	100402508	BASE CHZ PILOT PLAN1	20415
PH w-Starch blend_1	100402508	100 0000000000	1202	20414	100402508	BASE CHZ PILOT PLAN1	20414

Total Items: 1207 (Selected Items: 1)

Total Items: 1202 (Selected Items: 1)

Schedule History

POID	INSPLotId	SDate	EndDate	POTempId
1535465075784	1535465075784	2018-08-30	2018-08-30	PH w- Starch b
1535465075783	1535465075783	2018-08-29	2018-08-29	PH w- Starch b



Schedule from PO and INSP Predefined Templates

#1 Select ⇒ ProductionOrder

Step#1

Select PO Template

Step#2

Select INSP LOT Template

#2 Select ⇒ InspectionLot

Insp	SP	SPDesc	PO	ID
20415TEST_5	100402508	BASE CHZ PILOT PLAN1	20415	1202
20415_4	100402508	BASE CHZ PILOT PLAN1	20415	1201
20415_3	100402508	BASE CHZ PILOT PLAN1	20415	1200
20415	100402508	BASE CHZ PILOT PLAN1	20415	1199
20414	100402508	BASE CHZ PILOT PLAN1	20414	1198

Step#3

Select Start and End and Schedule

Start: 08/28/2018 End: mm/dd/yyyy

PO Template: flavored string nuggets_1 Version: 100002

PO Material: 100002

August, 2018

Sun	Mon	Tue	Wed	Thu	Fri
29	30	31	1	2	3
5	6	7	8	9	10
12	13	14	15	16	17
19	20	21	22	23	24
26	27	28	29	30	31



Schedule from History

flavored string nuggets_1	1	20415	3
PO Material: 100002947		Insp Material: 100402508	
#1 Select ⇒ ProductionOrder		#2 Select ⇒ InspectionLot	
ProductionOrder	Material	QTY	POID
OLivers string_1	100002947	100.0000000000	1206
flavored string nuggets_1	100002947	100.0000000000	1205
flavored string nuggets_1	100002947	100.0000000000	1204
PH w- Starch blend_1	100402508	100.0000000000	1203
PH w-Starch blend_1	100402508	100.0000000000	1202
Total Items: 1207 (Selected Items: 1)		Total Items: 1202 (Selected Items: 1)	

Step#1

Select a processed PO template from the history grid

Schedule History			
PO#	INSPLot#	StDate	POTempl
1535465075784	1535465075784	2018-08-30	PH w- Starch blend_1
1535465075783	1535465075783	2018-08-29	PH w- Starch blend_1

Step#2

Select Start and End Date and Schedule

Start: 08/28/2018 End: mm/dd/yyyy

#3 Select ⇒ Date Ranges ()

POTemplate: flavored string nuggets_1 Version: 100002

INSPLot: 204 Insp Ma

August, 2018

Sun	Mon	Tue	Wed	Thu	Fri	Sat
29	30	31	1	2	3	4
5	6	7	8	9	10	11
12	13	14	15	16	17	18
19	20	21	22	23	24	25



Schedule Inspection LOT for Dairy Liquid Receiving (Internal2165i)

Step#1

Check
Internal2165i

Start.
mm/dd/yyyy

End.
mm/dd/yyyy

≡Schedule≡

≡ Internal2165i

Step#2

Select INSP LOT
Template

#2 Select ⇒ InspectionLot

Insp	SP	SPDesc	PO	ID
20415TEST_5	100402508	BASE CHZ PILOT PLAN1	20415	1202
20415_4	100402508	BASE CHZ PILOT PLAN1	20415	1201
20415_3	100402508	BASE CHZ PILOT PLAN1	20415	1200
20415	100402508	BASE CHZ PILOT PLAN1	20415	1199
20414	100402508	BASE CHZ PILOT PLAN1	20414	1198

Step#3

Select Start and End Date and
Schedule

Start.
08/28/2018

End.
mm/dd/yyyy

POTemplate.

flavored string nuggets_1

Version.

PO Material.

100002

#3 Select ⇒ Date Ranges (mm/dd/yyyy)

August, 2018

Sun	Mon	Tue	Wed	Th
29	30	31	1	
5	6	7	8	9
12	13	14	15	16
19	20	21	22	23



HOW TO CREATE/EDIT Templates?

ProductionOrderTemplate

PO PO

ProductionOrder	Material	QTY	Storage Location Description	Fat Print Ratio	Milk Protein	Milk Fat
WPC Powder - Master_1	100002948	100 0000000000	1100	0.0000000000	0.0000000000	0.0000000000
Shmg - Master_1	100002947	600 0000000000	1100	0.0200000000	0.0200000000	0.0400000000
Starter Probiotic - Master_1	100401755	100 0000000000	1100	0.0000000000	0.0000000000	0.0000000000
Starter RC - Master_1	100401757	100 0000000000	1100	0.0000000000	0.0000000000	0.0000000000
Refresh - Master_1	100400074	500 0000000000	1100	0.0000000000	0.0000000000	0.0000000000
Q.C. - Master_1	100002945	500 0000000000	1100	0.0200000000	0.0300000000	0.0400000000

Total Items: 11 (Selected Items: 1)

BOM Position

PO	BOM Pos	Mat	QTY	Op	Str	St Desc	Routing	WC	Op TXT	CO Prod Log
Refresh -	10	100400001	1	0150	1115	REFIN	0150	REFIN.1	Refresh	0
Refresh -	20	200000101	1	0150	1115	REFIN	0150	REFIN.1	Refresh	0

Total Items: 50

Specifications

PO	Name	Value	Lower	Upper	DCP Gr	Material
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Total Items: 0

InspectionLotTemplate

InspectionLot Insp SP SP Desc PO ID

WPC Powder - Master_1	100002948	WPC 80 Pilot Plant	WPC Powder - Master_1	1
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Total Items: 1 (Selected Items: 1)

InspectionLot Attributes

InspectionLot	Attribute	Grp	Rank	El Gr	Analysis	Test Req	Last LCM	URL	Targ	L SL	SP
PROTE...	Protes...	10	None	X INDIV	1	None	0	0	0	0	3

Total Items: 1

InspectionLot Attribute Group

InspectionLot	AttributeGroupName	AutoGenerate SampleID	SP
	Baghouse Fines	1	
	Protein Dryer Bin	1	

Total Items: 12



EDIT PO and Inspection LOT Templates

Edit

P
O

ProductionOrder	Material	QTY	Storage Location Rec
Olivers string_1	100002947	100.0000000000	1100
flavored string nuggets_1	100002947	100.0000000000	1100
flavored string nuggets_1	100002947	100.0000000000	0
PH w- Starch blend_1	100402508	100.0000000000	1100

Total Items: 1207 (Selected Items: 1)

PONumber.

flavored string nuggets

Version.

1

Material.

100002947

POID.

1204

QTY.

100.0000000000

NumVats.

21

StorageLoc.

FATProtRatio.

0.0200000000

StkFat.

0.0300000000

StkFat.

0.0400000000

SetPH.

6.6000000000

RefFactor.

0.8500000000

Moisture.

0.5300000000

Salt.

0.0300000000

Fat.

0.4500000000

pH.

5.3000000000

New Template

• ClearAll •

• Delete •

Save

Edit

I
N
S
P

Insp	SP	SPDesc
20415TEST_5	100402508	BASE CHZ PILOT PLANT
20415_4	100402508	BASE CHZ PILOT PLANT
20415_3	100402508	BASE CHZ PILOT PLANT
20415	100402508	BASE CHZ PILOT PLANT
20414	100402508	BASE CHZ PILOT PLANT

InspectionLot

20415

Insp.Version

3

SPDesc

BASE CHZ PILOT PLANT

ProductionOrder

20415

Select

SpecificationName

100402508

Specification_ID

1200

New Template

• ClearAll •

• Delete •

Save

Screen Controls-

New Template: Creates a PO and InspectionLOT template

Clear All: Clear all Fields

Delete: Delete Selected Record

Save: Save Changes



EDIT SPEC, Attribute and AttrGroup

Edit

PO	BOMPos	Mat	QTY	Op	Stor	StDesc	Routing	WC	OpTXT	COPRODFlag
10332	110	200001131	1	10	1100	S-STARTER	10	STRC	Starter	
10332	120	200001172	1	10	1100	S-STARTER	10	STRC	Starter	

Total Items: 10182 (Selected Items: 1)

Scope: The following applies to edit BOM-Items, Specifications, Attributes for Inspection Lots and Attribute groups.

Edit BOM Position.

BOMPosition:	120	CompMaterial:	200001172	ComponentQTY:	1
OpAssign:	0020-VATL1	StorageLocation:	1100	StartLocDesc:	S-STARTER
RoutingOperation:	0040-CFGPL1	WorkCenter:	STRC	ShortText:	Starter
CoProductFlag:		NumVessels:	1	POId:	110
Selected PO:	flavored string nuggets_1				

[New BOM](#)
[AssignToCurrent](#)
[ClearAll](#)
[Delete](#)

Screen Controls-

New : Creates a BOM, Spec, Attribute and AttributeGroup.

AssignToCurrent: Take any item from the Grid and assign to the select PO or Inspection LOT.

Clear All: Clear all Fields

Delete: Delete Selected Record

Save: Save Changes

Grid Sorting:

Each grid will display associated items with PO or InspectionLots up on top

Same process applies to screens below

Insplot	Attribute	Grp	Back	FLGr	Analysis	Tooling	UnitID	U/L	Targ	U/L	SP
30309	RENIN	VAT	50	D-OK	X IND	1	0	0	0	0	03
30309	ON SE	VAT	0	X IND	0	MIN	30	0	10	0	03

Total Items: 6970 (Selected Items: 1)

Edit InspectionLot Attributes

Attribute Name	RENNET ADD	Attribute Title	RENNET ADD	Attribute Group	VAT RENNET A
Analysis Name	D-OK-NOK	Analysis Title	X INDIVIDUAL	Inspection Group	1
Unit		Target	0	Unit	
Unit	20	Spec	70000131	Unit	0
Operation	Vat	Work Center	VATL1	Display Digit	0
Recording Type	Q65	Auto Line	0	Specification ID	1

[New Attribute](#)
[AssignToCurrent](#)
[ClearAll](#)
[Delete](#)

Insplot	AttributeGroup Name	AutoGenerate SampleID	SP
30309	CHEM-VAT MILK	3	
30309	CHEM-VAT WHEY	3	

Total Items: 23713 (Selected Items: 1)

Edit InspectionLot Attribute Group

Attribute Group Name	CHEM-VAT WHEY	Attribute Group Desc	CHEM-VAT WHEY
AutoGenerate SampleID	3	Specification ID	1
Selected Insplot	20415_3		

PO	Name	Value	Lower	Upper	DOPGr	Material
50309	NIR MOJO AV	40.5	40.0	44.0	CM-D	100401178
50309	MOISTURE	52.50	51.00	54.00	CM-DR	100001469

Total Items: 4607 (Selected Items: 1)

Edit Specification.

Name	NIR MOJO AVERAGE	Value	40.5000000000	Lower	40.0000000000
Upper	44.0000000000	DOPGroup	CM-DRYMIX	Material	100401178
Spec ID	236	PO ID	2033	Selected PO:	PH w-Starc

[New Spec](#)
[AssignToCurrent](#)
[ClearAll](#)