

R11i Setting Up & Implementing WIP

Student Guide

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Preface

Profile

Before You Begin This Course

Before you begin this course, you should have the following qualifications:

- Thorough knowledge of work in process and discrete manufacturing
- Working experience with Oracle Applications

Prerequisites

- There are no prerequisites for this course.

How This Course Is Organized

This is an instructor-led course featuring lecture and hands-on exercises. Online demonstrations and written practice sessions reinforce the concepts and skills introduced.

Related Publications

Oracle Publications

Title	Part Number
Oracle Work in Process User's Guide	A83598-01

Additional Publications

- System release bulletins
- Installation and user's guides
- *read.me* files
- *Oracle Magazine*

Typographic Conventions

Typographic Conventions in Text

Convention	Element	Example
Bold italic	Glossary term (if there is a glossary)	The <i>algorithm</i> inserts the new key.
Caps and lowercase	Buttons, check boxes, triggers, windows	Click the Executable button. Select the Can't Delete Card check box. Assign a When-Validate-Item trigger to the ORD block. Open the Master Schedule window.
Courier new, case sensitive (default is lowercase)	Code output, directory names, filenames, passwords, pathnames, URLs, user input, usernames	Code output: <code>debug.set ('I", 300);</code> Directory: <code>bin (DOS), \$FMHOME (UNIX)</code> Filename: Locate the <code>init.ora</code> file. Password: User <code>tiger</code> as your password. Pathname: Open <code>c:\my_docs\projects</code> URL: Go to <code>http://www.oracle.com</code> User input: Enter <code>300</code> Username: Log on as <code>scott</code>
Initial cap	Graphics labels (unless the term is a proper noun)	Customer address (<i>but</i> Oracle Payables)
Italic	Emphasized words and phrases, titles of books and courses, variables	Do <i>not</i> save changes to the database. For further information, see <i>Oracle7 Server SQL Language Reference Manual</i> . Enter <code>user_id@us.oracle.com</code> , where <i>user id</i> is the name of the user.
Quotation marks	Interface elements with long names that have only initial caps; lesson and chapter titles in cross-references	Select "Include a reusable module component" and click Finish. This subject is covered in Unit II, Lesson 3, "Working with Objects."
Uppercase	SQL column names, commands, functions, schemas, table names	Use the SELECT command to view information stored in the LAST_NAME column of the EMP table.

Convention	Element	Example
Arrow	Menu paths	Select File→ Save.

Brackets	Key names	Press [Enter].
Commas	Key sequences	Press and release keys one at a time: [Alternate], [F], [D]
Plus signs	Key combinations	Press and hold these keys simultaneously: [Ctrl]+[Alt]+[Del]

Typographic Conventions in Code

Convention	Element	Example
Caps and lowercase	Oracle Forms triggers	When-Validate-Item
Lowercase	Column names, table names	SELECT last_name FROM s_emp;
	Passwords	DROP USER scott IDENTIFIED BY tiger;
	PL/SQL objects	OG_ACTIVATE_LAYER (OG_GET_LAYER (`prod_pie_layer`))
Lowercase italic	Syntax variables	CREATE ROLE <i>role</i>
Uppercase	SQL commands and functions	SELECT userid FROM emp;

Typographic Conventions in Navigation Paths

This course uses simplified navigation paths, such as the following example, to direct you through Oracle Applications.

(N) Invoice > Entry > Invoice Batches Summary (M) Query > Find (B) Approve

This simplified path translates to the following:

1. (N) From the Navigator window, select Invoice > Entry > Invoice Batches Summary.
2. (M) From the menu, select Query > Find.
3. (B) Click the Approve button.

Notations :

(N) = Navigator

(M) = Menu

(T) = Tab

(I) = Icon

(H) = Hyperlink

(B) = Button

Typographical Conventions in Help System Paths

This course uses a “navigation path” convention to represent actions you perform to find pertinent information in the Oracle Applications Help System.

The following help navigation path, for example—

(Help) General Ledger > Journals > Enter Journals

—represents the following sequence of actions:

1. In the navigation frame of the help system window, expand the General Ledger entry.
2. Under the General Ledger entry, expand Journals.
3. Under Journals, select Enter Journals.
4. Review the Enter Journals topic that appears in the document frame of the help system window.

Getting Help

Oracle Applications provides you with a complete online help facility.

Whenever you need assistance, simply choose an item from the Help menu to pinpoint the type of information you want.

To display help for a current window:

1. Choose Window Help from the Help menu, click the Help button on the toolbar, or hold down the Control key and type 'h'.

A web browser window appears, containing search and navigation frames on the left, and a frame that displays help documents on the right.

The document frame provides information on the window containing the cursor. The navigation frame displays the top-level topics for your responsibility, arranged in a tree control.

2. If the document frame contains a list of topics associated with the window, click on a topic of interest to display more detailed information.

3. You can navigate to other topics of interest in the help system, or choose Close from your web browser's File menu to close help.

Searching for Help

You can perform a search to find the Oracle Applications help information you want. Simply enter your query in the text field located in the top-left frame of the browser window when viewing help, then click the adjacent Find button.

A list of titles, ranked by relevance and linked to the documents in question, is returned from your search in the right-hand document frame. Click on whichever title seems to best answer your needs to display the complete document in this frame. If the document doesn't fully answer your questions, use your browser's Back button to return to the list of titles and try another.

R11i Setting Up & Implementing WIP

Chapter 1

R11i Setting Up & Implementing Work in Process

R11i/WIP

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Objectives

After completing this course you should be able to do the following:

- Describe the setup prerequisites.
- Define WIP Parameters.
- Set profile options.
- Execute the Setup for Work in Process.

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Agenda

Agenda

- **Overview of Setting Up**
- **WIP Parameters**
- **WIP Accounting Classes**
- **Shop Floor Statuses**
- **Schedule Groups**
- **Labor Rates**
- **Production Lines**
- **Standard Documents**
- **Profile Options**
- **Summary**

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Overview

Before you set up Oracle Work in Process, you should:

- Set up an Oracle Applications System Administrator responsibility.
- Set up Oracle Inventory.



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Overview of Implementation Wizard

Overview of Implementation Wizard

- If you are implementing more than one Oracle Applications product, you may want to use the Oracle Applications Implementation Wizard to coordinate your setup activities.
- The Implementation Wizard guides you through the setup steps for the applications you have installed, suggesting a logical sequence that satisfies cross-product implementation dependencies and reduces redundant setup steps.
- You can use the Wizard to see a graphical overview of setup steps, read online help, and open the appropriate setup window.

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You can use the Implementation Wizard as a resource center to see a graphical overview of setup steps, read on-line help for a setup activity and open the appropriate setup window. You can also document your implementation, for further reference and review, by using the Wizard to record comments for each step.

Overview of Setup Prerequisites

Overview of Setup Prerequisites

Before you set up Work in Process you must complete the setup for the following products:

- **Oracle Inventory** (see Oracle Inventory User's Guide)
- **Oracle Bills of Material** (see Oracle Bills of Material User's Guide)

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Optionally you may set up the following products:

Oracle Cost Management (see Oracle Cost Management User's Guide)

Oracle Project Manufacturing (see Oracle Project Manufacturing User's Guide)

Oracle Workflow (see Oracle Workflow User's Guide)

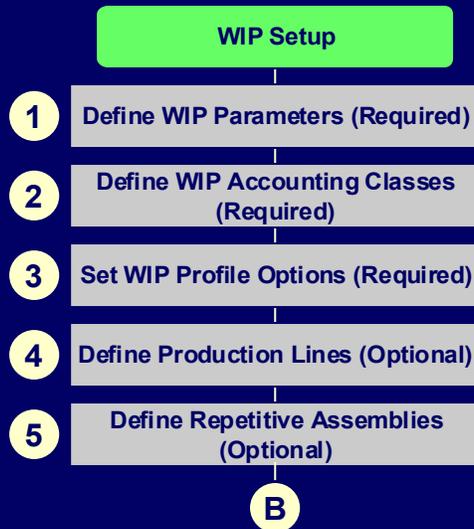
Oracle iSupplier Portal (see Oracle iSupplier Portal Implementation Manual)

Oracle Engineering (see Oracle Engineering User's Guide)

Oracle MRP/Master Scheduling and Supply Chain Planning (see Oracle MRP/Master Scheduling and Oracle Supply Chain Planning User's Guide)

Oracle Quality (see Oracle Quality User's Guide)

WIP Setup Flowchart



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WIP Setup Flowchart



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WIP Setup Flowchart



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Agenda

- Overview of Setting Up
- **WIP Parameters**
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Overview of WIP Parameters

Overview of WIP Parameters

- WIP parameters define modes of operation and default values that affect Work in Process.
- You can use WIP parameters to define modes of operation and to assign default values for various work in process functions.
- You can only define one set of WIP parameters per organization.
- The following pages will show the parameters, if they are required and their default value.



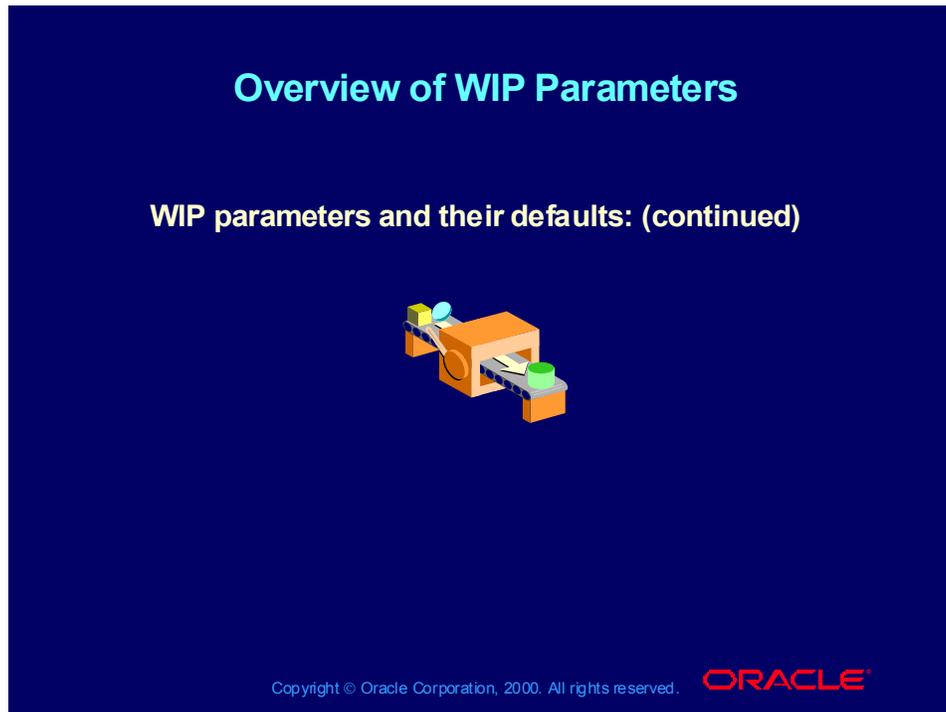
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Parameters	Required?	Default Value
<u>Discrete</u>		
Default Discrete Class	Optional	Null
Default Lot Number	Required	Job Name
Respond to Sales Order	Required	Always Changes
<u>Repetitive</u>		
Recognize Period Variances	Optional	All Schedules
Autorelease Days	Optional	0
<u>Average Costing</u>		
Default Completion Cost	Required	System Source Calculated
System Option	*Cond. Required	Use Predefined Resources

* Required if you select the System Calculated completion cost source.

Overview of WIP Parameters



Parameters	Required?	Default Value
<u>Average Costing (Cont'd)</u>		
Cost Type	*Cond. Required	Null
Auto Compute Final Completion	Optional	No
<u>Move Transactions</u>		
Require Scrap Account	Optional	Disabled
Allow Creation of New Shop Floor Statuses	Optional	Disabled Operations
Allow Moves Over No Move Shop Floor Statuses	Optional	Enabled
<u>Backflush Default</u>		
Supply Subinventory	Optional	Null
Supply Locator	Optional	Null
Lot Selection Method	Optional	Expiration Date
Lot Verification	Optional	All
*Required if the Default Completion Cost Source parameter is set to User Defined.		

Overview of WIP Parameters

WIP parameters and their defaults: (continued)



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Parameters	Required?	Default Value
<u>Intraoperation Steps</u>		
Intraoperation Steps	Optional	Are all enabled
<u>Outside Processing</u>		
Shop Floor Status for PO Move Resources	Optional	Null
Requisition Creation Time	Optional	At OSP Operation
Production Scheduler	Optional	Null
Shipping Manager	Optional	Null
<u>Scheduling</u>		
Use Constraint-Based Scheduler (checkbox)	Optional	Unchecked
Constraints	Optional	Resources
Horizon (days)	Optional	60

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Overview of WIP Parameters

WIP parameters and their defaults: (continued)



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Parameters	Required?	Default Value
<u>Other</u>		
Component ATP Rule	Optional	Null
Default Overcompletion		
Tolerance %	Optional	Null

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Practice 1-1 Overview

This practice will guide you through the WIP Parameter windows to help you understand how to define WIP Parameters.



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Practice 1-1

Review the WIP Parameters that are currently setup in the M3 Organization. Answer the questions provided.



(N) WIP > Setup > Parameters

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1. What are your options for the Default Discrete Class?
2. What is the default value for the Respond to Sales Order Changes field?
Note: The Costing tabbed region is only visible if your current organization has been defined as an Average Cost Organization in the Oracle Inventory Organization Parameters window. (The M3 organization is an average cost organization.)
3. Navigate to the Costing tabbed region. What is the Default Completion Cost Source?
4. Is the Auto Compute Final Completions check box selected? (This check box indicates whether the system should automatically determine when a completion transaction completes a job (quantity complete + scrap quantity = job quantity). The system calculates completion costs by taking the incurred job costs and dividing them by the completion quantity.)

Practice 1-1

Review the WIP Parameters that are currently setup in the M3 Organization. Answer the questions provided (continued)



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5. Navigate to the Move Transactions tabbed region. Is the “Require Scrap Account” check box selected? (This check box determines whether a scrap account is required when you move assemblies into and out of the “Scrap” Intraoperation step of an operation.)
6. Is the “Allow Creation of New Operations” check box selected? (This check box determines whether you can or cannot add an operation to a discrete job work in process routing during a move transaction.)
7. Navigate to the Backflush Defaults tabbed region. What is the default Backflush Supply Subinventory? Does this Supply Subinventory require a Supply Locator? (These two parameters determine which supply subinventory/locator is used when backflushing Operation Pull and Assembly Pull components that do not have defaults defined at the bill of material component level or at the item level.)
8. What options are available for the Backflush Lot Selection Method? (Determines how lot controlled Assembly Pull and Component Pull component items are selected during backflush transactions.)

Practice 1-1

Review the WIP Parameters that are currently setup in the M3 Organization. Answer the questions provided. (continued)



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9. Navigate to the Interoperation Steps tabbed region. Review the selected Intraoperation Steps. (These determine which intraoperation steps are enabled in your WIP routing operations.)
10. Navigate to the Outside Processing tabbed region. Is there a value selected in the Shop Floor Status for PO Move Resources parameter? If so, what is the value? (This selection determines which shop floor status is assigned to the Queue intraoperation steps of outside processing operations when you create discrete jobs and repetitive schedules.)
11. Navigate to the Scheduling tabbed region. If Oracle Manufacturing Scheduling has been installed, you can choose the Use Constraint Based Scheduler check box to activate the Constraint Based scheduling engine. Is this check box selected?
12. Navigate to the Other tabbed region. Is there a Component ATP Rule selected?

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Agenda

- Overview of Setting Up
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- **WIP Accounting Classes**
- Shop Floor Statuses
- Schedule Groups
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Overview of WIP Accounting Classes

- Accounting classes are assigned when jobs are defined and when repetitive assemblies are associated with production lines.
- You can define any number of WIP Accounting Classes and update them.
- The valuation and variance accounts that are associated with these accounting classes determine which accounts are charged.

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Overview of WIP Accounting Classes

The following pages will review each of the following WIP Accounting Classes:

- Discrete Accounting Classes
- Repetitive Accounting Classes
- Valuation Accounts
- Variance Accounts

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Discrete Accounting Classes

Discrete Accounting Classes

Standard Discrete Accounting Class

- You must assign an accounting class to every discrete job, schedule and workorder-less completion.
- You can define accounting classes for each type of discrete production you use:
 - Standard Discrete
 - Asset Non-Standard Discrete
 - Expense Non-Standard Discrete
 - Flow Manufacturing



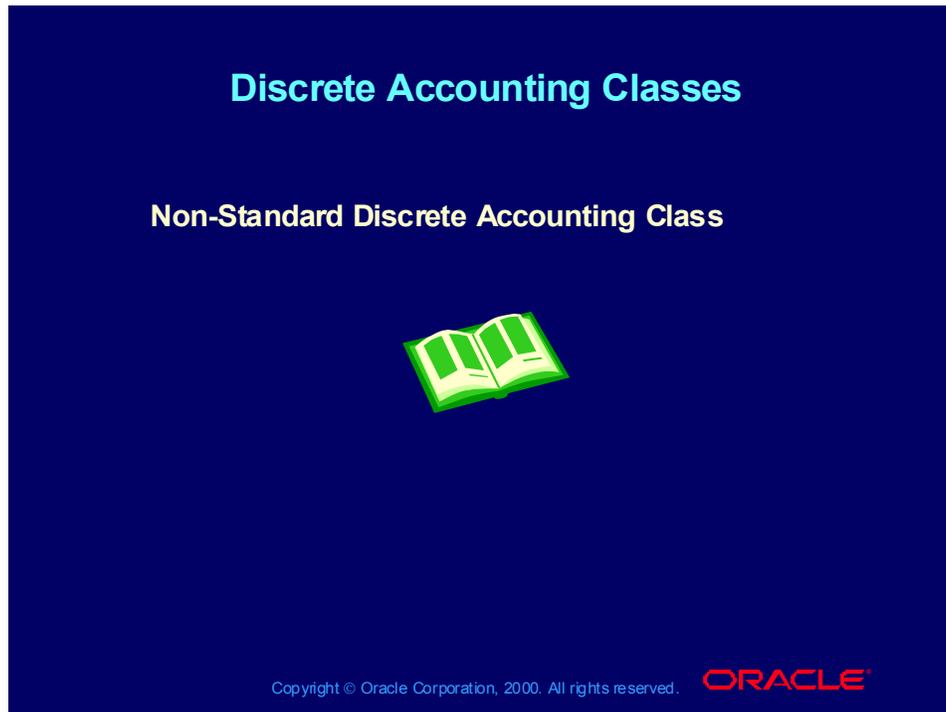
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Standard discrete accounting classes can be used to group job costs. For example, if you build subassemblies and finished goods, you can define your accounting classes so that you can separately value and report the costs associated with subassembly and finished goods production. Also, standard discrete accounting classes can be automatically defaulted when you create discrete jobs.

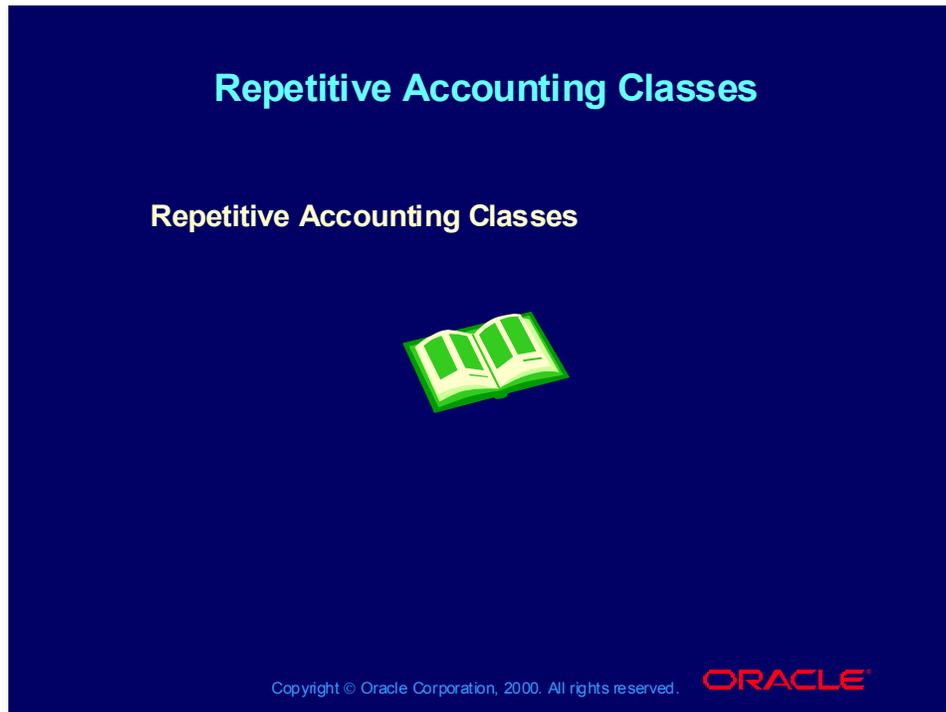
When you define an accounting class, you must assign valuation and variance accounts to it. When you issue materials to a job that uses this accounting class, the appropriate valuation accounts are charged. When the job is closed, final costs and variances are calculated and posted to the variance and valuation accounts. When the accounting period is closed, these journal entries are automatically posted to the general ledger.

Discrete Accounting Classes



Non-standard discrete accounting classes can be used to group and report various types of non-standard production costs, such as field service repair or engineering projects. For example, to track recurring expenses - machine maintenance or engineering projects - with non-standard jobs, you can define and assign an accounting class with a type of expense non-standard to these jobs. The valuation accounts carry the costs incurred on these expense jobs as an asset during the period and automatically writes them off to the variance accounts at period close. If you use non-standard discrete jobs to track production costs as assets, you can define and assign an accounting class with a type of asset non-standard. Asset non-standard discrete jobs are costed the same as standard discrete jobs. Valuation accounts are charged when material is issued to a job and final costs and variances are calculated and posted to the appropriate variance and valuation accounts when the job is closed. (Valuation accounts and Variance accounts are covered later in this course.)

Repetitive Accounting Classes



Repetitive accounting classes are used to group production costs and must be assigned to each repetitive line/assembly association that is created. Every schedule for that assembly on that line uses these accounts, which are charged whenever you transact against the line/assembly association. Repetitive accounting classes can also be automatically defaulted when you associate repetitive assemblies with production lines.

You can analyze repetitive manufacturing costs by assembly regardless of the line on which it was manufactured by using the same accounting class for all lines that build that assembly. You can use the same class for all assemblies on a line to do the line based cost reporting or you can use a different accounting class for every line/assembly association.

Valuation Accounts

Valuation Accounts

The following pages will discuss:

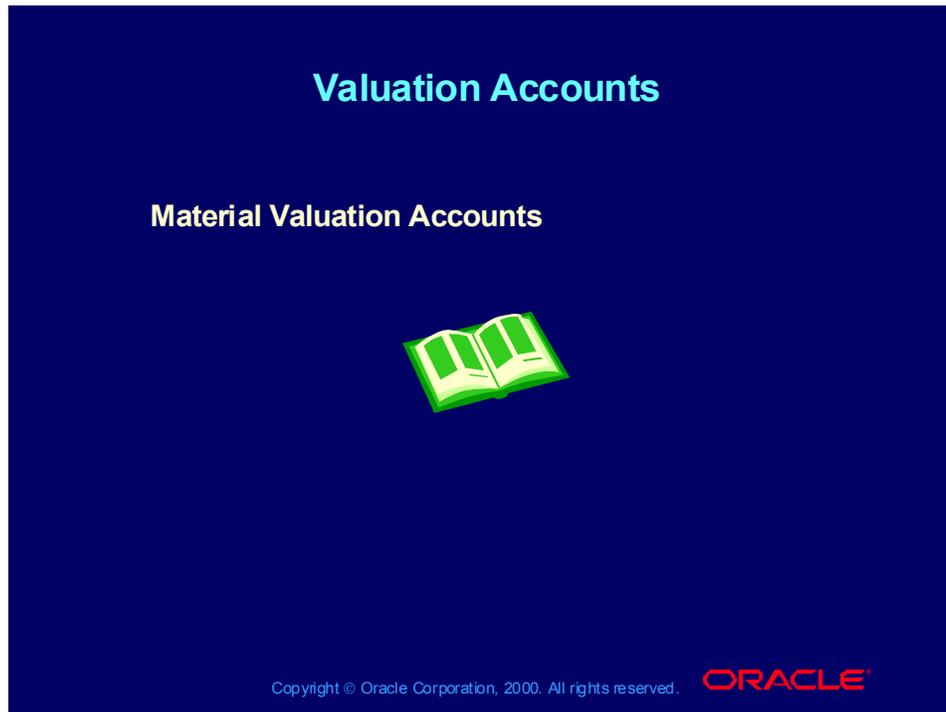
- **Material Valuation Account**
- **Material Overhead Valuation Account**
- **Resource Valuation Account**
- **Outside Processing Valuation Account**
- **Overhead Valuation Account**

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WIP accounting class valuation accounts are charged when you issue components, move assemblies, complete assemblies, and charge resources.

Valuation Accounts



Normally an asset account, this account tracks material costs. Under standard costing, it is debited at standard when you issue material to a job or schedule and credited at standard when you complete assemblies from a job or schedule, close a job or close an accounting period. Under average costing, this account is debited at the average cost at the time of the issue transaction and is credited when you complete assemblies from a job.

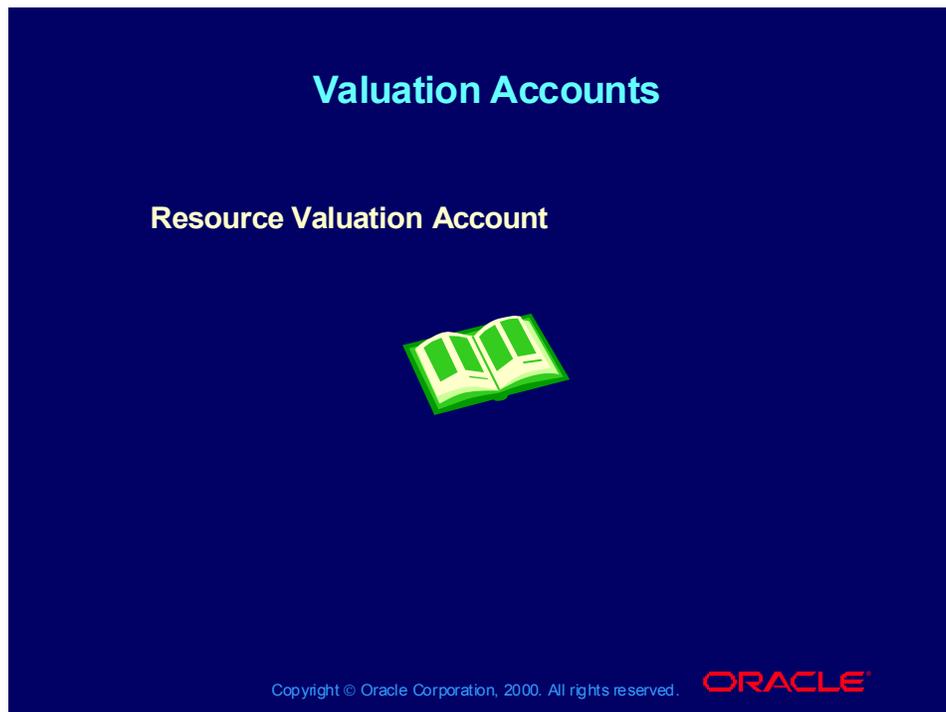
Valuation Accounts



Normally an asset account, this account tracks material overhead (burden) costs. Under standard costing, it is charged/debited at standard when you issue material with material overhead to a job or schedule and relieved at standard when you complete assemblies from a job or schedule, close a job or close an accounting period. Under average costing, this account is debited at the average cost at the time of the issue transaction.

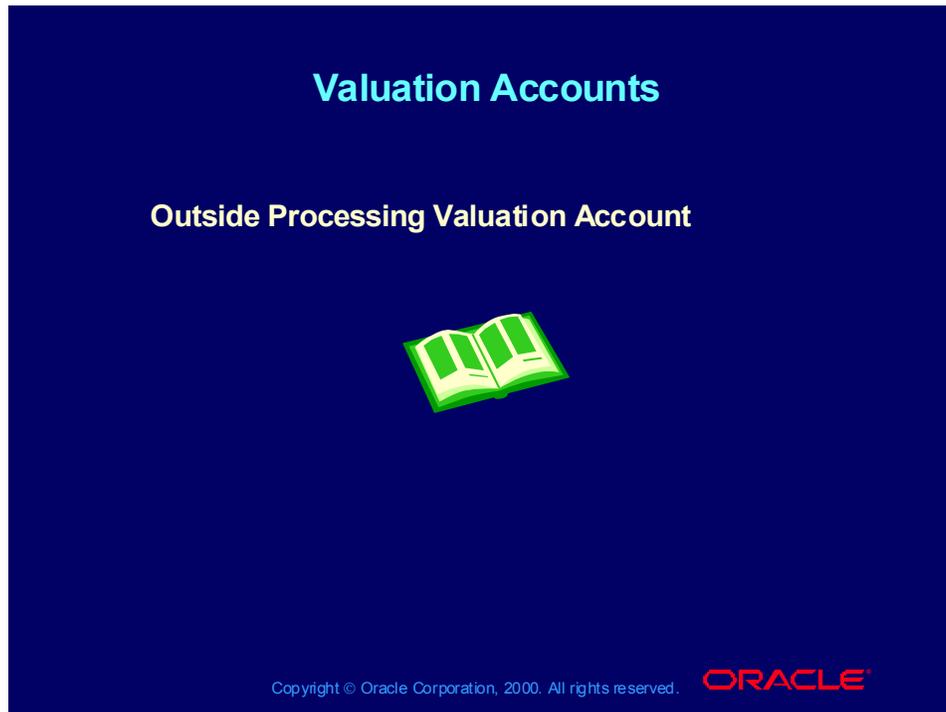
Note: When assemblies are completed and material overhead is earned, this account is not charged/credited. Instead, the material overhead account for the completion subinventory is debited.

Valuation Accounts



Normally an asset account, this account tracks resource costs. Under standard costing, it is charged/debited at standard when resources are charged to a job or schedule and relieved/credited at standard when you complete assemblies from a job or schedule, close a job, or close an accounting period. Under average costing, this account is debited and credited at the resource rate at the time the resource is charged.

Valuation Accounts



Normally an asset account, this account tracks outside processing costs. Under standard costing it is debited at the standard or purchase order cost when you receive items for a job or schedule. It is credited at standard when you complete assemblies from a job or schedule, close a job, or close an accounting period. Under average costing, the debiting of this account is based on item receipt (just as it is under standard costing).

Valuation Accounts



Normally an asset account, this account tracks resource or department overhead cost.

Variance Accounts

Variance Accounts

The following pages will discuss:

- **Material Variance Accounts**
- **Resource Variance Accounts**
- **Outside Processing Variance Accounts**
- **Overhead Variance Accounts**
- **Standard Cost Variance Accounts**
- **Expense Variance Accounts**

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Variance accounts associated with Standard Discrete and Non-Standard Asset accounting classes are charged when jobs are closed. Variance accounts associated with Expense Non-Standard Discrete, and optionally Repetitive accounting classes, are charged when accounting periods are closed.

Variance Accounts



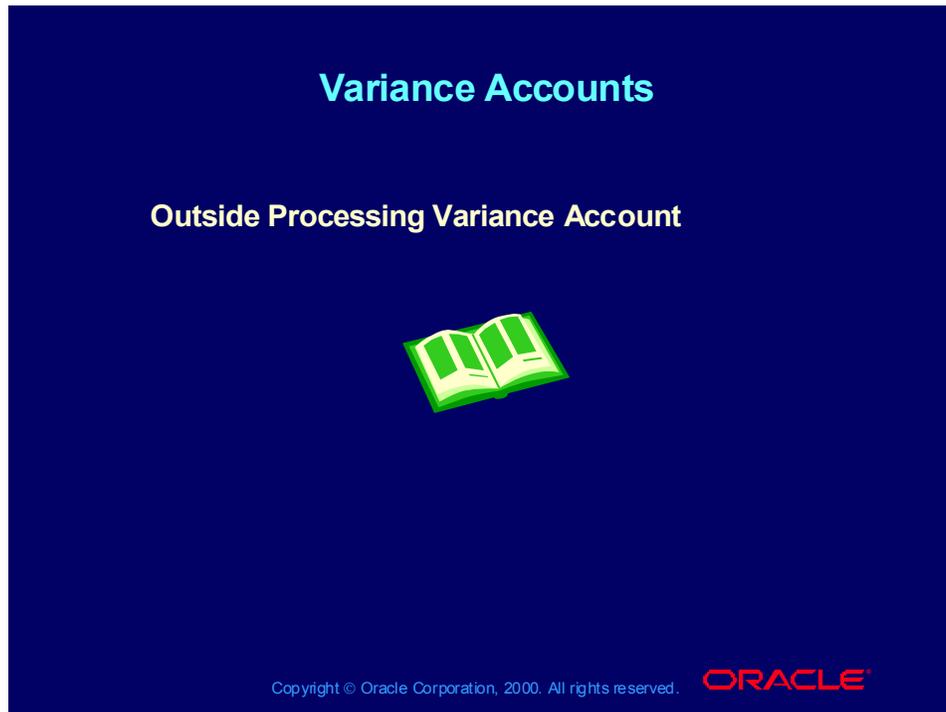
This account tracks variances that occur when the previous level material costs charged to the job or schedule do not equal the previous level material costs that are relieved. This calculation gives you a net material usage and configuration variance.

Variance Accounts



This account tracks variances that occur when the this level resource costs charged to the job or schedule do not equal the this level resource costs that are relieved. If you charge actual labor without creating resource rate variances (resource standard rate is set to No), the resource variance includes any rate, efficiency, and method variances. If you recognize rate variances or charge resources at standard, the resource variance includes resource efficiency, and any method variances.

Variance Accounts



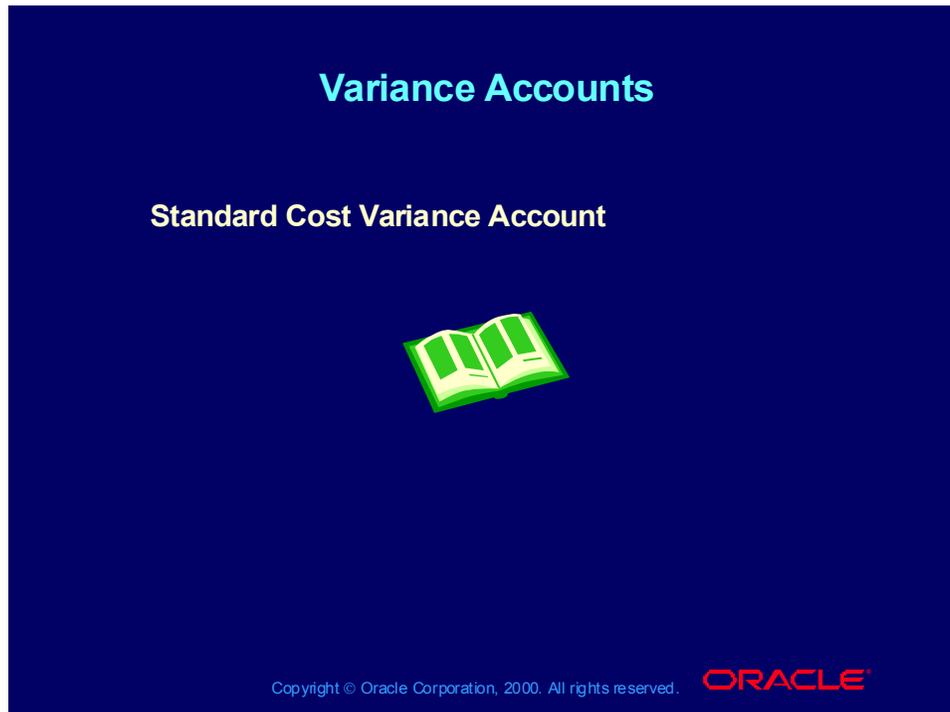
This account tracks the variances that occur when the outside processing costs charged to the job or schedule do not equal the outside processing costs that are relieved. If you do not calculate purchase price variance (resource standard rate is set to No), the outside processing variance includes any rate, efficiency, and method variances. If you recognize purchase price variance, this account includes efficiency and any method variances.

Variance Accounts



This account tracks the variances that occur when the overhead costs charged to the job or schedule do not equal the overhead costs relieved from the job or schedule. These variances include both efficiency and method variances.

Variance Accounts



This Variance account applies only to Standard Discrete and Asset Non-Standard. This account is charged for the sum of all the elemental standard cost adjustments when you perform a standard cost update that impacts an active job. Cost updates are not performed for repetitive schedules or expense non-standard jobs.

Variance Accounts



Normally an expense account, this account is debited and credited when issuing and completing non–standard expense jobs under both standard and average costing.

Practice 2-1 Overview

This practice will test your ability to define a new WIP Accounting Class in a standard costing organization. (M1)



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Practice 2-1

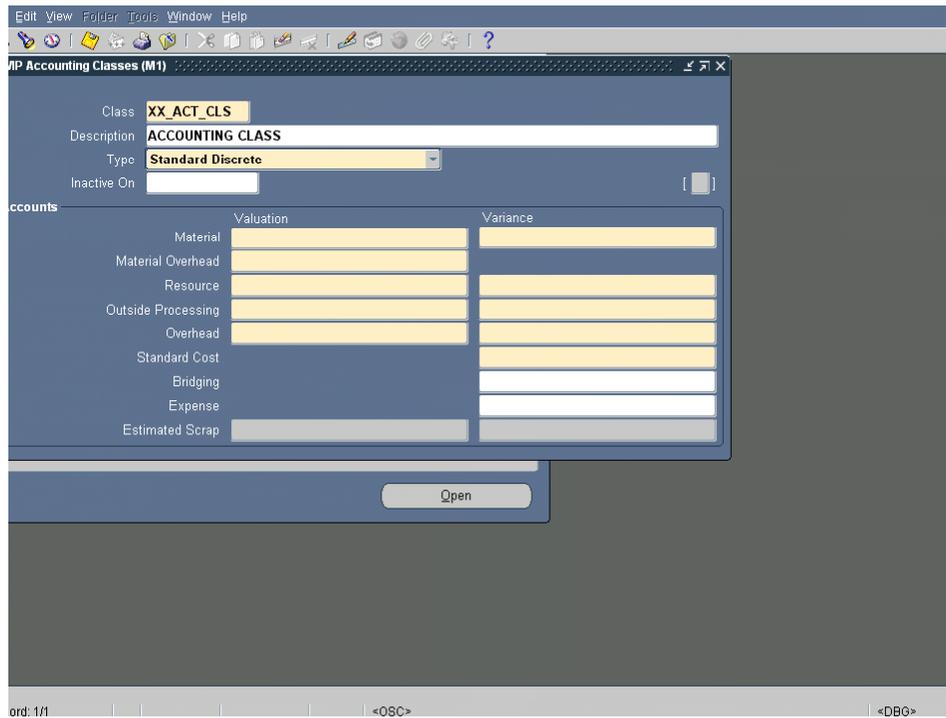
Define a new WIP Accounting Class



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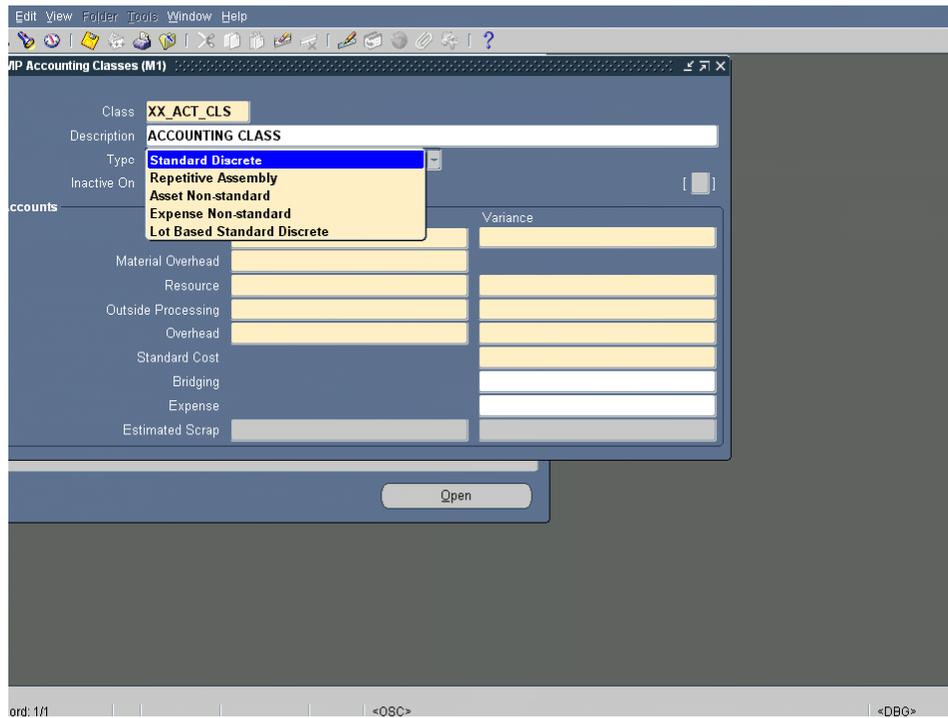
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1. In the M1 organization, navigate to the WIP Accounting Classes window.
2. Enter a unique accounting Class name XX_ACTG_CLS. (Substitute XX with your initials.)
3. Enter the description ACCOUNTING CLASS.
4. Select an accounting class Type of *Standard Discrete*.
5. Enter an Inactive On date.
6. Enter General Ledger accounts for each required Valuation and Variance account.
7. Save your work.



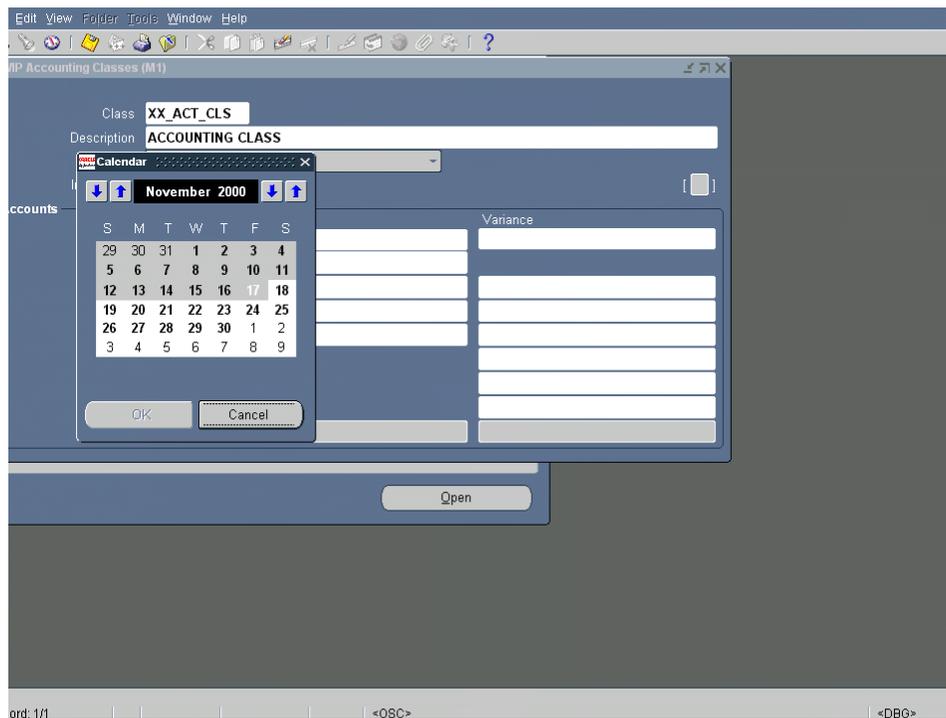
Practice 2-1 Solutions

1. Navigate to the WIP Accounting Classes window.
(N) WIP > Setup > WIP Accounting Classes
2. Enter a unique accounting Class name XX_ACT_CLS. (Substitute XX with your initials.)
3. Enter the description ACCOUNTING CLASS.



Practice 2-1 Solutions

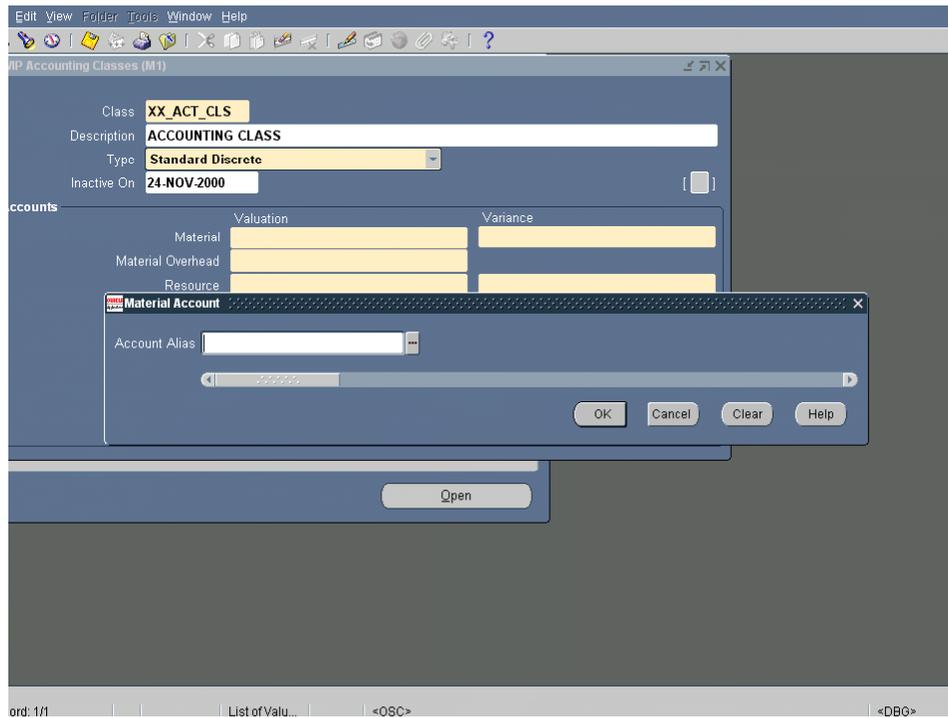
4. Select an accounting class Type of *Standard Discrete*.



Practice 2-1 Solutions

5. Enter an Inactive On date.

Note: If you enter an Inactive On date, you can no longer use this accounting class as of the date that you enter. The Inactive On date can be greater than or equal to the current date. If you do not enter an Inactive On date, the accounting class is active indefinitely.



Practice 2-1 Solutions

- Using the list of values, enter the General Ledger accounts for each required Valuation and Variance account.
- Save your work.

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- WIP Accounting Classes
- **Shop Floor Statuses**
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Overview of Shop Floor Statuses

Overview of Shop Floor Statuses

- You can control move transactions by assigning Shop Floor Statuses to intraoperation steps on the work in process routing. For example you may want to create a “Hold for Quality Check” status that can be assigned to an intraoperation step before moving to the next assembly step.
- You can assign Shop Floor Statuses to any intraoperation step associated with a job or repetitive line/assembly.
- Shop Floor Statuses that are assigned to a repetitive line/assembly are valid for all repetitive schedules being built on that production line.

(N) WIP > Move Transactions > Shop Floor Statuses > Shop Floor Statuses

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Practice 3-1 Overview

This practice will test your ability to define a new Shop Floor Status.



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Practice 3-1

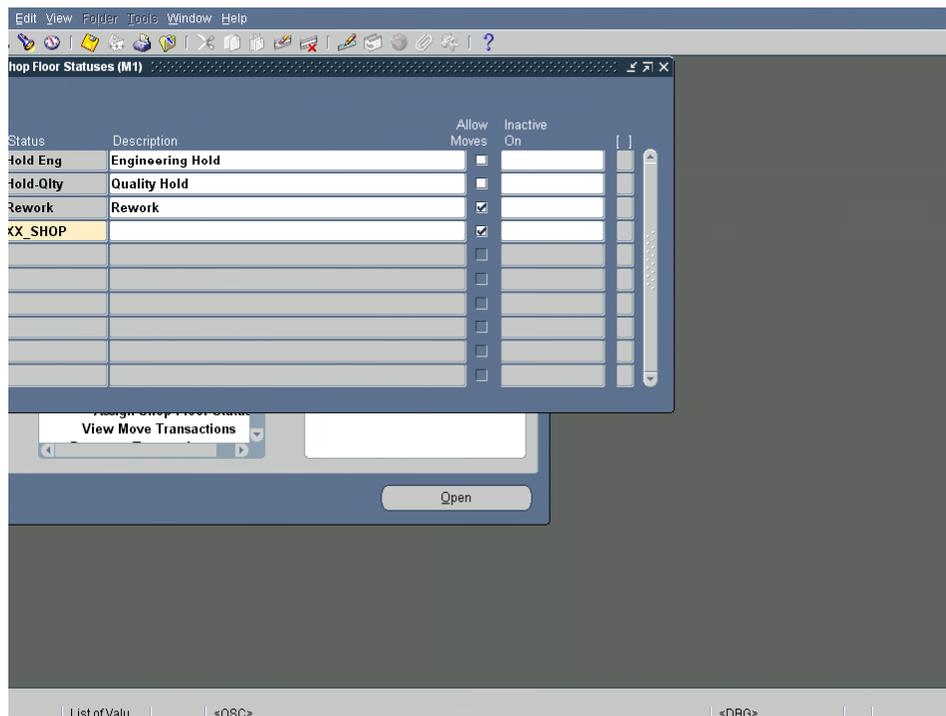
Define a new Shop Floor Status



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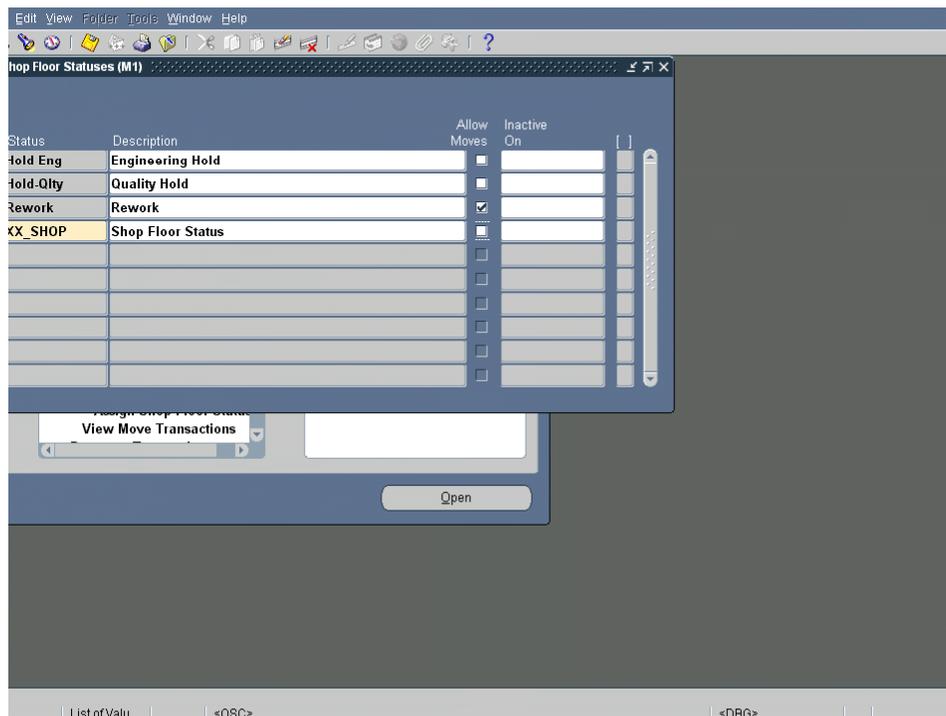
ORACLE

1. In the M1 organization, navigate to the Shop Floor Statuses Window.
2. In the first available line, enter a Status Name XX_SHOP.
(Substitute XX with your initials.)
3. Enter a Status description Shop Floor Status.
4. Optionally uncheck Allow Moves so that you can use this status to control move transactions. (Allow Moves defaults to checked.)
5. Enter an Inactive On date.
6. Save.



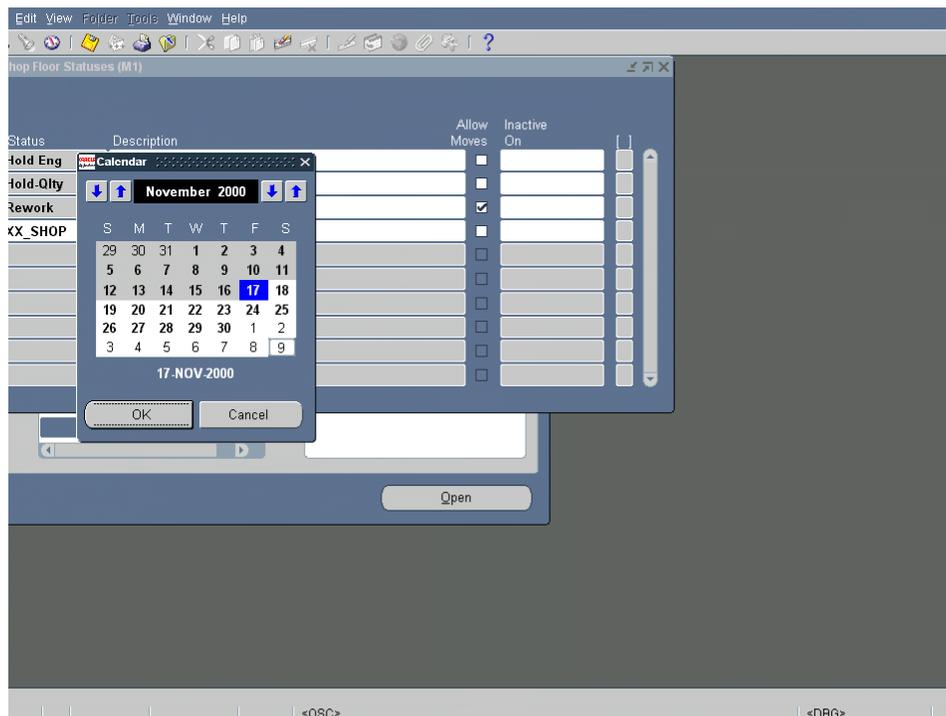
Practice 3-1 Solutions

1. In the M1 organization, navigate to the Shop Floor Statuses Window.
(N) WIP > Move Transactions > Shop Floor Statuses > Shop Floor Statuses
2. In the first available line, enter a Status Name XX_SHOP.
(Substitute XX with your initials.)



Practice 3-1 Solutions

3. Enter a Status description Shop Floor Status.
4. Optionally uncheck Allow Moves so that you can use this status to control move transactions. (Allow Moves defaults to checked.)



Practice 3-1 Solutions

5. Enter an Inactive On date.

Note: If you enter an Inactive On date, you can no longer use this accounting class as of the date that you enter. The Inactive On date can be greater than or equal to the current date. If you do not enter an Inactive On date, the accounting class is active indefinitely.

6. Save.

Agenda

- Overview of Setting Up
- WIP Parameters
- WIP Accounting Classes
- Shop Floor Statuses
- **Schedule Groups**
- Labor Rates
- Production Lines
- Standard Documents
- Profile Options
- Summary

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Overview of Schedule Groups

Overview of Schedule Groups

- You can assign flow schedules and discrete jobs to the schedule groups you define.
- Jobs and flow schedules within a given schedule group can be sequenced.
- Sequencing jobs and flow schedules within a schedule group makes it possible to prioritize, for example, by customer.
- You can update schedule groups.
- You cannot delete schedule groups that are assigned to jobs and flow schedules.

(N) WIP > Setup > Schedule Groups

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Practice 4-1 Overview

Practice 4-1 Overview

This practice will test your ability to define a new Schedule Group.



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Practice 4-1

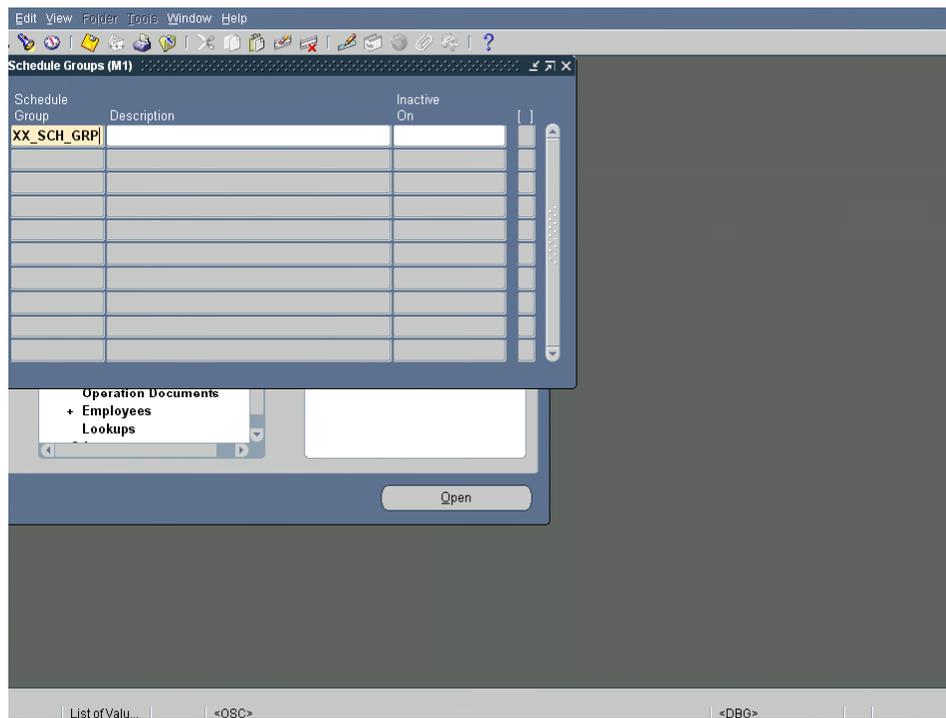
Practice 4-1

Define a new Schedule Group



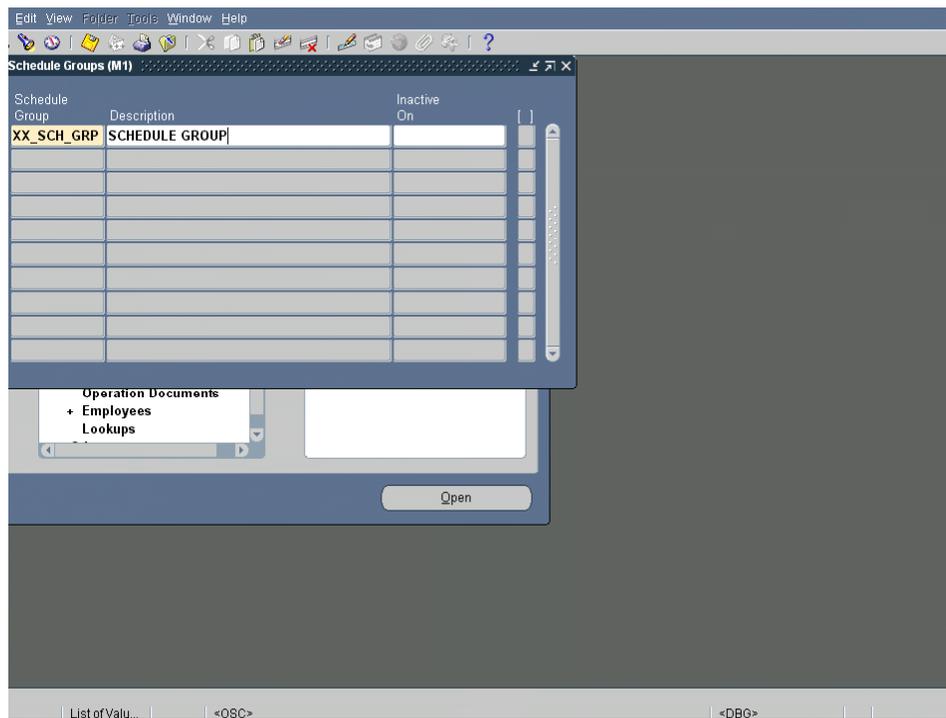
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1. Navigate to the Schedule Groups Window.
2. Enter a Schedule Group Name **XX_SCH_GRP**.
(Substitute **XX** with your initials.)
3. Enter a schedule group Description **SCHEDULE GROUP**.
4. Enter an Inactive On date.
5. Save.



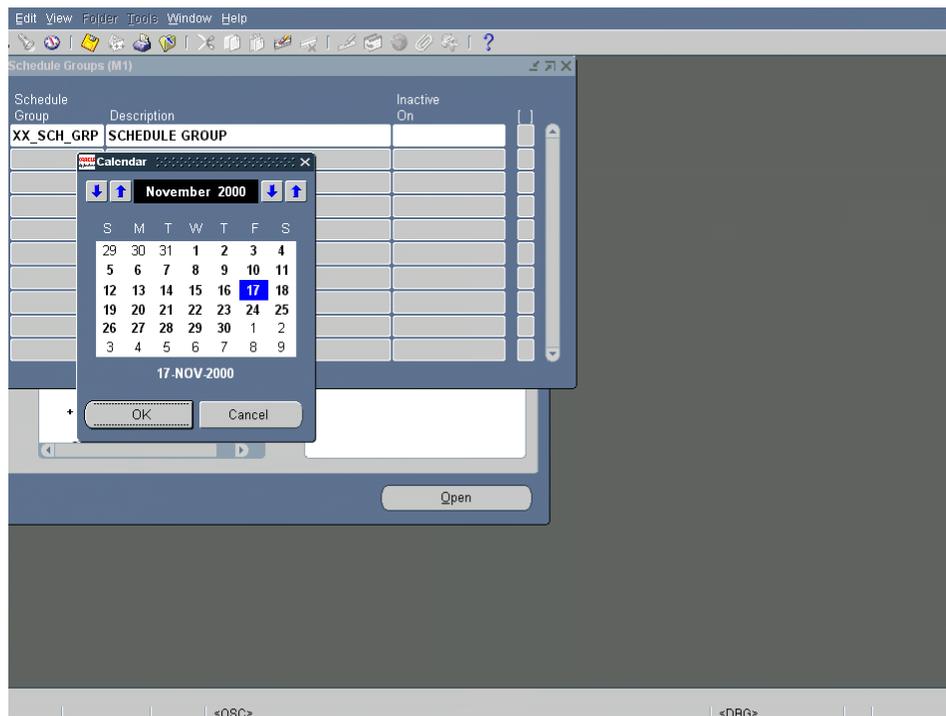
Practice 4-1 Solutions

1. Navigate to the Schedule Groups Window.
(N) WIP > Setup > Schedule Groups
2. Enter a Schedule Group Name XX_SCH_GRP.
(Substitute XX with your initials.)



Practice 4-1 Solutions

3. Enter a schedule group Description SCHEDULE GROUP.



Practice 4-1 Solutions

4. Enter an Inactive On date.

Note: If you enter an Inactive On date, you can no longer use this accounting class as of the date that you enter. The Inactive On date can be greater than or equal to the current date. If you do not enter an Inactive On date, the accounting class is active indefinitely.

5. Save.

Agenda

- Overview of Setting Up
- WIP Parameters
- WIP Accounting Classes
- Shop Floor Statuses
- Schedule Groups
- **Labor Rates**
- Production Lines
- Standard Documents
- Profile Options
- Summary

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Overview of Labor Rates

Overview of Labor Rates

- You can add, delete, and update the effective date of the hourly labor rates for person-type resources (employees).
- You can define multiple hourly labor rates for the same employee, as long as each rate has a different effective date.

(N) WIP > Setup > Employees > Labor Rates

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If you wish to use actual employee rates for labor costing, the hourly labor rate rather than the standard or predefined rate is used. You can enter an employee number when performing a person-type resource transaction in the Resource Transactions window or the Resource Transaction Open Interface process. The employee's most current hourly labor rate is used to compute the actual cost of the transaction.

Note: Oracle HR is the source for the employee names and numbers. If Oracle HR has not been installed, then you must manually enter employee names as well as employee rates.

Practice 5-1 Overview

This practice will test your ability to define a new Labor Rate.



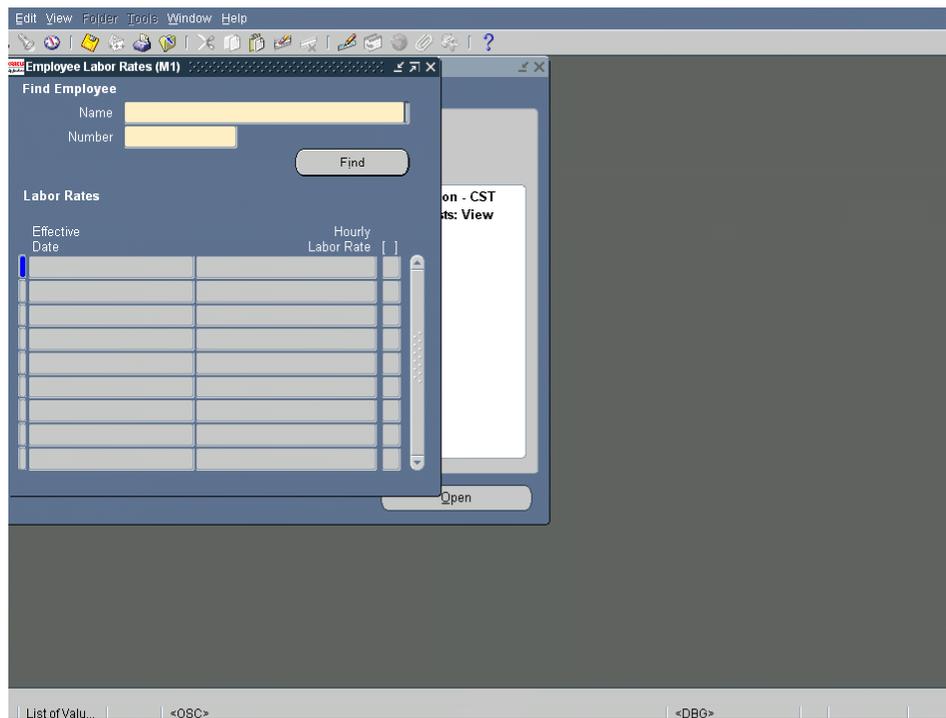
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Practice 5-1

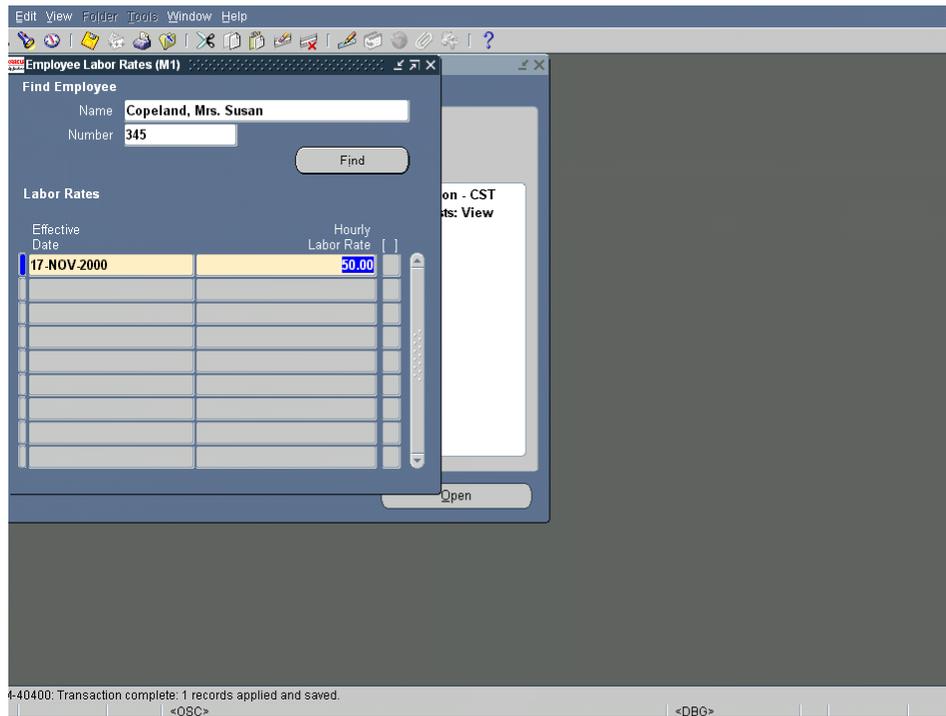


1. Navigate to the Employee Labor Rates Window.
2. Using the list of values, select an employee Name or Number.
3. Select the Effective Date for each hourly labor rate.
4. Enter the Hourly Labor Rate for the employee.
5. Save.



Practice 5-1 Solutions

1. Navigate to the Employee Labor Rates Window in the M1 organization.
(N) WIP > Setup > Employees > Labor Rates



Practice 5-1 Solutions

2. Find the employee Name or Number that your instructor gives you.
3. Select the today's date for the Effective Date for you hourly labor rate.
4. Enter \$50 for the Hourly Labor Rate.
5. Save.

Agenda

- Overview of Setting Up
- WIP Parameters
- WIP Accounting Classes
- Shop Floor Statuses
- Schedule Groups
- Labor Rates
- **Production Lines**
- Standard Documents
- Profile Options
- Summary

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Overview of Production Lines

- A production line describes a unique set of operations, departments, and/or manufacturing cells that produce one or more of your products.
- You can associate production lines with repetitive assemblies, discrete jobs, flow routings, schedules, and work order-less completions.
- You can define and update production lines.
- You cannot delete production lines.

(N) WIP > Setup > Production Lines

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Practice 6-1 Overview

Practice 6-1 Overview

This practice will test your ability to define a new production line.



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Practice 6-1



1. Navigate to the Production Lines Window.
2. Enter a production line Name **XX_LINE** (Substitute **XX** with your initials.)
3. Enter the production line Description **PRODUCTION LINE**.
4. Using the list of values, you may optionally, select an Exception Set.
5. Using the list of values, you may optionally, select an ATP Rule.
6. Enter the Minimum Hourly Rate of \$15
7. Enter the Maximum Hourly Rate of \$500
8. Enter the production line Start Time of 06:00:00
9. Enter the production line Stop Time of 17:00:00
10. Select the Lead Time Basis. (If the lead time varies by assembly, you can schedule the repetitive production time based on the routing of the assembly the line is building. You can set a fixed lead time if the lead time is determined by the production line and does not vary by assembly. You can update this field at any time.)

Practice 6-1

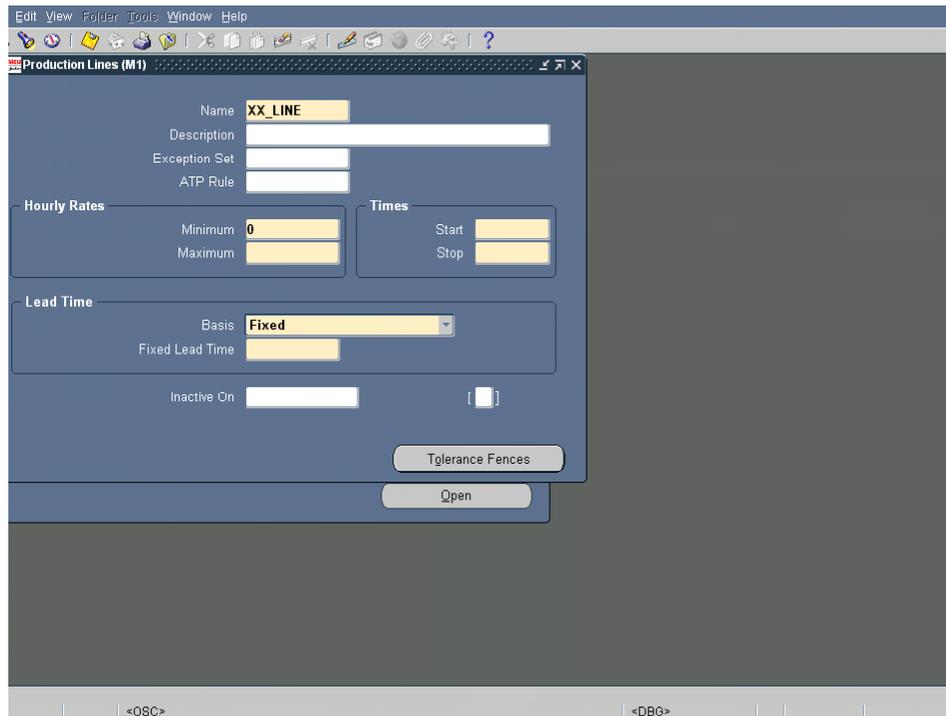
Define a new Production Line (continued)



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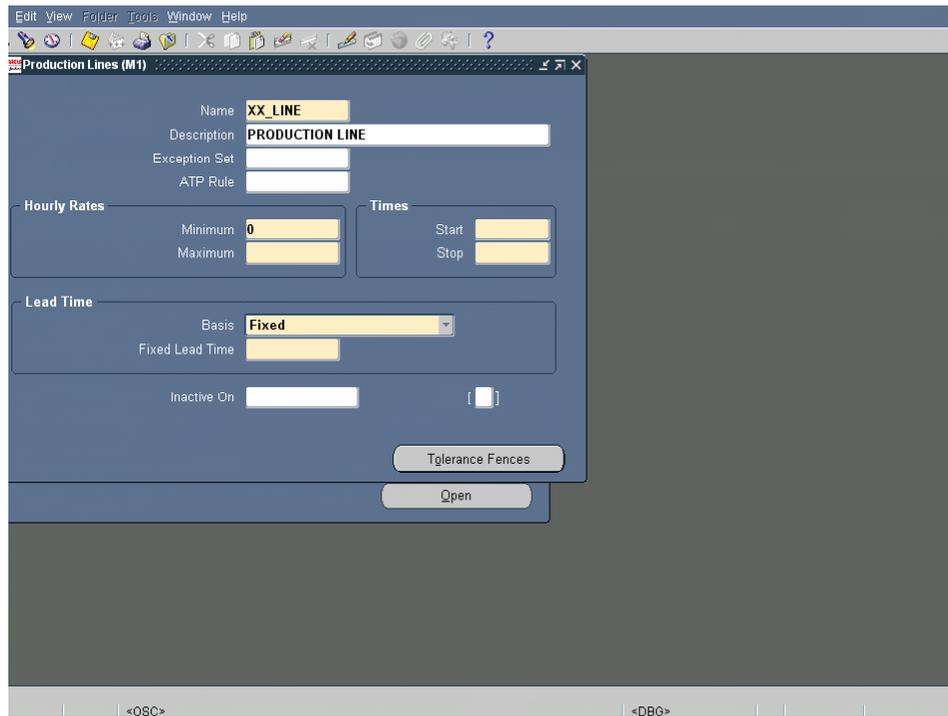
ORACLE

11. If necessary, enter the Fixed Lead Time, in hours per assembly, for the production line.
12. Enter an Inactive On date.
13. Save your work.



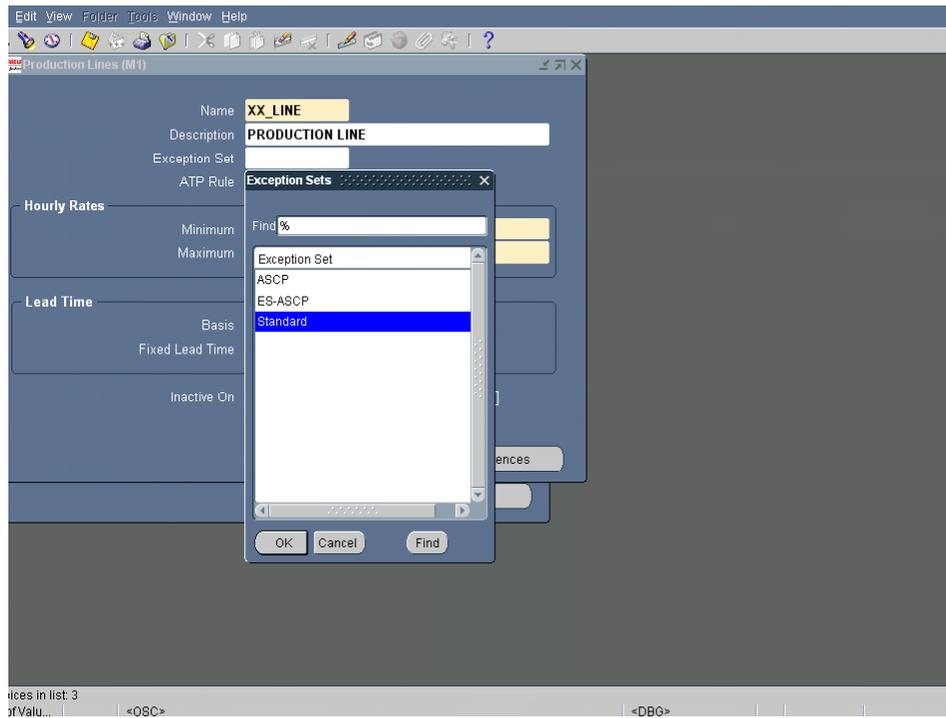
Practice 6-1 Solutions

1. Navigate to the Production Lines Window.
(N) WIP > Setup > Production Lines
2. Enter a production line Name XX_LINE (Substitute XX with your initials.)



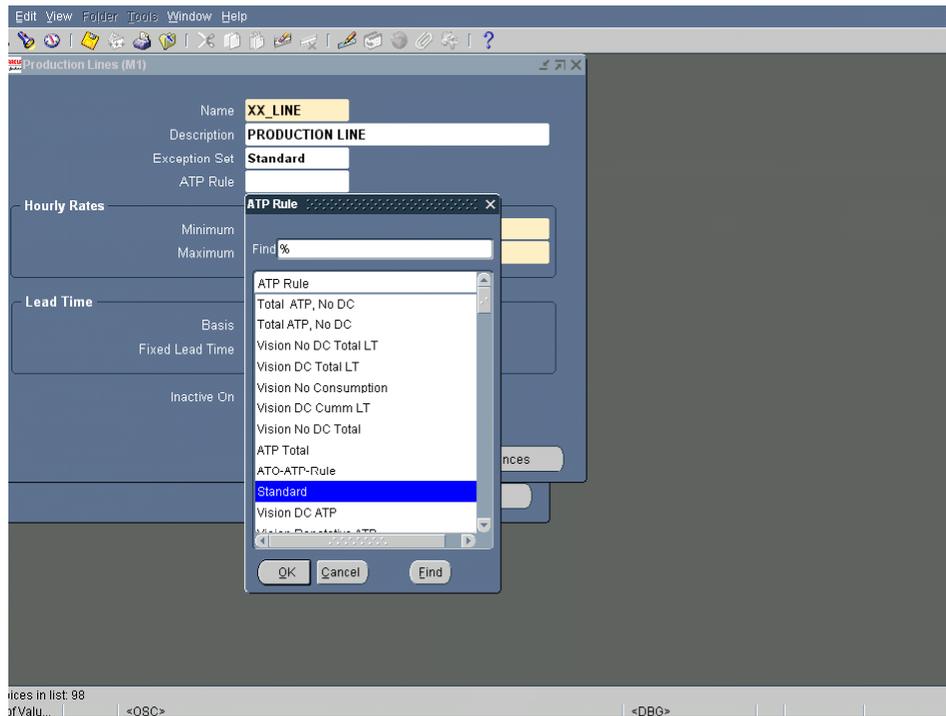
Practice 6-1 Solutions

3. Enter the production line Description PRODUCTION LINE.



Practice 6-1 Solutions

4. Optionally, using the list of values, select the *Standard* Exception Set. (Production lines are rate-based resources. The exception sets that you assign to them help you identify capacity problems.)



Practice 6-1 Solutions

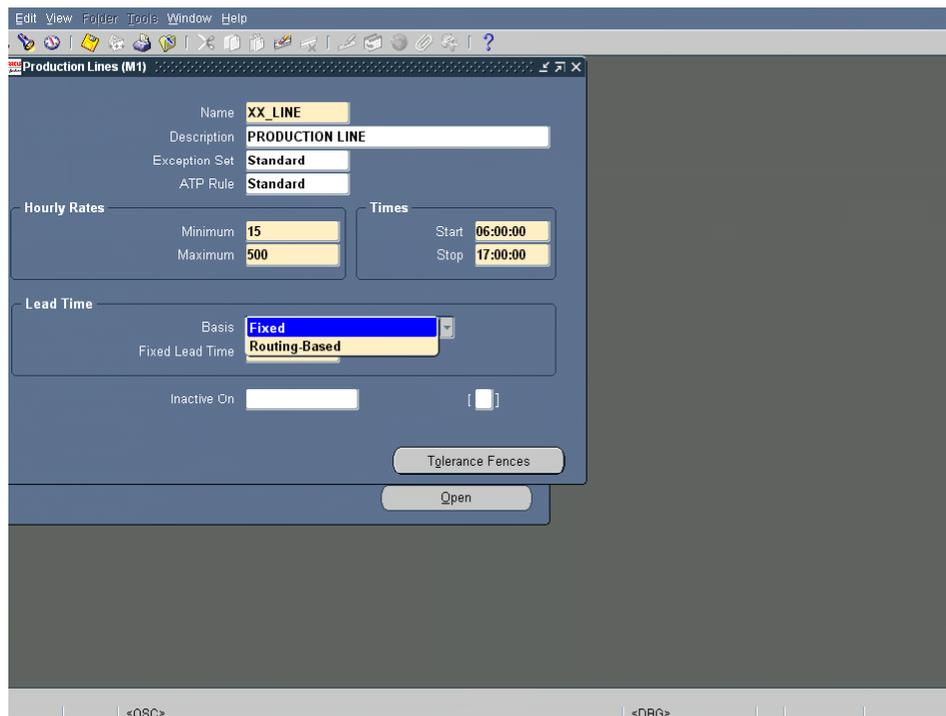
5. Optionally, using the list of values, select the *Standard* ATP Rule. (You can select any user-defined ATP rule. The ATP rule that you assign to the production line is used when determining the capable to promise status of the line resource.)

The screenshot shows the Oracle Production Lines (M1) form with the following configuration:

- Name: **XX_LINE**
- Description: **PRODUCTION LINE**
- Exception Set: **Standard**
- ATP Rule: **Standard**
- Hourly Rates: Minimum **15**, Maximum **500**
- Times: Start **06:00:00**, Stop **17:00:00**
- Lead Time: Basis **Fixed**, Fixed Lead Time (empty)
- Inactive On (empty)
- Buttons: Tolerance Fences, Open

Practice 6-1 Solutions

6. Enter the Minimum Hourly Rate of \$15
7. Enter the Maximum Hourly Rate of \$500
8. Enter the production line Start Time of 06:00:00
9. Enter the production line Stop Time of 17:00:00

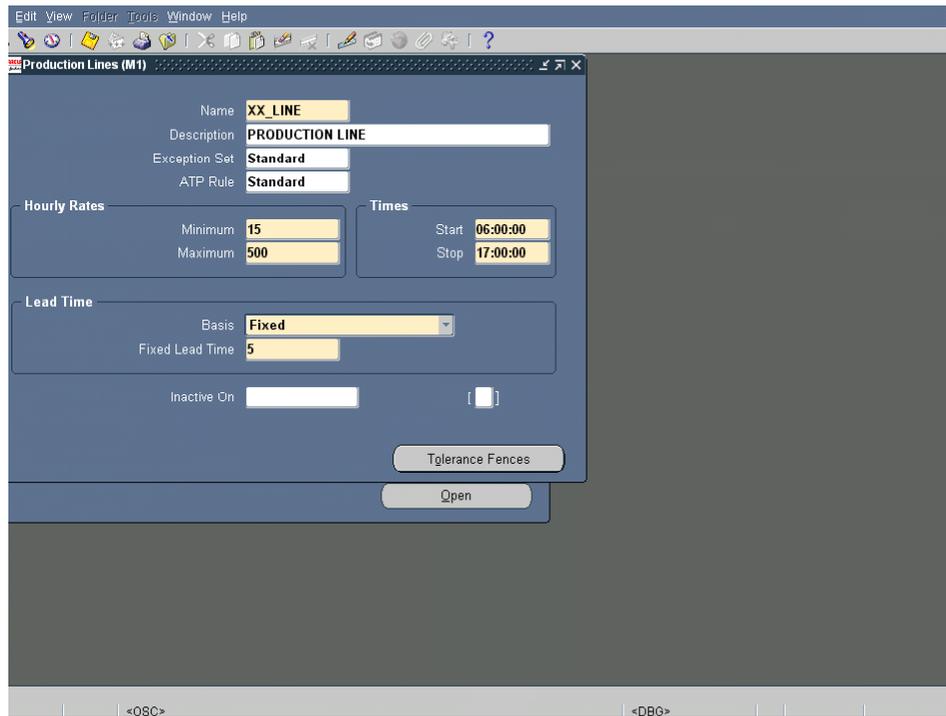


Practice 6-1 Solutions

10. Select the *Fixed* Lead Time Basis. (If the lead time varies by assembly, you can schedule the repetitive production time based on the routing of the assembly the line is building. You can set a fixed lead time if the lead time is determined by the production line and does not vary by assembly. You can update this field at any time.)

Fixed: The system schedules the first unit completion date and the operations of all repetitive schedules on this production line based on the fixed lead time hours you enter for the production line. Scheduling is done regardless of actual capacity or the lead time of the routing of the repetitive assembly.

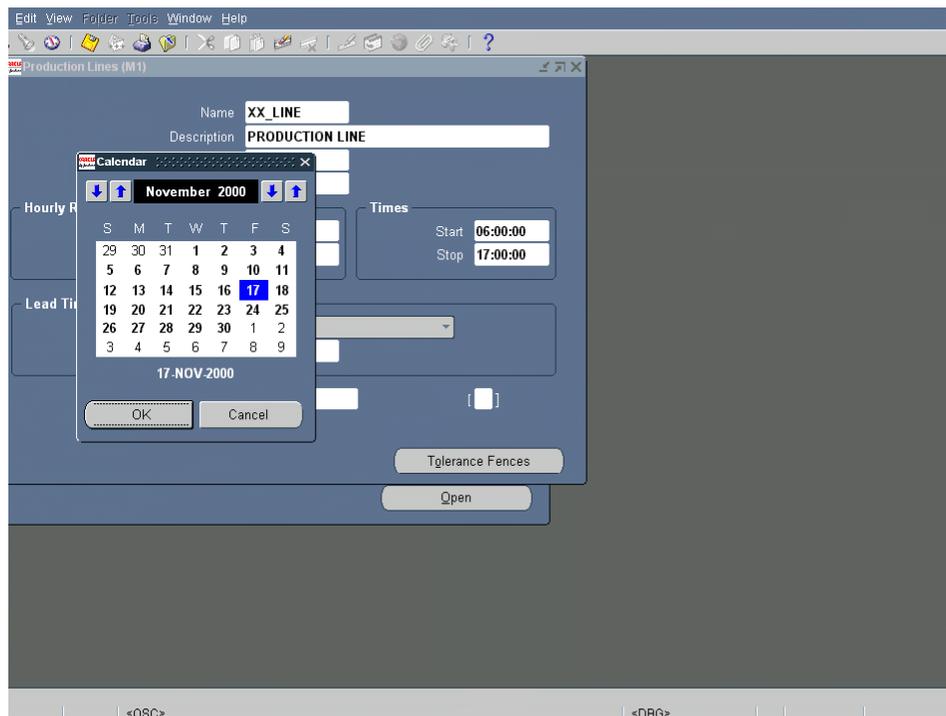
Routing-Based: The system schedules the first unit completion date and the operations of all repetitive schedules on this production line using the detailed shop floor scheduling algorithm, the routing of the assembly, and a quantity of 1.



Practice 6-1 Solutions

11. Enter a Fixed Lead Time of 5 hours.

Note: Because we entered a lead time basis of *Fixed*, we must enter the Fixed Lead Time, in hours per assembly, for the production line. This is the amount of time it takes to produce the first assembly, from start to finish on the production line. The daily quantity from that point on is set when you define individual repetitive schedules and must be less than or equal to the maximum hourly rate. The fixed lead time entered here is used to schedule repetitive schedules produced on this production line. You can update this field at any time. You cannot enter a value in this field for a routing-based production line.



Practice 6-1 Solutions

12. Enter an Inactive On date.

Note: If you enter an Inactive On date, you can no longer use this accounting class as of the date that you enter. The Inactive On date can be greater than or equal to the current date. If you do not enter an Inactive On date, the accounting class is active indefinitely.

13. Save your work.

Agenda

- Overview of Setting Up
- WIP Parameters
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- Schedule Groups
- Labor Rates
- Production Lines
- **Standard Documents**
- Profile Options
- Summary

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Overview of Standard Documents

Overview of Standard Documents

- You can define standard documents for discrete jobs, repetitive schedules, and job/schedule operations.
- Standard documents can then be attached to discrete jobs, repetitive schedules, and operations as required.



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For information on defining Standard Documents, refer to the online help and navigate to:

(N) Oracle Work in Process > Setting Up > Defining Operation Documents

Agenda

- Overview of Setting Up
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- Summary

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Overview of Profile Options

- **During Implementation, you set a value for each user profile option to specify how Work in Process controls access to and processes data.**
- **Generally, the system administrator sets and updates profile values.**
- **The following pages will give a description of each profile option and their options.**

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Profile Option Descriptions

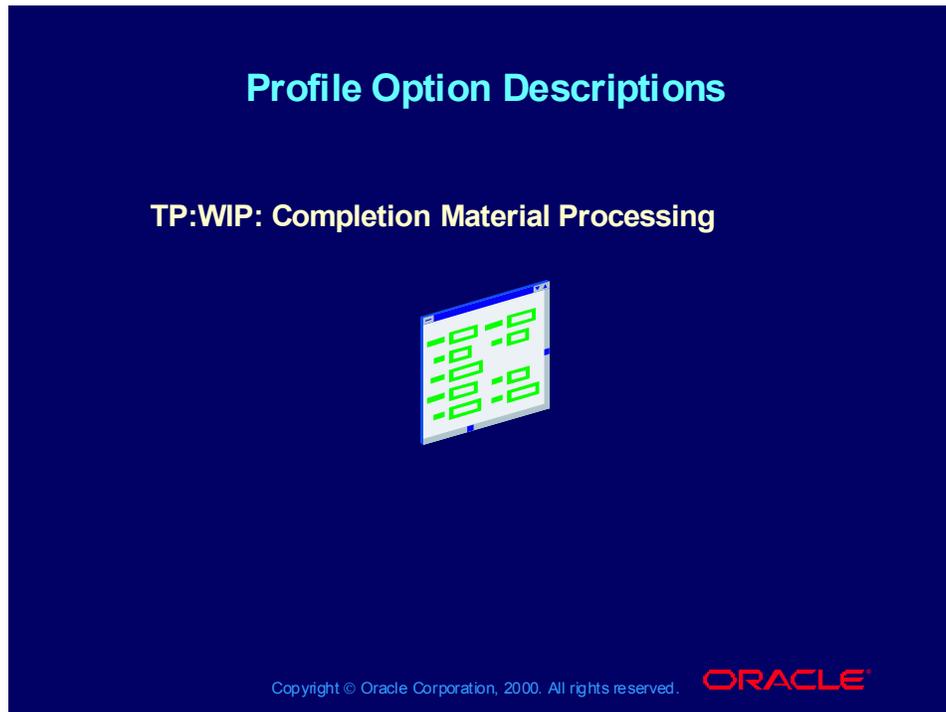


This profile option is used only when the TP:Move Transaction profile is set to *Background processing* and the transaction being processed is a move completion, move return, or operation pull backflush transaction.

Background Processing: When set to background, shop floor material transactions are processed by the inventory material transaction processor on a periodic basis.

Concurrent Processing: When set to concurrent, the inventory material transaction processor is launched to process the shop floor material transactions.

(Default) *Online Processing:* When set to online, the move transaction processor processes the shop floor material backflush portions of transactions online by calling the inventory material transaction processor.



This profile option controls material processing of assembly completion, assembly return, and assembly completion backflush transactions initiated using the Completion Transactions window. Available values are listed below:

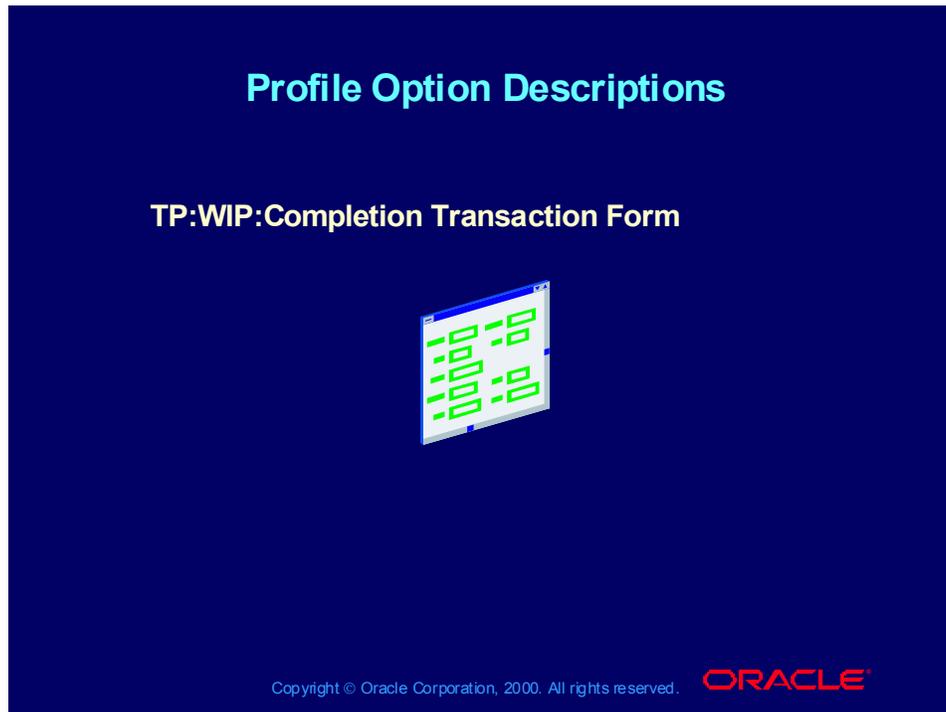
Background Processing: When you save a completion transaction, control is returned to you immediately. Assembly completions and returns and their associated backflush transactions are processed on a periodic basis.

Concurrent Processing: When you save a completion transaction, a concurrent process is spawned and control is returned to you immediately.

(Default) *Online processing :* When you save a completion transaction, the transaction is processed while you wait and control is returned once transaction processing is completed.

Note: If you set TP:WIP:Completion Transactions Form profile option to Background processing, this profile option is disregarded. Also, if you are using average costing, and the TP:INV: Transaction Processing Mode profile option in Oracle Inventory is set to Form level processing, you must set this profile option to Online to ensure that transactions are processed in the proper sequence.

Profile Option Descriptions



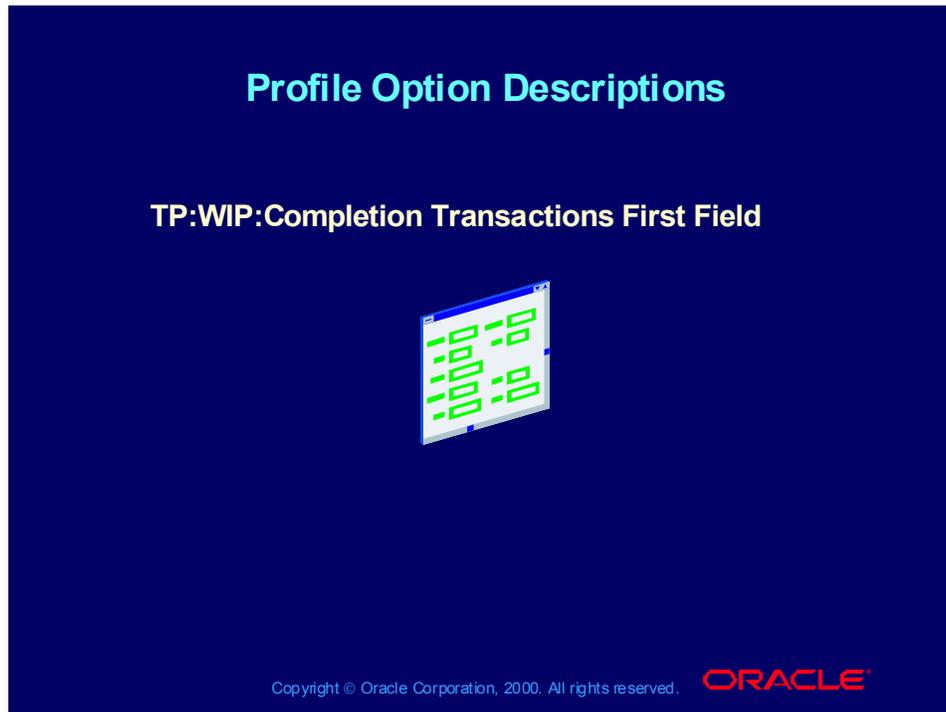
This profile option determines whether completion transactions are processed online or in the background when transacting assembly completions using the Completion Transactions window. A completion transaction includes updating the completion quantity of a job or repetitive schedule, identifying the component items and quantities to be backflushed, and transferring reservations from the final assembly order to appropriate sales order lines and deliveries. Available values are listed below:

Background Processing: When you save a completion transaction, control is returned to you immediately. Completion transactions are then processed on a periodic basis.

(Default) *Online Processing:* When you save a completion transaction, it is processed while you wait and control is returned once transaction processing is completed.

Note: If you are using average costing, and the TP:INV:Transaction Processing Mode profile option in Oracle Inventory is set to Form level processing, you must set this profile option to Online to ensure that transactions are processed in the proper sequence.

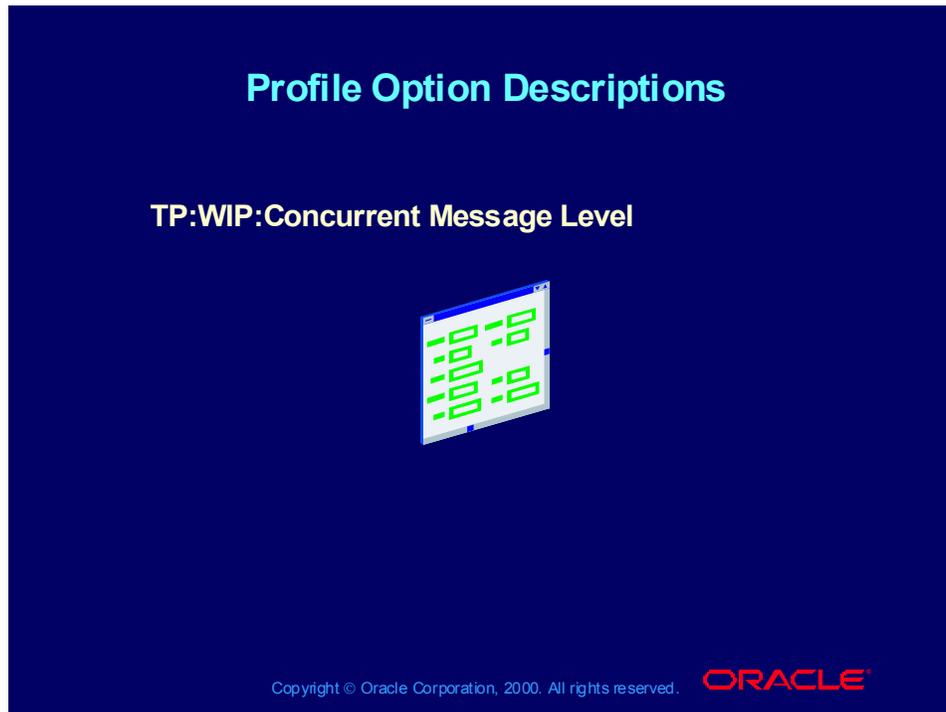
Profile Option Descriptions



This profile option determines which field the cursor defaults to when you first enter the Completion Transactions window. Set this option based on your predominant manufacturing environment: assemble-to-order, project or discrete job, or repetitive.

The available first field values are *Line*, *Assembly*, *Job* (Default), or *Sales Order*. You can navigate to another field to override the default.

Profile Option Descriptions



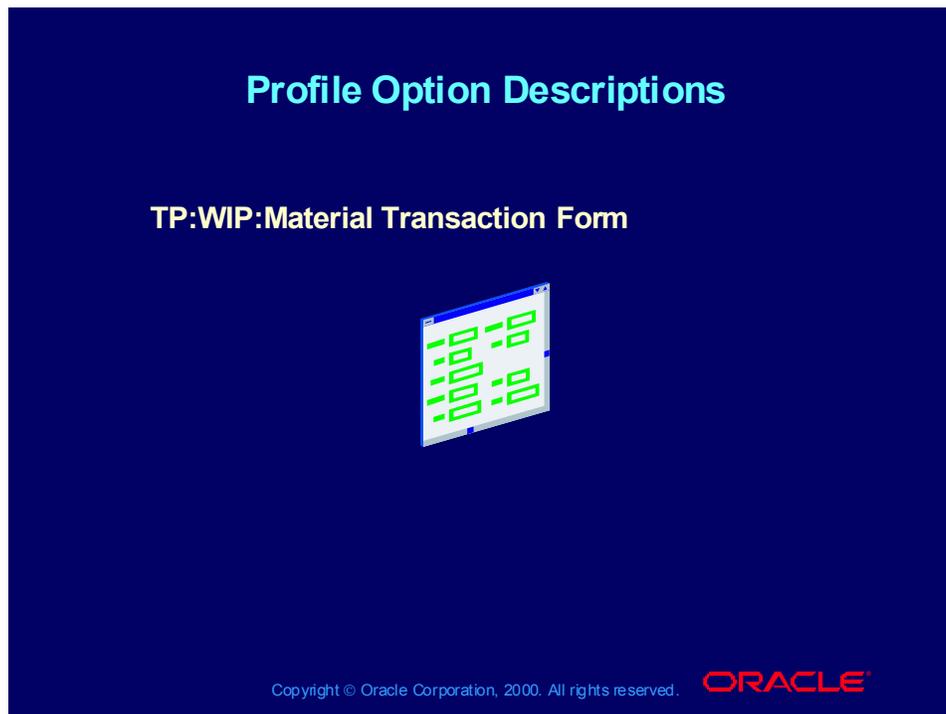
This profile option determines the level of detail reported in the move transaction concurrent log file during move transaction validation and processing. Available values are listed below:

(Default) *Message level 0* : Reports errors only.

Message level 1 : Reports processing activities and errors.

Message level 2 : Reports and time stamps processing activities and errors.

Profile Option Descriptions



This profile option controls the processing of component issue and return transactions entered in the WIP Material Transactions window. Available values are listed below:

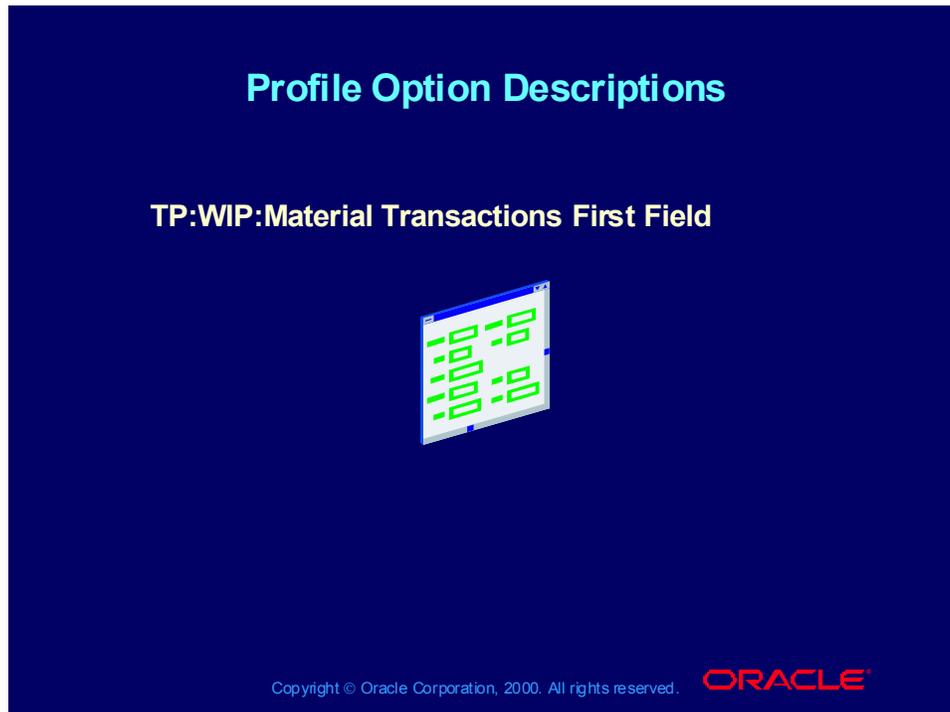
Background processing: When you save a material transaction, control is returned to you immediately. Transactions are then processed on a periodic basis.

Concurrent processing: When you save a material transaction, a concurrent process is spawned and control is returned to you immediately. The concurrent request number representing the concurrent process executing the issue or return transactions for the job or repetitive schedule is displayed.

(Default) *Online processing :* When you save a material transaction, the transaction is processed while you wait and control is returned once transaction processing is completed.

Note: If you are using average costing, and the TP:INV: Transaction Processing Mode profile option in Oracle Inventory is set to Form level processing, you must set this profile option to Online to ensure that transactions are processed in the proper sequence.

Profile Option Descriptions

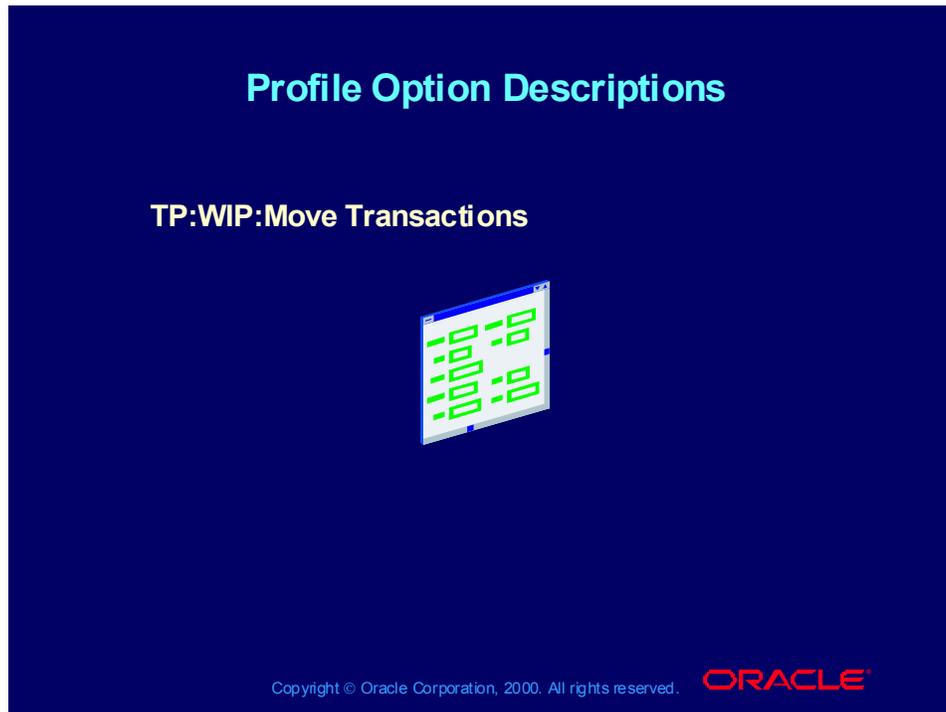


This profile option determines which field the cursor defaults to when you first enter the WIP Material Transactions window. Set this option based on your predominant manufacturing environment: assemble-to-order, project or discrete job, or repetitive.

The available first field values are *Line*, *Assembly*, *Job* (Default), or *Sales Order*. You can navigate to another field to override the default.

Note: You can only enter a Sales Order name if you have an ATO sales order linked to a job.

Profile Option Descriptions



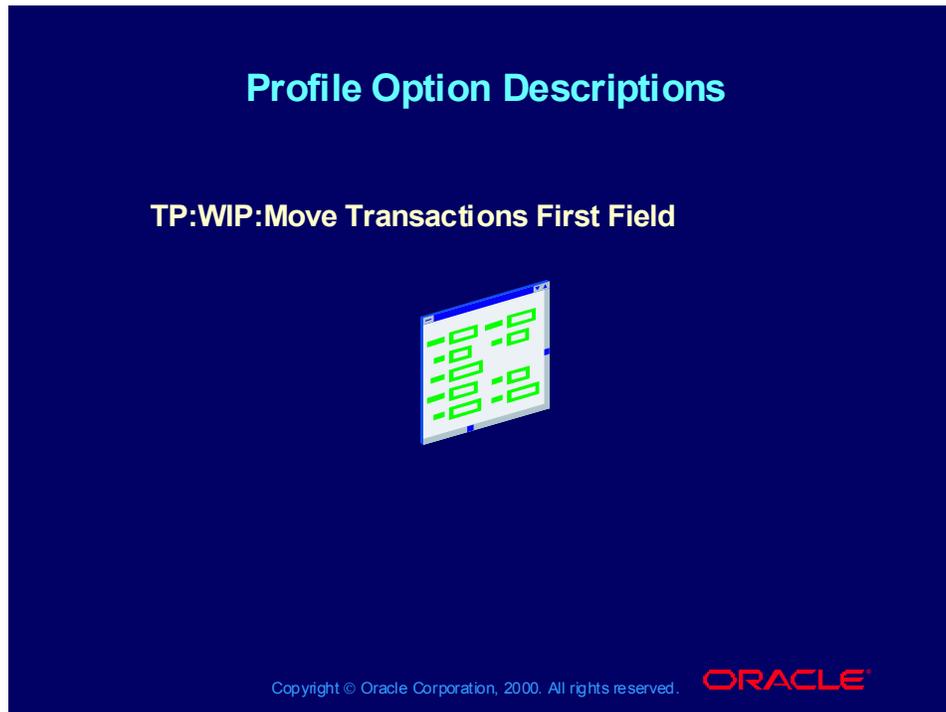
This profile option determines whether move transactions performed using the Move Transactions window are processed online or in the background. Available values are listed below:

Background processing: When you save a move transaction, control is returned to you immediately. Transactions are then processed on a periodic basis.

(Default) *Online processing:* When you save a move transaction, the transaction is processed while you wait and control is returned once transaction processing is completed.

Note: If you have this option set to Online processing, you cannot move more assemblies than are waiting at an operation step unless you have defined an Overcompletion Tolerance in WIP Parameters or for the job or assembly item. However, if you have this option set to Background processing, you can move any number of assemblies, but validation of the quantity takes place in the background. You can correct and resubmit transactions that have errors using the Pending Move Transactions window. Also, If you are using average costing, and the TP:INV:Transaction Processing Mode profile option in Oracle Inventory is set to Form level processing, you must set this profile option to Online to ensure that transactions are processed in the proper sequence.

Profile Option Descriptions

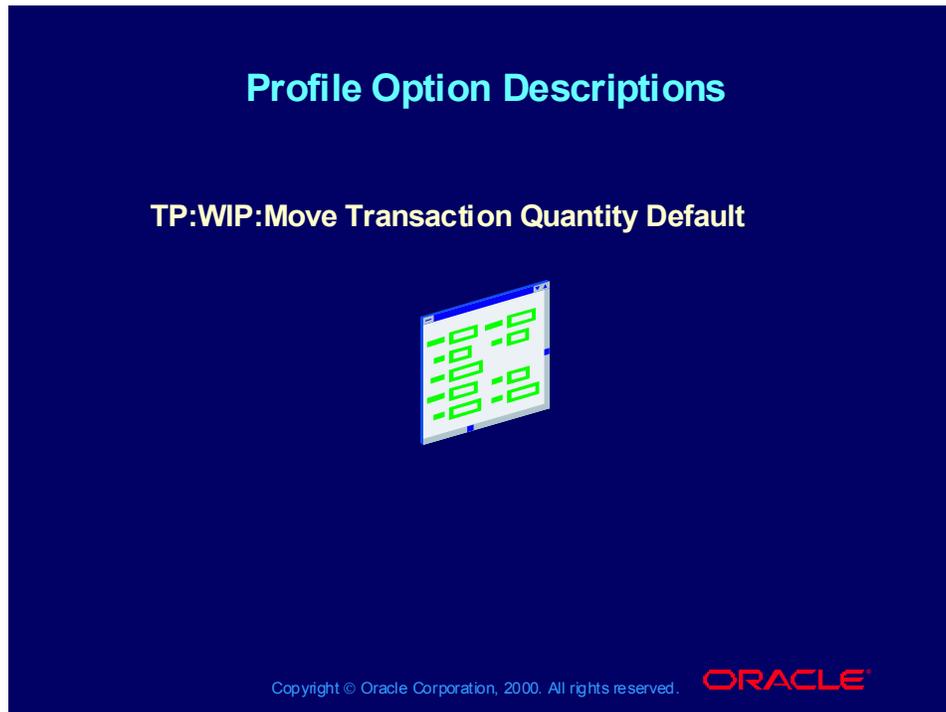


This profile option determines which field the cursor defaults to when you first enter the Move Transactions window. Set this option based on your predominant manufacturing environment: assemble-to-order, project or discrete job, or repetitive.

The available first field values are *Line*, *Assembly*, *Job* (Default), or *Sales Order*. You can navigate to another field to override the default.

Note: You can only enter a Sales Order name if you have an ATO sales order linked to a job.

Profile Option Descriptions



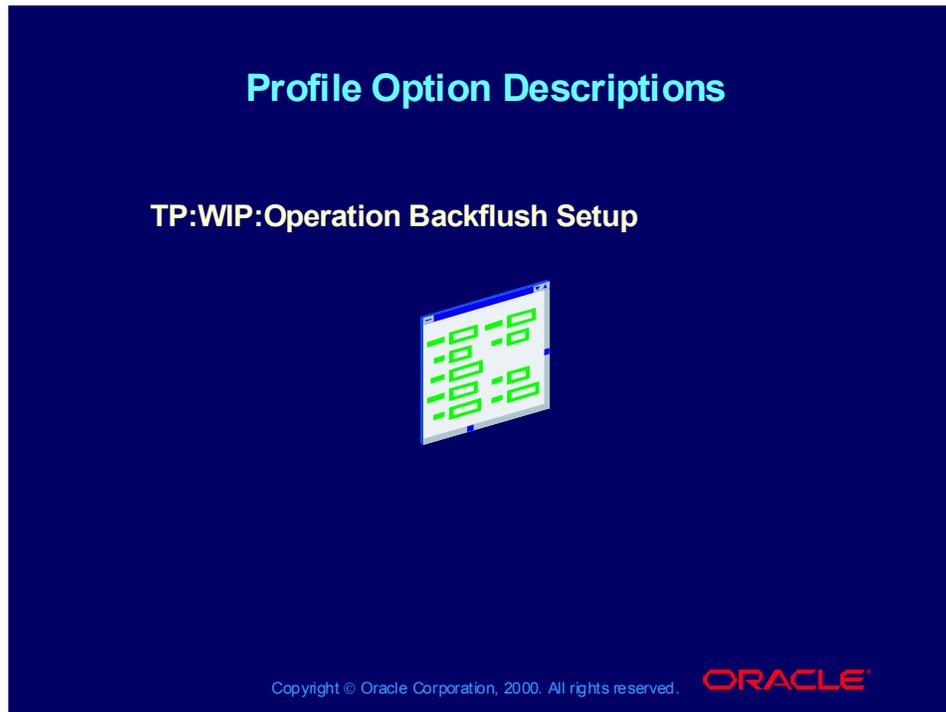
This profile option indicates if and how move transaction quantities are defaulted. Available values are listed below:

(Default) *None*: No transaction quantity is defaulted.

Minimum Transfer Quantity: When you perform a move transaction, the transaction quantity defaults to the minimum transfer quantity if the minimum transfer quantity is less than or equal to the available quantity. If the minimum transfer quantity is greater than the available quantity, and the available quantity is not zero, then the available quantity is defaulted.

Available Quantity: When you perform a move transaction, if the available quantity is not zero, the transaction quantity defaults to the available quantity.

Profile Option Descriptions

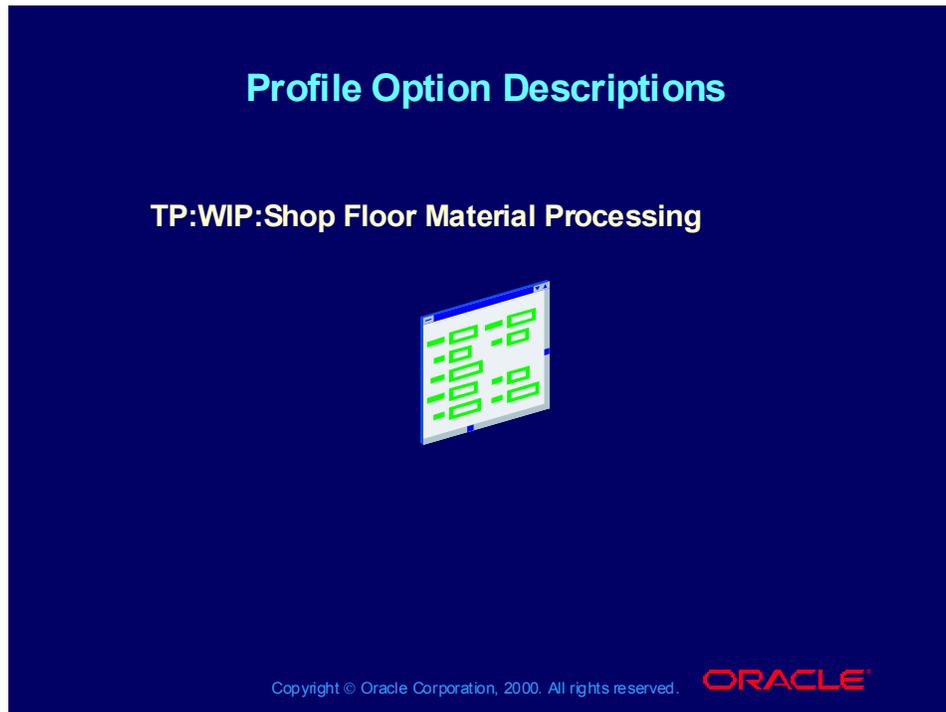


This profile option controls the backflush setup used in the Move Transactions window. This setup determines when the backflushing occurs for component items defined as Pull parts. It also determines how component lot numbers are derived. Available values are listed below:

Background processing: When you save a move transaction, control is returned to you immediately. The setup of operation backflush transactions is processed in the background on a periodic basis. Use this option only when lot numbers are automatically assigned (e.g., the *Lot Selection Method* parameter is set to Expiration Date or Receipt Date).

(Default) *Online processing:* When you save a move transaction, the setup of operation backflush transactions is processed while you wait and control is returned once the setup processing is completed. Use this option when lot/serial numbers must be manually assigned (e.g., the *Lot Selection Method* parameter is set to Manual).

Profile Option Descriptions



This profile option controls processing of operation and assembly pull backflush, assembly scrap, move completion, and move return transactions from the Move Transactions window. Available values are listed below:

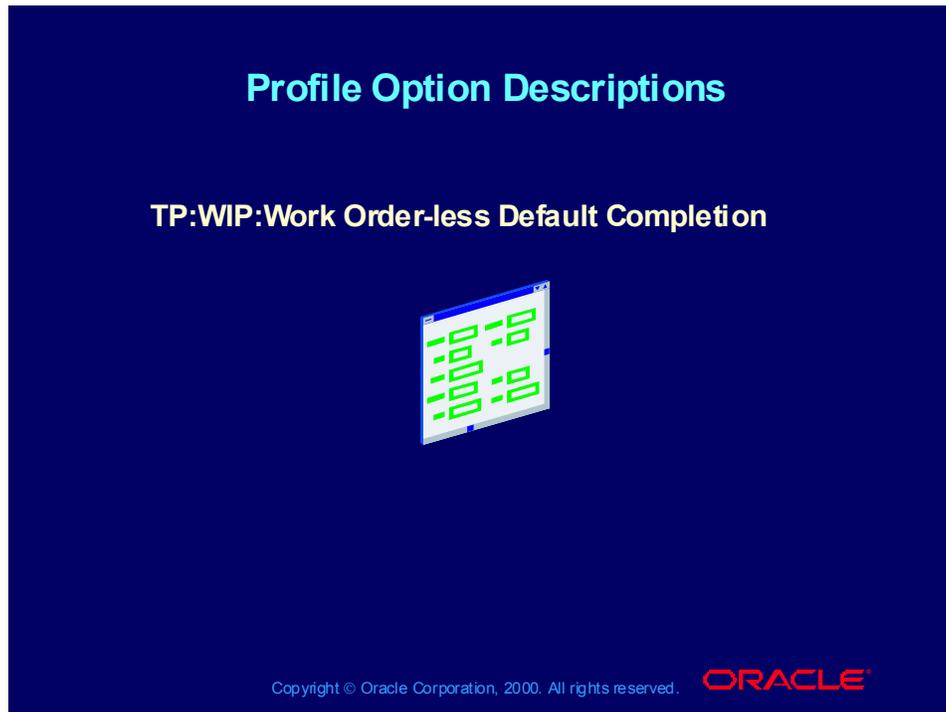
Background processing: When you save a move transaction, control is returned to you immediately.

Concurrent processing: Do not use background processing if you are backflushing lot controlled components that require manual entry of lot numbers either because of insufficient inventory or because the *WIP Backflush Lot Selection* parameter is set to Manual. When you save a move transaction, a concurrent process to process the material part of the move transaction is spawned and control is returned to you immediately.

The concurrent request number representing the concurrent process executing the move transactions for the job or repetitive schedule is displayed.

(Default) *Online processing* : When you save a move transaction, operation and assembly pull backflush, assembly scrap, move completion, and move return transactions are processed while you wait and control is returned once transaction processing is completed.

Profile Option Descriptions

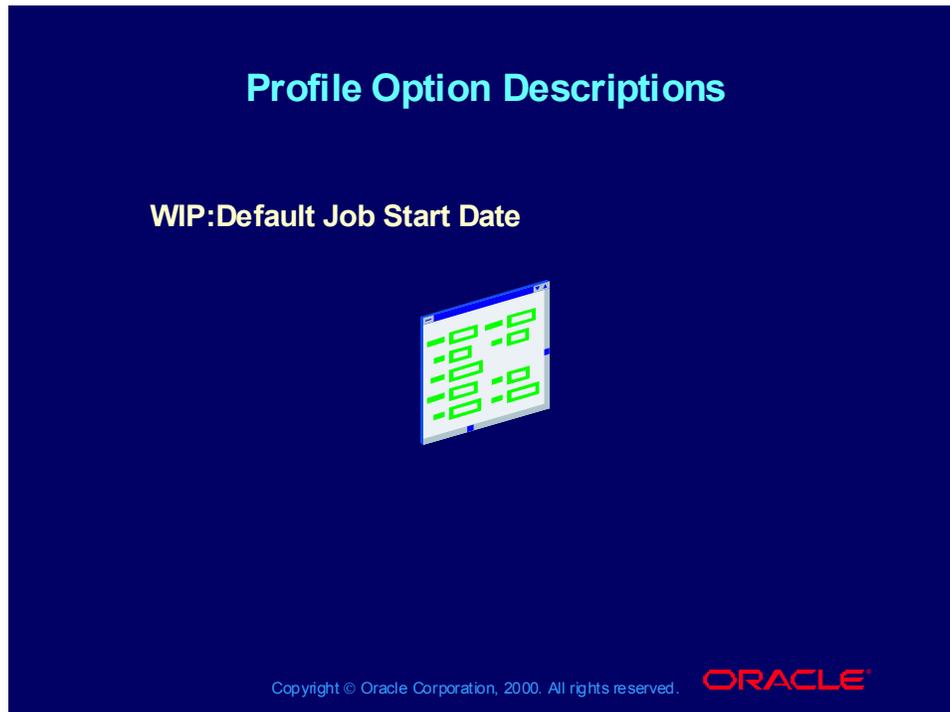


This profile option determines the default for the Scheduled flag in the Work Order-less Completions window.

Scheduled : The Schedule flag defaults to checked. Use this option if most of your work order-less completions are based upon flow schedules generated by the Line Scheduling Workbench.

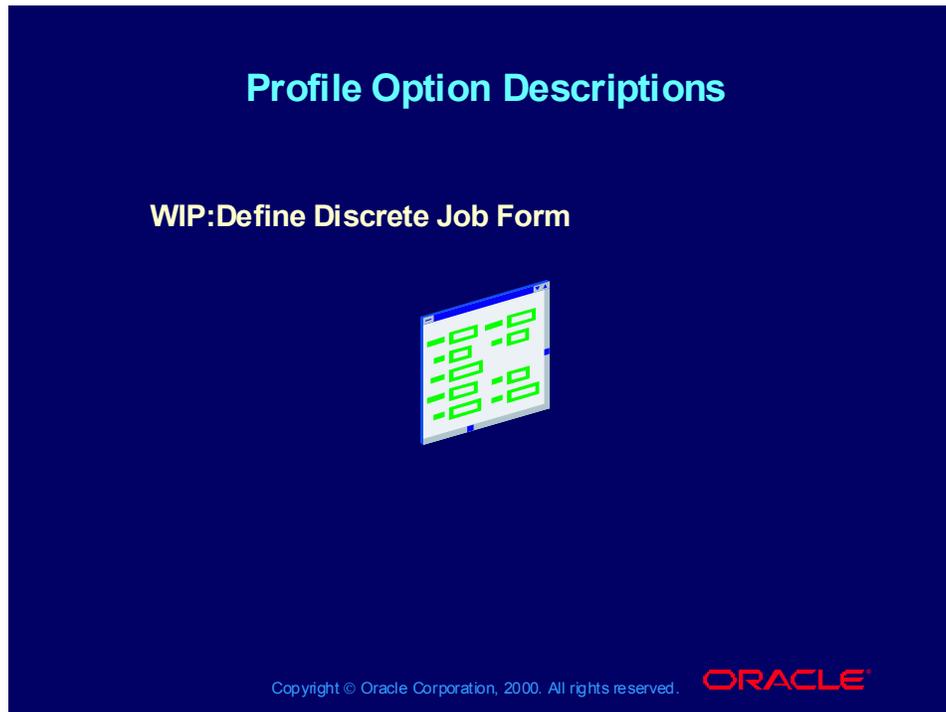
(Default) *Unscheduled* : The Scheduled flag defaults to unchecked. Use this option if most of your work order-less completions are manually entered and not based upon flow schedules generated by the Line Scheduling Workbench.

Profile Option Descriptions



This profile option determines whether the start dates for jobs default to the current date and time or not at all when defining jobs in the Discrete Jobs window. The options are *Yes* or *No* (Default) .

Profile Option Descriptions



This profile option Indicates how to load the bill of material and routing information when defining jobs in the Discrete Jobs window. Available values are listed below:

Concurrent definition: When you save a job, a concurrent process is spawned and control is returned to you immediately.

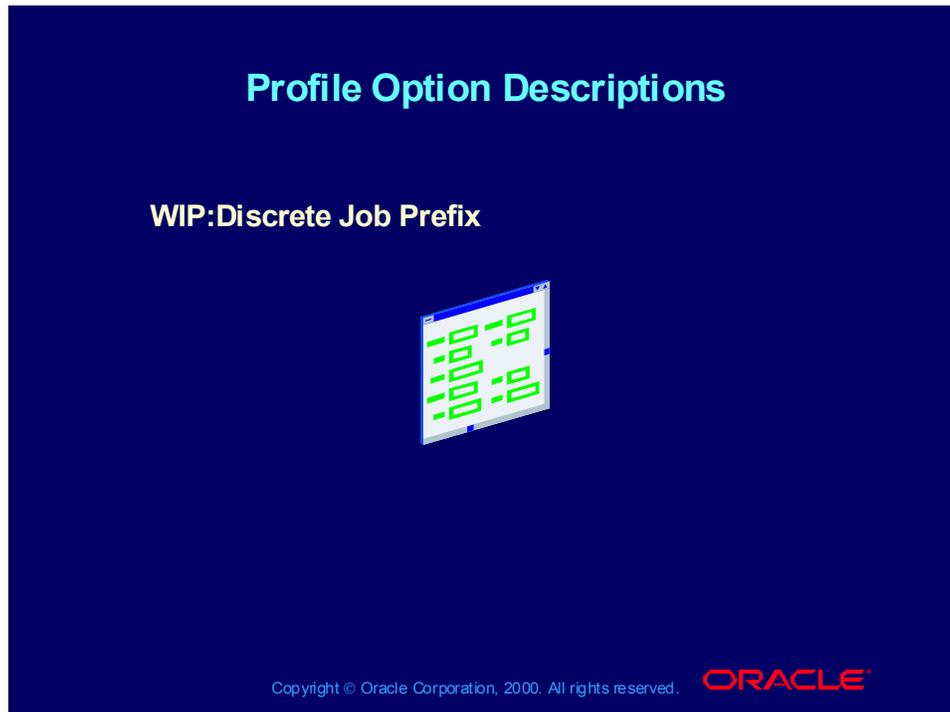
The concurrent request number representing the concurrent process is displayed. You can view the status of the process in the Concurrent Requests window. The concurrent process updates the job status to Pending Bill Load, and if the bill of materials load succeeds, updates the job status to Pending Routing Load.

Concurrent definition produces an output report that indicates the job, assembly, relevant dates, and successful completion of each step (bill of materials load, routing load, and costing load).

(Default) *Interactive definition:* When you save a job, job definition occurs immediately. The bill of material and routing are loaded while you wait and control is returned when the definition process is completed.

Note: If you have complex bills of material and long routings, concurrent processing is recommended.

Profile Option Descriptions



This profile option specifies the job prefix to use when autogenerating job names in the Discrete Jobs, Simulate Discrete Jobs, Import Jobs and Schedules, and AutoCreate windows in Work in Process, and in the Planner Workbench window in Oracle Master Scheduling/MRP and Oracle Supply Chain Planning. It is also used when autogenerating the numbers for flow schedules created in the Work Order-less Completions window.

Work in Process concatenates this prefix with a value from the sequence WIP_JOB_NUMBER_S to create a default discrete job name.

The default is *None*.

Profile Option Descriptions

Profile Option Descriptions

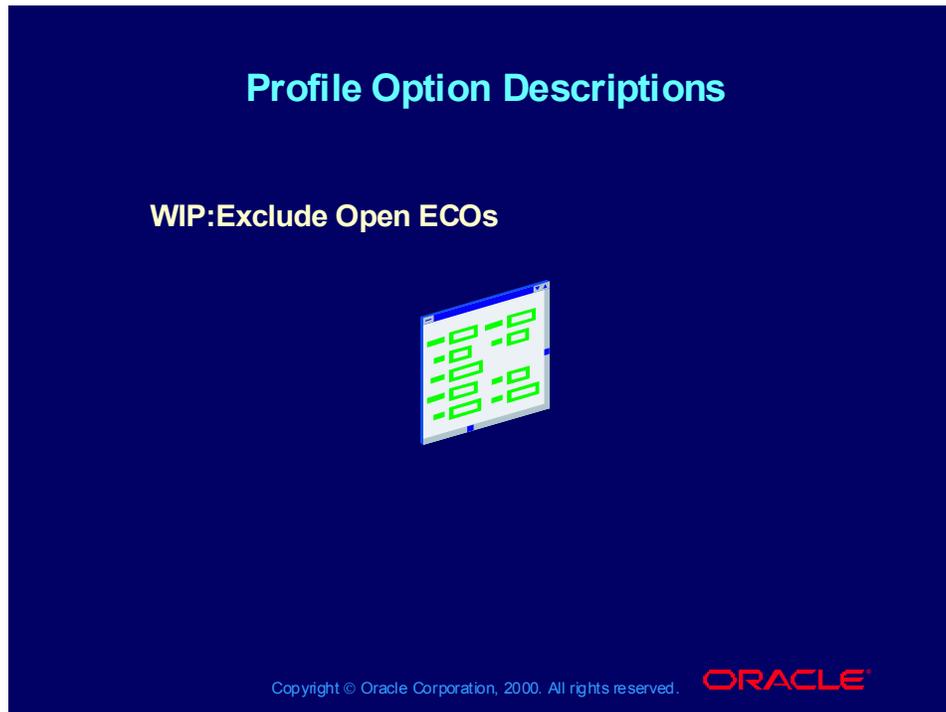
WIP:Enable Outside Processing Workflows



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This profile option determines whether or not outside processing workflows are enabled. The options are *Yes* and *No* (Default) .

Profile Option Descriptions

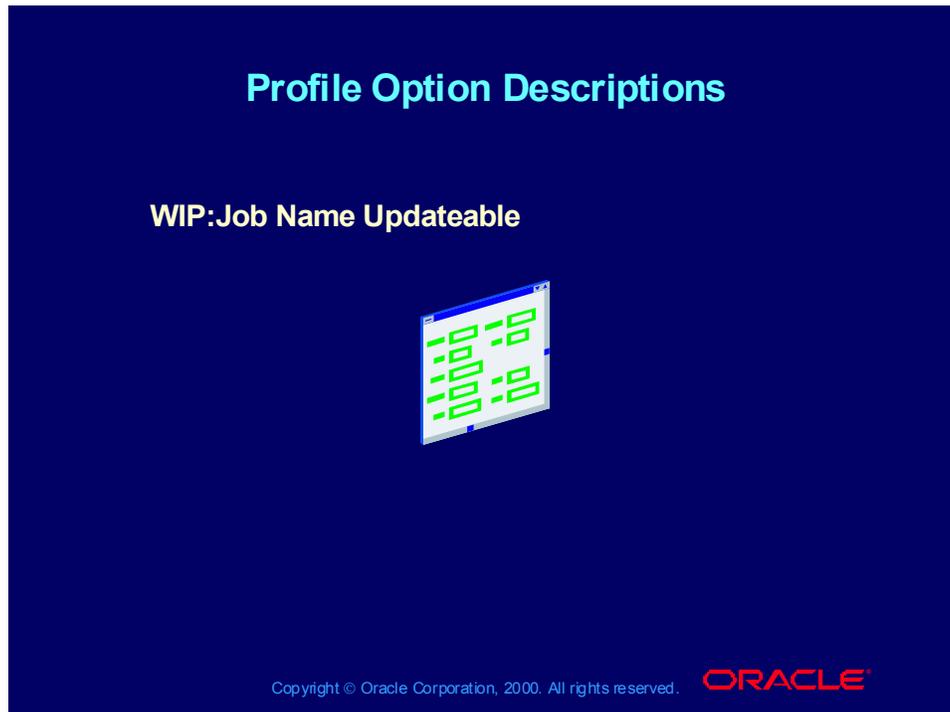


This profile option determines whether engineering change orders (ECOs) with Open statuses are excluded when you define jobs and schedules. If you exclude Open ECOs, only ECOs with Release, Schedule, and Implement statuses are implemented when you choose a bill of material revision or revision date and the bill of material is exploded. If you do not exclude Open ECOs, Open ECOs are included with Release, Schedule, and Implement ECOs.

This profile option also controls whether you can select revisions associated with open ECOs in the WIP Material Transactions window.

The default is *Yes*.

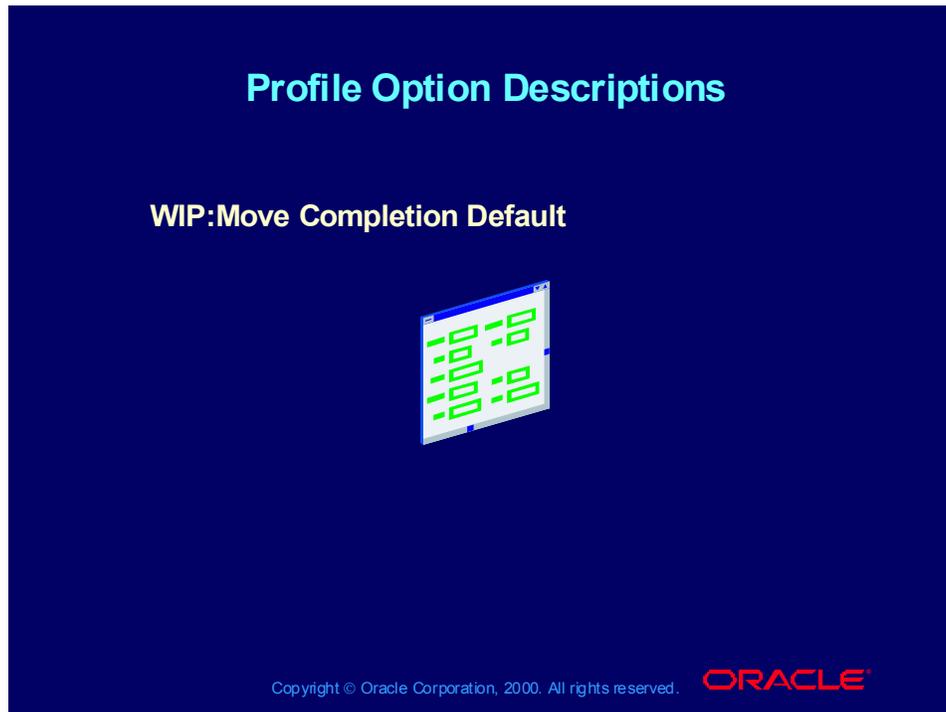
Profile Option Descriptions



This profile option determines whether you can update the names of existing jobs in the Discrete Jobs window.

The default is *Yes*.

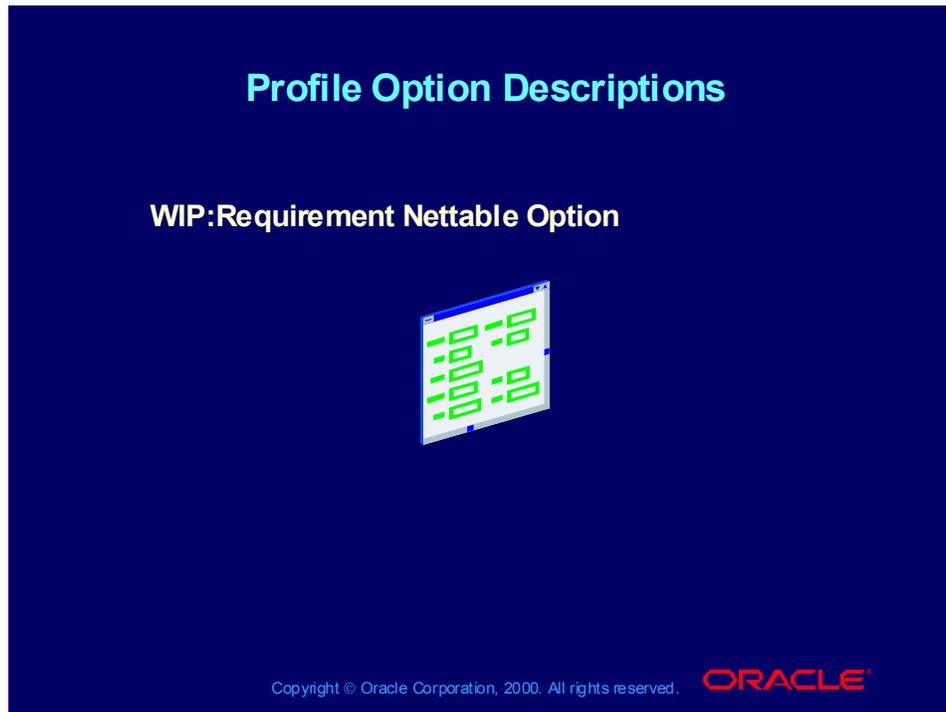
Profile Option Descriptions



This profile option determines the default transaction type for the Move Transactions window. If you specify Yes, the transaction type defaults to Complete. Otherwise, the transaction type defaults to Move. Note that you cannot specify that the Return transaction type be used as the default.

The default is *No*.

Profile Option Descriptions

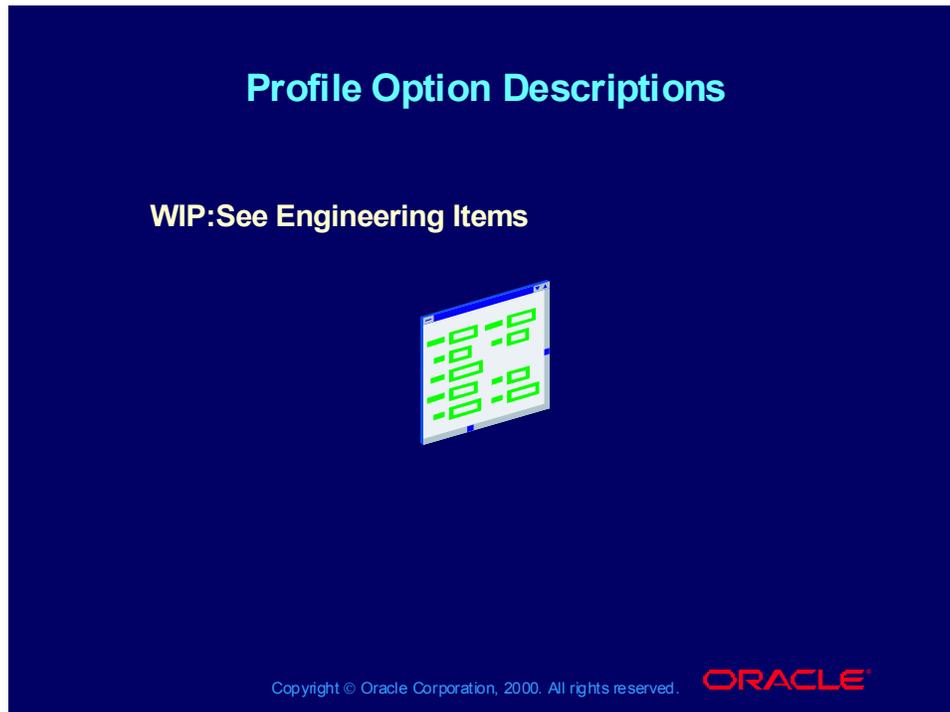


This profile option determines which subinventories to include when displaying on-hand quantities in the Material Requirements and View Material Requirements windows. Available values are listed below:

View only nettable subinventories: Include only nettable subinventories when displaying on-hand quantities.

(Default) *View all subinventories:* Include all subinventories (nettable and non-nettable) when displaying on-hand quantities.

Profile Option Descriptions



This profile option determines whether you can define jobs and schedules for engineering items and whether you can add engineering items as material requirements.

The default is *Yes*.

Security Functions

- **Function security is the mechanism by which user access to applications functionality is controlled.**
- **System administrators administer function security.**
- **Access to Work in Process functionality is controlled either by *menus and form functions/subfunctions* or by *form function parameters*.**



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Summary

You should now be able to do the following:

- **Describe the Setup Prerequisites**
- **Define WIP Parameters**
- **Set Profile Options**
- **Execute the Setup for Work in Process**

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