

b. Production LT

> The Production LT will be calculated only for Materials that are Produced. We will use SAP "Procurement Type = E" (In House Production) to identify those Materials.

When the item's procurement type is X, we will use the Purchased LT.

> In order to calculate P&I 'Production LT' we take as default the 'Processing time' from Work scheduling view (SAP Material Master). If this value is empty, we take the 'Inhouse production time'.

P&I Lead Time	Le vel Re qui red	Proposed SAP Field	Purpose in SAP	S A P L e v el	C o m m e n t
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Production LT

Material / Plant

Work scheduling view : Processing time (MARC-BEARZ) + Base quantity (MARC-BASMG)

Display Material 113952 (/Finished pdt & RM & SF)

MRP 4 | **Work scheduling** | Plant data / stor. 1 | Plant data / stor. 2 | Warehouse mgmt 1

Material: 113952 MACKAMINE 654 900 KG IBC
Plant: 7512 ZFR3 Clamecy

General Data

Base Unit of Measure	KG	kg	Unit of issue	
Production unit			P-S matl status	Valid from
Prodn Supervisor			Prod. Stor.Loc.	P1
Prod.Sched.Profile	Z001	Production	Mat. Grouping	
Serial no. profile		SerLevel	Overall profile	
		<input type="checkbox"/> Critical Part	<input type="checkbox"/> Version Indicator	
		<input type="checkbox"/> Batch rec. req.	Batch entry	<input checked="" type="checkbox"/> Batch Mgmt Rqt

Tolerance data

Underdely tol. 0,0 percent Overdely tol. 0,0 percent Unlimited

In-house production time in days

Lot size dependent	Setup time 0,00	Interoperation 0,00	Lot size independent	InhseProdTime 0
	Processing time 21,00	Base quantity 900		

or if not filled-in

MRP view or Work scheduling view : **Inhouse production time (MARC-DZEIT)**

Display Material 101544 (/Finished pdt & RM & SF)

MRP 1 | **MRP 2** | MRP 3 | MRP 4 | Work scheduling | Plant data / stor. 1 | Plant dat...

Material: 101544 AGUAR HP 105 25KG CARDBOARD CARTON
Plant: 7900 7424 / Chempak Houston

Procurement

Procurement type	E	Batch entry	
Special procurement		Prod. stor. location	
Quota arr. usage		Default supply area	
Backflush	2	Storage loc. for EP	
JIT delivery sched.		Stock det. grp	
<input type="checkbox"/> Co-product			
<input type="checkbox"/> Bulk material			

Scheduling

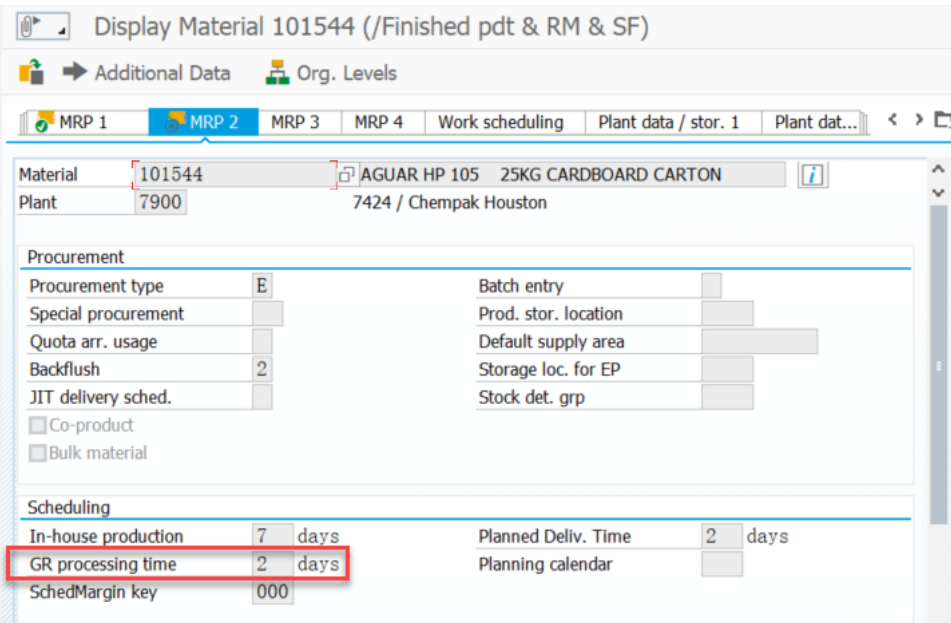
In-house production 7 days	Planned Deliv. Time 2 days
GR processing time 2 days	Planning calendar
SchedMargin key 000	

The Processing time + base quantity from 'Work scheduling view' or the inhouse production time are used by the MRP -> Scheduling activities.

Either Processing time + base quantity or Inhouse production time can be maintained.

Note: According to the Scheduling MRP parameter either those material master data will be used or the routing /recipe data will be used.

Material / Plant Work days

GR Processing LT	Material / Plant	<p>GR processing time (MARC-WEBAZ)</p>  <p>Display Material 101544 (/Finished pdt & RM & SF)</p> <p>Additional Data Org. Levels</p> <p>MRP 1 MRP 2 MRP 3 MRP 4 Work scheduling Plant data / stor. 1 Plant dat...</p> <p>Material 101544 AGUAR HP 105 25KG CARDBOARD CARTON Plant 7900 7424 / Chempak Houston</p> <p>Procurement</p> <table border="1"> <tr><td>Procurement type</td><td>E</td><td>Batch entry</td><td></td></tr> <tr><td>Special procurement</td><td></td><td>Prod. stor. location</td><td></td></tr> <tr><td>Quota arr. usage</td><td></td><td>Default supply area</td><td></td></tr> <tr><td>Backflush</td><td>2</td><td>Storage loc. for EP</td><td></td></tr> <tr><td>JIT delivery sched.</td><td></td><td>Stock det. grp</td><td></td></tr> <tr><td><input type="checkbox"/> Co-product</td><td></td><td></td><td></td></tr> <tr><td><input type="checkbox"/> Bulk material</td><td></td><td></td><td></td></tr> </table> <p>Scheduling</p> <table border="1"> <tr><td>In-house production</td><td>7 days</td><td>Planned Deliv. Time</td><td>2 days</td></tr> <tr><td>GR processing time</td><td>2 days</td><td>Planning calendar</td><td></td></tr> <tr><td>SchedMargin key</td><td>000</td><td></td><td></td></tr> </table>	Procurement type	E	Batch entry		Special procurement		Prod. stor. location		Quota arr. usage		Default supply area		Backflush	2	Storage loc. for EP		JIT delivery sched.		Stock det. grp		<input type="checkbox"/> Co-product				<input type="checkbox"/> Bulk material				In-house production	7 days	Planned Deliv. Time	2 days	GR processing time	2 days	Planning calendar		SchedMargin key	000			Number of workdays required after receiving the material for inspection and placement into storage.	Material / Plant Workdays
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To see the full list of LT extracted from SAP, please refer to: [Leadtimes coming from SAP](#)

Monolevel RLT Calculation

To calculate the total 'Monolevel' lead time of Produced Materials, we add the Good Receipt Processing time ("GR processing time" of SAP MM > MRP2 view).

Monolevel RLT Produced Materials = Production LT + GR Processing LT

SHS RLT Calculation

The SHS-dependent Replenishment Lead time (SHS RLT) will be calculated from a number of different lead times coming from SAP.

> This SHS RLT will be multilevel & multi-site

> We will compare this 'Industrial' RLT with the Promised LT to Customer ('Catalog LT') and adjust the Strategy of the Product (MTO, MTS, MTF) accordingly.

More information can be found [here](#).