

c. Purchased LT

> The Purchased LT will be calculated only for Materials that are Purchased. We will use SAP "Procurement Type = F" (External Procurement) to identify those Materials.

Be careful, when the item's procurement type is X, we will also use the Purchased LT.

> In order to calculate P&I 'Purchased LT' we take the sum of 'SAP Processing time for purchasing' + 'SAP Planned Delivery time' + 'GR processing time'

P&I Lead Times	Level Required	Proposed SAP Field	Purpose in SAP	SAP Level	Comment
Procurement LT	Material / Plant	SAP Processing time for purchasing (Workdays) Define at Plant SAP Custo (an example of value could be 2 days).	Time (Plant workdays) that the purchasing department requires to convert a purchase requisition into a purchase order.	Plant workdays	

Material / Plant

SAP Planned delivery time (Calendar days)

Could be maintained at different place:

- **Pld Delivery time from Purchase info Record** (1st priority)

Change Info Record: Purch. Organization Data 1

General Data	Conditions	Texts
Info record	5300005530	
Vendor	51018	Chicago Corporation Ltd.test ECC6 2
Material	136001	Sost. Aero - Mobile Test17
Material Group	0450	SEMI FIN.&FINISH PDT
Purchasing Org.	3200	Plant 8350 Standard

Control

Pl. Deliv. Time	10 Days	Tol. Underdl.		<input type="checkbox"/> No MText	
Purch. Group	GZF	Tol. Overdl.		<input type="checkbox"/> Ackn. Rqd	
Standard Qty	10.000 LB	<input type="checkbox"/> Unlimited		Conf. Ctrl	<input type="checkbox"/>
Minimum Qty		<input type="checkbox"/> GR-Bsd IV		Tax Code	JE
Rem. Shelf Life	D	<input type="checkbox"/> No ERS			
Shppg Instr.		Procedure		UoM Group	
Max. Quantity		Rndg Prof.			

Conditions

Net Price	10,00 CAD / 1 LB	Valid to	31.12.9999
Effective Price	10,00 CAD / 1 LB	<input type="checkbox"/> No Cash Disc.	
Qty Conv.	1 LB <-> 1 LB	Cond. Grp	
Pr. Date Cat.	No Control		
Incoterms			

- **Pld Delivery time from MRP2 view** (only if PIR is NA)

Material 101293 (/Finished pdt & RM & SF)

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

Material	101293	HODASURF DA 639	2250LB TT
Plant	0294	7424 / Sunland Greenville	

Procurement

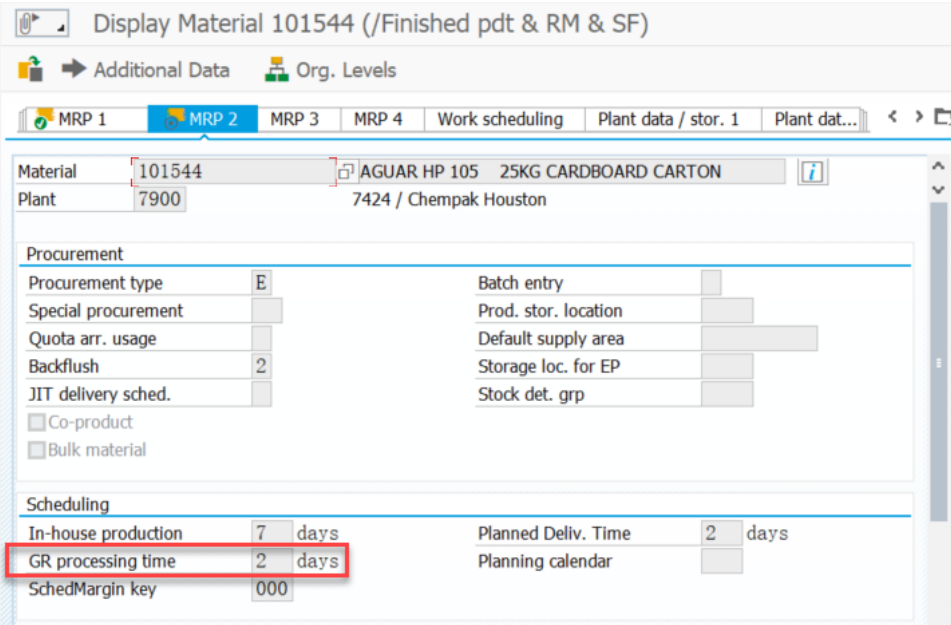
Procurement type	F	Batch entry	
Special procurement	I0	Prod. stor. location	
Quota arr. usage		Default supply area	
Backflush	2	Storage loc. for EP	
JIT delivery sched.		Stock det. grp	
<input type="checkbox"/> Co-product			
<input type="checkbox"/> Bulk material			

Scheduling

In-house production	0 days	Planned Deliv. Time	13 days
GR processing time	1 days	Planning calendar	US
SchedMargin key	000		

Number of calendar days needed to obtain the material or service if it is procured externally.

Material + MRP2 view 'Planned Delivery time' are defined, we take PIR as 1st priority.

GR Processing LT	Material / Plant	<p>GR processing time (MARC-WEBAZ)</p> 	Number of workdays required after receiving the material for inspection and placement into storage.	Material / Plant Workdays
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Attention on "Planned Delivery time" expected values:

1> For external procurement (purchased from Supplier):

The Planned Delivery time should contain the transit time + preparation time of Supplier to prepare the delivery/

2> For Internal procurement (purchased from another Solvay site = InterCo): it should only contain the Transit time.

For the ordering plant, this information is helpful to send the information to the supplying plant on time.

Note on Planned Delivery time determination for P&I:

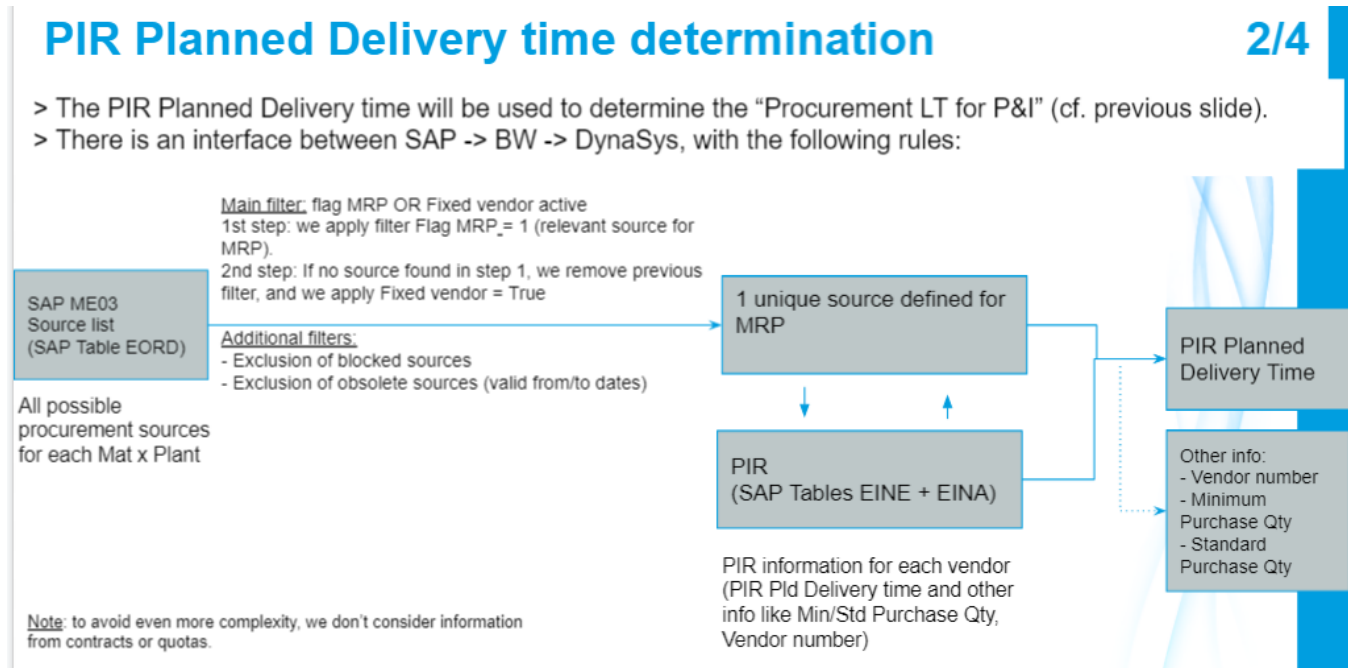
Note that in the determination of the Planned Delivery time, we have 2 sources: Purchase Info Record and MRP2 view. In DynaSys P&I, we follow MRP standard process: we take PIR Pld Delivery time as 1st priority. If it's not available, we take that from MRP2 view.

User can consult in SAP T-code ME01/ME02/ME03 or Table EORD, to see what are the different sources defined. For each source, then we need to consult tables EINE/EINA in SAP to get the Pld Delivery time.

To see the full list of LT extracted from SAP, please refer to: [Leadtimes coming from SAP](#)

More information about PIR Planned Delivery time

- > The PIR Planned Delivery time will be used to determine the “Procurement LT for P&I”.
- > There is an interface between SAP -> BW -> DynaSys to determine the 'PIR Planned Delivery time'
- > The same interface is used to determine the 'Vendor number', 'Minimum Purchase Quantity' and 'Standard Purchase Quantity'

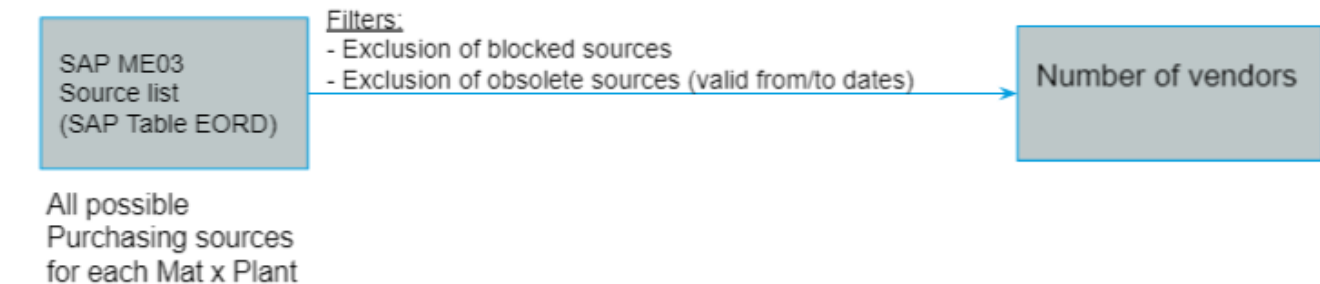


Number of Vendor / Suppliers

The “Number of Suppliers” (or “Number of vendors”) is calculated from the number of valide suppliers available in SAP Purchasing Source List, tcode ME03 (or can also access Table EORD).

In a nutshell, we take all sources and we apply the following filters in order to keep only the valid ones:

- Exclusion of blocked sources
- Exclusion of obsolete sources (using validity date)



Note: as we can see above, we take almost the same filters as when calculating the 'PIR Planned Delivery time' except the 'flag MRP' or 'Fixed vendor'

Monolevel RLT Calculation

Once we know the 'Procurement LT for P&I', we can proceed to calculate the Monolevel RLT and the SHS RLT.

Monolevel RLT	<p>Represents the total time between placing a production / replenishment order and the availability date.</p> <p>It's "monolevel" since it only considers the product's own lead times (scheduling / production lead time /) , does not consider other BOM level.</p> <ul style="list-style-type: none">• For Produced SKUs, Monolevel RLT = "Produced LT" + "GR processing LT"• For Purchased SKUs, Monolevel RLT = "Purchased LT" + "GR processing LT" <p>For more information about "Produced" or "Purchased LT", please refer to: Lead times coming from SAP</p>	Monolevel Independent of SHS
SHS RLT	<p>Represents the total time between placing a production / replenishment order and the availability date.</p> <p>It considers other BOM levels lead times (multi level) + distribution network (multi sites) and stock holding strategies.</p>	Multilevel LT SHS dependent

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

Monolevel RLT Purchased Materials = Procured 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](#).