

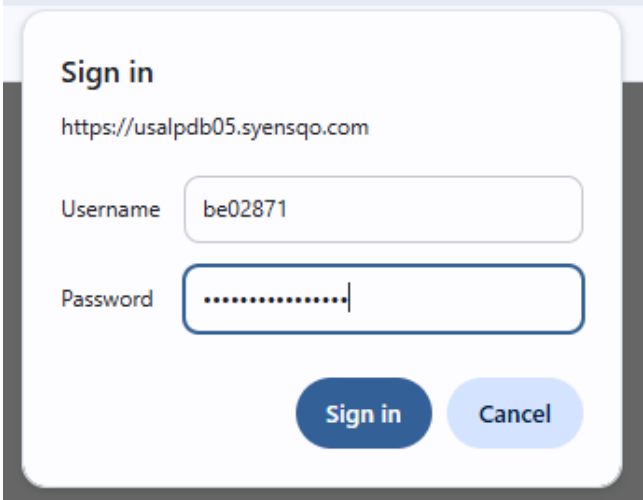
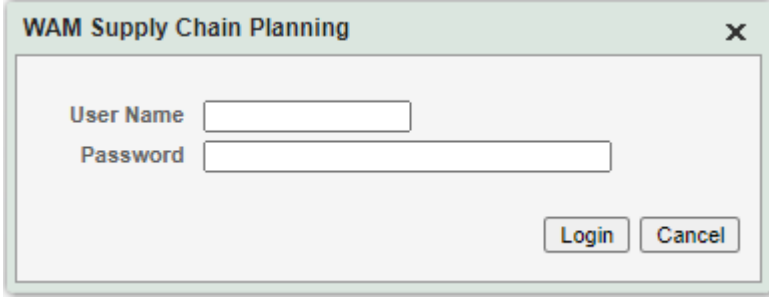
ADM - Advanced Data Management

- ADM Navigation
- Master Data
 - Material table
 - Material types
 - Material Search Codes
 - Location Dependent Quality Test Lag
 - Effect of the Quality Test Lag on the availability of the output product of a run:
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 - Merged Locations
 - Location types
 - Transit Times
 - Location Formula Number Map
 - Transitions
 - Transition Matrix and Default values
 - =====> this section below, and until the next divider seems not to be available with version 11.7 (our current version as of Aug 2023).
 - Product to product specific transitions
 - Transition by Groups
 - Classification
 - Class
 - Group
 - Material assignment to group:
 - Schedule colors
 - Package
 - Troubleshoot
- PF1 Schedule Interface Management
 - Schedule Upload Unit Parameters
 - Production Schedule Monitoring
 - Push Button Management
- WP1 Interface Management
 - Brazil Location Map
 - Brazil Material Map
- User Management

ADM Navigation

Access ADM and WebDP from your web browser of choice with this link: <https://usalpdb05.syensqo.com/ADMPrd/>

(if you need to access ADM, or WebDP in the dev system: <https://usalpdb06.syensqo.com/ADMDev/>)

Tips →	If it gives you this screen:  Enter your userID (not your email address) and network password.
	Then it takes you to the ADM screen were this other window pops up.  Just press enter.

A couple of tricks:

Using filters
Navigate from a table to another table
Mass change in ADM
Increase number of items displayed on one single page
Export into an Excel spreadsheet

Master Data

Material table

Picaso materials are not package specific. They match the SAP concept of a Material group.

WAM Supply Chain Planning

Materials

Editing Materials

***Material** PVDC PV910

***Nome Code** PVDC PV910

Description PVDC PV910

***Manager** Belden, Maria

***Material Type** Finished Products

Lot Size 1

***Unit of Measure** Met Tons

Search Code 4

Quality Test Lag (days) 2

Bulk Density 0

Box Liner Code

Box Shroud Code

Cust Tier 1

Margin 0

Inv Cost 40000

Bag Size Code 0

Material Field 1

Material Field 2 PVDC

Material Field 3 PVDC Resins

Material Field 4 PVDC

Material Field 5 PVDC Resins

Material Field 6

Material Field 7

Material Field 8 Resins

Material Field 9

Material Group Z68-22641

H4 Resins

The material fields are to be populated as below:

Field	Mandatory /Optional	Rule	Comment
Material	Mandatory		Once created, cannot be changed. Picaso materials are not package specific. They match the SAP concept of a Material group. For Finished goods and intermediates : Aromatics start with T and the second letter identifies the Product family . Aromatics is 4 - 6 digits of letters and numbers . For new products in STARS , STARS creates a 4 digit code and the interface to PICASO adds the T and product family in front(i.e. TF0J04). For FP, it is 14 character Short Description.
Nome Code	Mandatory	Same as Material	Must equal Material
Manager	Mandatory		Whomever is in charge. Usually the GP or the PM.
Material Type	Mandatory	Material Type	see below for different material types
Description	Mandatory	Free text	Long description
Lot Site			
Unit of Measure	Mandatory	as fit	Kilograms or Metric Tons : all other tables refer to that one. Example: production rates in production standards. Once set, better not change it.
Search Code	Mandatory	Material Search Code	See below critical for EP separation of Aromatics & FP; Not to be mistaken with the Inventory target search code.
Quality Test Lag	Optional	Important for ATP	Production end date + QC test lag = product availability : consider the effect of the Quality test lag on the grid and on the SAP Planned orders.
Bulk Density			
Box Liner Code			

Box Shroud Code			
Cust Tier			
Margin			
Inv Cost	Mandatory	default with 40000	used by EP: Additives = 10,000; Resins & intermediates = 20,000 ; Finished goods = 40,000
Bag Size Code			= 1 for Abacus products
Material Field 1			was used for Stock or MTO but Inventory targets Search Code manages that now
Material Field 2		5 character	Product family : critical since used in many reports to separate product family
Material Field 3			Business
Material Field 4			Product family full description
Material Field 5			Product family subgroups used in variety of ways
Material Field 6			Product family subgroups used in variety of ways
Material Field 7			Product family subgroups used in variety of ways
Material Field 8			Used to be H4 before H4 field was added
Material Field 9			
Material Group	Mandatory	as per SAP	(recognized as Material Field 10)
H4	Mandatory	as per SAP	For it to work, you want to update the Product Family / Business Unit table.
Business Unit	Mandatory		Once this table is updated, the fields will auto populate.
Finance Material Type	Mandatory		H4: SPP H4 mapping
Archetype	still used?		
Material Field 15	Optional		~~For Tavaux: A material with a flag in this field will be factored in with the optimizer. that project has been cancelled~~
Material Field 16	Mandatory		used for HPAM
Material Field 17	Mandatory		used for H5
Material Field 18	Optional	X if product is under allocation	

Material types

Material types	Identifier	What for
Finished Goods	P	Finished goods
Additives	A	Raw Materials / Additives
Intermediates	I	Bulk, polymers
Package Materials	P	Package Materials

Resins	R	Resins
sfm	M	monomers (TFEM, Sulfones, VF2,...)
wide spec		wide spec or substandard

Material Search Codes

Search code	What for
900	Obsolete
999	New products (interfaced)
1	Aromatics
2	FluoroPolymers
4	PVDC
7	FP intermediates

Location Dependent Quality Test Lag

The material shows a global Quality test lag:

Editing Materials

X

*Material

PVDC PV910

*Nome Code

PVDC PV910

Description

PVDC PV910

*Manager

Belden, Maria

▼

*Material Type

Finished Products

▼

Lot Size

1

*Unit of Measure

Met Tons

▼

Search Code

4

Quality Test Lag (days)

2

Bulk Density

0

Box Liner Code

Box Shroud Code

Cust Tier

1

Margin

0

Inv Cost

40000

Bag Size Code

0

Material Field 1

Material Field 2

PVDC

Material Field 3

PVDC Resins

Material Field 4

PVDC

Material Field 5

PVDC Resins

Material Field 6

Material Field 7

What if the QC time is not the same in the two (or more) production plants that this product is manufactured?

Hit the  Quality Test Lag key. It takes you to the Location Dependent Quality Test Lag Table.

The Location dependent Quality test lag let you deal with locations where the Quality test lag differs from the material default.

Quality Test Lag

 Refresh  Edit  Add  Copy  Delete  Show/Hide Filter  Close

Material	Location	Quality Lag
pvdc pv910		
PVDC PV910	Default for all locations	2

Adding Quality Test Lag

*Material

...

*Location

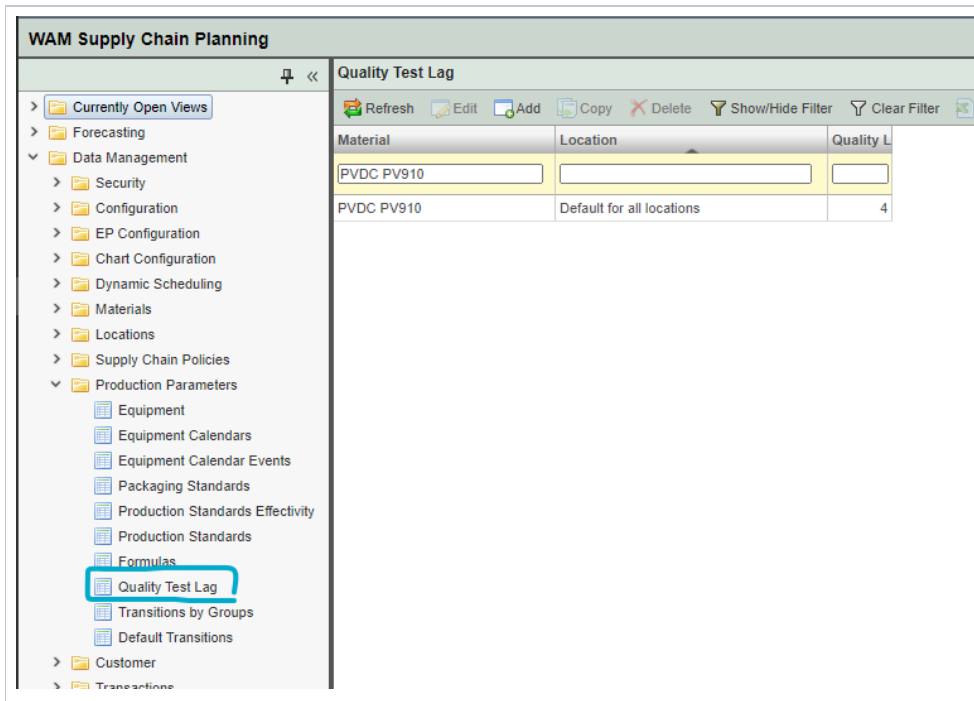
...

*Quality Lag

Save

Cancel

Note: you may access the Location Dependent Quality Test Lag directly from there:



Effect of the Quality Test Lag on:

- the production schedule: none
- the grid: it offsets the availability of the output product of a run. See below
- the SAP Planned order: it offsets the end date of the planned order corresponding to a run.

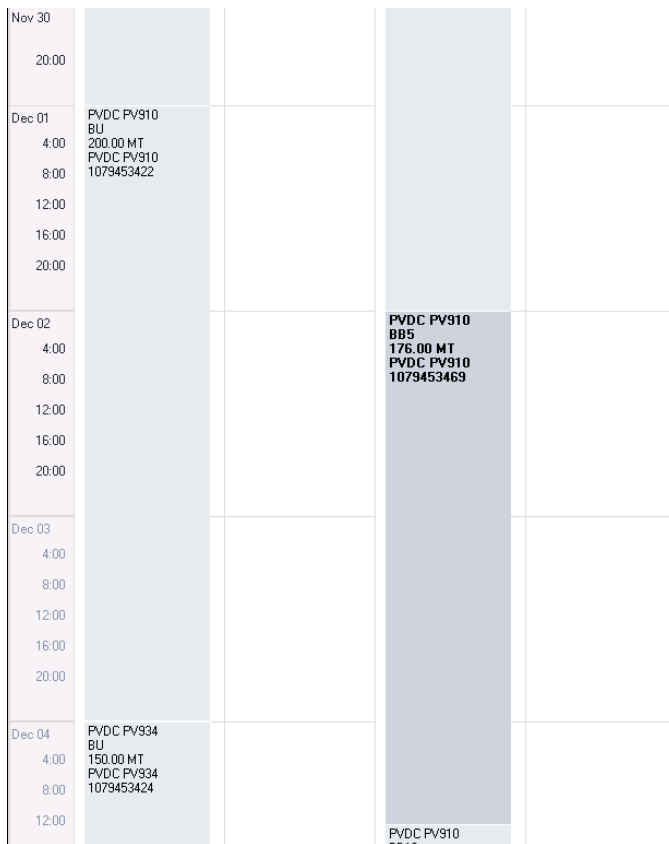
In order to avoid duplicating QC times when one is maintained in SAP, you want to use the Schedule Upload Lag Adjustment Table.

Keep in mind that the Picaso SAP interface always uses these two factors (Quality Test Lag and Schedule Upload Lag Adjustment). This is hardcoded in the interface.

Effect of the Quality Test Lag on the availability of the output product of a run:

Consider this run. Its attributes:

- Product: PVDC PV910
- Package: BB5
- Line: SUSP PKG
- Formula 80 (from possible formulas for that line, determined by [Production Standard](#) and [Production Standard Effectivity](#))
- Quantity 176 MT
- Start Date: Dec 02 2022
- End Date: Dec 04 2022 - 12:00 (determined by quantity and rate. Rate from Production Standard Effectivity)
- Customer Order: SAP Planned Order number. This Run has already been interfaced with SAP.

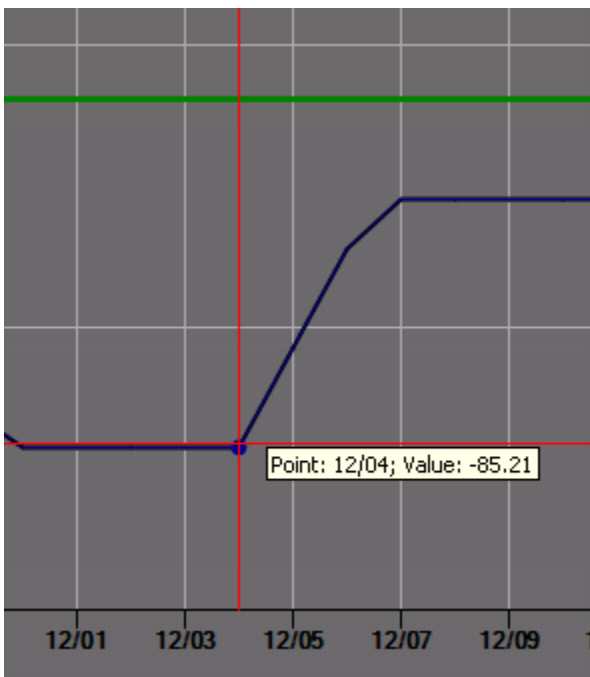


Run Properties

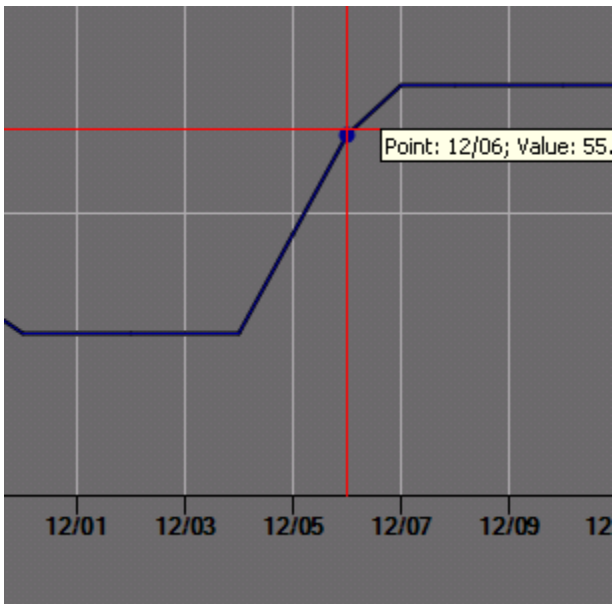
General	Formula	Predecessors	Successors	Notes	Orders
Line:	SUSP PKG				
Sku Code:	0161835	PVDC PV910			
Product:	PVDC PV910	PVDC PV910			
Package:	BB5	Big Bag, 1200 KG			
Formula:	80/V01-TAW-BB5-V01 S800-P				
Start:	12/02/2022	at:	00:00:00		
☐ Run Should Start On or After this date and time:					
Lot Size:	56.0000 MT				
Quantity:	176.00 MT				
176.00 MT Gross Production at 100 % Yield and 95.00 Op %					
Rate:	3.0877 MT/Hour	<< 2.4569 (std rate)			
Duration:	2 days 12 hr 0 min	Ends:	12/04/2022	at:	12:00:00
Run Reference #:					
Status:					
Customer Order:	1079453469				
Lot Number:					
Link Info:					
☐ Output Reported					
☐ Completed					
☐ Exportable					
Type: Free					
Calc Size OK Cancel					

The effect of the plot of a 2 days QC Lag:

- despite the run starting Dec 02, it will start affecting (increasing) the projected inventory Dec 04



- the run ends on Dec 04, but the projected inventory will continue to increase until Dec 06



Effect of the Quality Test Lag on the end date of the corresponding SAP Planned order:

Consider the dates of this run:

- Start Date: Nov 07 2022 - 15:26
- End Date: Nov 08 2022 - 12:04
- Customer Order: 1079448688 (SAP Planned Order number).

Prd	Product Description	Pkg	Unit
Nov 03			
Nov 04			
Nov 05	AS-4133 HS BK 324 C5		
Nov 06	AS-4133 HS BK 324 BJ 50.00 MT TFSN 1079448725		
Nov 07	AS-4145 HS BK 324 C5		
Nov 08	AS-4145 HS BK 324 BJ A-1133 HS BK 324 BJ 27.00 MT TFWC 1079447948 A-1145 HS BK 324 BJ 30.00 MT TFWD 1079447948 AS-1133 HS BK 324 C5 36.00 MT TFSF 1079447966		
Nov 09			
Nov 10			
Nov 11			
Nov 12	AS-1133 HS BK 324 BJ 22.00 MT TFSF		
Nov 13	AS-1145 HS BK 324 C5		

General	Formula	Predecessors	Successors	Notes	Orders
Line:	D2				
Sku Code:	0066328	CPDS AMODEL (PPA)			
Product:	TFPD	AT-6115 HS NT			
Package:	C5	BOX, 500 LINED			
Formula:	2(0revac				
Start :	11 / 07 / 2022	at:	15 : 26 : 00		
☐ Run Should Start On or After this date and time: / / at : : :					
Lot Size:	5.0000	MT			
Quantity:	9.00	MT			
9.78 MT Gross Production at 92 % Yield and 95.00 Op %					
Rate:	0.4990	MT/Hour << 0.4990 (std rate)			
Duration:	0 days 20 hr 38 min	Ends:	11 / 08 / 2022	at:	12 : 04 : 00
Run Reference #:	10614510	☐ Output Reported ☐ Completed ☒ Exportable Type: Free			
Status:					
Customer Order:	1079448688				
Lot Number:					
Link Info:					
Calc Size OK Cancel					

And the dates of its corresponding SAP Planned Order:

- Start Date: Nov 07 2022
- End Date: Nov 15 2022

Stock order	1079448688	Standard in-house pro...
Material	66328	PPA AT-6115 HS NT C500 P
Planning Plant	AQS	SSP-US /AUGUSTA

Header Assignment Master Data

Quantities

Order quantity	9 000,000	KG	Scrap quantity	0,000
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Dates/Times

	Basic Dates	Production Dates	Other Dates
End	15.11.2022		Available for MRP 15.11.2022
Start	07.11.2022		GR processing time 0
Opening	02.11.2022		

Other Data

Production Plant	AQS
Storage Location	FPWM
Production Version	0001
BOM Explosion Number	

Firming

☒ Planned Order
☐ Components
☐ Capacity Dispatched
☒ Conversion Indicator

	Picaso Run	SAP Planned Order	Difference
Start Date	Nov 07 2022	Nov 07 2022	same
End Date	Nov 8 2022	Nov 15 2022	7 day

What is going on? This:

Quality Test Lag		
Material	Location	Quality L
tfpd		
TFPD	Default for all locations	7

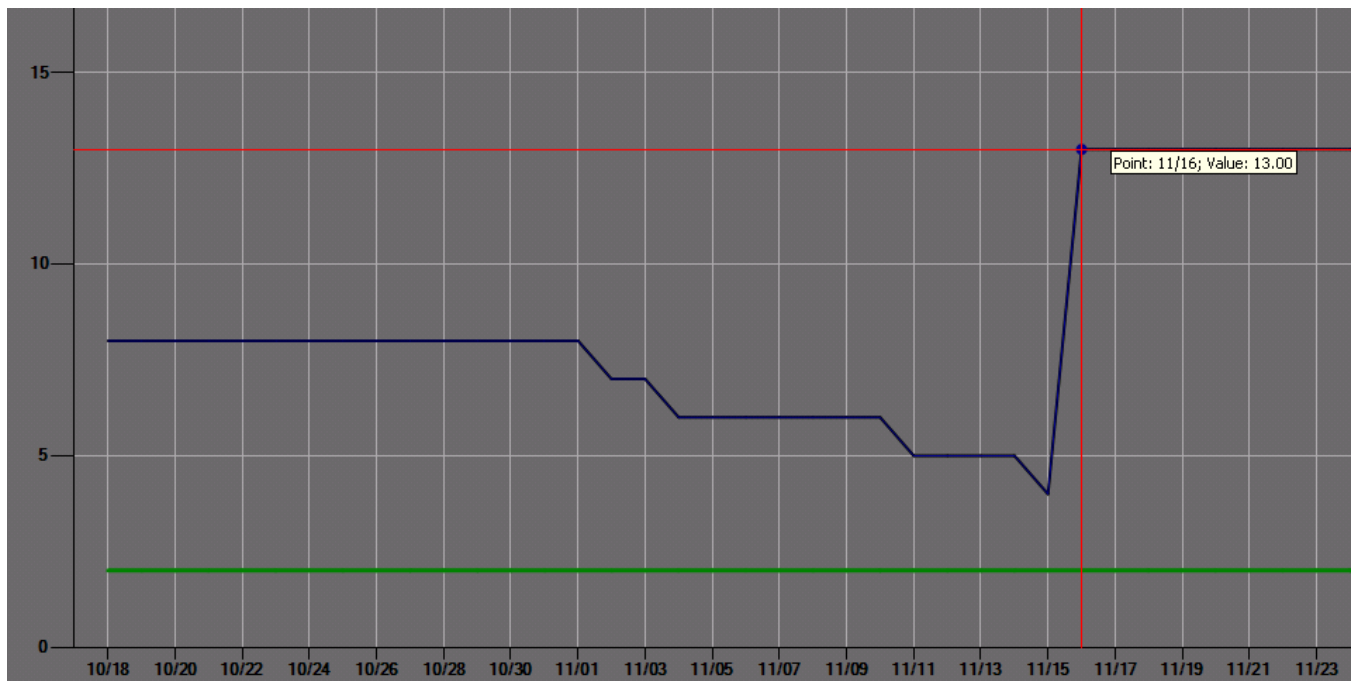
The Quality Test Lag adds to the SAP Planned order End Date:

	Picaso Run	SAP Planned Order	Difference
Start Date	Nov 07 2022	Nov 07 2022	same
End Date	Nov 8 2022	Nov 15 2022	= Picaso End Date + QC Lag

Why this? Because the QC Lag affects the availability of the output product in Picaso, and in order to achieve the same in SAP, the interface offsets the End date of the Planned order accordingly.

This results in the availability date of the output product in Picaso and SAP to (better) match. See below:

Picaso plot (TFPD / C5 in AQS)



SAP MD04 (66328 / AQS)

✓

Show Overview Tree

LTP

Fcst

Adj MatMast

Material

66328

PPA AT-6115 HS NT C500 P

Plant

AQS

MRP Type

Z0

Material Type

Z700

Unit

KG

Individual List

Cross-Plant View

A..	Date	MRP ...	MRP element data	Rescheduli...	E..	Receipt/Reqmt	Available Qty	Pr...	St...
	18.10.2022	Stock					8 000,000		
	01.11.2022	Order	0005807802/000010/0...			1 000,000-	7 000,000		
	03.11.2022	Order	0005807804/000010/0...			1 000,000-	6 000,000		
	10.11.2022	Order	0005811914/000010/0...			1 000,000-	5 000,000		
	14.11.2022	Order	0005811916/000010/0...			1 000,000-	4 000,000		
	15.11.2022	PlOrd.	1079448688/Stck*			9 000,000	13 000,000	0001	FPWM
	01.12.2022	Order	0005807807/000010/0...			1 000,000-	12 000,000		
	01.12.2022	Order	0005812408/000010/0...			1 000,000-	11 000,000		

In Plants where the QM module is operational, Lab time is also maintained in SAP. In order to avoid duplicating Lab times (in Picaso and SAP0, you want to maintain the [Schedule Upload Lag Adjustment](#) table.

SKU Mapping

SAP code added to SKU Code mappings (SKU code is 7 digits with leading 0's)

WAM Supply Chain Planning

Close All

Arrange All

Help

Settings

At

SKU Code Mappings

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Excel Import

Excel Exp

Alternate SKU Codes

Material	Package	SKU Code	SKU Description
pvdc pv910			
PVDC PV910	BB1- Big Bag, 500 KG	0180948	PVDC PV910
PVDC PV910	BB10- Big Bag, 250 kg	0192897	PVDC RSN S8/900 COM
PVDC PV910	BB5- Big Bag, 1200 KG	0161835	PVDC PV910
PVDC PV910	BU - BULK	0038690	PVDC PV910

Currently Open Views

SKU Code Mappings

Forecasting

Data Management

Security

Configuration

EP Configuration

Chart Configuration

Dynamic Scheduling

Materials

Materials

Material Equivalents

Material Name History

Material Types

Classifications

SKU Code Mappings

Alternate SKU Codes

Inventory Targets and Preferences

Used by DRP, DS, EP, the grids, and inventory targeting reports.

Note: for RM, we use inventory targets for EP (Replenishment type must be "Purchased" and Supplier must be "000124143" so that it doesn't generate an unassigned supply).

Used by the Forecast adjustment program (for the "Lead Time" field).

The material fields are to be populated as below:

Field	Mandatory /Optional	Rule	Comment
Material	Mandatory		
Package	Mandatory		
Location	Mandatory		
SKU Code & SKU Description	Mandatory	Auto-populated	
Resupply from (Location)	Mandatory	use same location if produced use other location otherwise	if "Resupply from (Location)" = "Location", then ADM knows that this product is produced in said location.
Resupply in (Package)	Mandatory	use same as above package (99.9% of the time)	
Min Reorder Qty	Mandatory		used by DRP and Inventory Targeting. The unit of measure used is found in the material master.
Safety Stock Units	Mandatory	Inv Unit or Days	If Inv Unit, this is a fixed safety stock. The unit of measure can be found in the material master If Days, Safety stock is demand driven (days of coverage)
Safety Stock	Mandatory		
High Target Units	Mandatory		If Inv Unit, this is a fixed high target. The unit of measure can be found in the material master If Days, High target is demand driven (days of coverage)
Ship Resupply to	Optional	keep blank	
Time fence (days)	Optional	use 0	
Stockouts allowed (days)	Optional	use 7	DRP will not trigger new recommendation if stock out is less or equal to

Forecast ignored (days)	Optional	use 7	Applies to unconsumed forecast. Even if forecast still visible on the grid, it will not trigger any recommended replenishment if within X days of the end of the month
Responsible = MTO or STK	GBU Mandatory	STK or MTO	shown on the grid
Search code	GBU Mandatory	1 (if MTO) or 0 (if STK)	used by DRP
Cust Srvc Tgt	GBU Mandatory	use 95 an adjust later	used to recommend safety stocks
Lead Time (days)	GBU Mandatory	use 30 (?) and adjust later.	used by forecast adjustment algorithm (adjust fcst to confirmed demand within Lead Time)

Formula

A formula is a list of ingredients. It is our SAP Bill of Materials.

Most formulas are created in Picaso by uploading SAP BOM's. Other formulas are created from STARS.

(automatic refresh if BOM modified? TBC)

Formulas numbers	are generated automatically in Picaso as per another ADM table . These numbers will be used in Production Standards Effectivity. Formula 9 are created in Picaso (i.e. not from SAP or STARS interface)
Formula descriptions	are named after the SAP Production version they are created from. Therefore, a BOM <u>not</u> associated to a Production Version will not load in Picaso. Nomenclature: <Production version number> - <Plant> - <Package code> - <Production version description>
I/O Type	Continuous / Ending / Beginning how does the output product of a run affects projected inventory
I/O Lag (hours)	TBC

When creating a run in the Picaso Scheduler, specify the formula (or keep the default). This formula will determine the production version used when creating the Planned order in SAP.

Unless, the [Schedule Upload Unit Parameter](#) indicates otherwise (two main options: always use production version 0001 or production version is determined by the formula)

The screenshot displays the 'WAM Supply Chain Planning' application. On the left is a navigation tree with categories like 'Forecasting', 'Data Management', 'Materials', and 'Production Parameters'. The 'Formulas' option under 'Production Parameters' is highlighted with a red box. The main area shows a table of formulas:

Material	Formula	Formula Description
pvdc pv910		
PVDC PV910	80	V01-TAW-BB5-V01 S800-P
PVDC PV910	81	V01-TAW-BB1-V01 S800-P
PVDC PV910	82	V01-TAW-BU-V01 S800
PVDC PV910	83	V01-TAW-BB10-V01 S800-P

An 'Editing Formulas' dialog box is open in the foreground, showing the details for the selected formula (Material: PVDC PV910, Formula Number: 80, Formula Description: V01-TAW-BB5-V01 S800-P). The dialog includes fields for 'Notes', 'I/O Type' (set to 'Continuous'), and 'IO Lag (Hours)' (set to '0'). 'Save' and 'Cancel' buttons are at the bottom right.

SKU Code Mappings (Material = PVDC PV910)

Refresh
 Edit
 Add
 Copy
 Delete
 Show/Hide Filter
 Clear Filter
 Fields
 Alternate SKU Codes

Material	Package	SKU Code	SKU Description
PVDC PV910	BB1- Big Bag, 500 KG	0180948	PVDC PV910
PVDC PV910	BB10- Big Bag, 250 kg	0192897	PVDC RSN S8/900 COM
PVDC PV910	BB5- Big Bag, 1200 KG	0161835	PVDC PV910

Selection Conditions

Plant	TAN	SLVFR-FR /TAVAU	(P
Material	161835		
MRP Controller		Detailed pl	
Key date		Rate-based	
Production line		Rough-Cut	

Production versions

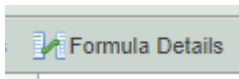
	Plant	Material	Pr...	Text	Lock	M.
☐	TAN	161835	V01	V01 S800-P	Not... ▾	
☐	TAN				Not... ▾	

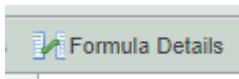
Formulas

Refresh
 Edit
 Add
 Copy
 Delete
 Show/Hide Filter
 Fields
 Formula Details
 Formula Effectivity

Material	Formula	Formula Description
pvdc PV910		
PVDC PV910	80	V01-TAW-BB5-V01 S800-P
PVDC PV910	81	V01-TAW-BB1-V01 S800-P

Formula Details



Select a formula, hit the  key. The formula details is the actual list of components of a formula.

This formula has only one component (it is a repackaging formula).

WAM Supply Chain Planning

Currently Open Views

Forecasting

Data Management

- Security
- Configuration
- EP Configuration
- Chart Configuration
- Dynamic Scheduling
- Materials
- Locations
- Supply Chain Policies
- Production Parameters
 - Equipment
 - Equipment Calendars
 - Equipment Calendar Events
 - Packaging Standards
 - Transitions
 - Production Standards Effectivity
 - Production Standards
 - Formulas**
 - Quality Test Lag

Formula Details (Formula Number = 80, Material = PVDC PV910)

Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export

Formula	Material	Element	Package	In/Out	Units
80	PVDC PV910	PVDC PV910	BU	Input	% Wgt

Editing Formula Details (Formula Number = 80, Material = PVDC PV910)

*Formula Number80

*MaterialPVDC PV910

*ElementPVDC PV910

*PackageBU

*In/OutInput

*Units% Wgt

*Amount Used100

*I/O TypeContinuous

IO Lag (Hours)0

SaveCancel

Materials	Output product
Element	Input product (i.e. component)
Package	Package code of the component
In/Out	Input for all components of the formula
Units	either % for variable quantity or absolute amount for fixed quantity
I/O Type	Beginning / Continuous / Ending
IO Lag (Hours)	TBC

Production Standards

Similarly to an SAP Production version, the Production standard indicates which products/packages are qualified on which lines.

WAM Supply Chain Planning

Production Standards

Unit Material Package Lot Size Min Run Default Yield % Up time Batch Res Time Co-Product Co-Product pct Notes Setup Time Configuration Cycle Position Cycle Frequency

Unit	Material	Package	Lot Size	Min Run	Default	Yield %	Up time	Batch Res Time	Co-Product	Co-Product pct	Notes	Setup Time	Configuration	Cycle Position	Cycle Frequency
RESINES	PVDC PV910	BU	56	56	✓	100	100	0							
SUSP PKG	PVDC PV910	BB1	56	56	✓	100	95	0							
SUSP PKG	PVDC PV910	BB10	56	56	✓	100	95	0							
SUSP PKG	PVDC PV910	BB5	56	56	✓	100	95	0							

Editing Production Standards

*Unit SUSP PKG

*Material PVDC PV910

*Package BB5

*Lot Size 56

*Min Run Length 56

Default ☒

*Yield % 100

*Up time (%) 95

*Batch Res Time (min) 0

Co-Product

Co-Product pct 0

Notes

*Setup Time (hrs) 0

Configuration

*Cycle Position 0

*Cycle Frequency 1

Allow Skip ☐

*Qty Increment 0

*Pct of Tot 100

Save Cancel

Field	Mandatory /Optional	Rule	Comment
Unit	Mandatory		
Material	Mandatory		
Package	Mandatory		
Lot size	Mandatory	see Dynamic Scheduling	in combination with Min Run, it is used by DS to determine automatically generated run quantity
Min Run	Mandatory	see Dynamic Scheduling	in combination with Min Run, it is used by DS to determine automatically generated run quantity. Also used to calculate Inventory targets in production locations.
Default	Optional	one default production standard per product /package/location	Used by EP & Inventory targeting to determine the preferred mode of production.
Yield	Mandatory	between 0 and 100	percentage of component loss (see below)
Up Time	Mandatory	between 0 and 100	efficiency loss (see below)
Bath Res Time	Mandatory	set to 0	no idea what this stuff does
Setup Time	Mandatory	set to 0	no idea what this stuff does
Cycle position	Mandatory	see Dynamic Scheduling	position on the production wheel. Sequence in which DS will schedule a run.
Cycle frequency	Mandatory	see Dynamic Scheduling	in combination with equipment cycle length , determine how many times per cycle length is DS going to create a run. e.g. if cycle length is 30 days and Cycle frequency is 2, then DS will generate two runs per month.
Allow skip	Optional	leave blank	no idea what this stuff does
Qty increment	Mandatory	set to 0	no idea what this stuff does
Pct to Tot	Mandatory	set to 0 or 100	used by EP to calculate production penalty (in combination with Swing %)

Up Time

Equivalent (however NOT identical) to OEE.

OEE is a line efficiency indicator that factors in planned downtimes, unfavorable production rates, times when lines do not run due to no demand, etc.

Up Time does not account for these aforementioned factors, because they are already accounted for on the production schedule as separated events (downtimes, for examples, are captured on the production schedule, therefore they not need being incorporated in the Up Time)

Up Time indicates how real life events will affect standard production rates.

Up time affects [run duration](#).

Standard Rate	Run duration for a 10 t run	Up Time = 100 %	Up Time = 90 %	Up Time = 50 %	Comment
0.5 MT / h	20 h (= 10 MT / (0.5 MT /h))	20 h (= 20h / 1)	22h13 (= 20h / 0.9)	40h (= 20h / 0.5)	Up time affects the run duration. It does not affect consumption nor production rate

Find an example of how Up Time affects a run [here](#)

Yield

Equivalent to SAP assembly scrap.

Affects [component consumption quantity](#) of runs using that production standard.

Also affects [output gross quantity](#) (not the net quantity). Net quantity is affecting the output product grid. This is the effective quantity of in-spec product we expect to get. Add the losses to this to get to the gross quantity.

And, finally, affects [run duration](#).

What if affects	Standard output/input rate or run duration	Run with Yield = 100 %	Run with Yield = 90 %	Run with Yield = 50 %
Output product	1500 kg	1500 kg	1500 kg / 0.9 = 1666.7 kg	1500 kg / 0.5 = 3000 kg
Input Product A	400 kg	400 kg	400 kg / 0.9 = 444.4 kg	400 kg / 0.5 = 800 kg
Input Product B	100 kg	100 kg	100 kg / 0.9 = 111.1 kg	100 kg / 0.5 = 200 kg
Input Product C	1000 kg	1000 kg	1000 kg / 0.9 = 1111.1 kg	1000 kg / 0.5 = 2000 kg
Run duration	24 h (for 1500 kg of output product)	24 h	24 h / 0.9 = 26 h 40min	24 h / 0.5 = 48 h



Yield and Up Time have a cumulative effect. In other words, the duration of a run will be affected by both Up Time and Yield.

What if affects	Standard output/input rate or run duration	Run with Yield = 90 % and Up Time = 80 %
Output product	1500 kg	1500 kg / 0.9 = 1666.7 kg
Input Product A	400 kg	400 kg / 0.9 = 444.4 kg
Input Product B	100 kg	100 kg / 0.9 = 111.1 kg
Input Product C	1000 kg	1000 kg / 0.9 = 1111.1 kg
Run duration	24 h (for 1500 kg of output product)	24 h / 0.9 / 0.8= 33 h 20 min

Production Standards Effectivity

Ties together a [Production Standard](#) and a [formula](#). Also the Production Standard Effectivity is where the production rate is maintained. The unit of the production rate (e.g. kg/h) does not show on this ADM view.

The volume (e.g. kg) derives from the [material master](#). The time (e.g. hours) derives from the equipment definition.

The Default flag drives which production standard effectivity auto-populates when creating a run. There should only be one default per production standard.

WAM Supply Chain Planning Close All Arrange All Help Settings About Logout be028

Production Standards Effectivity

Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset Settings

Fields Formula Production Standard

Production Standard	Unit	Material	Package	Formula	Effective	Expiration D	Rate	Default
		pvdc pv910						
RESINES / PVDC PV910 / BU	RESINES	PVDC PV910	BU	82	1/1/2020	12/31/2099	3.541	✓
SUSP PKG / PVDC PV910 / BB1	SUSP PKG	PVDC PV910	BB1	81	1/1/1900	1/1/2099	2.4569	✓
SUSP PKG / PVDC PV910 / BB10	SUSP PKG	PVDC PV910	BB10	83	1/1/1900	12/31/2099	2.4569	✓
SUSP PKG / PVDC PV910 / BB5	SUSP PKG	PVDC PV910	BB5	80	1/1/1900	12/31/2099	2.4569	✓

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 Quality Test Log
 Transitions by Groups

Field	Mandatory/Optional	Rule	Comment
Production Standard	Mandatory	Pick Production Standard to which PSE applies	
Unit	Mandatory	Pick unit from Production Standard	
Material	Mandatory	Pick Material from Production Standard	
Package	Mandatory	Pick Package from Production Standard	
Formula	Mandatory		
Effective date	Mandatory	always use 01/01/1990	US date format
Effective end date	Mandatory	always use 12/31/2099	US date format
Rate	Mandatory		unit of measure from the material master
Default	Optional		If X default PSE when inserting a run on the schedule

Product Family / Business Unit

The Material groups are interfaced from SAP into Picaso.

However, in order for the Picaso Material table to autopopulate the H4, Business Unit, and Finance Material Type field, you want to assign these three attributes to their corresponding material group in this table.

WAM Supply Chain Planning

Client-Specific Data

- Production Postings
 - ATP Truth
 - Blocked Transfers
 - Color Definitions
 - Consumption Exceptions
 - Customer Name Overrides
 - Customer Xref
 - Customer Tiers
 - Exchange Rate Scenarios
 - Forecast Edit Log
 - Forecast Privileges (Annual)
 - JCodes (Oudenaarde)
 - Location Formula Number Map
 - Lot Numbers
 - Master Batch
 - MTO Products
 - PGL Code Prefix Mapping
 - Process Order Uploads
 - Schedule Colors
 - Schedule Upload Configuration
 - Schedule Upload Lag Adjustme
 - Schedule Upload Location Over
 - Schedule Upload Unit Paramete
 - Schedule Upload Production Ve
 - Sparsing
 - Sulfone and Powder Flags
 - Inventory Targets Upload
 - Product Family / Business Unit**

Product Family / Business Unit

Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset S

Material Group Description	Material Group	Product Hierarchy Desc	Product Hierarchy	H4	Business Ur
PVDC PV910					
PVDC PV910	Z68-22641	PVDC RSN S8/900 COM	KEB1	Resines	Barrier Polym

Editing Product Family / Business Unit

*Material Group Description PVDC PV910

*Material Group Z68-22641

Product Hierarchy Description PVDC RSN S8/900 COM

Product Hierarchy KEB1

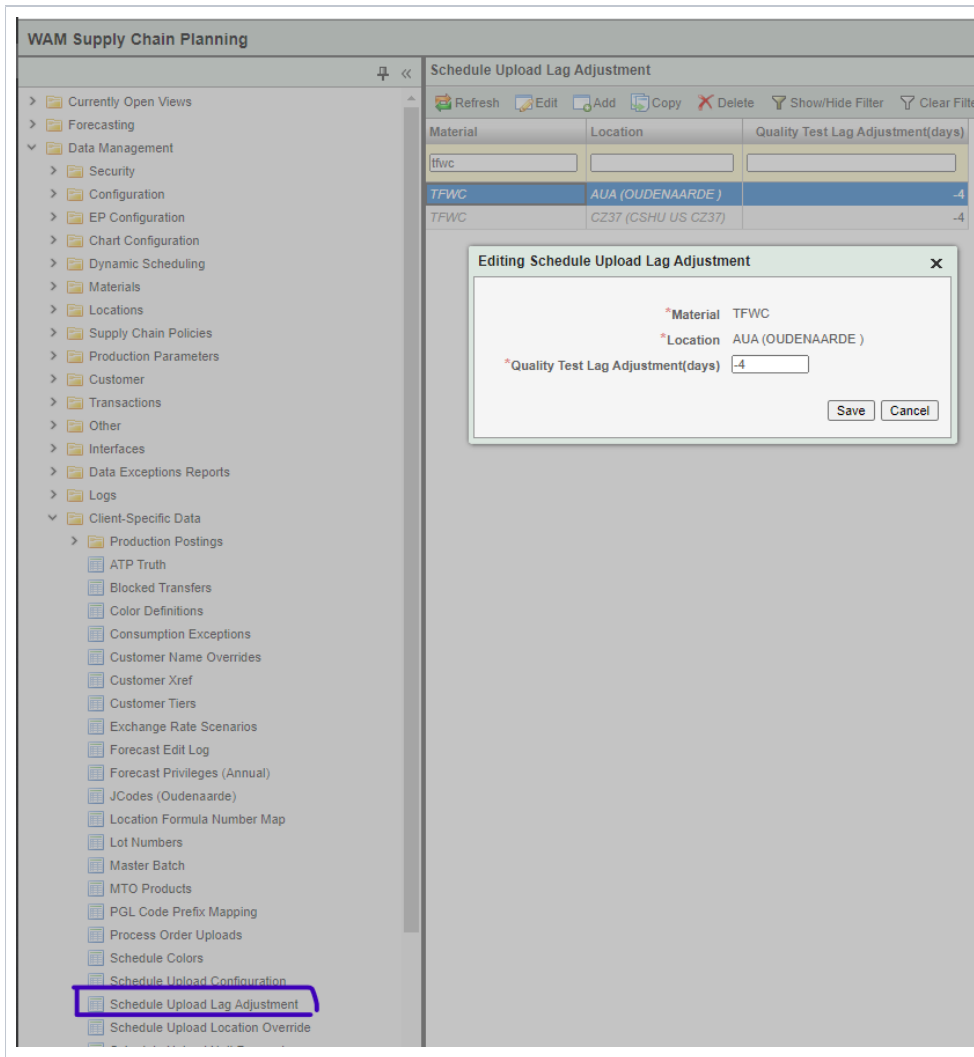
H4 Resines

Business Unit Barrier Polymers

Finance Material Type Finished Products

Save Cancel

Schedule Upload Lag Adjustment



The schedule upload lag adjustment has no effect in Picaso (neither on the grid, no anywhere else). It only affects the interface to SAP for planned orders.

Used when the GRPT / QM Module with Average Inspection Duration are used in SAP.

The lag adjustment prevents QC Times to be counted twice when they are maintained both in SAP and Picaso.

The Schedule Upload Lag Adjustment affects the SAP Planned order end date as below. Consider this Picaso run in plant AUA (Oudenaarde):

Run Properties					
General	Formula	Predecessors	Successors	Notes	Orders
Line:	C05				
Sku Code:	0066043	CPDS AMODEL (PPA)			
Product:	TFWC	A-1133 HS BK 324			
Package:	C5	BOX, 500 LINED			
Formula:	226(14-AUA-C5-14-L5-D-A1004B-3540HP)				
Start:	11 / 24 / 2022 at 14 : 15 : 00				
☐ Run Should Start On or After this date and time: / / at : : :					
Lot Size:	9.0000 MT				
Quantity:	☐ 40.00 MT 42.11 MT Gross Production at 95 % Yield and 97.00 Op %				
Rate:	☐ 0.8000 MT/Hour << 0.8000 (std rate)				
Duration:	☒ 2 days 6 hr 16 min Ends: 11 / 27 / 2022 at 20 : 31 : 00				
Run Reference #:	10616870		☐ Output Reported		
Status:			☐ Completed		
Customer Order:	1079493064		☒ Exportable		
Lot Number:			Type: Free		
Link Info:					

... and its corresponding SAP Planned order:

Stock order	1079493064	Standard in-house pro...
Material	66043	PPA A-1133 HS BK324 C500 P
Planning Plant	AUA	SSPB-BE /OUDENAARDE

Header Assignment Master Data

Quantities

Order quantity	40 000,000	KG	Scrap quantity	0,000
----------------	------------	----	----------------	-------

Dates/Times

	Basic Dates	Production Dates	Other Dates
End	28.11.2022		Available for MRP 28.11.2022
Start	24.11.2022		GR processing time 0
Opening	19.11.2022		

Other Data

Production Plant	AUA
Storage Location	FPWM
Production Version	0014
BOM Explosion Number	

Firming

- ☒ Planned Order
- ☐ Components
- ☐ Capacity Dispatched
- ☒ Conversion Indicator

Recap:

	Picaso Run	SAP Planned Order
Start Date	Nov 24 2022	Nov 24 2022
End Date	Nov 27 2022	Nov 28 2022

Why such a difference? Consider the QC Lag: 5 days for TFWC in Oudenaarde

Quality Test Lag		
Refresh Edit Add Copy Delete Show/Hide Filter Clear		
Material	Location	Quality L
TFWC		
TFWC	CSHU US CZ37	7
TFWC	Default for all locations	4
TFWC	OUDENAARDE	5

Based on QC Lag only, this is what should have happened:

	Picaso Run	SAP Planned Order	Effect of the QC Lag
Start Date	Nov 24 2022	Nov 24 2022	none
End Date	Nov 27 2022	Dec 2 2022	= Picaso End Date + QC Lag = Nov 27 2022 + 5 = Dec 2 2022

Still not adding up.

But, there is a QC Lag Adjustment record for TFWC in AUA

Schedule Upload Lag Adjustment		
Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter		
Material	Location	Quality Test Lag Adjustment(days)
TFWC		
TFWC	AUA (OUDENAARDE)	-4
TFWC	CZ37 (CSHU US CZ37)	-4

Now, it does add up:

	Picaso Run	SAP Planned Order	Effect of the QC Lag	Effect of the Adjustment
Start Date	Nov 24 2022	Nov 24 2022	none	none
End Date	Nov 27 2022	Nov 28 2022	Dec 2 2022	= Dec 2 2022 + (-4) = Nov 28 2022

Learn more about this: [Determine QC Time](#), [GRPT](#), [Average Inspection Time](#), [QC Lag Adjustment](#)

Material Equivalents

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Material Equivalents

Refresh

Edit

Add

Copy

Material (parent)	Material (child)
PTFEFEED900ST	PTFEFEED4000ST
PTFEFEED900ST	PTFE FEED400NR
PTFEFEED900ST	PTFE FEED400ST
PTFEVPASTEFREE	ALG DF11-FREE
PTFEVPASTEFREE	ALG DFC-FREE
PTFEWTAPECHRM	PTFEWTAPEDRRM
PTFEWTAPECHRM	PTFEWTAPERM
S22	SOLK 22
TGBD	TGBE
TGBN	L165

Equipment

Equipment typically represent a production line.

WAM Supply Chain Planning

Close All

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Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset Settings Fields Production Standards

Unit Name	Local	Area Cod	Facility	Default R	Standard	Operation	Up	Hit	Transition	Cycle Le	Wip Keep	Ty	Be	Class	Owner	Min Run	Lag (hrs)	Con
	CZS																	
ALG-CZS	CZS	PP-PI	ALG-CZ	100	Qty/Hour	Continuous	95	99	Changsu P	30								
PLYMS-CZS	CZS	PP-PI	PLY-CZ	100	Qty/Hour	Continuous	100	99	Changsu P	30								
TCN POTCZ	CZS	PP-PI	TCN-CZ	100	Qty/Hour	Continuous	95	100	CZ TCN P	1								
TCN CMPCZ	CZS	PP-PI	TCN-CZ	100	Qty/Hour	Continuous	95	100	CZ TCN P	30								
RX F CZ	CZS	PP-PI	TCN-CZ	100	Qty/Hour	Continuous	100	100	CZ TCN R	1								
VF2-CZS	CZS	PP-PI	TCN-CZ	29	Qty/Day	Continuous	100	100	monomers	30								
F0001	CZS	PP-PI	SS-CZS	0.3	Qty/Hour	Continuous	95	100	GZ PVDF F	30								
XCOMPOUND	CZS	PP-PI	SS-CZS	0.4	Qty/Hour	Continuous	95	100	TA PVDF E	1								
LINE 1	CZS	PP-PI	SS-CZS	0.2	Qty/Hour	Continuous	96	100	CZ PVDF L	1								
CZ F0000	CZS	PP-PI	SS-CZS	0.3	Qty/Hour	Continuous	95	100	CZ PVDF F	30								
CZ F002	CZS	PP-PI	SS-CZS	0	Qty/Hour	Continuous	95	100	CZ PVDF F	30								
CZ LINE2	CZS	PP-PI	SS-CZS	0.2	Qty/Hour	Continuous	96	100	CZ PVDF L	0								
CZ LINE 2	CZS	PP-PI	SS-CZS	0.2	Qty/Hour	Continuous	96	100	CZ PVDF L	0								
CZ F0002	CZS	PP-PI	SS-CZS	0.3	Qty/Hour	Continuous	95	100	CZ PVDF F	30								

Editing Equipment

*Unit Name

XCOMPOUND

*Location

CZS - CHANGSHU PLY

*Area Code

PP-PI

*Facility

SS-CZS

Default Rate

0.4

Standard Rate Units

Qty/Hour

Operation Mode

Continuous

Up Rate (%)

95

Hit Rate (%)

100

Transition Matrix

TA PVDF BUSS 1

Cycle Length (days)

1

Wip Keep Days

3

Type

0

Bed Volume

0

*Class

Finishing Lines

*Owner

Changshu Planners

*Min Run Qty

10

*Lag (hrs)

0

*Config Change (hrs)

0

User

- select one -

Production Pkg

BJ - BAGS, 25 KG

Consumption Pkg

BU - BULK

Wave/Jump

Jump

Schedule By

Qty

batched

☐

Generate Pkg Consumption

☐

generate raw mat'l wip

☐

combine runs

☐

Pass Transition Downstream

☐

Exportable

☒

*Calendar

24 H-7 D

Save DRP To Schedule

☐

Unit Position

6

Save

Cancel

Field	Mandatory /Optional	Rule	Comment
Unit Name	Mandatory		
Location	Mandatory		
Area Code	Mandatory	PP-PI or PP-REM	
Facility	Mandatory	same as unit name 	
Default Rate	Optional		auto-populates if production standard effectivity rate is empty
Standard Rate Unit	Mandatory		is the time unit of measure used for rates with production standard effectivity
Operation mode			
Up rate (%)	Optional		default if production standard Up Rate is empty
Hit Rate (%)	Optional		default if production standard Yield rate  is empty
Transition matrix	Optional		drives automated transition times for that line (e.g. 8h transition between product A and product B). Transition tables are configured separately and assigned to equipments.
Cycle length	Mandatory	30 days for monthly production wheels 60 for bi-weekly production wheels etc.	used for inventory targeting and Dynamic Scheduling.
Class	Mandatory	Finishing line / Packaging Lines / Reactors	Selection / grouping field.

Exportable	Optional		if active, runs on that equipment are uploaded to SAP. Runs themselves will show this exportable checkbox as active. More about Production schedule interface here
Calendar	Mandatory		Assign an existing calendar (see Equipment Calendars)
Unit Position	Optional		position of the line on the production schedule .
Schedule by	Mandatory	Qty / Lot size / Package	(Qty is default). Default unit of measure when creating a new run.

Equipment Calendars

See [here](#) how they affect the available/unavailable time of an equipment on the Production schedule.

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Equipment Calendars

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Calendar Name	Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
Default							
Oudenaarde							
3ALP							
Changshu							
24 H-7 D							
24 Hours/5							
CHXX							
24 Hours/4							
24 Hours 6							
RTP FW							
PFR							
PFR 2							
24Hours 6							
24//6 CZS							
16 Hours/5							
24 H-3 Day							
12 / 5							
24h/7d SM							
24 H/ 6 D C							
LO1							

Editing Equipment Calendars

*Calendar Name 24 Hours/4 Days

Sunday Workday? ☐

Monday Workday? ☒

Tuesday Workday? ☒

Wednesday Workday? ☒

Thursday Workday? ☒

Friday Workday? ☐

Saturday Workday? ☐

Sunday Start

Monday Start

Tuesday Start

Wednesday Start

Thursday Start

Friday Start

Saturday Start

Sunday End

Monday End

Tuesday End

Wednesday End

Thursday End

Friday End

Saturday End

Description

Max Push Days

Save Cancel

Field	Mandatory /Optional	Comment
Calendar Name	Mandatory	

XXX Workdays	Optional	select days that line is operational.
XXX Start	Optional	Start time of each respective day
XXX End	Optional	End time of each respective day
Description	Optional	
Max Push Days	Optional	?

Equipment Calendar Events

For fixed downtimes. See [here](#) how they are used on the Production schedule.

WAM Supply Chain Planning

Equipment Calendar Events

Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel In

Calendar Name	Event Name	Event Type	All Day Event?	Event Start	Event End
Default	NewYearsDay	0	☒	1/1/2006 12:00:00 A	1/1/2006
PFR 2	Sunday Off	0	☒	9/19/2021 12:00:00 A	9/19/2021
PFR 2	Day off	0	☒	9/26/2021 12:00:00 A	9/26/2021

Adding Equipment Calendar Events

*Calendar Name: CHXK

*Event Name: Summer Turnaround

Event Type: 0

All Day Event? ☒

Event Start: 07/01/2023

Event End: 07/15/2023

Save Cancel

Field	Mandatory/Optional	Comment
Calendar Name	Mandatory	to which calendar (hence, which equipment) does that fixed downtime applies?
Event Name	Mandatory	
Event Type	Mandatory	0 by default. Leave it.
Start and Date	Mandatory	use US format: MM/DD/YYYY

Locations

WAM Supply Chain Planning								Close All	Arrange All	He
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Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Transit Times (in) Transit Times (out) Inventory Orders (in) Orders (out) Eqpt Lines Location Calendars										
Location	Type	Ship-to	Cust Name	Company	Region	merge	Merge Into			
??	Warehouse	002028419	DONTKNOW	VD	VD					
00	Vendor	00	VENDOR	VD	VD					
0000	Vendor	0000	NONE	VD	VD					
0027	Warehouse	0027	CHOCBAYU	US	US					
0028	Plant	0028	GRN	US	US	✓	GREENVILLE			
0035	Plant	0035	STNDRIDG	US	US					
0090	Warehouse	0090	CAD	US	US					
0091	Warehouse	0091	PORTLAND	US	US					
0096	Plant	0096	RTP - X	US	US					
0102	Warehouse	0102INV	RP	US	US					
0177	Warehouse	000177	EDSEMINI KAI	ADAC	ID					

Merged Locations

Location types

Material types	Identifier	What for
Plant	P	Manufacturing facility
Warehouse		Storage facility
Vendor		Vendor

Transit Times

Applies to DRP Records and SAP STO's.

WAM Supply Chain Planning

Close

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Locations

Location Calendars

Transit Times

DRP Location Calendars

Supply Chain Policies

Transit Times

Refresh

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Clear Filter

Excel In

From	To	Package	Transit T
AQS		CX	
AQS - AUGUSTA	AUA - OUDENAARDE	CX- BOX 750kg LINED	35
AQS - AUGUSTA	9RBB - JPN TOKYOARO	CX- BOX 750kg LINED	60
AQS - AUGUSTA	9006 - KOREA 9006	CX- BOX 750kg LINED	60
AQS - AUGUSTA	9Q1C - JPN KOBE FLU	CX- BOX 750kg LINED	57
AQS - AUGUSTA	9017 - CHINA IM WH	CX- BOX 750kg LINED	60
AQS - AUGUSTA	CZ37 - CSHU US CZ37	CX- BOX 750kg LINED	60
AQS - AUGUSTA	8HBN - SHANGHIAEXEL	CX- BOX 750kg LINED	63
AQS - AUGUSTA	9034 - SING WHSSCAP	CX- BOX 750kg LINED	60
AQS - AUGUSTA	9Q1B - JPN KOKE ARO	CX- BOX 750kg LINED	60

Location Formula Number Map

WAM Supply Chain Planning

Location Formula Number Map																																																															
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Location	Formula Number																																																														
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53ZD - RTP WINONA	200																																																														
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BUF - BUSSI	80																																																														
CHXK - CHEVIGNY CHP	80																																																														
CZ08 - CSHU EU CZ08	200																																																														
CZ37 - CSHU US CZ37	200																																																														
CZS - CHANGSHU PLY	80																																																														
GDS - GREENVILLE	200																																																														
KAL - KALLO	200																																																														
MHF - MARSHALLTON	80																																																														
MJS - MARIETTA	200																																																														
ORF - ORANGE	80																																																														
PNZ - INDIA PANOLI	200																																																														
RCF - ROCCABIANCA	80																																																														
SEM - SEMBACH	200																																																														
SMF - SPINETTA	80																																																														
TAE - TAV TAE TAH	80																																																														
TAO - TAV/PVDF TAV	80																																																														
TAOF - TAV/VF2 TAVF	80																																																														
TAW - TAV TAW TAN	80																																																														
TAXK - TAVAUX PVDC	80																																																														
THF - W DEPTFORD	80																																																														

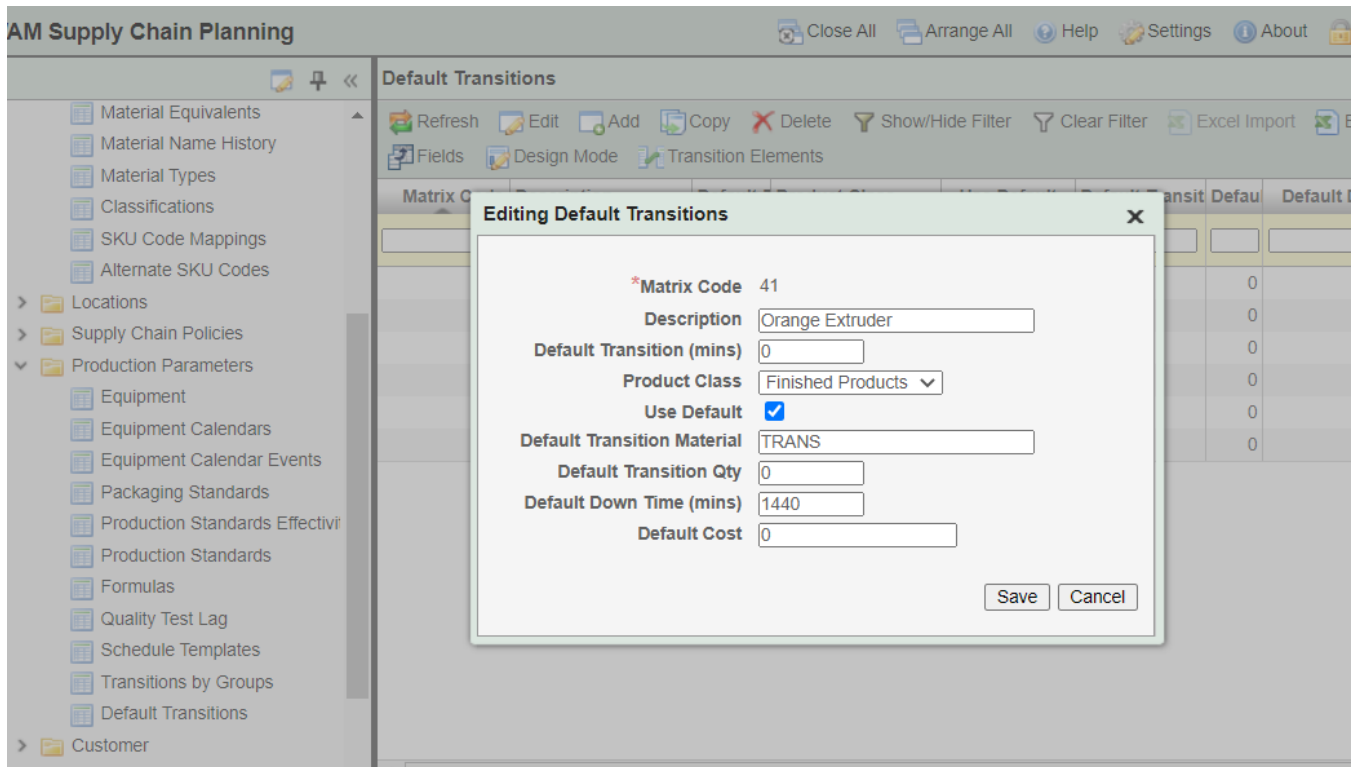
Transitions

Transition tables drive automated changeover time calculation between runs. Find [here](#) how they are used by the Production Schedule & Dynamic Scheduling

Transition Matrix and Default values

Default Transitions

This is the default transitions between runs on a Line . The Transition matrix is inserted in the Equipment master data . This is also used for transitions within a group.



Field	Mandatory/Optional	Rule	Comment
Matrix Code	Mandatory	Numerical	Pick the next available.
Description	Mandatory	N/A	Name of the transition matrix
Default Transition (mins)	Optional	N/A	default downtime <i>before</i> a run
Product Class	?		
Use Default	optional		if active, all default values are in use (unless ...tbc). This significantly reduces maintenance.
Default Transition Material	Optional	always 'TRANS'	TBC
Default Transition Qty	Optional	TBC	TBC
Default Down Time (mins)	Optional	TBC	default downtime <i>after</i> a run
Default Cost	Optional	TBC	unused

=====> this section below, and until the next divider seems not to be available with version 11.7 (our current version as of Aug 2023).

Product to product specific transitions

Select a matrix, then hit the  Transition Elements. It takes you to the list of product-to-product transition rules.

Use the Edit/Add/Copy/Delete keys to update the list of transitions.

Transition Elements (Matrix Code = 13)

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Excel Import

Excel Export

Matrix Code	Initial Material	Final Material	Trans Material	Allow Seq	Down Time
13	TRGA	TFSF		✓	2400
13	TRGA	TFSK		✓	2400
13	TRGA	TFSP		✓	2400
13	TRGA	TFWC		✓	2400
13	TRGA	TFWD			
13	TFSF	TRBR			
13	TFSK	TRBR			
13	TFSP	TRBR			
13	TFTF	TRBR			
13	TFWC	TRBR			
13	TFWD	TRBR			
13	TFTF	TRGA			
13	TFBL	TMXN			
13	TFBQ	TMXN			
13	TFK8	TMXN			
13	TFK9	TMXN			
13	TMXC	TFTQ			
13	TMXD	TFTQ			
13	TMXN	TFTQ			

Editing Transition Elements (Matrix Code = 13)

*Matrix Code

13

*Initial Material

TFTF

*Final Material

TRGA

Trans Material

Allow Seq

☒

Down Time

2400

Transition Time (mins)

0

Transition Qty

0

*Transition Cost

0

Save

Cancel

Field	Mandatory/Optional	Rule	Comment
Matrix Code	Mandatory	N/A	Sequential number identifying a transition matrix
Initial Material	Mandatory		
Final Material	Mandatory		
Transition Material	Optional		TBC
Allow Seq	Mandatory		Allow seq must be checked
Down Time	Optional	TBC	Downtime <i>after</i> a run
Transition Time (mins)	Optional	TBC	Downtime <i>before</i> a run
Transition Qty	Optional	TBC	TBC
Transition Cost	Optional	TBC	TBC



changes to a transition table become active after the overnight run. Not right away.

Tips →	Take advantage of the default value at table header level and only insert exceptions in the product to product table.
i	Note that the product to product transition table gets auto-populated overnight with product-to-self sequences, with a downtime of 0. This is what prevents transition times between runs of the same product.

=====> end of obsolete section.

Transition by Groups

Another, less labor intensive way to manage transition:

1. assign materials to groups (groups to be defined in the [classification](#) table)

2. define transitions between groups instead of between materials. Always check the Allow Seq flag or it will not work. Input the transition in the Down time field

Transitions by Groups

Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset Settings Fields

Design Mode Apply Transitions Effective Transitions

Matrix Code	Init Type	Init Object	Final Type	Final Object	Down Time	Allow Seq	T
Oud	trans					☐	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 IXEF NT 1 - CO4 IXEF NT 1	1440	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	1440	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	360	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	960	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	1200	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	1200	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL BK GP 1 - CO4 RADEL BK GP 1	2160	☒	
Oud CO4	Trans Group	CO4 IXEF BK 1 - CO4 IXEF BK 1	Trans Group	CO4 RADEL NT GP 1 - CO4 RADEL NT GP 1	2160	☒	

Editing Transitions by Groups

*Matrix Code Oud CO4

*Init Type Trans Group

*Init Object CO4 IXEF BK 1 - CO4 IXEF BK 1

*Final Type Trans Group

*Final Object CO4 UDEL NT GP 1 - CO4 UDEL NT GP 1

Trans Product

Down Time 1440

Allow Seq ☒

Transition Time (mins)

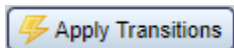
Transition Qty

*Transition Cost 0

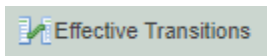
*Record ID 4207

107 items

After making updates to transition by groups , always "Apply Transitions"



After Apply Transitions is completed , exit PICASO and open PICASO to see the impacts



This is all the transitions from Product to Product either created from the Default transitions table for a line or the Transitions by group . This is a view only table

Field	Mandatory /Optional	Rule	Comment
Matrix code	Mandatory	Matrix description in default transitions table of the related equipment	
Init Type	Mandatory	Trans group	
Init Object	Mandatory	Group already created in classification	We can only choose the existing groups in the list, the groups only show up once created in "classification"
Final Type	Same as Init Type	Same as Init Type	
Final Object	Mandatory	Group already created in classification	We can only choose the existing groups in the list, the groups only show up once
Allow Seq	Optional	Check	It's not mandatory, but we need to check it so that works
Down time	Optional	Indicate transition time between the 2 groups	Here we prefer using Down time than transition time

Then Save and Apply transitions. We should wait for the night job to see the change.

In effective Transitions, with filter " group to group", we find all member products affected to the same group with the same down time.

In the example mentioned above, we have setup a transfer from group (white products) to group (blue products). See detail of classification below:

Members (Class = PXWht)		
Refresh Edit Add Copy		
Class	Group	Member
PXWht	PXWht	PVDC PVS119
PXWht	PXWht	PVDC PVS127
PXWht	PXWht	PVDC PVS128
PXWht	PXWht	PVDC PVS801
PXWht	PXWht	PVDC PVS827
PXWht	PXWht	PVDC PVS855
PXWht	PXWht	PVDC PVS929
PXWht	PXWht	PVDC PVS930
PXWht	PXWht	PVDC XVS971
PXWht	PXWht	PVDC XVS976

Class	Group	Member
PXBLUE	PXBLUE	PVDC PVS109
PXBLUE	PXBLUE	PVDC PVS802
PXBLUE	PXBLUE	PVDC PVS826
PXBLUE	PXBLUE	PVDC PVS856
PXBLUE	PXBLUE	PVDC XVS828

After the creation of transition group, from any white product to any blue product, we have the same down time.

Transitions by Groups									
Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset Settings Fields Apply Transitions Effective Transitions									
Matrix Code	Init Type	Init Object	Final Type	Final Object	Trans Product	Down Time	Allow Seq		
ta pvc premix			trans group				☐		
TA PVDC PREMIX	Trans Group	Premix White Products - White products	Trans Group	Premix Blue Products - Blue products		960	☒		

Effective Transitions (Matrix Code = 69)									
Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset Settings Fields									
Init Product	Final Product	Trans Product	Down Time	Allow Seq	Transition Time (mins)	Transition Qty	Inv Unit	Transitio	Derived From
				☐					group
PVDC PVS119	PVDC PVS109		960	☒			MT	0	GROUP TO GROUP - TRANS ID: 4630
PVDC PVS119	PVDC PVS802		960	☒			MT	0	GROUP TO GROUP - TRANS ID: 4630
PVDC PVS119	PVDC PVS826		960	☒			MT	0	GROUP TO GROUP - TRANS ID: 4630
PVDC PVS119	PVDC PVS856		960	☒			MT	0	GROUP TO GROUP - TRANS ID: 4630
PVDC PVS119	PVDC XVS828		960	☒			MT	0	GROUP TO GROUP - TRANS ID: 4630
PVDC PVS127	PVDC PVS109		960	☒			MT	0	GROUP TO GROUP - TRANS ID: 4630

When we've got the same down time between 2 groups of products, it's practical to configure this way, when down time changes, we only need to make one modification.



there are limitations and good practices to using transition by groups

The group level transition views are not turned on by default because there are some limitations to its use. Below are some guidelines for using group transitions:

- 1) The transition matrix size is dependent on the number of equipment lines that a transition matrix is assigned to. **It is good to assign a transition matrix to as few equipment units as possible.** This helps avoid a situation where the derived transition matrix produces many invalid transitions. Assign each group of products to a transition matrix and only use that matrix on the equipment lines that make the given group of products.
- 2) **Limit the number of production standards on an equipment line.** Reducing this number isn't always an option. But it is good to make sure unused production standards are deleted or archived if using group transition functionality.
- 3) One other thing to be aware of is the way transition groups are configured. **There is an increased risk of a conflict when enumerating the transitions and the same product(s) is included in several different groups.**
- 4) By reviewing any one matrix and squaring the total number of products in that matrix, the total rows expected in the derived view can be determined. **When the total rows starts getting towards 100 thousand, there will likely be a slowdown in performance.**

Classification

Classifications or groups of materials are effectively used for GRID selections and for transitions for Groups

If it is for Transitions by Groups , make sure the Transition group flag is Checked

Classifications start with a CLASS then a GROUP then members in a Group

I recommend making the Class code and the Group code the same . It makes it easier to find later. In GRID Selections , input the Group code

Class

WAM Supply Chain Planning						
Classifications						
Class Code	Description	Required Class	Multi Class	Inherit Values	Transition Group	
TCN SM	Tecnoflon SM no PFR					
TCNCZ1	TCNCZ1					☒
TCNCZ2	TCNCZ2					☒
TCNMST	TCN MASTER BATCH					
TCNPRD	TCN PRD Loc					
TERP	TCN TERP SLCL					
TorAI	Torlon AI Resin					☒
Toray	Ryton/Toray Swap					
TorRes	Torlon 4000 Resin					☒
UDEL	Udel CMP Resin					
UDELNR	Udel Neat Resin		☒			
UDLRES	Udel Resin					
UPPRDS	UP PRODUCTS		☒			
Veradi	Veradel/Virantage		☒			
WDPRD	W Deptford Prod Grou					

Group



Once the class is created, open the follower window (), and create the corresponding group:

Classifications

Class Code	Description	Required Class	Multi Class	Inherit Values	Transition Group
TCN SM	Tecnoflon SM no PFR				
TCNCZ1	TCNCZ1				✓
TCNCZ2	TCNCZ2				✓
TCNMST	TCN MASTER BATCH				
TCNPRD	TCN PRD Loc				
TERP	TCN TERP SLCL				
TorAI	Torlon AI Resin				✓
Toray	Ryton/Toray Swap				
TorRes	Torlon 4000 Resin				✓
UDEL	Udel CMP Resin				
UDELNR	Udel Neat Resin		✓		
UDLRES	Udel Resin				
UPPRDS	UP PRODUCTS		✓		
Veradl	Veradel/Virantage		✓		
WDP RD	W Deptford Prod Group				
WDT CRM	W Deptford Tecno RM				
XBLINE	By preferred line				
XYDAR	Xydar				
Z57-GF	ZSK-57 5030 Natural				✓
Z57-GR	ZSK-57 4301/4275 Gr				✓
ZSK50A	ZSK50 GP A				✓
ZSK50B	ZSK50 GP B				✓
ZSK50C	ZSK50 GP C				✓
ZSK50D	ZSK50 GP D				✓
ZSK50E	ZSK50 GP E				✓
ZSK50G	ZSK50 GP G				✓

Page Size: 999 ☐ Auto

Groups

Group Code	Group Description
TCNCZ1	TCNCZ1

Editing adm_Groups (grid)

*Group Code TCNCZ1

Group Description TCNCZ1

Save Cancel

Material assignment to group:

Hit the follower window key () , this time, from the Group section:

Groups

Group Code	Group Description
TCNCZ1	TCNCZ1

It opens the Material/Group Mapping.

It pulls in all materials defined in ADM. Use the filter to narrow that list down.

Assign materials to the group as below (with the checkbox).

Groups

Group Code

TCNCZ1

Group Description

TCNCZ1

Sorted by:

1 / 1

Page Size: 20

Auto

Material/Group Mappings

Product	Group Meml	Nome Code	Description	Manager
	☐		%215	
TC CR N 215 CB		TC CR N 215 CB	TECNOFLON CR N 215 CRUMB	IT91860
TC CR N 215LX		TC CR N 215LX	TECNOFLON CR N 215 LATEX	IT91860
TC CRN215LXWET		TC CRN215LXWET	TECNOFLON CR N 215 LATEX WET	IT91860
TCN CRB N215		TCN CRB N215	TECNOFLON CRUMB N215	IT91860
TCN CRB N215CZ	☒	TCN CRB N215CZ	TECNOFLON CRUMB N215 CZ	IT91860
TCN LX N215		TCN LX N215	TECNOFLON LATEX N215	IT91860
TCN LX N215 CZ		TCN LX N215 CZ	TECNOFLON LATEX N215 CZ	IT91860
TCN N215SM		TCN N215SM	TECNOFLON N 215	IT91860
TCNN215/U		TCNN215/U	TECNOFLON N 215/U	IT91860

Schedule colors

Package

Package code definition.

WAM Supply Chain Planning

Currently Open Views

Forecasting

Data Management

Security

Configuration

EP Configuration

Chart Configuration

Dynamic Scheduling

Materials

Locations

Supply Chain Policies

Production Parameters

Customer

Transactions

Other

Packages

Units of Measure

Forecast Edit Series Groups

adm_inventory_targets

Order Document Types

Interfaces

Data Exceptions Reports

Logs

Client-Specific Data

Packages

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Excel Import

Excel Export

Reset Settings

Fi

Pkg Cod	Pkg Nam	Short Na	Nome Co	Weight/V	merge pkg	Merge into Pkg	Pieces in Pkg	Wgt in Pkg	Volume	Lag	Min Reo
bj					☐						
BJ	BAGS, 25	BJ		Weight			40	25	1	0	1
BJ1	BAGS, 20	BJ1		Weight			1	20	1	0	1
BJ2	BAGS, 20	BJ2		Weight							

Editing Packages

*Pkg Code

BJ

*Pkg Name

BAGS, 25 KG

*Short Name

BJ

Nome Code

Weight/Volume

Weight

merge pkg

☐

Merge into Pkg

Pieces in Pkg

40

Wgt in Pkg

25

Volume

1

Lag

0

Min Reorder Qty

1

Round Lots to Pkg

0

Save

Cancel

Troubleshoot

PF1 Schedule Interface Management

Schedule Upload Unit Parameters

Schedule Upload Configuration

For the overnight program to upload the schedule for a location then USER MSAUSALP must added to the table for that location

WAM Supply Chain Planning					
Schedule Upload Configuration					
Blocked Transfers Color Definitions Consumption Exceptions Customer Name Overrides Customer Xref Customer Tiers Exchange Rate Scenarios Forecast Edit Log Forecast Privileges (Annual) JCodes (Oudenaarde) Location Formula Number Map Lot Numbers Master Batch MTO Products PGL Code Prefix Mapping Process Order Uploads Schedule Colors Schedule Upload Configuration Schedule Upload Lag Adjustm Schedule Upload Location Ovr Schedule Upload Unit Parame Schedule Upload Production v Sparsing Sulfone and Powder Flags	User Name	User ID	Location Name	Location	Unit Specific
					Upload from TSO
	ms				
	WAM Overnights User	MSAUSALP	POWDER TECH	50QA	
	WAM Overnights User	MSAUSALP	REO PBURG	53ID	
	WAM Overnights User	MSAUSALP	ICO ALLENTOW	53MD	
	WAM Overnights User	MSAUSALP	REMRAM	53SD	
	WAM Overnights User	MSAUSALP	LTL COLORCMP	53TD	
	WAM Overnights User	MSAUSALP	AMETEK WAP	53UD	
	WAM Overnights User	MSAUSALP	RTP WINONA	53ZD	
	WAM Overnights User	MSAUSALP	ROWLAND	54SD	
	WAM Overnights User	MSAUSALP	PIPERPLASTIC	54UD	
	WAM Overnights User	MSAUSALP	KTN-LAPORTE	5A00	
	WAM Overnights User	MSAUSALP	INFINITY	5D02	
	WAM Overnights User	MSAUSALP	RTP FT WORTH	5D13	
	WAM Overnights User	MSAUSALP	PET RYTON	5D16	
	WAM Overnights User	MSAUSALP	RTP S BOSTON	5D33	
	WAM Overnights User	MSAUSALP	WELCH DRY	5D39	
	WAM Overnights User	MSAUSALP	LYONDELLBASE	5D40	
	WAM Overnights User	MSAUSALP	ADDIPLAST	6133	
	WAM Overnights User	MSAUSALP	KSK SHANGHAI	6903	
	WAM Overnights User	MSAUSALP	KSK ZHONGSHA	6905	
	WAM Overnights User	MSAUSALP	MOCOM	8DAO	

Drives:

- conversion of planned orders into process orders in SAP: e.g. 3 days means that planned orders with an end date (TBC) within 3 days will be converted.
- how SAP production versions are selected in SAP when creating planned orders:

Use 0001 or production version override	self-explanatory
JCODES for AUA	IDK
CL_FormulationCrossRef Table	Production version driven by formula assigned to the run

WAM Supply Chain Planning

Process Order Uploads

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Excel Import

Excel Export

Reset Settings

Fields

RecID	SKU Code	Material	Package	Location	Unit Name	Production Version	Quantity	Start
	0209296							
3602	0209296	FOMB S-ME	DS2	SMF	ATEX	0001	4000	2022
646	0209296	FOMB S-ME	DS2	SMF	ATEX	0001	5000	2022
647	0209296	FOMB S-ME	DS2	SMF				

Editing Process Order Uploads

*RecID 3602

*SKU Code 0209296

*Material FOMB S-ME

*Package DS2

*Location SMF

*Unit Name ATEX

*Production Version 0001

*Quantity 4000

*Start Date 2022-11-21

*Start Time 08:00:00

*End Date 2022-11-29

*Run Number 18732238

*SAP Order Type PlannedOrder

*SAP Order Number 1078658139

*Inherited From

*Batch Number

*Firm 1

*Release 0

*ReProcess 0

*Notes Planned Order Created

*Last Updated 2022-11-22 19:01:16

*Record Source SAP

*Change Number 9

*DetScheduleFlag 0

GoodsRecipient 41

UnloadingPoint ATEX

Save

Cancel

Push Button Management

Configure who can run the on-demand [production schedule interface](#).

This table let one user run the interface for either one (or multiple) location, or for a set of equipment (production lines) within that location.

Upload Unit Names (UserID = IT91509 , Location = SMF)

 Refresh  Edit  Add  Copy  Delete  Show/Hide Filter

UserID	Location	Unit Name
IT91509	SMF	ADV MICRO
IT91509	SMF	BASCULA1
IT91509	SMF	BASCULA2
IT91509	SMF	FOMBYDER
IT91509	SMF	FOMBZDER
IT91509	SMF	SOLVERA
IT91509	SMF	TABLE A
IT91509	SMF	TABLE B
IT91509	SMF	TABLE C
IT91509	SMF	TABLE D
IT91509	SMF	TABLE E
IT91509	SMF	TABLE F
IT91509	SMF	TABLE G
IT91509	SMF	TABLE H

WP1 Interface Management

Picaso is also interfaced with WP1.

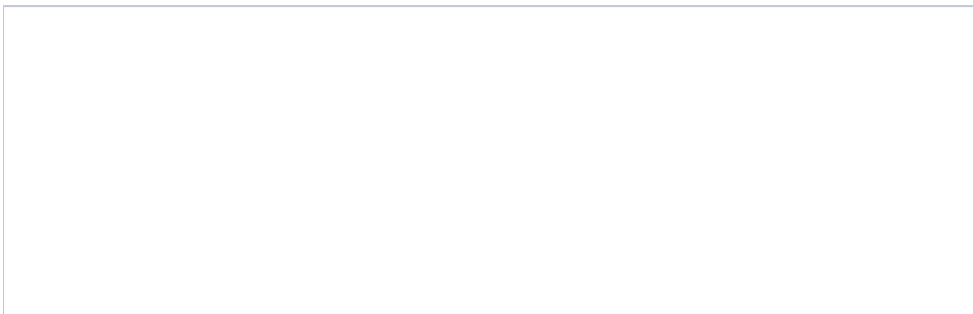
This is a one way interface, that brings: orders and stocks from WP1 to Picaso.

There is no PicasoWP1 interface: no schedule upload, no forecast upload.

Historically developed for a few locations in Brazil (hence the name of the hereafter tables), this interface and the aforementioned table work for any location / product in WP1.

The overnight program brings the WP1 data (Inventory , customer orders , Stock transfers, etc) and converts them to PF1 codes .

Brazil Location Map



WAM Supply Chain Planning

Brazil Location Map

- > EP Configuration
- > Chart Configuration
- > Dynamic Scheduling
- > Materials
- > Locations
- > Supply Chain Policies
- > Production Parameters
- > Customer
- > Transactions
- > Other
- > Interfaces
- > Data Exceptions Reports
- > Logs
- > Client-Specific Data

 - > Production Postings
 - ATP Truth
 - Blocked Transfers
 - Color Definitions
 - Consumption Exceptions
 - Customer Name Overrides
 - Customer Xref
 - Customer Tiers
 - Exchange Rate Scenarios
 - Forecast Edit Log
 - Forecast Privileges (Annual)
 - JCodes (Oudenaarde)
 - Location Formula Number Map
 - Lot Numbers
 - Master Batch
 - MTO Products
 - PGL Code Prefix Mapping
 - Process Order Uploads
 - Schedule Colors
 - Schedule Upload Configuration
 - Schedule Upload Lag Adjustm
 - Schedule Upload Location Ove
 - Schedule Upload Unit Parame
 - Schedule Upload Production V
 - Sparsing
 - Sulfone and Powder Flags
 - Inventory Targets Upload
 - Product Family / Business Unit
 - Brazil Location Map
 - Brazil Material Map

Refresh
 Edit
 Add
 Copy
 Delete
 Filter

Brazil Plant Code	Picaso Location
0229	0229 - BRAZIL SANTO
7525	7525 - BRAZIL SAWP1
8308	

Fields to be populated as below:

Brazil Plant Code	Picaso Location	Comment
WP1 plant code	Corresponding Picaso plant code	Picaso plant code, also PF1 code.

Even if merging going on, WP1 plant code to map with its corresponding PF1 location. I.e. 0229 is parent and 7525 is child. But do not map WP1 plants to 0229.

In the above example, the WP1 plant codes and the Picaso plant codes are identical.

But we have an example of WP1 plant codes that map to PF1 plant codes that are different:

4044	5012 - SOLMEX S.D.
7525	7525 - BRAZIL SAWP1

Even if merging going on, WP1 plant code to map with its corresponding PF1 location. I.e. 0229 is parent and 7525 is child. But do not map WP1 plants to 0229.

In the above example, the WP1 plant codes and the Picaso plant codes are identical.

But we have an example of WP1 plant codes that map to PF1 plant codes that are different:

4044	5012 - SOLMEX S.D.
7525	7525 - BRAZIL SAWP1

Even if merging going on, WP1 plant code to map with its corresponding PF1 location. I.e. 0229 is parent and 7525 is child. But do not map WP1 plants to 0229.

In the above example, the WP1 plant codes and the Picaso plant codes are identical.

But we have an example of WP1 plant codes that map to PF1 plant codes that are different:

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WAM Supply Chain Planning

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Fields to be populated as below:

Brazil Material Code	Picasso SKU Code	Comment
WP1 Material code	Corresponding Picasso SKU	The Brazil Material code field has no leading zero.

User Management