

Picasso Production Schedule

-

Picasso Production Schedule - Classic

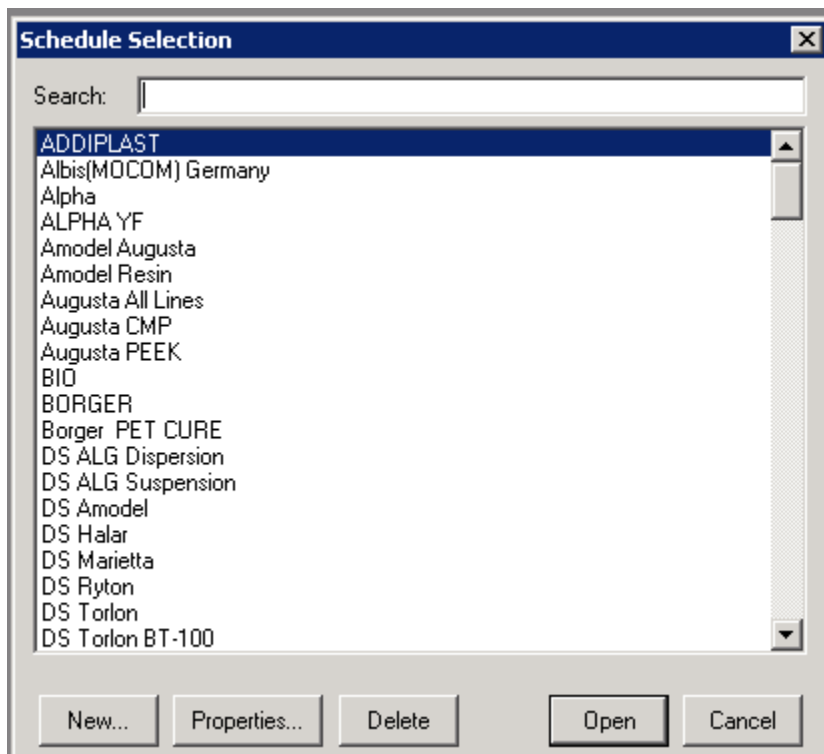
- Open a schedule
 - Schedule properties
- Schedule properties - Edit Display
- Navigation
 - Navigation buttons
 - Color schemes
 - Linking runs together
 - Candidate runs
 - Run details
- Inserting a run on the schedule
 - From scratch
 - Header Tab
 - Start Date/Time
 - Quantity/Duration
 - Run references
 - Formula
 - Effect of yield on components quantity
 - Predecessor / Successor
 - Notes
- Copy from another run
- Copying multiple runs
- Modifying a run
- Moving a run
- Deleting one/multiple runs
- Inserting a floating downtime
- Units of measure and lot sizing
 - Package
 - Lot size
- Transitions
- Equipment Calendars
- Equipment Calendar Events (fixed downtimes)
- Saving a schedule
 - to Master Schedule
 - as a Scenario
- Production Schedule upload to SAP
- Print a schedule

Dynamic Scheduling

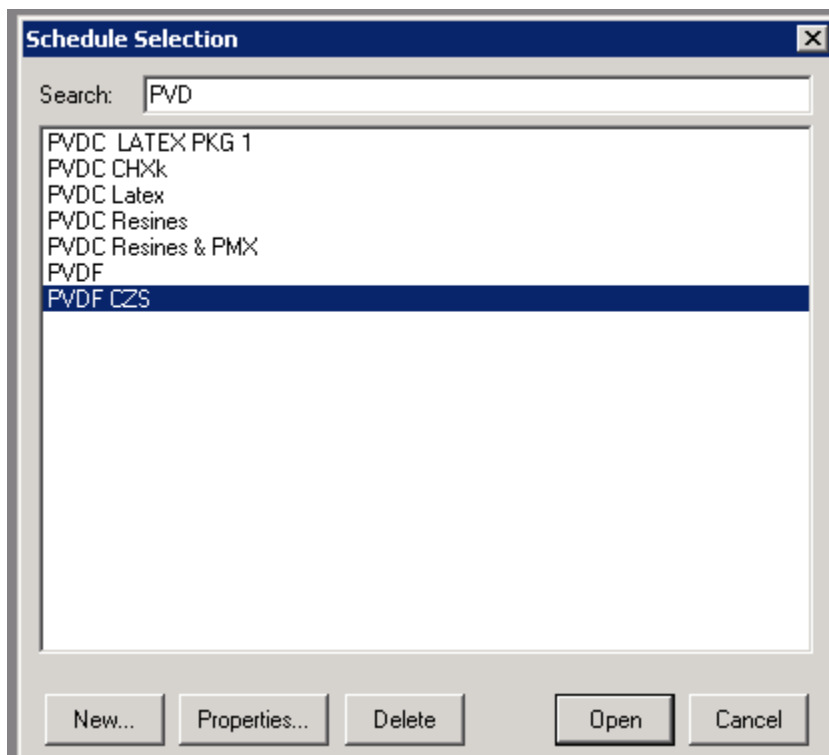
Picasso Production Schedule - Classic

Open a schedule

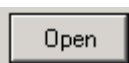
In Picasso, hit this icon:  . It opens a list of Schedules:



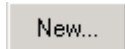
Use the search to find the one you need.



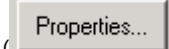
Once you find the one you were looking for, hit:



You may also create a schedule (hit:

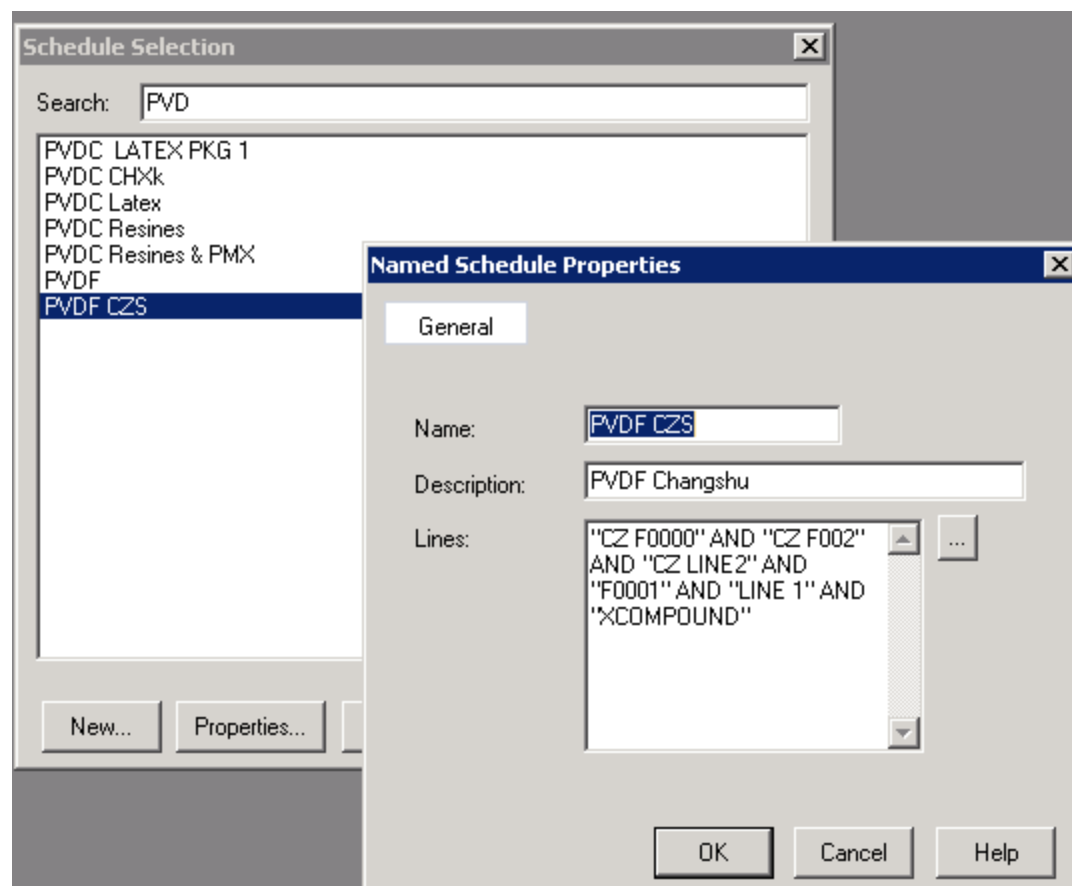


) and/or understand how a grid works by looking at its properties (

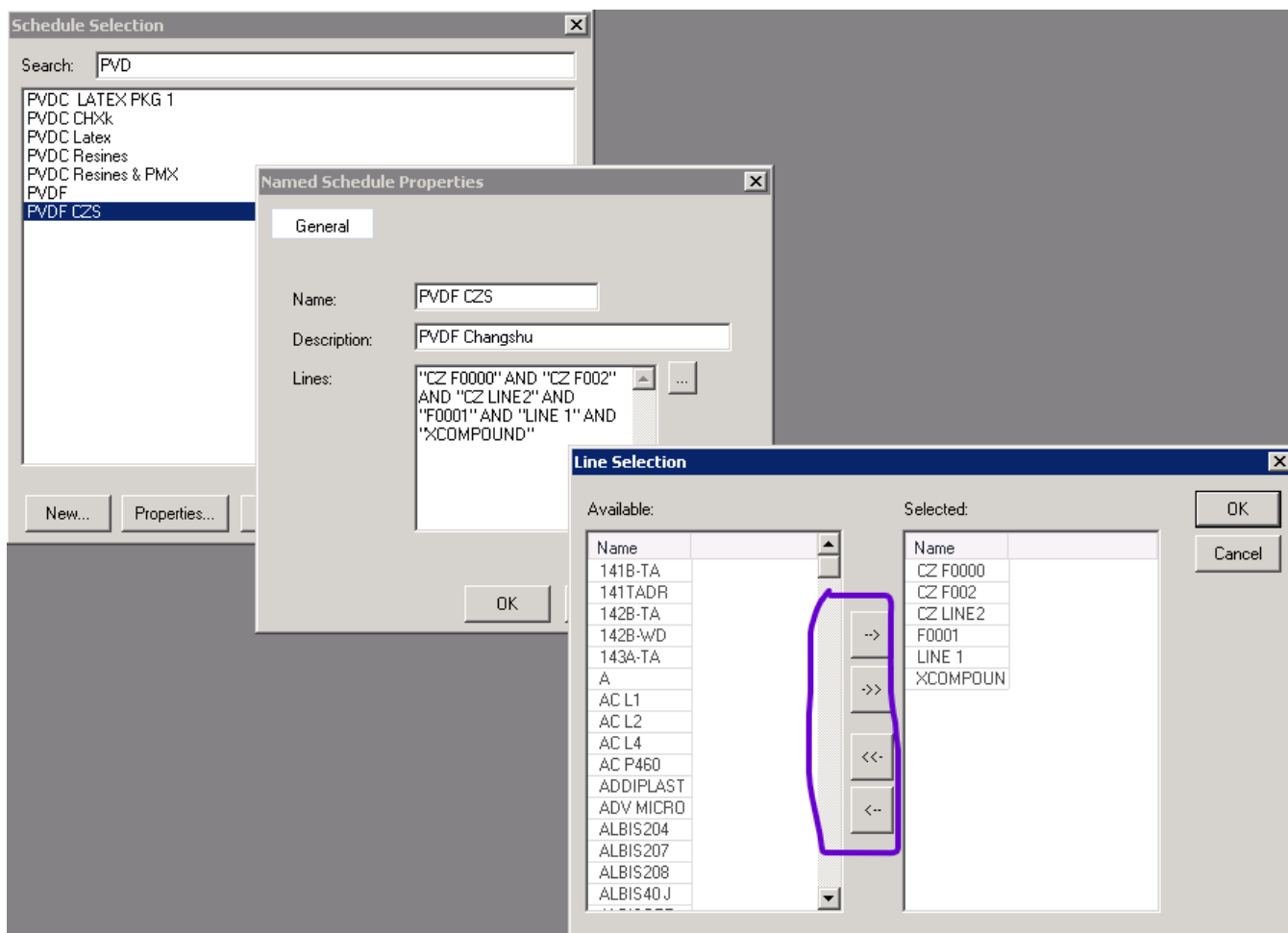


Schedule properties

The schedule properties, beside its name and description, is mostly its a list of lines.



Use the  icon to open the inventory of lines; and use the arrow keys to update the list of lines.



All lines show next to each other, in a sequence that is determined by the equipment "Unit Position"

(no color scheme) Drag and drop runs										Qty		Prod Name								
LINE 1 CZS R	CZ LINE 2 CZS R	F0001 CZS F	CZ F002 CZS F	CZ F0000 CZS F	XCOMPOUND CZS F															
Nov 22																				
Nov 23																				
12:00																				
Nov 24																				
12:00																				
Nov 25		PVDF 5130/1001 CZ D1 35.00 MT P 5130/1001 CZ 000060397461	PVDF 5130/1001 CZ B12 20.00 MT P 5130/1001 CZ 000060395813		PVDF 6008/0001 CZ B1 3000.00 MT P 6008/0001 CZ 1080422831															
Nov 26			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397368																	
12:00			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397366																	
Nov 27			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397366																	
12:00			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397367																	
Nov 28			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397588																	
12:00			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
Nov 29			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
12:00			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
Nov 30			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
12:00			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 5130/1001 CZ 000060397587																	
			PVDF 5130/1001 CZ B11 20.00 MT P 513																	

Schedule properties - Edit Display

EDIT SCHEDULE Properties

Each User can display fields in the sequence you want from top to bottom

For example display Product description on top line then Qty on next line , etc

System will save for each User

Navigation

Navigation buttons

	jumps to today
	zoom in - horizontal
	zoom out - horizontal
	zoom in - vertical
	zoom out - vertical

Color schemes

TBC

Linking runs together

Key	Function
	Select two runs, then hit this key. Runs are now linked in a predecessor / successor relationship. See Predecessor/Successor .
	To cancel the relationship.

Candidate runs

Picasso generated runs. Resulting from imbalance between demand and supply

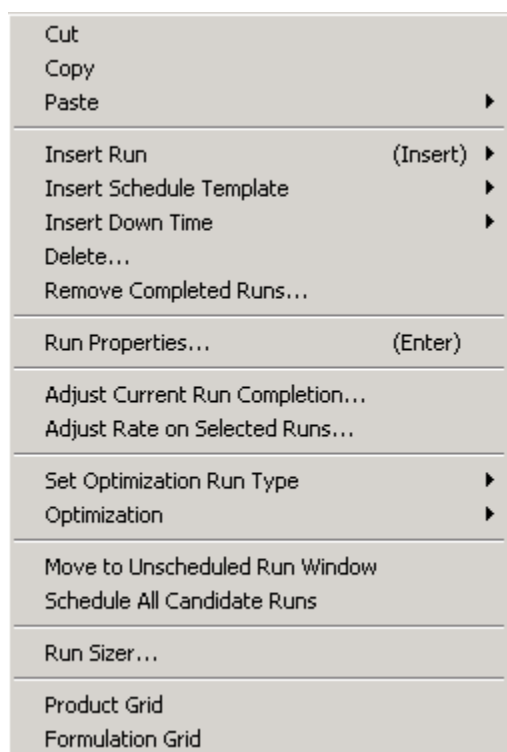
Run details

12:00										00:00 MT									
Prd	Product Description	Pkg Unit	Qty (net)	Rate	Op%	Yield	Formula	Run Id	Start Date	Start Time	Dur.	Product Name	Qty (gross)	Run Ref #	Status	Cust Order	Notes		
P 513	PVDF 5130/1001 CZ	BL CZ LINE2	657.00 MT	1.20 MT / Hour	80.00	00.00	85	43487	11/01/2022	12:00 AM	684.37	P 5130/1001 I	657.00 MT	00018299		000060395811	Test Gaelig to see if SAP is con		

Inserting a run on the schedule

From scratch

Position your cursor on the production line / existing run on that line. Right click:



and select " ".

You may insert a run after or before an existing run:



It opens a window as below:

Run Properties

General

Formula

Predecessors

Successors

Notes

Orders

Line:

XCOMPOUND

Sku Code:

0204346

PVDF 6008/0001

Product:

P 6008/0001 CZ

PVDF 6008/0001 CZ

Package:

BJ

BAGS, 25 KG

Formula:

80(0001-CZS-BJ -PVDF 6008/0001 *CZ

Start :

11 / 27 / 2022

at: 07 : 15 : 00

☐ Run Should Start On or After this date and time:

/

/

at:

:

:

Lot Size:

1.0000

MT

Quantity:

0.00

MT

0.00 MT

Gross Production at

100

% Yield and

80.00

Op %

Rate:

0.4000

MT/Hour

<<

0.4000 (std rate)

Duration:

0

days

0

hr

0

min

Ends:

11 / 27 / 2022

at: 07 : 15 : 00

Run Reference #:

☐ Output Reported

Status:

☐ Completed

Customer Order:

☒ Exportable

Lot Number:

Type: Free

Link Info:

Calc Size

OK

Cancel

Header Tab

In that window, populate either the SKU, or the Picaso material & package code. Picaso will pull in complementary data.

The [default formula](#) auto-populates. You may pick another valid formula if necessary.

Valid means: within validity date & formula assigned to the relevant production line via [production standard effectivity](#).

For this product/package/line, there is only one production standard effectivity:

Would there be more than one, the one with the default check mark would be selected automatically by default (duh!).

Start Date/Time

Line:

XCOMPOUND

Sku Code:

0204346

PVDF 6008/0001

Product:

P 6008/0001 CZ

PVDF 6008/0001 CZ

Package:

BJ

BAGS, 25 KG

Formula:

80(0001-CZS-BJ -PVDF 6008/0001 *CZ

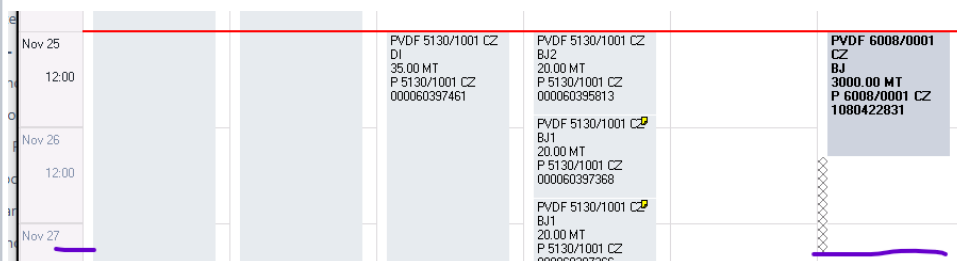
Production Standard Effectivity (Unit = XCOMPOUND, Material = P 6008/0001 CZ, Package = BJ)							
Production Standard	Unit	Material	Package	Formula	Effective Date	Expiration Date	Rate
XCOMPOUND / P 6008/0001 CZ / BJ	XCOMPOUND	P 6008/0001 CZ	BJ	80	8/12/2022	12/31/2099	0.4

As per previous run (+transition), the new run can start Nov 27 at 7:15 am the earliest.

Start : 11 / 27 / 2022 at 07 : 15 : 00

☐ Run Should Start On or After this date and time:

/ / at : : :



You may also anchor the new run to a given date /time (here, we indicate that we want the new run to start no earlier than Nov 30 at 8:15 am)

Start : 11 / 27 / 2022 at 07 : 15 : 00

☒ Run Should Start On or After this date and time:

11 / 30 / 2022 at 08 : 15 : 00

Quantity/Duration

Enter a quantity:

It results in the duration of the run being recalculated as per rate (here, 0.4 MT/h), [Up Time](#) from the line (or Op, here = 80%), and [yield](#) (here = 100 %)

Lot Size: 1.0000 MT

☐ Quantity: 0 MT

0.00 MT Gross Production at 100 % Yield and 80.00 Op %

☐ Rate: 0.4000 MT/Hour << 0.4000 (std rate)

☒ Duration: 0 days 0 hr 0 min Ends: 11 / 30 / 2022 at 08 : 15 : 00

Duration = 10 MT / (0.4 MT/h) = 25 h.

However, a 80 % **Up Time** affects negatively the **duration**: 25 h / 0.8 = 31.25 h. Or 1 day, 7h, and 15 min.

The yield is 100 %, therefore it does not affect the run duration.

Lot Size: 1.0000 MT

☐ Quantity: 10 MT

10.00 MT Gross Production at 100 % Yield and 80.00 Op %

☐ Rate: 0.4000 MT/Hour << 0.4000 (std rate)

☒ Duration: 1 days 7 hr 15 min Ends: 12 / 01 / 2022 at 15 : 30 : 00

If the **yield** was set to 80% (you can modify it in the run, and it will only affect that run), it would result in both:

- **longer run duration**: 31.25 h / 0.8 = 39.06 h. Or 1day, 15h, and 4 min
- **increased Gross Production**: 10 MT / 0.8 = 12.5 MT
 - **net production unchanged** (i.e. what is seen on the grid and affects projected inventory) remains at 10 MT
- **increased component consumption** (see [Effect of yield on components quantity](#)).

Lot Size: 1.0000 MT

☐ Quantity: 10.00 MT

12.50 MT Gross Production at 80 % Yield and 80.00 Op %

☐ Rate: 0.4000 MT/Hour << 0.4000 (std rate)

☒ Duration: 1 days 15 hr 4 min Ends: 12 / 01 / 2022 at 23 : 19 : 00

The standard rate is pulled from the production standard efficiency (through the formula picked for that run).

Production Standard	Unit	Material	Package	Formula	Effective Date	Expiration Date	Rate	Default
XCOMPOUND / P 6008/0001 CZ / BJ	XCOMPOUND	P 6008/0001 CZ	BJ	80	8/12/2022	12/31/2099	0.4	

The rate can be modified in the run itself. It will only affect that run and its duration.

Lot Size: MT

☐ Quantity:

10.00 MT Gross Production at % Yield and 80.00 Op %

☐ Rate: MT/Hour << 0.4000 (std rate)

☒ Duration days hr min Ends: / / at: : :

Hit << to revert to the standard rate.

blocked URL

Note that you may enter quantity with [alternative units of measures or multiples of lot size](#):

Lot Size: MT

☐ Quantity:

0.00 MT

☐ Rate: MT/Hour

Run references

Run Reference #:

Status:

Customer Order:

Lot Number:

Link Info:

☐ Output Reported

☐ Completed

☒ Exportable

Type:

Field	Description
The Run Reference #	is a Picaso internal reference number that is automatically generated once the run is saved.
Customer Order	Once a run has been uploaded to SAP and a Planned order/Process order as been created in SAP, the SAP number populates the Customer Order field. Find more about the Picaso Schedule upload to SAP here .
Lot Number	If an output lot number is assigned to a Process order in SAP, it will also show here.
Exportable	The Exportable checkbox is inherited from the equipment . It can also be checked on or off by hand. If active, that run is selected for upload to SAP.
Output Reported	When activated, this flag indicates that production is complete, resulting in the run not affecting the plot nor the grid nor any query any longer.
Completed	will not interface with SAP. Even when activated, the run still shows on the grid, the plot and PicReports.
Type	Fixed: Dynamic Scheduling (DS) will not delete run when updating schedule; Free -DS will delete run when updating schedule

Formula

The formula tab of a run shows the components of said run. Here, only one component.

GeneralFormulaPredecessorsSuccessorsNotesOrders

Raw Material	Prod Nome Name	Responsible	Responsible \$
P 6008/1001 CZ	PVDF 6008/1001 CZ	0057158	PVDF 6008/1

AddModifyDelete

Hit the

Add

 button to insert more components.

Highlight the component and hit the

Modify

 button to display/modify the component's

- consumption rate (100%)
- resulting quantity (-10 MT)
- usage (consumption, since this is a component)
- type (continuous)
- lag (0 days, i.e. no lag)

Run Properties

GeneralFormulaPredecessorsSuccessorsNotesOrders

Raw Material	Prod Nome Name	Responsible	Responsible \$
P 6008/1001 CZ	PVDF 6008/1001 CZ	0057158	PVDF 6008/1

Edit Formulation Component: (Product=P 6008/0001 CZ, Formula=80)

Component Information

Component:

P 6008/1001 CZ

Package:

BU

Amount used:

100.000000

%

Quantity:

-10.000000

MT

Usage

☒ Consumed

☐ Pkg Consumed

☐ Produced

Type

☐ Beginning

☒ Continuous

☐ End

Offset

☐ Lead (-)

☒ Lag (+)

0

Days

0

Hours

OK

Cancel

Modify

Delete

OK

Cancel

These values are auto-populated from the standard formula details:

Formula Details (Formula Number = 80, Material = P 6008/0001 CZ)

RefreshEditAddCopyDeleteShow/Hide FilterClear FilterExcel ImportExcel ExportReset

Formula	Material	Element	Package	In/Out	Units	Amount	I/O Type
80	P 6008/0001 CZ	P 6008/1001 CZ	BU	Input	% Wgt	100	Continuous

Editing Formula Details (Formula Number = 80, Material = P 6008/0001 CZ)

*Formula Number80

*MaterialP 6008/0001 CZ

*ElementP 6008/1001 CZ

*PackageBU

*In/OutInput

*Units% Wgt

*Amount Used100

*I/O TypeContinuous

IO Lag (Hours)0

SaveCancel

Effect of yield on components quantity

Using the example above: 80% yield results in an increased component consumption:

- increased : -10 MT / 0.8 = -12.5 MT

Component Information

Component:P 6008/1001 CZ

Package:BU

Amount used:100.000000%

Quantity:-12.500000MT

Contrary to output gross production, the effect of a yield is visible on the component's grid.

Predecessor / Successor

By default, a predecessor / successor relationship links together two consecutive runs on the same production line.

Insert Run (Insert) Before... After... action

Insert Schedule Template

When inserting a run, the **Insert Schedule Template** decides what is going on with the relationship.

XCOMPOUND
CZS
F

PVDF 6008/0001 CZ
BJ
10.00 MT
P 6008/0001 CZ

Predecessor

PVDF 6008/0001
CZ
BJ
10.00 MT

Reference

Run Properties

General					Formula					Predecessors					Successors					Notes					Orders				
Id					Process					Pkg					Line					Prd Desc									
44061					P 6008/0001 CZ					BJ					XCOMPOUND					PVDF 6008/0001 CZ									

Calc Size

OK

Cancel



ox lets y

[illegible]

Link Properties

Predecessor: ID: 18781812 P 6008/0001 CZ

Successor: ID: 44013 P 6010/1001 CZ

OK

Cancel

Swap

Link Type: **Finish-to-Start (FS)** Regular

Cleanout Time: 0 days 0 hrs 0 mins

Down Time: 0 days 0 hrs 0 mins

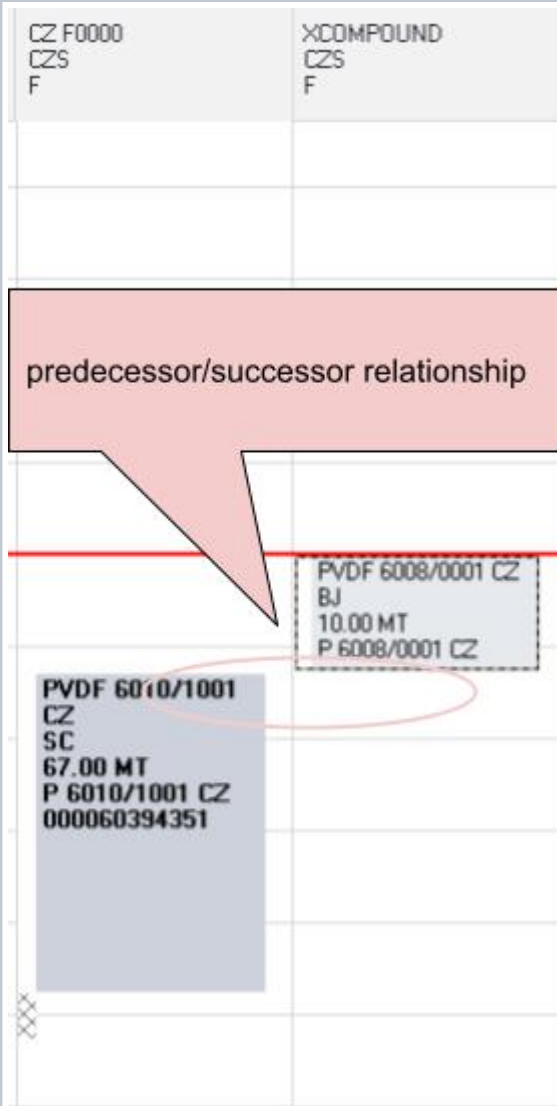
Transition Time: 0 days 0 hrs 0 mins

Transition Process: Qty: 0

Config Change Time: 0 days 0 hrs 0 mins

Setup Time: 0 days 0 hrs 0 mins

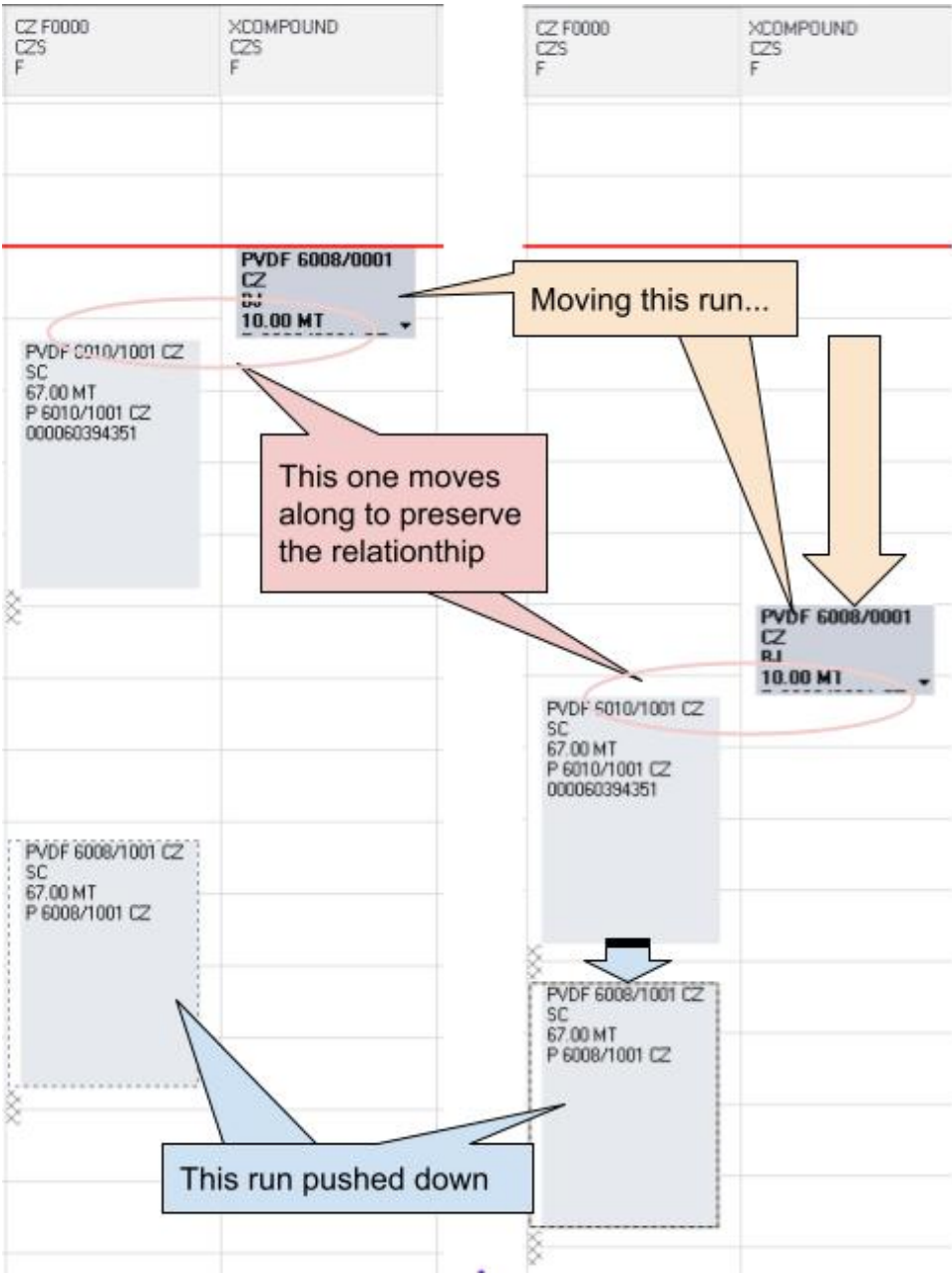
Once saved, the runs are linked. In this example, the PVDF 6006/0001 CZ run on XCOMPOUND is the predecessor and the PVDF 6010/1001 CZ is the successor.



Note that because of this relationship, the later run to the left (PVDF 6010/1001 CZ) was pushed down to meet the requirements of that relationship.

Now that these runs are linked together, moving one run results in the other run moving too to comply with the link properties.

Any other run in the way will be pushed down.



Hit the  key to cancel the relationship.

Notes

Free text. A yellow icon in the run header

PVDF 6008/0001 CZ
BJ
250.00 Lots
P 6008/0001 CZ

signals that there is something there.

Notes can also be inherited from Production Standard Notes and Formulation Notes.

The screenshot shows the 'Run Properties' dialog box with the 'Notes' tab selected. The dialog has a title bar with a close button. Below the title bar are six tabs: 'General', 'Formula', 'Predecessors', 'Successors', 'Notes', and 'Orders'. The 'Notes' tab is active, showing three text areas: 'Production Standard Notes:', 'Formulation Notes:', and 'Run Notes:'. The 'Run Notes:' area contains the text 'One does not simply walk into Mordor'. At the bottom right of the dialog are three buttons: 'Calc Size', 'OK', and 'Cancel'. A purple circle highlights a yellow icon in the run header of the main window on the left.

Copy from another run

Copying multiple runs

Modifying a run

Moving a run

Deleting one/multiple runs

Inserting a floating downtime

Units of measure and lot sizing

As long as they have been defined, other units of measure can be used

Lot Size: MT

☐ Quantity:

MT
MT
Lots
Pkgs

☐ Rate: MT/Prod

Package

Picking package let you enter quantity in multiple of the material package code. Here, 25 kg bags. The 25 kg is defined in the [packages table of ADM](#)

Lot Size: MT

☐ Quantity:

Pkgs

 x 0.025 MT per pkg = 0.00 MT

0.00 MT Gross Production at % Yield and 80.00 Op %

15 kg bags will therefore translate in a 380 kg run.

Lot Size: MT

☐ Quantity:

Pkgs

 x 0.025 MT per pkg = 0.38 MT

0.38 MT Gross Production at % Yield and 80.00 Op %

Lot size

Going with Lots let you enter quantity in multiple of one lot size. Here, 1 MT. The lot size comes from the [Production Standard](#) for this material on this line.

Lot Size: MT

☐ Quantity:

Lots

 x 1.00 MT per lot = 0.00 MT

0.00 MT Gross Production at % Yield and 80.00 Op %

This default lot size can be modified in the run itself (and for the sake of this example, we will do just that). Lot size is now 0.35 MT per lot.



once modified in the run, it updates the corresponding production standard in ADM.

Lot Size: MT

☐ Quantity:

Lots

 x 0.35 MT per lot = 0.00 MT

0.00 MT Gross Production at % Yield and 80.00 Op %

It is now much easier when thinking in lots: just enter the number of lots to be produced (here: 250 lots); Picaso will calculate how it translates in MT: 87.50 MT.

Lot Size:

0.35

MT

Quantity:

250

Lots

x 0.35 MT per lot = 87.50 MT

87.50 MT

Gross Production at

100

% Yield and

80.00

Op %

The lot size comes from the [Production Standard](#) for this material on this line:

Production Standards (Material = PVDF 6008/0001 CZ)																		
Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter Excel Import Excel Export Reset Settings Fields Production Standard Effectivity																		
Unit	Material	Package	Lot Size	Min Run	Default	Yield %	Up time	Batch Re	Co-Prod	Co-Prod	Notes	Setup Tir	Configur	Cycle Position	Cycle Fre	Allow Sk	Qty Incre	Pct of Tot
XCOMPOUND	PVDF 6008/0001 CZ	BJ	1	1		100	80	0		0		0		0	1		0	100

Transitions

Picaso calculates changeover times between runs (if configured in [ADM](#)).

The transition in the right-hand screen screenshot, indicated by XXX, is generated automatically.

CO4
AUA
F

IXEF 1032/9008
C4
15.00 MT
TXAJ
1081412787

No transition

IXEF 1032/9008
BJ
20.00 MT
TXAJ
1081412785

Transition time
= 240 min

XXX

IXEF 1521/9008
C4
15.00 MT
IXEF 1521/9008
BJ
15.00 MT
TXAP
1081412779

No transition

The duration is derived from the transition matrix assigned to the line (here, line CO4 in Oudenaarde) in the [equipment table](#).

Equipment

RefreshEditAddCopyDeleteShow/Hide Filter

Unit Name	Local	Area Code	Facility	Default Rate	Standard Rate Units	Operation Mode	Up Rate (%)	Hit Rate (%)	Transition Matrix
co4	au								
CO4	AUA	PP-PI	CO4	1	Qty/Hour	Continuous	98	98	

Editing Equipment

*Unit NameCO4

*LocationAUA - OUDENAARDE

*Area CodePP-PI

*FacilityCO4

Default Rate1

Standard Rate UnitsQty/Hour

Operation ModeContinuous

Up Rate (%)98

Hit Rate (%)98

Transition MatrixOudenaarde

Cycle Length (days)30

The transition matrix itself can be found in the ADM [Transition Table](#).

If the Default checkbox is activated, the Default values are used.

Here, there is a default Down time of 240 min.

Transitions

RefreshEditAddCopyDeleteShow/Hide Filter

Matrix Code	Description	Default Transition (mins)	Product Class

Editing Transitions

*Matrix Code13

DescriptionOudenaarde

Default Transition (mins)0

Product ClassFinished Products

Use Default

Default Transition MaterialTRANS

Default Transition Qty0

Default Down Time (mins)240

Default Cost0

Save

In this example, no product-to-product specific record match the actual run sequence.

Hence, default duration being used (240 min).



Transitions

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

Matrix Code Description Default Transition (mins) Product Class Use Default Default Transition Material Default Transition

ouden

12 Oudehaande

Transition Element' key takes you to the product-to-product specific transitions

Transition Elements (Matrix Code = 13)

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

Matrix Code	Initial Material	Final Material	Trans Mat	Allow Seq	Down Time	Transition Time (mins)	Transition Qty	Trans
13	TFSP	TRBR			2400	0	0	
13	TFSE	TRBR		✓	2400	0	0	
13	TFSP	TRBR		✓	2400	0	0	
13	TFTP	TRBR		✓	2400	0	0	
13	TFTP	TRGA		✓	2400	0	0	
13	TFAD	TRBR		✓	2400	0	0	
13	TFWC	TRBR		✓	2400	0	0	
13	TRGA	TFSP		✓	2400	0	0	
13	TRGA	TFSE		✓	2400	0	0	
13	TRGA	TFSP		✓	2400	0	0	
13	TRGA	TFWC		✓	2400	0	0	
13	TRGA	TFAD		✓	2400	0	0	
13	TRGN	TFPL03			2100	0	0	
13	TRGN	TFPL04			2100	0	0	
13	TRGN	TFBL			2100	0	0	
13	TRGN	TFDQ			2100	0	0	
13	TXAJ	TXAJ			2400	0	0	
13	TXAJ	TXAJ			2400	0	0	
13	TXAJ	TXAJ			2400	0	0	

Only one record for TXAJ (transition to self)
Therefore default is used

Editing Transition Elements (Matrix Code = 13)

Matrix Code 13

Initial Material TXAJ

Final Material TXAJ

Trans Material

Allow Seq ☒

Down Time 0

Transition Time (mins) 0

Transition Qty 0

Transition Cost 0

Instead of a list of product-to-product transition being maintained in the transition matrix, groups of products are defined. The transition rules are defined at group level.

Transitions by Groups

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

Matrix Code	Init Type	Init Object	Final Type	Final Object
0				
Oudenaarde	Trans Group	CO5 Amodel Black Gr 1 - CO5AB1	Trans Group	CO5 Amodel B
Oudenaarde	Trans Group	CO5 Amodel Black Gr 3 - CO5 AMODEL BK 3	Trans Group	CO5 Amodel B
Oudenaarde	Trans Group	CO5 Amodel Black Gr 1 - CO5AB1	Trans Group	CO5 Amodel B

Editing Transitions by Groups

*Matrix Code

*Init Type

*Init Object

*Final Type

*Final Object

Trans Product

Down Time

Allow Seq ☒

Transition Time (mins)

Transition Qty

*Transition Cost

*Record ID 4117

Save

Groups are defined in the [Classification table](#), and products are assigned to them.

Members (Class = CO5AB3)				
 Refresh	 Edit	 Add	 Copy	 Del
Class	Group	Member		
CO5AB3	CO5AB3	TFAR		
CO5AB3	CO5AB3	TFSN		

Equipment Calendars

Lines recurring downtimes (i.e. weekends, shifts, etc.) are maintained there.

In this example, lines CO2, CO3 & CO4 are down every WE.

Line CO5 is a 24/7 type line.

	CO2 AUA F	CO3 AUA F	CO4 AUA F	CO5 AUA F
jun 23				
jun 24				
jun 25				
jun 26				
jun 27				
jun 28				
jun 29				
jun 30				
jul 01				
jul 02				

Lines CO2 CO3 and CO4 are assigned to "24 Hours/5 Days" calendar

Line CO5 is assigned to "24 H/6 D OUD" calendar.

Equipment															
Unit Name	Standard Operator	Up Hrs	Transition Matrix	Cycle Ld Wip Keep	Type	Bel Class	Owner	Min Run (Lag Hrs)	Config Chd User	Production Pkg	Consumption Pkg	Wave/Jut Sched ba	G pl cci (P.E)		
ISO															
CO2	Qty/Hour	Continuous	98	Oudenaarde	30	7	ACI	0	Finishing Lines	Oudenaarde Schedul 1	0	0	BJ - BAGS, 25 KG	CS - BOX, 500 UNL/ET Jump	Qty
CO3	Qty/Hour	Continuous	98	Oud Line2	30	7	ACI	0	Finishing Lines	Oudenaarde Schedul 1	0	3	BJ - BAGS, 25 KG	CS - BOX, 500 UNL/ET Jump	Qty
CO4	Qty/Hour	Continuous	98	Oud CO4	30	7	ACI	0	Finishing Lines	Oudenaarde Schedul 1	0	0	BJ - BAGS, 25 KG	CS - BOX, 500 UNL/ET Jump	Qty
CO5	Qty/Hour	Continuous	98	Oud CO5	30	7	ACI	0	Finishing Lines	Oudenaarde Schedul 1	0	0	BJ - BAGS, 25 KG	CS - BOX, 500 UNL/ET Jump	Qty

"24 Hours/5 Days" calendar shows that Sundays and Saturdays are off.

Equipment Calendars

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Calendar Name	Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday	Sunday
24	☐							
24 H-7 D	☒							
24 Hours/5 Days	☐							
24 Hours/4 Days								
24 Hours 6 days	☒							
24Hours 6 days SMF								
24//6 CZS								
24 H-3 Days/12 H- 1								
24h/7d SM	☒							
24 H/ 6 D OUD	☒							

Editing Equipment Calendars

*Calendar Name24 Hours/5 Days

Sunday Workday?

☐

Monday Workday?

☒

Tuesday Workday?

☒

Wednesday Workday?

☒

Thursday Workday?

☒

Friday Workday?

☒

Saturday Workday?

☐

Sunday Start

Monday Start

3/23/2013 12:00:00 AM

Tuesday Start

3/23/2013 12:00:00 AM

Wednesday Start

3/23/2013 12:00:00 AM

Thursday Start

3/23/2013 12:00:00 AM

Friday Start

3/23/2013 12:00:00 AM

Saturday Start

Sunday End

Monday End

3/23/2013 11:59:00 PM

Tuesday End

3/23/2013 11:59:00 PM

Wednesday End

3/23/2013 11:59:00 PM

Thursday End

3/23/2013 11:59:00 PM

Friday End

3/23/2013 11:59:00 PM

Saturday End

Description

24 Hours/5 Days

Max Push Days

365

Save

"24 H/6 D OUD" calendar configuration shows that all days are working days.

Equipment Calendars

Refresh

Edit

Add

Copy

Delete

Show/Hide Filter

Clear Filter

Calendar Name	Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
24							
24 H-7 D							
24 Hours/5 Days							
24 Hours/4 Days							
24 Hours 6 days							
24Hours 6 days SMF							
24//6 CZS							
24 H-3 Days/12 H- 1 d							
24h/7d SM							
24 H/6 D OUD							

Editing Equipment Calendars

*Calendar Name24 H/ 6 D OUD

Sunday Workday?

Monday Workday?

Tuesday Workday?

Wednesday Workday?

Thursday Workday?

Friday Workday?

Saturday Workday?

Sunday Start7/1/2020 6:00:00 PM

Monday Start7/1/2020 12:00:00 AM

Tuesday Start7/1/2020 12:00:00 AM

Wednesday Start7/1/2020 12:00:00 AM

Thursday Start7/1/2020 12:00:00 AM

Friday Start7/1/2020 12:00:00 AM

Saturday Start7/1/2021 12:00:00 AM

Sunday End7/1/2020 11:59:00 PM

Monday End7/1/2020 11:59:00 PM

Tuesday End7/1/2020 11:59:00 PM

Wednesday End7/1/2020 11:59:00 PM

Thursday End7/1/2020 11:59:00 PM

Friday End7/1/2020 11:59:00 PM

Saturday End7/1/2021 5:59:00 PM

Description24 H/ 6 D OUD

Max Push Days365

Save



note that runs will overlap no-working days. In this example, the run duration is 16h.

But it'll start Friday around noon, and complete early Monday morning.

CO4 AUA F	CO5 AUA F
IXEF 1032/9008 BJ 20.00 MT	
IXEF 1521/9008 BJ 20.00 MT TXAP 1082454900	

Run Properties

General	Formula	Predecessors	Successors	Notes
Line: CO4				
Sku Code:	0127262	N-MXD6 (IXEF)		
Product:	TXAP	IXEF 1521/9008		
Package:	BJ	BAGS, 25 KG		
Formula:	222(18-AUA-BJ-18-L4-Z-RADIPOL-3540-HY)			
Start:	05/05/2023 at 11:58:00			
☐ Run Should Start On or After this date and time:				
Lot Size:	1.0000 MT			
Quantity:	20.00 MT			
20.41 MT Gross Production at 98% Yield and 98.00				
Rate:	1.3000 MT/Hour << 1.3000 (std rate)			
Duration:	0 days 16 hr 1 min Ends: 06/05/2023 at 03			
Run Reference #:	10619691			
Status:				
Customer Order:	1082454900			
Lot Number:				
Link Info:				
☐ Output Rep				
☐ Completed				
☒ Exportable				
Type: Free				
Calc Size OK				

Equipment Calendar Events (fixed downtimes)

This is where you want to manage your shutdowns and fixed downtimes.

Contrary to floating downtimes, these events cannot move. They are therefore ideal to represent annual shutdown.

Insert a fixed downtime in the [Equipment Calendar Events](#) table.

Equipment Calendar Events

Refresh Edit Add Copy Delete Show/Hide Filter Clear Filter

Calendar Name	Event Name	Event Type	All Day Event?	Event Start
24 H/ 6 D OUD	Planned stop	0	☒	7/15/2023 12:00:00
Default	New Year's Day	0	☒	1/1/2006 12:00:00
PFR 2				
PFR 2				

Editing Equipment Calendar Events

*Calendar Name 24 H/ 6 D OUD

*Event Name Planned stop

Event Type 0

All Day Event? ☒

Event Start 7/15/2023 12:00:00 AM

Event End 8/4/2023 12:00:00 AM

Save Cancel

It will create show on the Schedule



that event will only update after the overnight jobs. Hence, 24h after the event is inserted in the calendar

	C02 AUA F	C03 AUA F	C04 AUA F	C05 AUA F	
jul 20					
jul 21					
jul 22					
jul 23					
jul 24					
jul 25					
jul 26					
jul 27					
jul 28					
jul 29					
jul 30					
jul 31					
aug 01	MTO/PARA USAGE BJ 70.00 MT TXCD 1082462541				
aug 02					
aug 03					
aug 04					
					PPS XE5000NA 010 C4 35.00 MT TRBR



Note that a fixed downtime applies to a calendar. Hence to all lines assigned to that calendar.

Saving a schedule



Only one person may edit a schedule at a time.

One person editing, other people displaying is fine.

[blocked URL](#)

Some plants created a Google Chat Room to check with other site planners when going in a schedule in edit mode

to Master Schedule as a Scenario

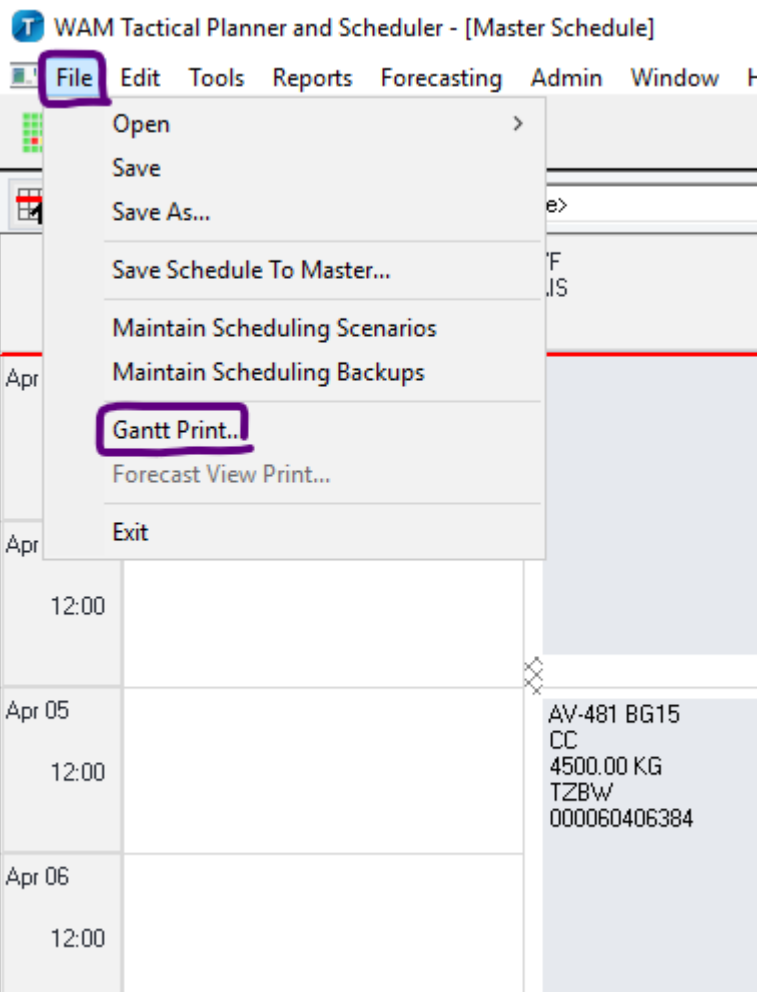
Production Schedule upload to SAP

The production schedule is uploaded once a day into SAP. For more on this, read the corresponding [note](#).

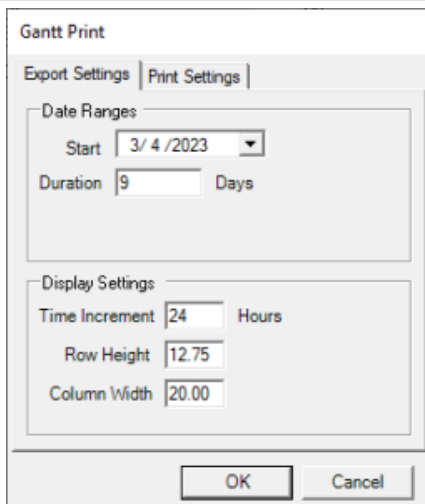
On-demand upload is also supported. Security must be given to a user to be allowed to upload the schedule. When running on-demand, runs on lines /locations that the user is allowed for are uploaded into SAP. More about this [here](#).)

Print a schedule

From the menu, pick "Gantt Print..."



Hit 'OK'



The layout of the Grant may be configured: click "Add-ins", then "Time Scale", then ch

FILE HOME INSERT PAGE LAYOUT FORMULAS DATA REVIEW VIEW ADD-INS

Print Titles Eqpt Lines Time Scale Run Blocks

o
s
e
“
S
et
S
c
al
e
”
fr
o
m
th
e
d
r
o
p
d
o
w
n
li
st
,
y
o
u
s
h
o
u
l
d
s
e
e
a
n
E
di
t
Ti
m
e
S
c
al
e
w
in
d
o
w
o
p
e
n
u
p
(
S
e
e
d
e
m
o
s
cr
e
e
n
s
h
o
t
b
el
o
w
).

T
h
i
s
a
b
l
e
s
t
o
u
p
d
a
t
e
t
h
e
T
i
m
e
I
n
c
r
e
m
e
n
t
v
a
l
u
e.

Edit Time Scale

×

Start Date

3/30/2023

Start Time

4:34:00 PM

Duration

21

(days)

Time Increment

24

(hours)

Row height

13

OK

Cancel

Dynamic Scheduling

Dynamic Scheduling is an add-on to standard Picaso. It enables the generation of a production schedule with more sophisticated which, contrary to the standard, can account for the production wheel, production cycle, and other constraints that can be programmed.