



Critical
manufacturing
an ASM PT company

Plan

10.2

April 2026

DOCUMENT ACCESS

Public

DISCLAIMER

The contents of this document are under copyright of Critical Manufacturing S.A. it is released on condition that it shall not be copied in whole, in part or otherwise reproduced (whether by photographic, or any other method) and the contents therefore shall not be divulged to any person other than that of the addressee (save to other authorized offices of his organization having need to know such contents, for the purpose for which disclosure is made) without prior written consent of submitting company.

Plan

Estimated time to read: 7 minutes

A **Plan** is the central entity for the attainment of an production need. A **Plan** represents a matrix of quantities indexed by:

- A manufacturing unit (**Product** or **Product Group**) called Plan Item.
- A set of time periods called Time Frames.

This matrix will be associated to a Critical Manufacturing MES Plan Item level (**Area, Facility, Site** or **Enterprise**) and the **Plan** is used to hold the definitions and actual quantities that are planned to be produced on a specific manufacturing level and within a given time frame.

This document will guide you through the required configurations and set up for the **Plan** functionality.

Note

The **Plan** entity is not directly related to any other plan; namely, the **Inspection Plan, Maintenance Plan, and Sampling Plan** entities.

Overview

The **Plan** entity is intended to fulfil a specific production demand and can be used at different practical levels.

Note

Plan is used for a different type of planning from the **Schedule** entity. **Plan** is used to assign quantities or volumes to specific time frames and is used at different planning levels. **Schedule** is used to assign start and end dates to jobs at the Detailed Scheduling level.

In Critical Manufacturing MES, **Plan** is a structure that represents any production plan at any level, which is relevant to MES, in the form of production volumes for a certain manufacturing unit or specified item(s) and for a specified horizon.

Its purpose is to validate or track and to compare the plan volumes with the actual volumes recorded in MES.

Main objectives of **Plan**:

- Track if the volumes are being kept.
- Allow importing Planned Volumes from an external system - commercial planning solution or through Master Data Package loading.

Note

There is currently no underlying engine that allows finite capacity planning at all levels supported by the **Plan** entity. Therefore, **Plan** information must be filled in by the user via the [GUI](#) or [Master Data Package](#) from an Excel sheet or by integrating with an external commercial planning solution.

Setting up a Plan

To have a functioning **Plan**, you have to set up other Critical Manufacturing [MES](#) entities as shown in the following table:

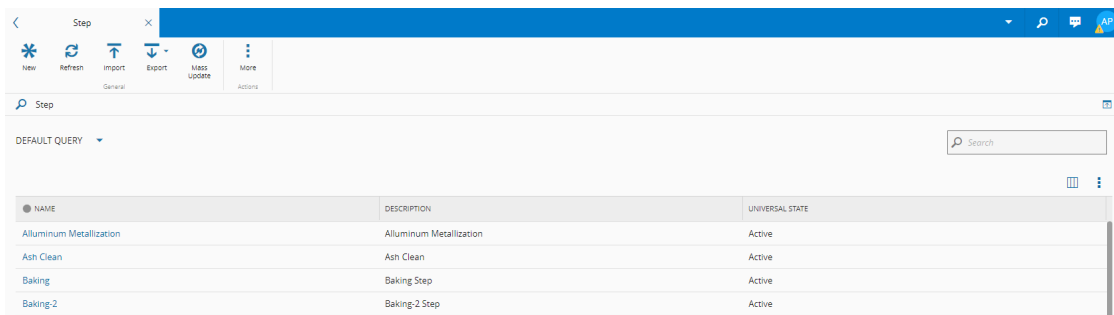
Step Number	Step	Description
1	Enable Is Plan Counting Step	For any Step you intend to use as a counting step for the actual volumes, and you can use as many as you need, the Is Plan Counting Step configuration must be active.
2	Create a Calendar	Has to have calendar days generated.

Table: Steps to set up the Plan-related entities

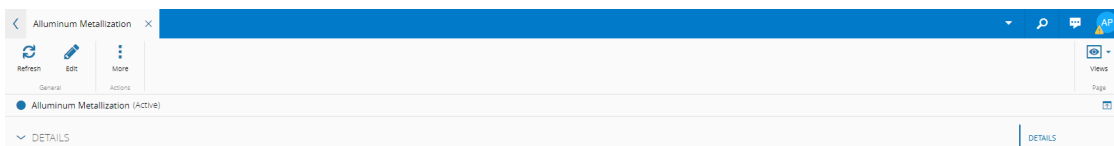
The next sub-sections will cover the required configuration steps in more detail.

Step 1: Step

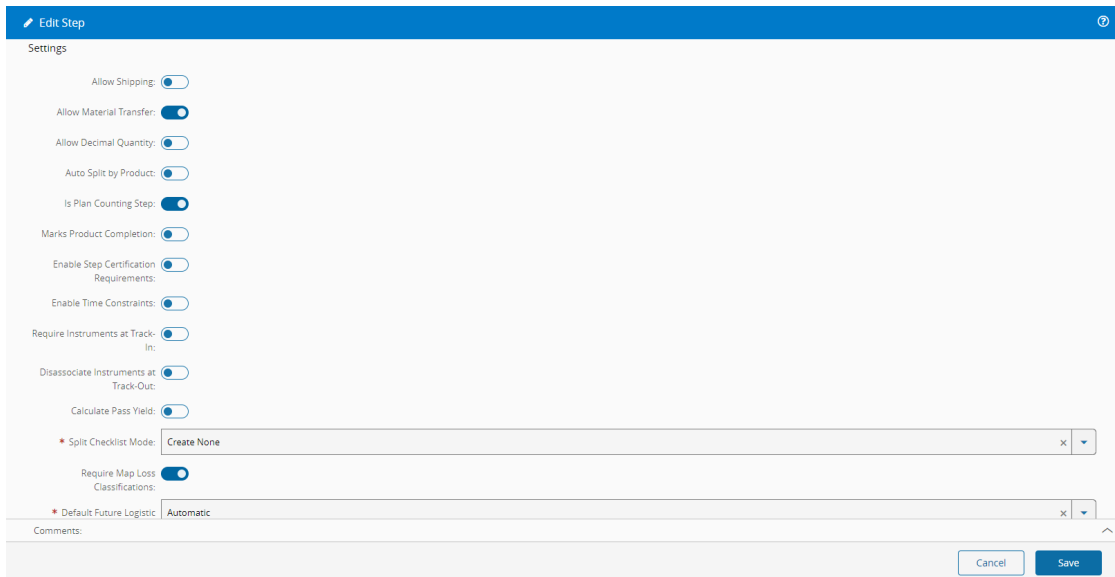
1. Select the **Step** you intend to use:



2. Select **Edit** on the top ribbon:



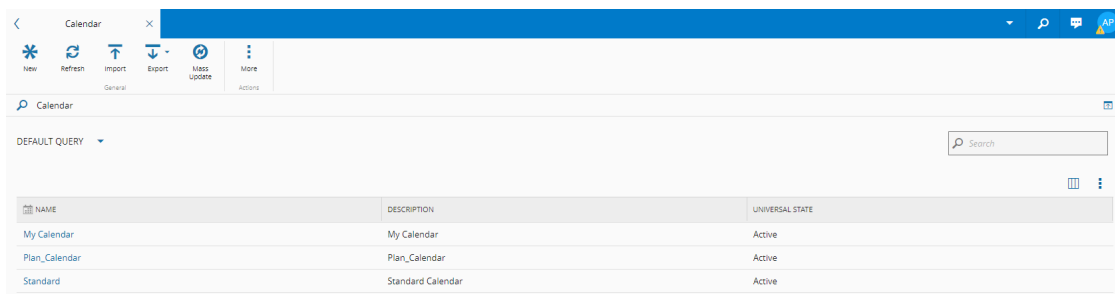
3. Go to **Settings** and enable Is Plan Counting Step:



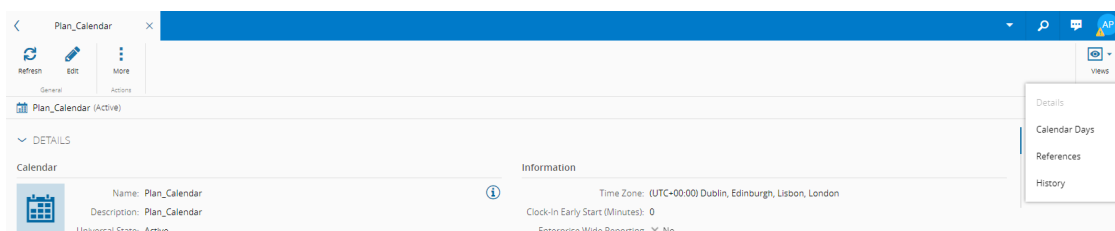
4. Select **Save**.

Step 2: Calendar

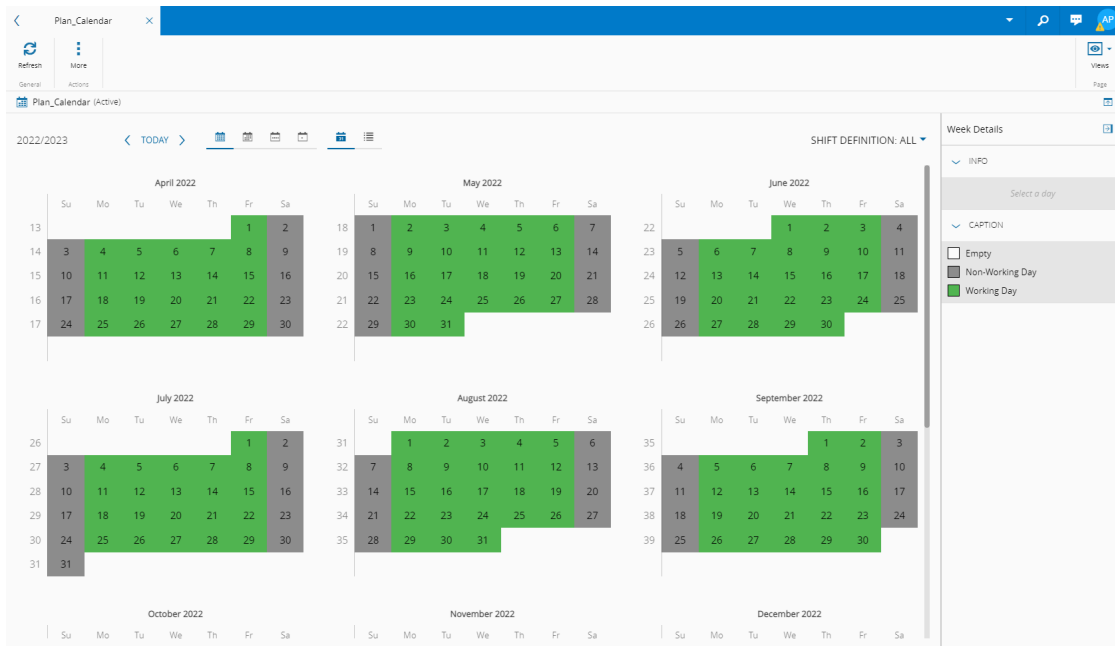
1. Select the **Calendar** you intend to use:



2. In **Views**, select Calendar Days:



3. Make sure you have calendar days generated:

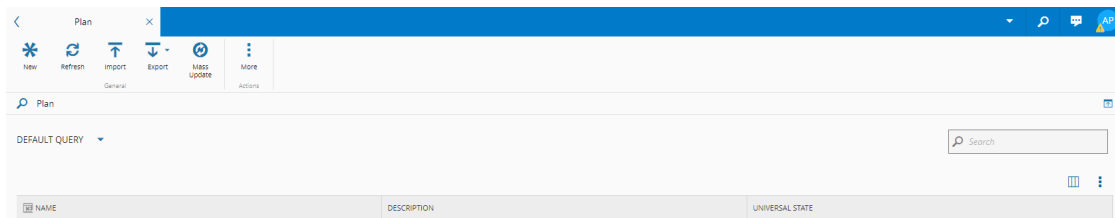


Using Plan

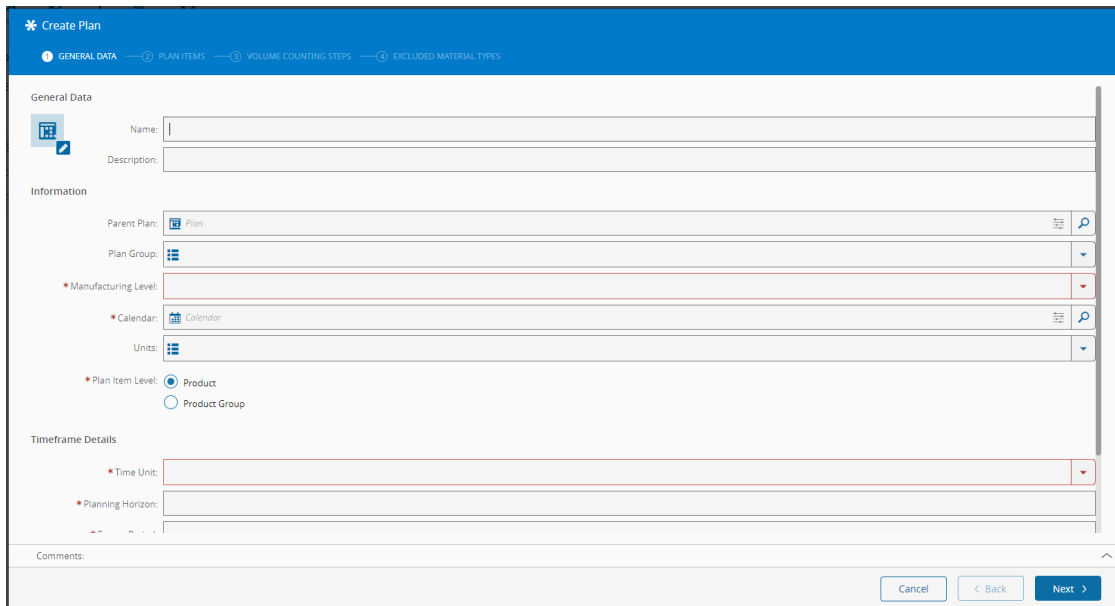
After setting up the required configurations mentioned above, the **Plan** functionality can be used, as described in the next sections.

Create Plan

1. Create your plan:



2. To establish a hierarchy and have all you need to define **Plan** values in detail, complete all fields and wizard steps accordingly, and keep the information below in mind:




3. **General Data** and **Plan Items** wizard steps:

- complete the Parent Plan field with an already existing plan.
- complete the Plan Group field with a lookup value, which can be used to classify Plans at the same level and that refer to the same overall process.
- select the Plan Item Level accordingly - Product/Product Group.
- establish the scope and horizon.
- establish the Frozen Period, which will prevent changes to the initial values.
- select the Sub-Plan Synchronization Mode, which automatically defines the terms of breaking down targets.

4. **Volume Counting Steps** and **Excluded Material Types** wizard steps:

- define how actual plan values will be counted.
- define the **Step** for counting so when a material reaches it the actual values/volumes will be updated with the quantity of that material.
- it is possible to have multiple counting steps.
- establish additional precision by defining a Flow Path or Logical Flow Path.
- specify material types of materials you do not want to count or exclude.

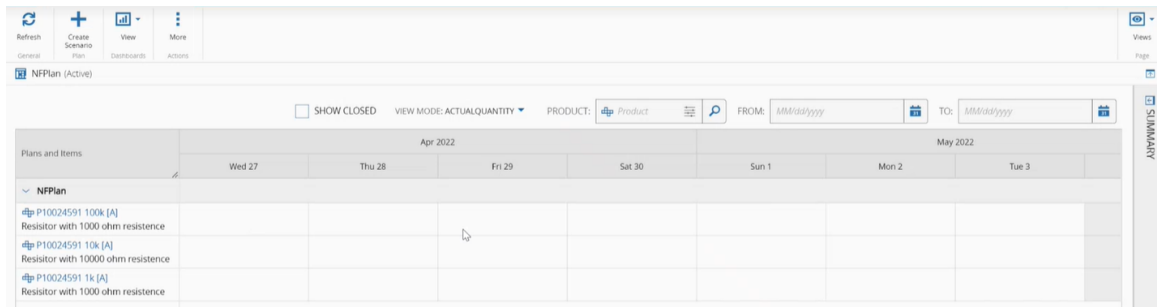
5. At the end select **Create**.

 **Note**

For more information, see [Plan](#).

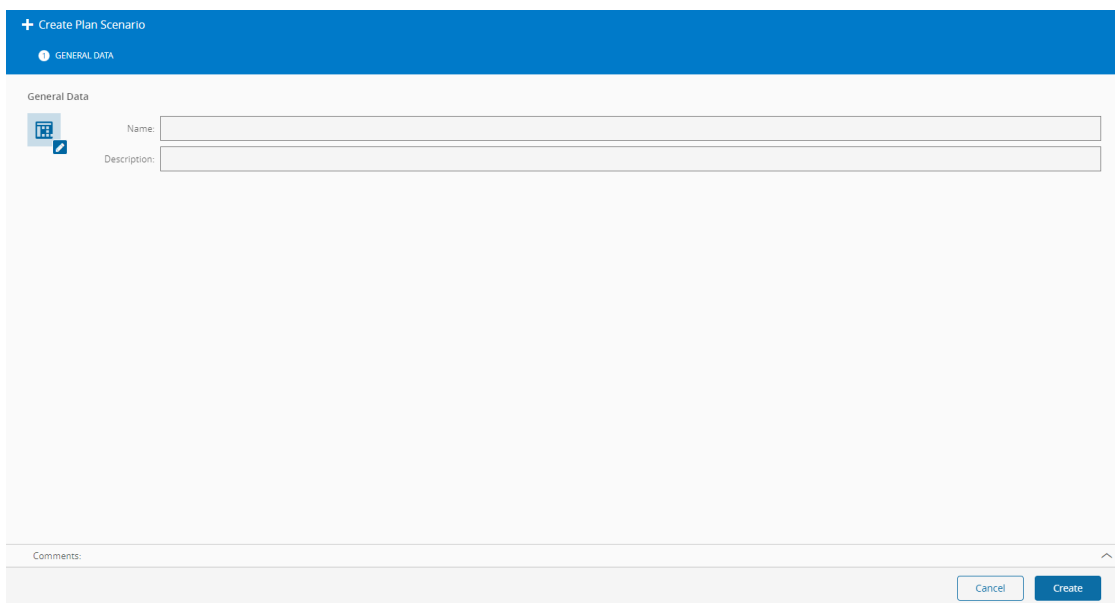
Create Scenario

When your **Plan** is created for the first time (this example uses: Area, and Product, and Day), it is empty:

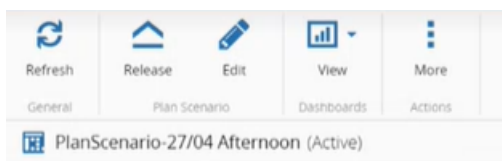


For it to have values you need to create a Plan Scenario. Your **Plan** will then be updated based on the Plan Scenario, which is a set of Planned Volumes created at a certain moment in time. Follow the steps below to create your Plan Scenario:

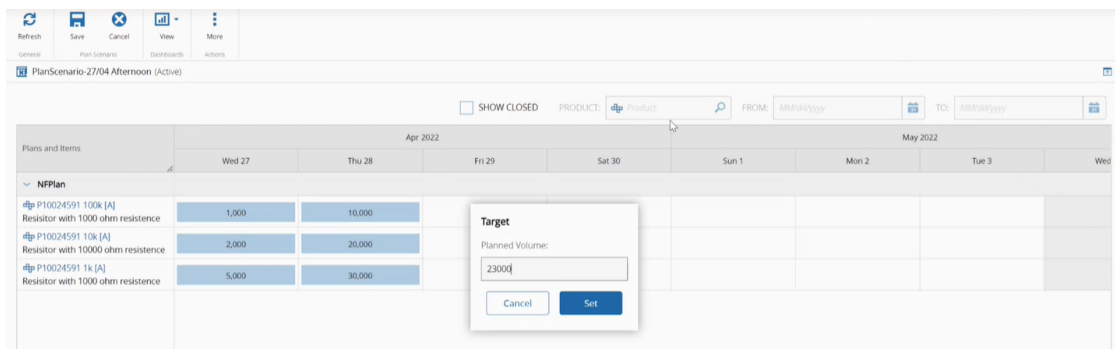
1. Select **Create Scenario** on the top ribbon.
2. Provide a Name, optionally, a Description, and select **Create**.



3. Select **Edit** on the top ribbon:



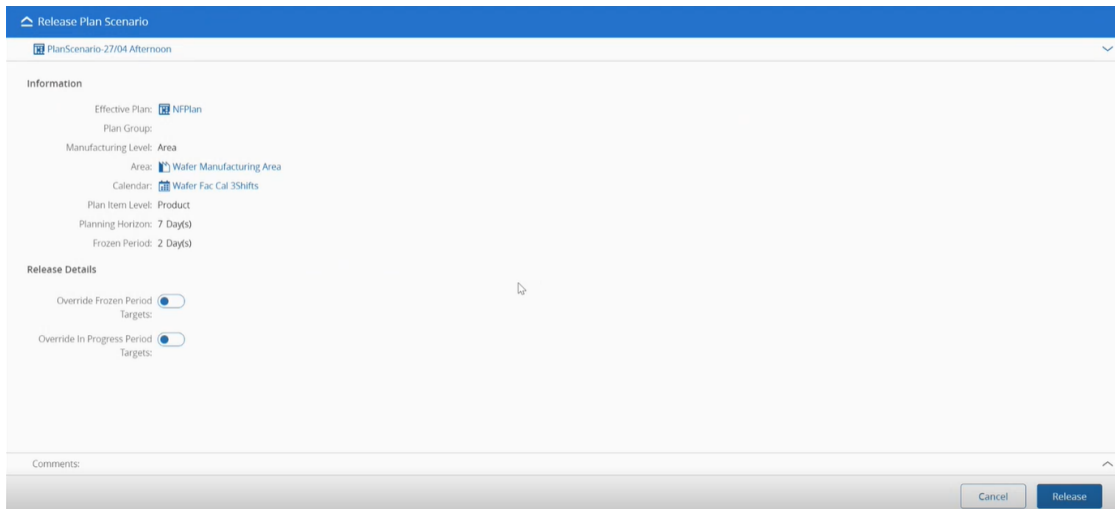
4. Start completing your **Plan** with your planned targets:



Note

These steps done via the GUI can also be achieved by using Master Data Package or API if it is integrated with an external system.

- At the end, select **Save** on the top ribbon.
- Select **Release** on the top ribbon, confirm the page information and select **Release** for your plan to take effect:



- Plan values are displayed as 0 of X, this is, there are currently no actual plan values because no **Material** has been processed:

Plans and Items	Apr 2022			May 2022			
	Wed 27	Thu 28	Fri 29	Sat 30	Sun 1	Mon 2	Tue 3
NFPlan							
P10024591 100k [A] Resistor with 1000 ohm resistance	0 of 1,000	0 of 10,000	0 of 23,000				
P10024591 10k [A] Resistor with 10000 ohm resistance	0 of 2,000	0 of 20,000	0 of 41,000				
P10024591 1k [A] Resistor with 1000 ohm resistance	0 of 5,000	0 of 30,000	0 of 56,000				

Note

There are two possible view modes, **Actual Quantity** | **Actual Percentage**, and if you select a plan time frame item, a **Summary** view is displayed on the right:

Plans and Items	Apr 2022			May 2022		
	Wed 27	Fri 29	Sat 30	Sun 1	Mon 2	Tue 3
NFPlan						
P10024591 100k [A] Resistor with 1000 ohm resistance	0 of 1,000	0 of 10,000	0 of 23,000			
P10024591 10k [A] Resistor with 10000 ohm resistance	0 of 2,000	0 of 20,000	0 of 41,000			
P10024591 1k [A] Resistor with 1000 ohm resistance	0 of 5,000	0 of 30,000	0 of 56,000			

SUMMARY

In Progress: 0%

0 of 1000

Information

Planned Volume: 1,000
Actual Volume: 0

Last Released By: CMP/cmsu
Last Released On: 04/27/2022 04:05 PM
Last Released Plan Scenario: PlanScenario-27/04 Afternoon

8. From your **Plan** go to **Views**, followed by **Details**.
9. Select **Volume Counting Steps**, open the **Step** and place your **Material** in the **Step**.

Process Material

1. The **Plan** will be updated with the actual quantities whenever the **Material** is moved to a Plan Counting Step, if:
 - it matches the Product or Product Group of a Plan Item.
 - its Units match the Units of the **Plan**, if defined.
 - its Material Type does not match any of the Excluded Material Types of the **Plan**.

In which case, the **Plan** will be updated with its quantity.

Note

If no Unit is defined, the Primary Quantity of the **Material** will be considered; if it is defined, the Primary or Secondary Quantity will be used, depending on which of the Units of the **Material** match it.

Plans and Items	Apr 2022			May 2022			
	Wed 27	Thu 28	Fri 29	Sat 30	Sun 1	Mon 2	Tue 3
NFPlan							
⊕ P10024591 100k [A] Resistor with 1000 ohm resistance	50 of 1,000	0 of 10,000	0 of 23,000				
⊕ P10024591 10k [A] Resistor with 10000 ohm resistance	0 of 2,000	0 of 20,000	0 of 41,000				
⊕ P10024591 1k [A] Resistor with 1000 ohm resistance	0 of 5,000	0 of 30,000	0 of 56,000				

Note

The most recent data can also be accessed in the **Summary** view.

2. To see what the Planned Values were when a certain Plan Scenario was released, access the **Plan Scenarios** section and open the intended scenario:

Plans and Items	Apr 2022			May 2022			
	Wed 27	Thu 28	Fri 29	Sat 30	Sun 1	Mon 2	Tue 3
NFPlan							
⊕ P10024591 100k [A] Resistor with 1000 ohm resistance	1,000	10,000	23,000				
⊕ P10024591 10k [A] Resistor with 10000 ohm resistance	2,000	20,000	41,000				
⊕ P10024591 1k [A] Resistor with 1000 ohm resistance	5,000	30,000	56,000				

Plan Item State

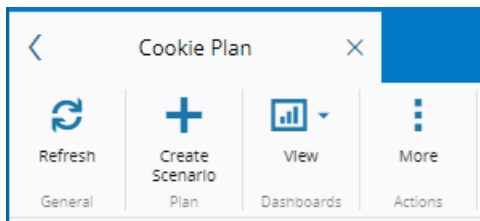
The color shown at the top of each time frame item indicates its execution state as described below:

Color	Execution State
-------	-----------------

Color	Execution State
Red	Target not Reached
Green	Target Reached
Dark Green	Target Overachieved
Yellow	In Progress
Gray	Frozen (Within the Frozen Period)
Blue	Planned (With a Planned Target Value)

Plan Status Overview Dashboard

A Dashboards View button is available on the top ribbon:



This dashboard shows a summary of the most recent time frames:





Legal Information

Disclaimer

The information contained in this document represents the current view of Critical Manufacturing on the issues discussed as of the date of publication. Because Critical Manufacturing must respond to changing market conditions, it should not be interpreted to be a commitment on the part of Critical Manufacturing, and Critical Manufacturing cannot guarantee the accuracy of any information presented after the date of publication. This document is for informational purposes only.

Critical Manufacturing makes no warranties, express, implied or statutory, as to the information herein contained.

Confidentiality Notice

All materials and information included herein are being provided by Critical Manufacturing to its Customer solely for Customer internal use for its business purposes. Critical Manufacturing retains all rights, titles, interests in and copyrights to the materials and information herein. The materials and information contained herein constitute confidential information of Critical Manufacturing and the Customer must not disclose or transfer by any means any of these materials or information, whether total or partial, to any third party without the prior explicit consent by Critical Manufacturing.

Copyright Information

All title and copyrights in and to the Software (including but not limited to any source code, binaries, designs, specifications, models, documents, layouts, images, photographs, animations, video, audio, music, text incorporated into the Software), the accompanying printed materials, and any copies of the Software, and any trademarks or service marks of Critical Manufacturing are owned by Critical Manufacturing unless explicitly stated otherwise. All title and intellectual property rights in and to the content that may be accessed through use of the Software is the property of the respective content owner and is protected by applicable copyright or other intellectual property laws and treaties.

Trademark Information

Critical Manufacturing is a registered trademark of Critical Manufacturing.

All other trademarks are property of their respective owners.