



**Critical**  
manufacturing  
an ASM PT company

# Replanning

11.0

March 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.

## scheduling

# Replanning

Re-scheduling is an essential process. As both customer demand and shop floor conditions can be quite volatile, plans quickly become obsolete; this is made even more significant by the fact that scheduling is an operational planning system, considering all the entities present in the shop-floor. As such, whether done on a regular basis to accommodate new demand and smooth out small, long term plan deviations, or done also on a contingency basis, to resolve major disturbances (Resource breakdowns, for example), Re-scheduling is a necessity.

However, it is important to take into consideration that it may not be possible to put a new plan immediately into practice. There might be delays caused by issuing the new plan, for example, in retrieving the necessary components, durables or setting up the Resources. In addition, the planner may have decided to close the plan for a certain period, not being possible to change that portion of the plan in the schedule.

As such scheduling gives the option of fixing the initial part of the planning horizon to what was set in the original plan by using a Frozen Period. This is defined by default in the Schedule but can be overridden in the Schedule Scenario level.

For every Schedule Scenario Job that falls within the horizon defined by the Frozen Period, the system will attempt to preserve the original plan, by:

1. Attempting to keep the Resource allocations the same as they were in the homologous Schedule Scenario Jobs.
2. Attempting to preserve the sequence of Schedule Scenario Jobs for each Resource.

However, this approach of attempting to preserve part of the original plan may collide with several common situations:

## Delays

Whenever one or more Schedule Scenario Jobs were scheduled to be executed at a time which has, by the time of the new Planning Start Date, already passed. As these Schedule Scenario Jobs still need to be executed, scheduling will move them to a feasible moment (after the Planning Start Date). If a Frozen Period is defined, the system will attempt to preserve the sequence of Schedule Scenario Jobs for each Resource; as such, the Schedule Scenario Jobs with the most delay will be the first to be planned.

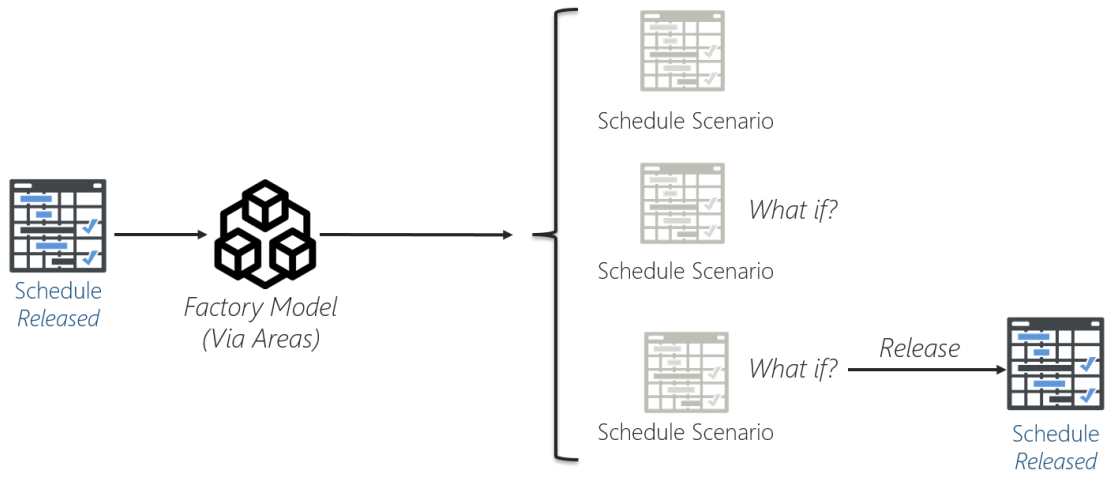
## Anticipation

Should one or more Schedule Scenario Jobs that were planned for after the new Planning Start Date already have been executed in the past, then there will be periods of availability, where the corresponding Resources will be in a standby mode. In this case, and should the Frozen Period include these moments of availability, it will be assumed that resource capacity should be utilized to its fullest, and scheduling will attempt to occupy this excess capacity by anticipating other Schedule Scenario Jobs.

## Capacity Changes

Major disturbances, such as, for example, a Resource breakdown, which renders part of the schedule caught by Frozen Period infeasible. This will result in the normal re-scheduling of the affected Schedule

Scenario Jobs.





# 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.