



Critical
manufacturing
an ASM PT company

Validations and Overriding

11.3

April 2026

DOCUMENT ACCESS

Public

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scheduling

Validations and Overriding

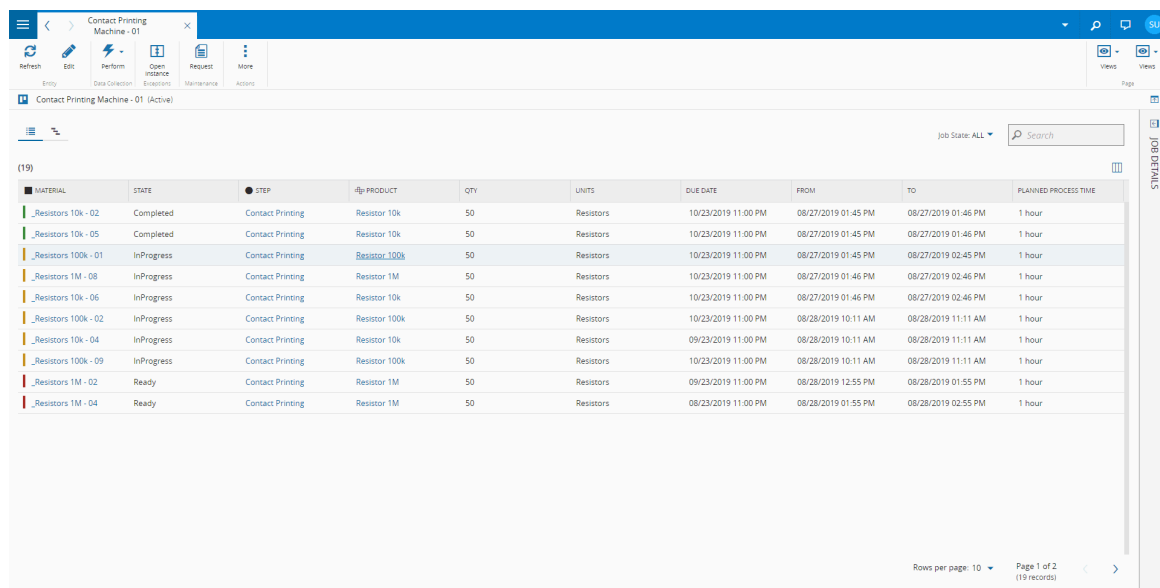
When using Scheduling for execution, there is a major change that occurs in the system regarding the normal operating mode, since Dispatching and Track-In selection becomes optional: the dispatch order is suggested by the scheduling sequence allocations and sort rule sets.

Besides this, two more validations can be activated depending on the configuration:

1. By activating the Schedule property *Enforce Scheduled Durables* at Track-In, the system will verify if each individual durable suggested by the Schedule for a Job is attached to the Resource during *Track-In*.
2. By activating the Schedule property *Enforce Scheduled Personnel at Track-in*, the system will verify if each individual Employee suggested by the Schedule for a Job is checked-in at the Resource during *Track-in*.

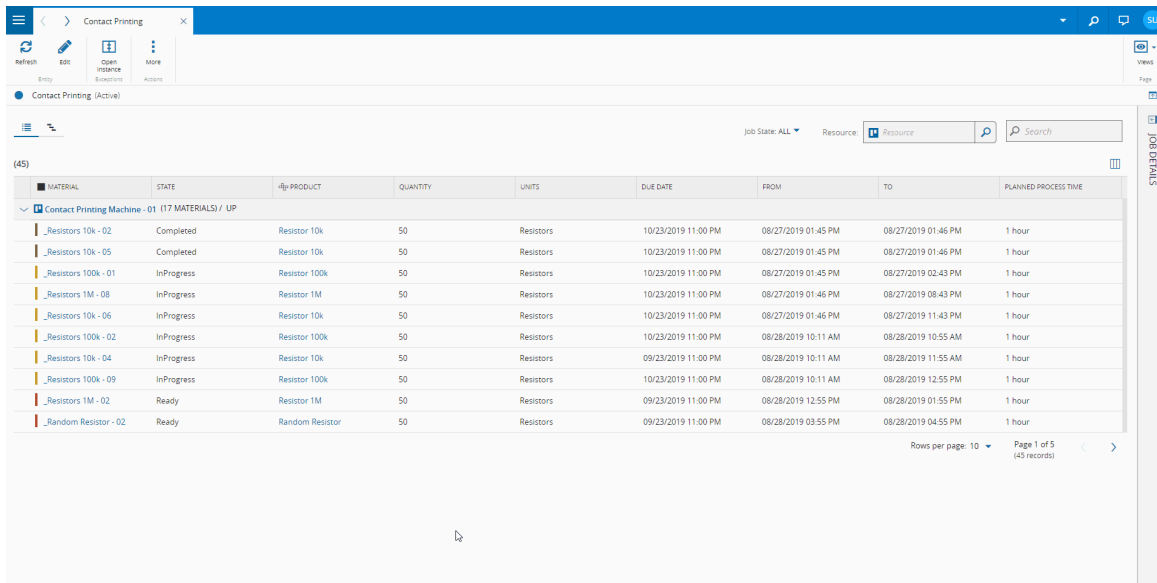
Dispatching/Resource Allocation

As can be seen below, each Job shown in the FabExplorer has a Resource allocation given by the Scheduling, replacing the typical dispatching operation.



MATERIAL	STATE	STEP	PRODUCT	QTY	UNITS	DUE DATE	FROM	TO	PLANNED PROCESS TIME
_Resistors 10k - 02	Completed	Contact Printing	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:45 PM	08/27/2019 01:46 PM	1 hour
_Resistors 10k - 05	Completed	Contact Printing	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:45 PM	08/27/2019 01:46 PM	1 hour
_Resistors 100k - 01	InProgress	Contact Printing	Resistor 100k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:45 PM	08/27/2019 02:45 PM	1 hour
_Resistors 1M - 08	InProgress	Contact Printing	Resistor 1M	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:46 PM	08/27/2019 02:46 PM	1 hour
_Resistors 10k - 06	InProgress	Contact Printing	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:46 PM	08/27/2019 02:46 PM	1 hour
_Resistors 100k - 02	InProgress	Contact Printing	Resistor 100k	50	Resistors	10/23/2019 11:00 PM	08/28/2019 10:11 AM	08/28/2019 11:11 AM	1 hour
_Resistors 10k - 04	InProgress	Contact Printing	Resistor 10k	50	Resistors	09/23/2019 11:00 PM	08/28/2019 10:11 AM	08/28/2019 11:11 AM	1 hour
_Resistors 100k - 09	InProgress	Contact Printing	Resistor 100k	50	Resistors	10/23/2019 11:00 PM	08/28/2019 10:11 AM	08/28/2019 11:11 AM	1 hour
_Resistors 1M - 02	Ready	Contact Printing	Resistor 1M	50	Resistors	09/23/2019 11:00 PM	08/28/2019 12:55 PM	08/28/2019 01:55 PM	1 hour
_Resistors 1M - 04	Ready	Contact Printing	Resistor 1M	50	Resistors	08/23/2019 11:00 PM	08/28/2019 01:55 PM	08/28/2019 02:55 PM	1 hour

Should this allocation be unsatisfactory or infeasible to execute, you can perform regular Dispatching by selecting the preferred Material and Resource either on the Material page or on the Step view of the FabExplorer, in an identical process to the *Dispatch and Track-In* operation. In addition, it is also possible to reallocate a Material to another Resource without tracking in by performing an *Adjust Schedule Job*, either by clicking on the respective button or by dragging and dropping the Job in the Calendar View.



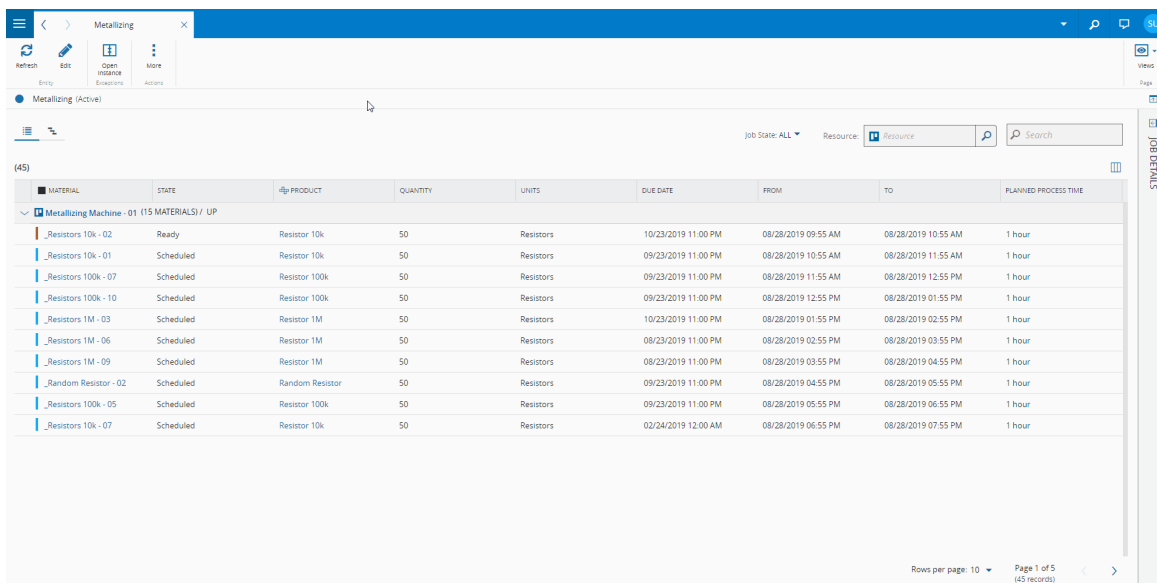
MATERIAL	STATE	PRODUCT	QUANTITY	UNITS	DUE DATE	FROM	TO	PLANNED PROCESS TIME
Contact Printing Machine - 01 (17 MATERIALS) / UP								
Resistors 10k - 02	Completed	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:45 PM	08/27/2019 01:46 PM	1 hour
Resistors 10k - 05	Completed	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:45 PM	08/27/2019 01:46 PM	1 hour
Resistors 100k - 01	InProgress	Resistor 100k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:45 PM	08/27/2019 02:43 PM	1 hour
Resistors 1M - 08	InProgress	Resistor 1M	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:46 PM	08/27/2019 08:43 PM	1 hour
Resistors 10k - 06	InProgress	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/27/2019 01:46 PM	08/27/2019 11:43 PM	1 hour
Resistors 100k - 02	InProgress	Resistor 100k	50	Resistors	10/23/2019 11:00 PM	08/28/2019 10:11 AM	08/28/2019 10:55 AM	1 hour
Resistors 10k - 04	InProgress	Resistor 10k	50	Resistors	09/23/2019 11:00 PM	08/28/2019 10:11 AM	08/28/2019 11:55 AM	1 hour
Resistors 100k - 09	InProgress	Resistor 100k	50	Resistors	10/23/2019 11:00 PM	08/28/2019 10:11 AM	08/28/2019 12:55 PM	1 hour
Resistors 1M - 02	Ready	Resistor 1M	50	Resistors	09/23/2019 11:00 PM	08/28/2019 12:55 PM	08/28/2019 01:55 PM	1 hour
Random Resistor - 02	Ready	Random Resistor	50	Resistors	09/23/2019 11:00 PM	08/28/2019 03:55 PM	08/28/2019 04:55 PM	1 hour

Unplanned Materials

If a Material has not been planned (was not caught by the last Schedule Scenario that was released), and therefore doesn't have a Schedule Scenario Job for its current Step, then it can't be tracked-in to a Scheduling Resource. In order to do this, you must perform a traditional *Dispatch* operation, with the added input of the Planned Start Date for this Job (defaults to the present date and time).

Durable and Labor Enforcement

As mentioned earlier in this section, it is possible to have the system validate whether the Durables and Employees allocated to each individual Job are associated with the Resource during *Track-In*. It is possible to check which Durables and/or Employees are associated with a certain Job by selecting it in the Schedule, opening the details tab on the right, and expanding the Durables or Employees tabs respectively.



MATERIAL	STATE	PRODUCT	QUANTITY	UNITS	DUE DATE	FROM	TO	PLANNED PROCESS TIME
Metallizing Machine - 01 (15 MATERIALS) / UP								
Resistors 10k - 02	Ready	Resistor 10k	50	Resistors	10/23/2019 11:00 PM	08/28/2019 09:55 AM	08/28/2019 10:55 AM	1 hour
Resistors 10k - 01	Scheduled	Resistor 10k	50	Resistors	09/23/2019 11:00 PM	08/28/2019 10:55 AM	08/28/2019 11:55 AM	1 hour
Resistors 100k - 07	Scheduled	Resistor 100k	50	Resistors	09/23/2019 11:00 PM	08/28/2019 11:55 AM	08/28/2019 12:55 PM	1 hour
Resistors 100k - 10	Scheduled	Resistor 100k	50	Resistors	09/23/2019 11:00 PM	08/28/2019 12:55 PM	08/28/2019 01:55 PM	1 hour
Resistors 1M - 03	Scheduled	Resistor 1M	50	Resistors	10/23/2019 11:00 PM	08/28/2019 01:55 PM	08/28/2019 02:55 PM	1 hour
Resistors 1M - 06	Scheduled	Resistor 1M	50	Resistors	08/23/2019 11:00 PM	08/28/2019 02:55 PM	08/28/2019 03:55 PM	1 hour
Resistors 1M - 09	Scheduled	Resistor 1M	50	Resistors	08/23/2019 11:00 PM	08/28/2019 03:55 PM	08/28/2019 04:55 PM	1 hour
Random Resistor - 02	Scheduled	Random Resistor	50	Resistors	09/23/2019 11:00 PM	08/28/2019 04:55 PM	08/28/2019 05:55 PM	1 hour
Resistors 100k - 05	Scheduled	Resistor 100k	50	Resistors	09/23/2019 11:00 PM	08/28/2019 05:55 PM	08/28/2019 06:55 PM	1 hour
Resistors 10k - 07	Scheduled	Resistor 10k	50	Resistors	02/24/2019 12:00 AM	08/28/2019 06:55 PM	08/28/2019 07:55 PM	1 hour

i Info

To learn more about scheduling durables, please check the [Scheduling Durables page](#)

i Info

To learn more about scheduling labor, please check the [Scheduling Labor page](#)

As with other scheduling validations, it is possible to ignore this constraint by using *Track-In with Schedule Override*. Note that other constraints regarding Durables and Employees which are not imposed by scheduling still apply while using *Track-in with Schedule Override*.



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