



Critical
manufacturing
an ASM PT company

Scheduling Durables

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scheduling

Scheduling Durables

Durables are tools which may be used together with a Resource in order to produce different Products. It may occur that, for the same Resource, different Products may require different durables. Furthermore, it may be possible that, for a single operation, more than one type of durables is required, with each individual durable having its own Maintenance Plan, and the same pool of durables can be shared across multiple Resources.

If durables are a constraining factor in the production process, given these considerations or others, it may become important to include them in scheduling. Scheduling supports durables scheduling, in other words, constraining the operations execution to when both the required Resource and durables are available.

i Durables scheduling significantly worsens the performance of scheduling in terms of time. Therefore, this functionality should only be activated when durables are a constraining factor.

In order to implement durable scheduling, it is necessary to:

- Activate durables scheduling
- Specify the durable availability
- Specify the durable demand

Activating Durables Scheduling

Activating durable scheduling is done through the Schedule, with two properties:

- Schedule Durables - activates the functionality.
- Enforce Scheduled Durables at Track-In - when executing the Schedule the system will enforce, at Track-In, that the exact durables that were scheduled are the ones attached to the Resource (in other words, it is not just sufficient to have the correct quantity of durables of the correct Product, it must be the ones determined by scheduling).

i Info

If the property ExcludeFromScheduling has been set to true at setup, the Durable Material will not be considered for scheduling.

i If the Schedule's property Holds Processing Mode is set to Exclude and the Durable is put on hold, it will not be considered for scheduling.

Specifying the Durable Availability

For Durables to be considered, they must:

- Be in a Step where Include in Scheduling is set to True, and be present in an Area connected to the Schedule

- Belong to a Product that has both Include in Schedule and Is Durable set to true.
- Not have Exclude from Scheduling set to True and not be hold if the Schedule's property Holds Processing Mode is set to Exclude

Info

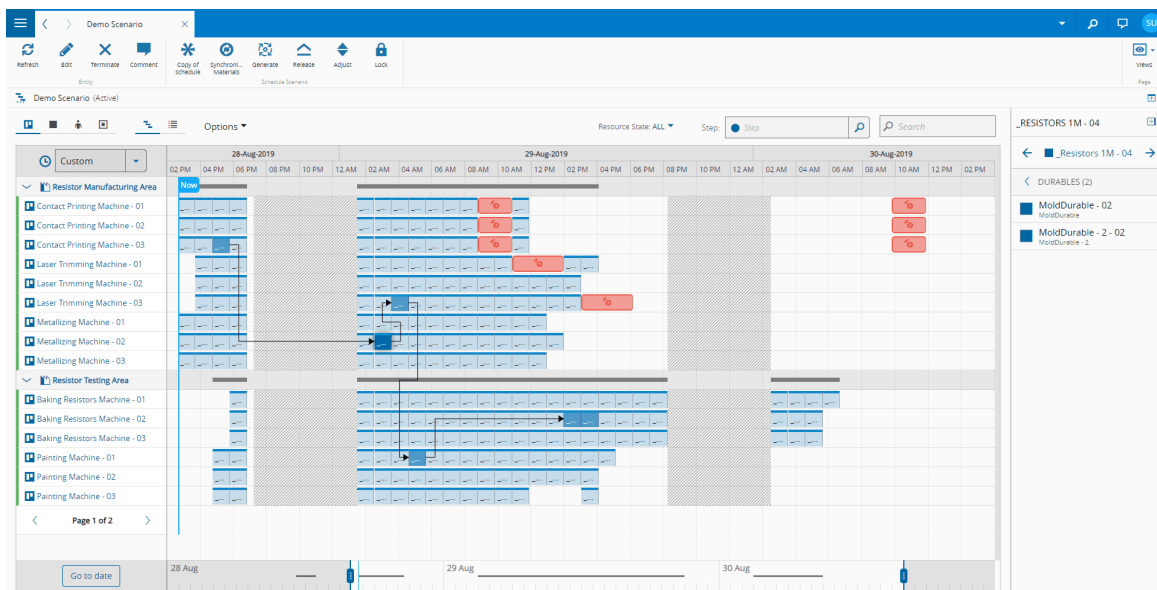
The processing Flow of the durable itself is not considered, that is, the scheduler will never attempt to plan the durable's processing through the various Steps of its Flow.

Specifying the Durable Demand

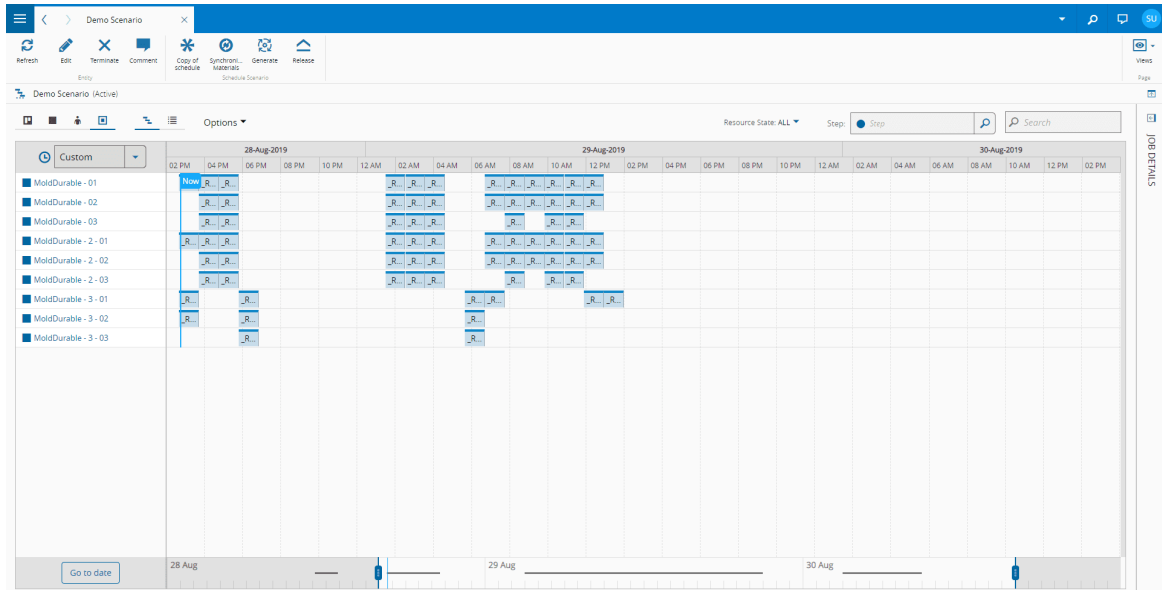
To implement Durable Demand, it is necessary to have:

- A BOM of Scope Durables, for each set of durables required.
- The MaterialDurablesContext smart table should provide a BOM for every context where durables are required. In addition, if Usage Steps are used in the BOM, then only BOM Products whose Usage Steps match the Step of the MaterialDurablesContext will be used for that Context.

It is possible to see the durable allocation to a particular Schedule Scenario Job by selecting the Job, opening the details tab on the right, and expanding the Tools tab.



In addition, by navigating to the Durables view, it is possible to see which Jobs are assigned to each Durable.





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