

Line Verification

11.2

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DOCUMENT ACCESS

Public

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Line Verification

The Line Verification feature addresses the need for systematic verification activities while a **Material** is being processed. These verifications are particularly relevant in high-sensitivity production environments, where any changes in conditions, such as operator shifts, can impact product quality.

Info

- Maintenance Management is a separately licensed module required to access this feature.
- This feature is part one of a two-part process that pairs seamlessly with the Setup and Line Clearance feature. Check out the [Setup and Line Clearance](#) tutorial.

Overview

In this tutorial, we will explore expand the following sections:

- Feature Overview – explaining how Line Verification works
- Scenario – presenting a simplified example to understand the logic
- Configuration – showing a step-by-step guide to trigger verifications on in-process **Materials**, after shift breaks and shift changes
- Execution – triggering in-process **Material** verification using the feature
- Final Notes – pointing out some additional insights and considerations

Feature Overview

This feature is event-based and is triggered after a **Material** is tracked, ensuring that critical verification occurs while the **Material** is in-process.

The feature is implemented within the Maintenance Management module and is driven by a **Maintenance Plan** assigned dynamically through a context resolution of the Smart Table [MaterialInProcessVerificationContext](#), creating a **Maintenance Plan** Instance when a **Material** is tracked in. This plan outlines the specific verification activities required for each **Material** during processing. In this tutorial, we will explore the time based activities, triggered on shift change events.

Once a **Material** is tracked in, a **Maintenance Plan** Instance is created and remains active throughout the time the **Material** is in-process, until it is tracked out. During this window, there is the need to execute verification activities, such as inspecting equipment, recalibrating scales, and checking environmental conditions (for example, temperature or humidity).

Scenario

To assess how this industry and production requirement is addressed by Critical Manufacturing MES, let's consider a simplified model:

- **Shift Definition:** 6 shifts covering 24 hours.
- **Facility:** General Facility
- **Area:** Area 1
- **Flow** and **Step:** General Flow with Step 1

- **Products:** Product A
- **Resources:** Resource 1
- **Service:** Service A, required by Step 1 and Provided by Resource 1
- **Role**

Suppose that the process at Step 1 requires the operator with the Process Verification Role to monitor the temperature and humidity of the environment whenever a **Material** is in-process, at two specific moments: when the next shift employees return from their mid-shift break, and after a shift change. There is a scheduled and automatically triggered verification requested for the material that was left in-process.

Additionally, during shift changes, the new operators are required to:

- Confirm that all necessary durables are in the correct position
- Acknowledge the materials that are currently in line for processing at Step 1.

Configuration

Basic entities like **Facility**, **Area**, **Services**, **Products**, **Parameters**, **Resources** and **Roles** won't be detailed.

Useful Documentation

There are some entities whose configurations require closer attention:

- **Calendar** and **Shift Definition**
- **Step**
- **Data Collection** and **Checklist**
- **Maintenance Plan**

Calendar and Shift Definition

This scenario assumes the existence of a **Calendar** with a **Shift Definition** that includes six shifts, covering the full 24-hour day.

Keep in mind the correct sequence when setting this up:

- First, create the Calendar.
- Then, define the Shift Definition.
- Finally, associate the Shift Definition with the Calendar.

The following images display the general configuration settings of the **Calendar** and **Shift Definition**:

Standard Calendar

Refresh

Edit

More

Standard Calendar (Active)

Calendar

Name: Standard Calendar

Description: Standard Calendar

Universal State: Active

Data Group:

Information

Time Zone: (UTC+00:00) Dublin, Edinburgh, Lisbon, London

Clock-In Early Start (Minutes): 0

Enterprise Wide Reporting: X No

Dimension:

Fiscal Start Day: 1

Fiscal Start Month: January

Week Start Day: Monday

Day Start Time: 02:00 AM - Current Day

WEEK DEFINITION

Manage

Week Days (7)

DAY	SHIFT DEFINITION	COST OVERTIME FACTOR
Monday	Standard Shift	1
Tuesday	Standard Shift	1
Wednesday	Standard Shift	1
Thursday	Standard Shift	1
Friday	Standard Shift	1
Saturday	Non-Working Day	
Sunday	Non-Working Day	

Shift Definition

Standard Shift

Refresh

Edit

More

Standard Shift (Active)

Shift Definition

Name: Standard Shift

Description: Standard Shift

Universal State: Active

Data Group:

Information

Calendar: Standard Calendar

Start Time: 02:00 AM

SHIFTS

Refresh

Manage

Shifts (6)

NAME	START TIME	END TIME	COST OVERTIME FACTOR	TEAM PATTERN	CODE AND COLORS
Shift 1	02:00	06:00	1		<input type="checkbox"/> 1 >
Shift 2	06:00	10:00	1		<input type="checkbox"/> 1 >
Shift 3	10:00	14:00	1		<input type="checkbox"/> 1 >
Shift 4	14:00	18:00	1		<input type="checkbox"/> 1 >
Shift 5	18:00	22:00	1		<input type="checkbox"/> 1 >
Shift 6	22:00	02:00	1		<input type="checkbox"/> 1 >

Rows per Page: 50

Page 1 of 1 (6 Records)

Page 3 of 15

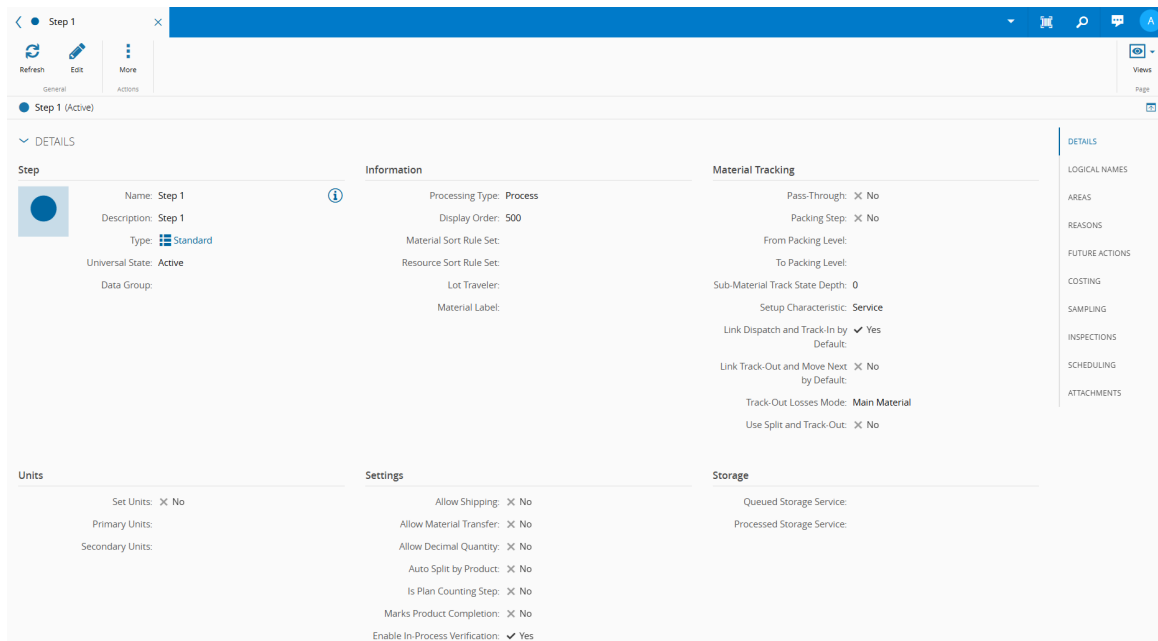
Useful Documentation

- [Create Calendar](#)
- [How to: Create a Calendar](#)
- [Create Shift Definition](#)
- [How to: Create a Shift Definition](#)

Step

For a **Step** to support in-process verification, the property `Enable In-Process Verification` must be set to true under the Settings section in the details of the **Step**.

The following images display the general configuration of the **Step**.



The screenshot shows the configuration for 'Step 1' in a software interface. The interface is divided into several sections:

- General:** Includes a 'Refresh' button, 'Edit' and 'More' options, and a 'Views' dropdown.
- DETAILS:**
 - Step:** Name: Step 1, Description: Step 1, Type: Standard, Universal State: Active, Data Group: (empty).
 - Information:** Processing Type: Process, Display Order: 500, Material Sort Rule Set: (empty), Resource Sort Rule Set: (empty), Lot Traveler: (empty), Material Label: (empty).
 - Material Tracking:** Pass-Through: X No, Packing Step: X No, From Packing Level: (empty), To Packing Level: (empty), Sub-Material Track State Depth: 0, Setup Characteristic: Service, Link Dispatch and Track-In by Default: Yes, Link Track-Out and Move Next by Default: X No, Track-Out Losses Mode: Main Material, Use Split and Track-Out: X No.
 - Units:** Set Units: X No, Primary Units: (empty), Secondary Units: (empty).
 - Settings:** Allow Shipping: X No, Allow Material Transfer: X No, Allow Decimal Quantity: X No, Auto Split by Product: X No, Is Plan Counting Step: X No, Marks Product Completion: X No, Enable In-Process Verification: Yes.
 - Storage:** Queued Storage Service: (empty), Processed Storage Service: (empty).
- RIGHT SIDEBAR:** A list of categories including LOGICAL NAMES, AREAS, REASONS, FUTURE ACTIONS, COSTING, SAMPLING, INSPECTIONS, SCHEDULING, and ATTACHMENTS.

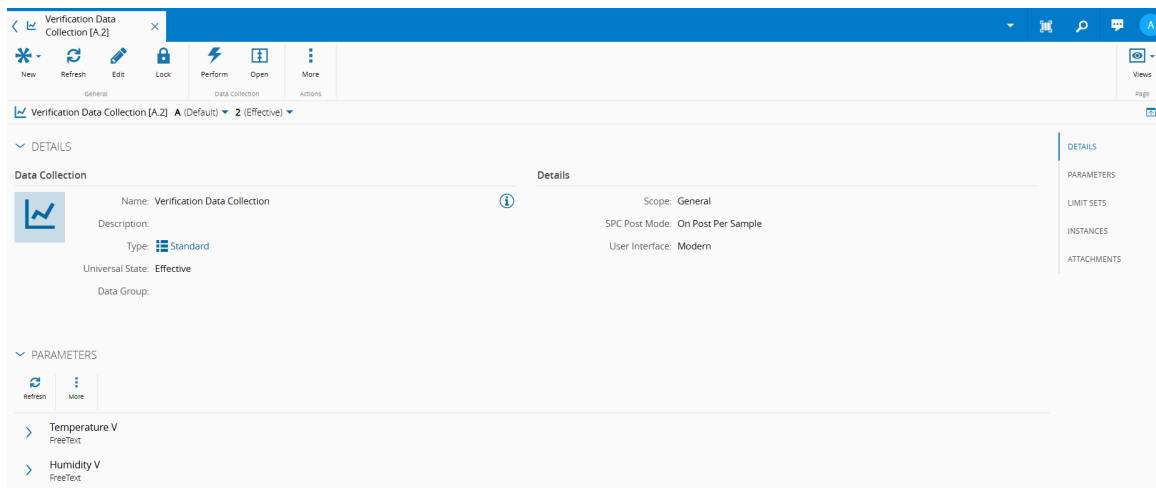
Useful Documentation

- [Create Step](#)
- [How to: Create a Step](#)

Data Collection and Checklist

The Data Collection consists of gathering a sample and recording two key **Parameters**: Temperature and Humidity.

The following image displays the general configuration of the **Data Collection**.



Verification Data Collection [A.2]

DETAILS

Data Collection

Name: Verification Data Collection

Description:

Type: Standard

Universal State: Effective

Data Group:

Details

Scope: General

SPC Post Mode: On Post Per Sample

User Interface: Modern

PARAMETERS

Temperature V
FreeText

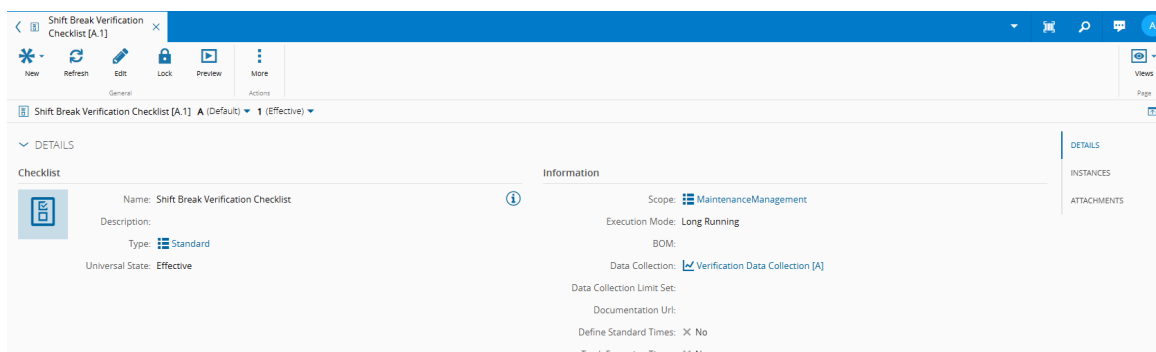
Humidity V
FreeText

The **Checklist** is scoped under Maintenance Management and incorporates the **Data Collection**. Since the requirements differ for each scenario, there are two distinct **Checklists**.

The Shift Break **Checklist** includes two items, each corresponding to the collection of one **Parameter**: temperature and humidity.

The following images display the configuration of the Shift Break **Checklist**.

Shift Break



Shift Break Verification Checklist [A.1]

DETAILS

Checklist

Name: Shift Break Verification Checklist

Description:

Type: Standard

Universal State: Effective

Information

Scope: MaintenanceManagement

Execution Mode: Long Running

BOM:

Data Collection: Verification Data Collection [A]

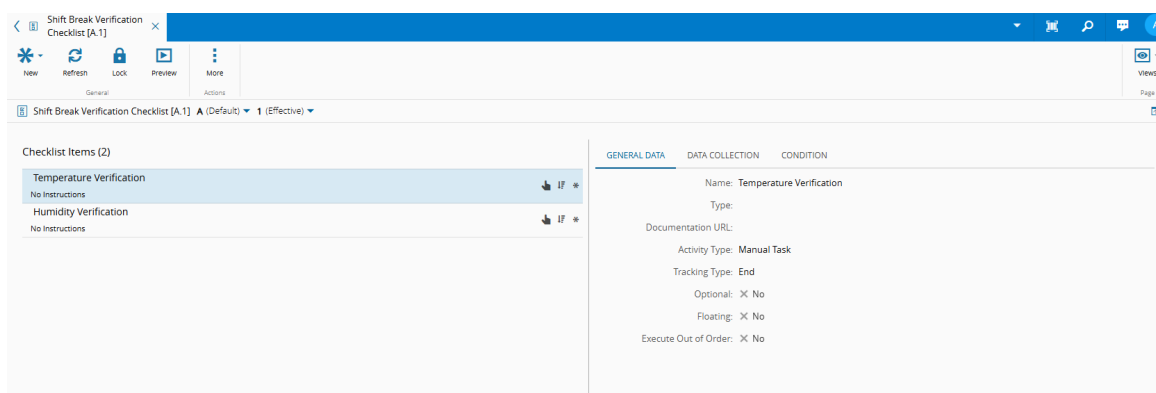
Data Collection Limit Set:

Documentation Url:

Define Standard Times: No

Track Execution Times: No

Item 1 - General Data



Shift Break Verification Checklist [A.1]

GENERAL DATA

Checklist Items (2)

Temperature Verification
No Instructions

Humidity Verification
No Instructions

GENERAL DATA

Name: Temperature Verification

Type:

Documentation URL:

Activity Type: Manual Task

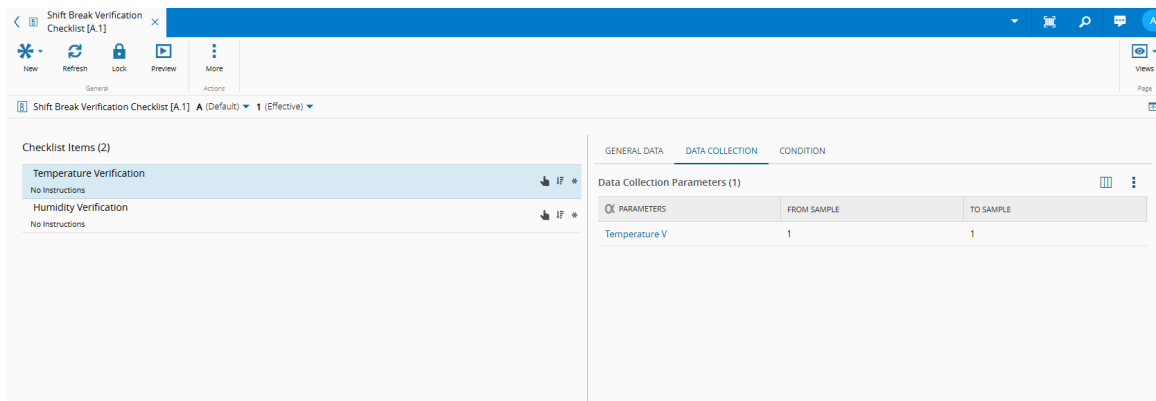
Tracking Type: End

Optional: No

Floating: No

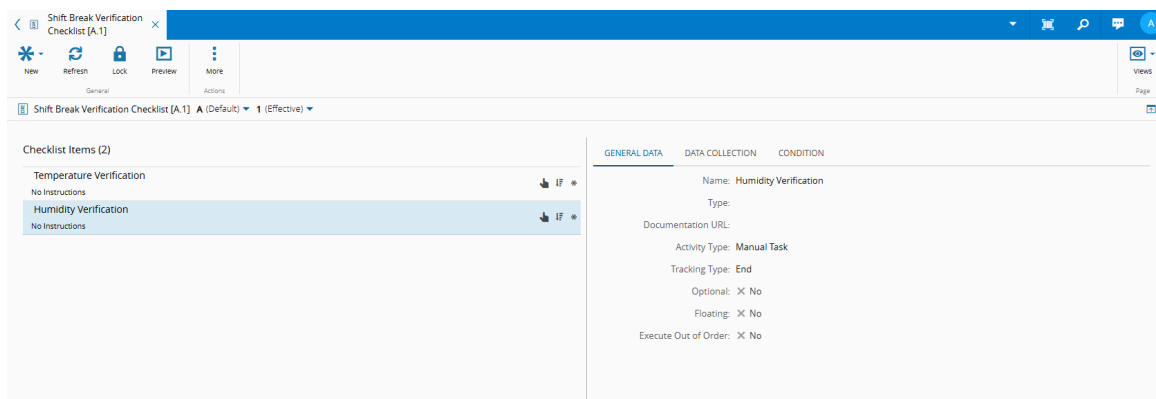
Execute Out of Order: No

Item 1 - Data Collection



PARAMETERS	FROM SAMPLE	TO SAMPLE
Temperature V	1	1

Item 2 - General Data



Name: Humidity Verification

Type:

Documentation URL:

Activity Type: Manual Task

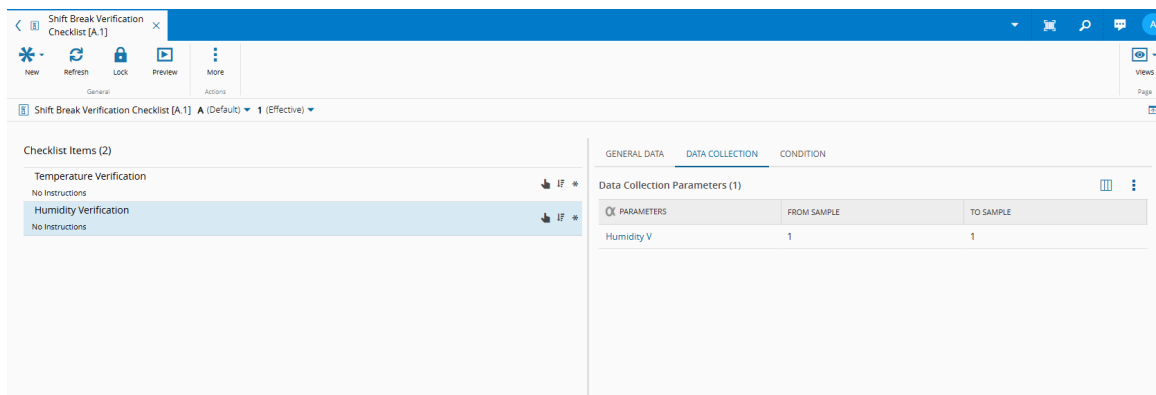
Tracking Type: End

Optional: ☒ No

Floating: ☒ No

Execute Out of Order: ☒ No

Item 2 - Data Collection



PARAMETERS	FROM SAMPLE	TO SAMPLE
Humidity V	1	1

The Shift Change **Checklist** contains four items:

- The first two are the same as in the shift break case, capturing Temperature and Humidity data.
- The remaining two require the operator to verify:
 - That Durables are in the correct position.
 - The status and acknowledgment of Work In Progress materials queued at the step.

The following images display the configuration of the Shift Change **Checklist**.

Shift Change

Shift Change Verification Checklist ...

New

Refresh

Edit

Lock

Preview

More

General

Actions

Views

Page

Shift Change Verification Checklist [A.1] A (Default) 1 (Effective)

DETAILS

INSTANCES

ATTACHMENTS

Checklist

Name: Shift Change Verification Checklist

Description:

Type: Standard

Universal State: Effective

Information

Scope: MaintenanceManagement

Execution Mode: Long Running

BOM:

Data Collection: Verification Data Collection [A]

Data Collection Limit Set:

Documentation Url:

Define Standard Times: No

Track Execution Times: No

Item 1 - General Data

Shift Change Verification Checklist ...

New

Refresh

Lock

Preview

More

General

Actions

Views

Page

Shift Change Verification Checklist [A.1] A (Default) 1 (Effective)

GENERAL DATA

DATA COLLECTION

CONDITION

Checklist Items (4)

Temperature Verification

No Instructions

IF *

Humidity Verification

No Instructions

IF *

Check durables position

No Instructions

IF *

Check incoming WIP

No Instructions

IF *

GENERAL DATA

Name: Temperature Verification

Type:

Documentation URL:

Activity Type: Manual Task

Tracking Type: End

Optional: No

Floating: No

Execute Out of Order: No

Item 1 - Data Collection

Shift Change Verification Checklist ...

New

Refresh

Lock

Preview

More

General

Actions

Views

Page

Shift Change Verification Checklist [A.1] A (Default) 1 (Effective)

GENERAL DATA

DATA COLLECTION

CONDITION

Checklist Items (4)

Temperature Verification

No Instructions

IF *

Humidity Verification

No Instructions

IF *

Check durables position

No Instructions

IF *

Check incoming WIP

No Instructions

IF *

Data Collection Parameters (1)

PARAMETERS

FROM SAMPLE

TO SAMPLE

Temperature V

1

1

Item 2 - General Data

Shift Change Verification Checklist ...

New

Refresh

Lock

Preview

More

General

Actions

Views

Shift Change Verification Checklist [A.1] A (Default) 1 (Effective)

Checklist Items (4)

Temperature Verification

No Instructions

IF *

Humidity Verification

No Instructions

IF *

Check durables position

No Instructions

IF *

Check incoming WIP

No Instructions

IF *

GENERAL DATA

DATA COLLECTION

CONDITION

Name: Humidity Verification

Type:

Documentation URL:

Activity Type: Manual Task

Tracking Type: End

Optional: X No

Floating: X No

Execute Out of Order: X No

Item 2 - Data Collection

Shift Change Verification Checklist ...

New

Refresh

Lock

Preview

More

General

Actions

Views

Shift Change Verification Checklist [A.1] A (Default) 1 (Effective)

Checklist Items (4)

Temperature Verification

No Instructions

IF *

Humidity Verification

No Instructions

IF *

Check durables position

No Instructions

IF *

Check incoming WIP

No Instructions

IF *

GENERAL DATA

DATA COLLECTION

CONDITION

Data Collection Parameters (1)

PARAMETERS

FROM SAMPLE

TO SAMPLE

Humidity V

1

1

Item 3 - General Data

Shift Change Verification Checklist ...

New

Refresh

Lock

Preview

More

General

Actions

Views

Shift Change Verification Checklist [A.1] A (Default) 1 (Effective)

Checklist Items (4)

Temperature Verification

No Instructions

IF *

Humidity Verification

No Instructions

IF *

Check durables position

No Instructions

IF *

Check incoming WIP

No Instructions

IF *

GENERAL DATA

CONDITION

Name: Check durables position

Type:

Documentation URL:

Activity Type: Manual Task

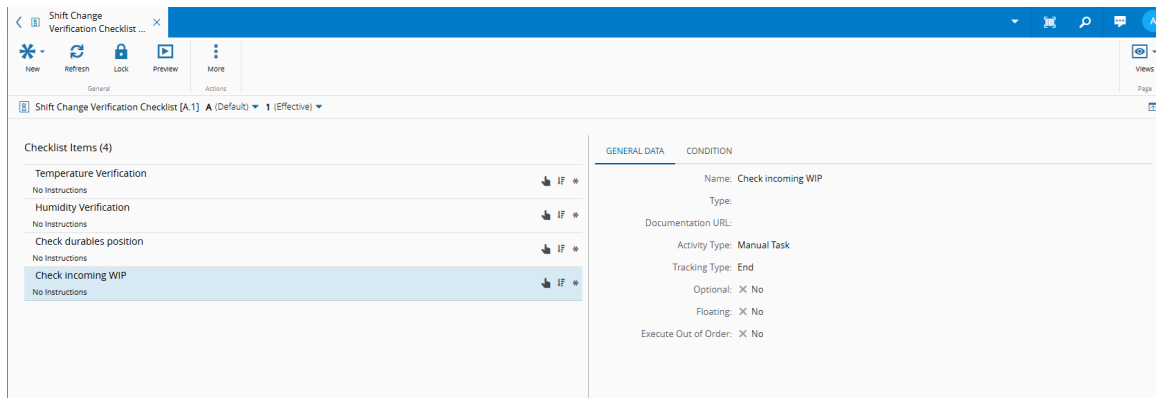
Tracking Type: End

Optional: X No

Floating: X No

Execute Out of Order: X No

Item 4 - General Data



Checklist Items (4)	GENERAL DATA	CONDITION
Temperature Verification No Instructions		Name: Check incoming WIP
Humidity Verification No Instructions		Type:
Check durables position No Instructions		Documentation URL:
Check incoming WIP No Instructions		Activity Type: Manual Task
		Tracking Type: End
		Optional: X No
		Floating: X No
		Execute Out of Order: X No

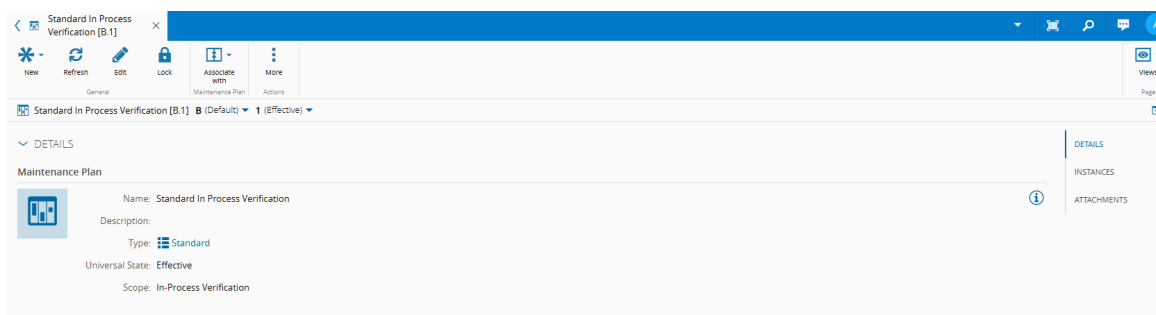
Useful Documentation


- [Create Data Collection](#)
- [How to: Create a Data Collection](#)
- [Create Checklist](#)
- [How to: Create a Checklist](#)

Maintenance Plan

For this scenario, we will define a single **Maintenance Plan** of scope In-Process Verification. The associated maintenance activities must use a time based schedule type, allowing us to leverage the "On Shift Change" time due scale to implement the intended logic.

The following image displays the configuration of the **Maintenance Plan**.



DETAILS	DETAILS
Maintenance Plan  Name: Standard In Process Verification Description: Type: Standard Universal State: Effective Scope: In-Process Verification	INSTANCES ATTACHMENTS

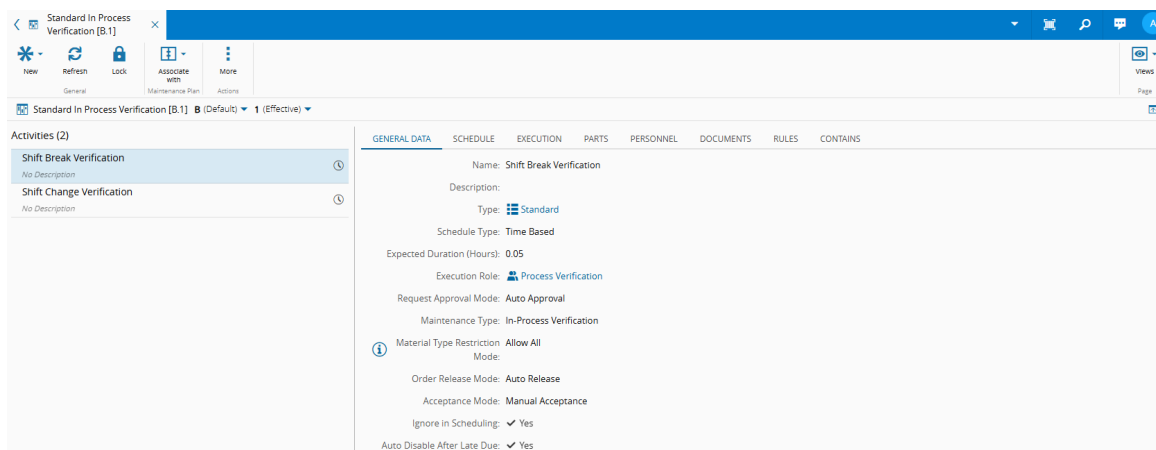
Maintenance Activities Overview:

Maintenance Activity Order	Trigger	Duration	Due Window	Tolerance	Activity

Maintenance Activity Order	Trigger	Duration	Due Window	Tolerance	Activity
Shift Break Verification	Halfway through the shift (offset of 50%)	3 minutes (0.05 hours)	Must be completed 15 minutes (0.25 hours) after the mid-shift break	Cannot be performed before the halfway point of the shift, but can be completed anytime within the 15-minute window	Perform Shift Break Checklist and Data Collection
Shift Change Verification	When the shift changes	6 minutes (0.1 hours)	Must be completed 15 minutes (0.25 hours) after the shift change	Early or late completion allowed within a 15-minute window	Perform Shift Change Checklist and Data Collection

The following image displays the configuration of the Shift Break Verification maintenance activity.

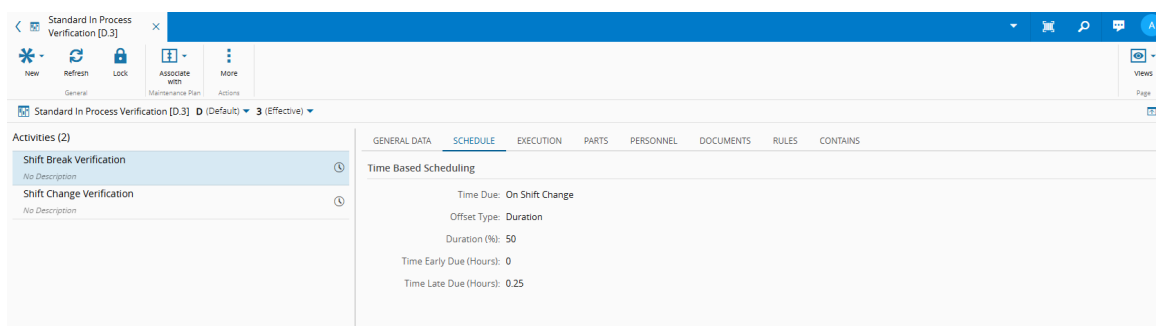
General



The screenshot shows the 'General' tab for the 'Shift Break Verification' activity. The left sidebar lists 'Shift Break Verification' and 'Shift Change Verification'. The main panel displays the following configuration details:

- Name:** Shift Break Verification
- Description:**
- Type:** Standard
- Schedule Type:** Time Based
- Expected Duration (Hours):** 0.05
- Execution Role:** Process Verification
- Request Approval Mode:** Auto Approval
- Maintenance Type:** In-Process Verification
- Material Type Restriction:** Allow All
- Order Release Mode:** Auto Release
- Acceptance Mode:** Manual Acceptance
- Ignore in Scheduling:** ☒ Yes
- Auto Disable After Late Due:** ☒ Yes

Schedule



The screenshot shows the 'Schedule' tab for the 'Shift Break Verification' activity. The left sidebar lists 'Shift Break Verification' and 'Shift Change Verification'. The main panel displays the following scheduling details:

- Time Based Scheduling**
- Time Due:** On Shift Change
- Offset Type:** Duration
- Duration (%):** 50
- Time Early Due (Hours):** 0
- Time Late Due (Hours):** 0.25

Execution

Standard In Process Verification [B.1]

Activities (2)

- Shift Break Verification
- Shift Change Verification

GENERAL DATA SCHEDULE EXECUTION PARTS PERSONNEL DOCUMENTS RULES CONTAINS

Begin and Complete Mode: Manual Begin And Complete

Perform

Checklist: Shift Break Verification Checklist [A]

Data Collection: Verification Data Collection [A]

Data Collection Limit Set:

Rework

Checklist:

Data Collection:

Data Collection Limit Set:

Charts (0)

CHART DISPLAY MODE

No data to show.

Rows per Page: 10 Page 1 of 1 (0 Records)

The following image displays the configuration of the Shift Change Verification maintenance activity.

General

Standard In Process Verification [D.3]

Activities (2)

- Shift Break Verification
- Shift Change Verification

GENERAL DATA SCHEDULE EXECUTION PARTS PERSONNEL DOCUMENTS RULES CONTAINS

Name: Shift Change Verification

Description:

Type: Standard

Schedule Type: Time Based

Expected Duration (Hours): 0.1

Execution Role: Process Verification

Request Approval Mode: Auto Approval

Maintenance Type: In-Process Verification

Material Type Restriction: Allow All

Mode:

Order Release Mode: Auto Release

Acceptance Mode: Manual Acceptance

Ignore in Scheduling: Yes

Auto Disable After Late Due: Yes

Schedule

Standard In Process Verification [B.1]

Activities (2)

- Shift Break Verification
- Shift Change Verification

GENERAL DATA SCHEDULE EXECUTION PARTS PERSONNEL DOCUMENTS RULES CONTAINS

Time Based Scheduling

Time Due: On Shift Change

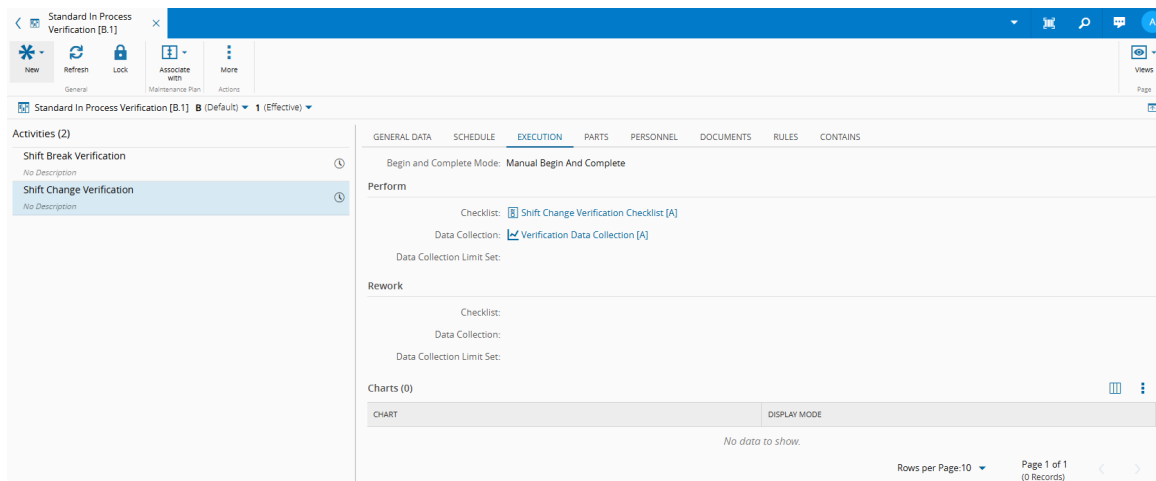
Offset Type: Hours

Hours: 0.25

Time Early Due (Hours): 0.25

Time Late Due (Hours): 0.25

Execution



To connect all elements of the configuration, the system uses the Smart Table [MaterialInProcessVerificationContext](#). In this table, it is defined:

- The **Step** (which must have In-Process Verification enabled)
- Optional context variables to refine applicability
- The corresponding **Maintenance Plan** to be triggered when the **Material** is tracked-in at that **Step**

The following table displays the Smart Table configuration.

Step	Maintenance Plan	Owner Role
Step 1	Standard In Process Verification	Process Verification

Useful Documentation

- [How to: Assign Roles to a User](#)
- [How to: Add Value to Smart Table](#) for assigning a **Maintenance Plan** to a **Step** on the [MaterialInProcessVerificationContext](#) Smart Table
- [Create Maintenance Plan](#)

This is the [Master Data](#) file used to create this model.

Execution

After all configurations are completed, the operation that sets everything in motion is the Track-In of a **Material** at a **Step** where in-process verification is enabled.

Once the **Material** is tracked in, navigating to the Material Maintenance View will display its Maintenance Plan Instances, as illustrated in the image below.

Shift Change

Material P1.3

Refresh Edit View Reports Transaction Undo Change Merge Split Hold Record Loss/Bonus Process Open Instance Exceptions Data Collection Printing Documents Change Begin Skip Update Schedule... More Views Page

Material P1.3 (Active)

2025 < JULY > DISPLAY: NAME TYPE: ALL Pending Terminated Search

Sun	Mon	Tue	Wed	Thu	Fri	Sat
29	30	1	2	3	4	5
6	7	8	9	10	11	12
13	14	15			18	19
20	21	22			25	26
27	28	29			1	2
3	4	5			8	9

Activities

- USAGE BASED (0)
 - No usage based activities
- AD-HOC (0)
 - No ad-hoc activities

09/07-Shift Change ... 09/07-Shift Break Verif...

Name: 09/07-Shift Change Verification.0004
 Activity: Shift Change Verification
 Schedule Type: TimeBased
 Schedule State: BeforeEarlyDue
 Execution State: Released
 Material: Material P1.3
 Maintenance Type: InProcessVerification

Owner Role: Process Verification
 Execution Role: Process Verification
 Schedule Date: 07/09/2025 06:15 PM
 Duration: 6m
 Start Date: 07/09/2025 06:00 PM
 End Date: 07/09/2025 06:15 PM
 Early Due: 07/09/2025 06:00 PM
 Late Due: 07/09/2025 06:30 PM

Shift Break

Material P1.3

Refresh Edit View Reports Transaction Undo Change Merge Split Hold Record Loss/Bonus Process Open Instance Exceptions Data Collection Printing Documents Change Begin Skip Update Schedule... More Views Page

Material P1.3 (Active)

2025 < JULY > DISPLAY: NAME TYPE: ALL Pending Terminated Search

Sun	Mon	Tue	Wed	Thu	Fri	Sat
29	30	1	2	3	4	5
6	7	8	9	10	11	12
13	14	15			18	19
20	21	22			25	26
27	28	29			1	2
3	4	5			8	9

Activities

- USAGE BASED (0)
 - No usage based activities
- AD-HOC (0)
 - No ad-hoc activities

09/07-Shift Change ... 09/07-Shift Break Verif...

Name: 09/07-Shift Break Verification.0004
 Activity: Shift Break Verification
 Schedule Type: TimeBased
 Schedule State: BeforeEarlyDue
 Execution State: Released
 Material: Material P1.3
 Maintenance Type: InProcessVerification

Owner Role: Process Verification
 Execution Role: Process Verification
 Schedule Date: 07/09/2025 08:00 PM
 Duration: 3m
 Start Date: 07/09/2025 08:00 PM
 End Date: 07/09/2025 08:15 PM
 Early Due: 07/09/2025 08:00 PM
 Late Due: 07/09/2025 08:15 PM

In the example, the **Material** was tracked in at 04:55 PM.

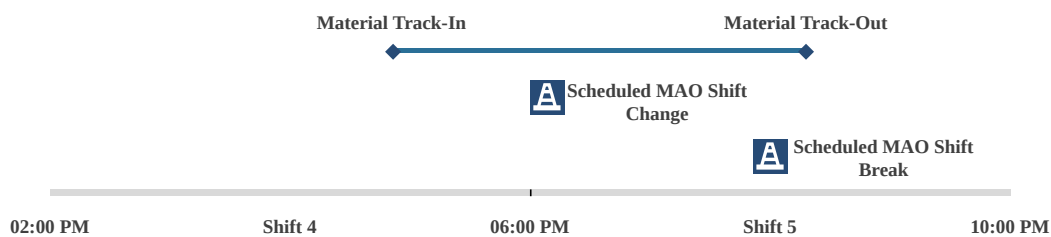
The next shift begins at 06:00 PM, so two Maintenance Activity Orders are created:

- One with a due date at 06:15 PM PM, for the Shift Change Verification
- Another with a due date at 08:00 PM, for the Shift Break Verification

If the due time arrives and the **Material** is still in process, the verification must be performed.

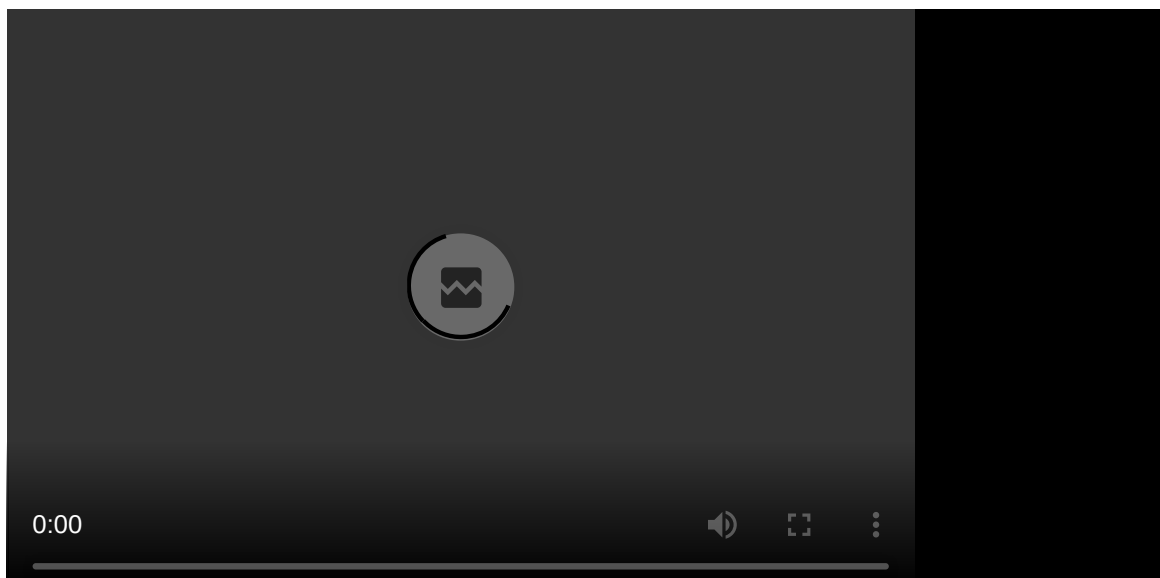
If a user attempts to Track-Out the **Material** without completing the required verification, the system will notify them about the pending In-Process Verification Maintenance Plan Instance.

Refer to the diagram below for a clear, visual timeline of these events.



The operations required to carry out these verifications follow the standard Maintenance Activity Order flow: Begin, Perform, and Complete.

The video below illustrates the execution of this scenario.



Useful Documentation

- For a more in-depth understanding of this module, please refer to the [\[\[tutorials-maintenancemanagement\]\]](#) tutorial.

Note

- The Material Traceability View includes a dedicated section to accommodate In-Process Verifications.
- The **Material** `In-Process Verification Maintenance Plan Instance` the reference to the associated instance.

Final Considerations

Keep in mind the following behaviors and consequences related to the In-Process Verification Maintenance Plan Instance:

- Terminate / Abort **Material** - Terminates the instance and clears the associated property
- Split / Expand **Material** - Resets the instance in the resulting child materials
- Merge **Material** - Merge is blocked if any of the Materials involved have an active instance
- Track-In **Material** - Creates a new Maintenance Plan Instance based on the resolved **Maintenance Plan** from the In-Process Verification context of the **Material**; sets the In Process Verification Maintenance Plan Instance accordingly
- Track-Out **Material** - Validates the Maintenance Activity Orders associated with the instance; if validation passes, terminates the instance and clears the property



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