



WIP Cycle Counting

It's not easy keeping track of Work In Process, which -- by its nature -- is always a moving target.

RF/BAR's "WIP Cycle Counting" module gives you the tools to help you keep your WIP accurate, every day, all year.

Whether you use **discrete work orders** or **advanced repetitive** for tracking WIP, **RF/BAR's** "WIP Cycle Counting" modules provide you with the means of:

- **Step 1. Generate cycle counts to be performed today and print the "WIP cycle count worksheet"**
- **Step 2. Enter the WIP cycle counts, by either reading bar-coded Item and Work Center labels**
- **Step 3. Report today's WIP accuracy metrics from the cycle count batch results and update the MFG/PRO WIP quantities to match the counts**
- **Step 4. Summarize the WIP accuracy metrics by Day, Month and Year.**

MFG/PRO Cycle Counting Parameters

MFG/PRO's "vanilla" Inventory Cycle Counting Parameters are used for defining **WIP Cycle Counting parameters**:

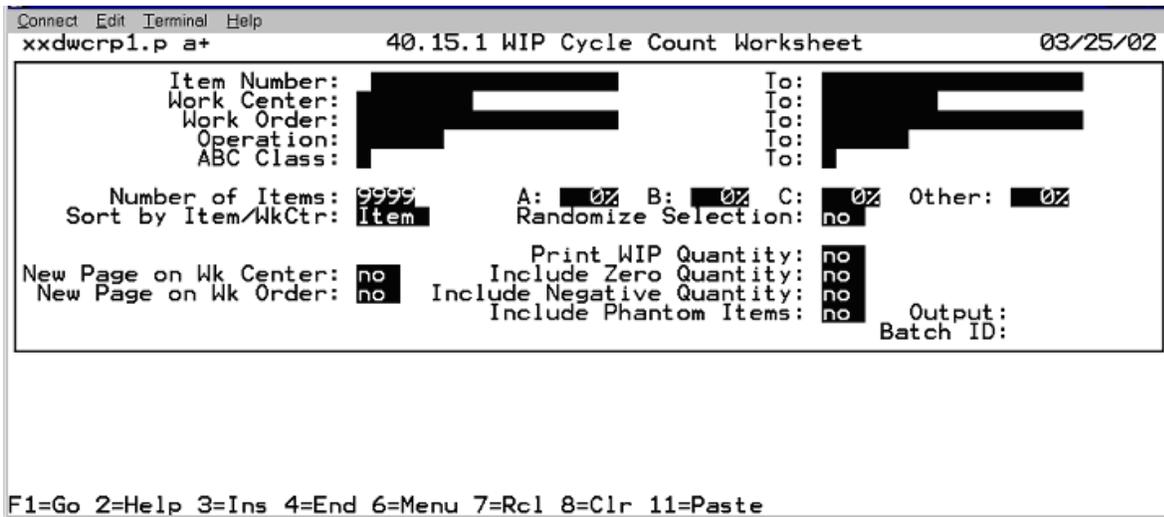
- **In order to begin the WIP cycle count process, you should make sure you have classified all WIP items by their "Inventory ABC Code". This can be done using "Item ABC Status Report Update" (Menu Entry 1.5.9).**
- **For those items that you feel need to have their Cycle Count Interval Days changed from the default value, maintain the "Cycle Count Interval" field in either "Item Inventory Data Maintenance" (1.4.5) or "Item-Site Inventory Data Maintenance" (1.4.16).**

Main Menu for WIP Cycle Counting

Main Menu for **Simplifying's** WIP Cycle Count MFG/PRO bolt-on module:

- | | |
|----|--------------------------------|
| 1. | WIP Cycle Count Worksheet |
| 2. | WIP Cycle Count Entry |
| 3. | WIP Cycle Count Results Report |
| 4. | WIP Cycle Count Summary Report |

1. WIP Cycle Count Worksheet



WIP Cycle Count Worksheet. This is a very complex program that calculates the WIP Items to cycle count today, given the selection criteria that you choose.

The "Selection Criteria":

- **Number of Items:** Enter the number of Work Order Operation WIP Quantities you want to count in this batch.
- **ABC-other:** Enter the percentage that you want the Work Order WIP Quantities counted for each associated ABC Class of each Item.
- **Sort by Item/WorkCenter:** Sort by Item to output the Worksheet by Item, Sort by WorkCenter to output the Worksheet by WorkCenter.
- **Randomize Selection:** Randomly choose the Work Orders to count, given all the other selection criteria you have chosen.
- **Print WIP Quantity:** "Yes" will cause the MFG/PRO WIP Quantity to print on the Worksheet report, making that information available to the cycle counters to use as they see fit. "No" hides the Work Order WIP Quantity.

Example report:

Item Lot/serial	WO ID Ref	WkCenter Operation	Description	ABC	Last CNT	Qty WIP	UM	Qty counted	counted By	Date counted
22-100 321-B	124446	Elec01 10	CORO, POWER, UK Electrical Assy 1	C	11/03/01		EA	()	()	()
22-100 321-B	124446	Elec02 15	CORO, POWER, UK Electrical Assesbly 2	C	11/02/01		EA	()	()	()
22-100 321-B	124446	Elec04 20	CORO, POWER, UK Electrical QA	C	11/02/01		EA	()	()	()
30-100 GPR-4501	166656	Elec01 10	BATTERIES, ALKALINE, STD. Electrical Assy 1	B	12/12/01		EA	()	()	()
30-1000 B-0100	444456	Elec01 10	BATTERIES, ATOMIC, STD. Electrical Assy 1	A	01/03/02		EA	()	()	()
30-1000 B-0100	444456	Elec04 20	BATTERIES, ATOMIC, STD. Electrical QA	A	01/02/02		EA	()	()	()

Item Number:	To:
Work Center:	To:
Work order:	To:
Operation:	To:
Last Count:	To:
ABC Class:	To:
Number of Items: 99999999	A: 0% B: 0% C: 0% other: 0%
Sort by Item or WkCtr: Item	Randomize Selection: no
Past due only: yes	Print WIP Quantity: no
New Page on WkCtr: no	Include Zero Quantity: no
New Page on WkOrder: no	Include Negative Quantity: no
Print bar code: no	Include Phantom Items: no

2. WIP Cycle Count Entry

Wireless Terminal WIP Cycle Count Entry Screen

```
Discrete WIP CycleCnt
WC: FINISH
WO: 01234567
OP: 100
UM: EA
Who: MFG
Date: 01/02/2011

WC: _____
PARENT:
-----

Count: _____
```

All of the requested count information is displayed, sequenced by Work Center & Work Order Number, and all you have to enter are:

- Work Center (**WC**)
- Parent Part (**PARENT**)

The resulting Work Order (**WO**) and Operation (**OP**) are displayed.

Finally, type the WIP Count Quantity (**Count**)

Easy!

WIP Cycle Count Entry Full-Screen (entered from written counts on WIP CC Worksheet document)

```
Connect Edit Terminal Help
xxdwcmt1.p SS          40.15.2 WIP Cycle Count Entry          03/25/02
Counted By: FJ      Cycle Count Type (I/R): Initial

Rec#  Item Number  Work Order  OPN#  Work Ctr  Count  UM  WHO  Date
Cnt
0000

F1=Go 2=Help 3=Ins 4=End 6=Menu 7=Rcl 8=C1r 11=Paste
```

CHUI WIP Cycle Count Entry. Perform the cycle counting called for in the WIP Cycle Count Worksheet report and record the results.

Enter

1. Item Number: Parent part number
2. Work Order: Work Order number (for discrete work orders only)
3. OPN#: WO Operation Number
4. Work Ctr: Work Center
5. Count: Quantity counted at Operation/Work Center
6. UM: Unit of measure of count
7. WHO: Who counted
8. Date Cnt: Effective date of count

If the **WIP Quantity variance** falls within the acceptable range, according to “Inventory Physical & Cycle Count Tolerances by ABC Code” in 3.24 Inventory Control File Maintenance, then the transaction will update the counted WIP Quantity in the Work Order Operation.

If the variance is **out of tolerance**, then you will receive a warning specifying that “Warning – Count is out of Tolerance, Quantity in WIP will not be changed”. Be sure to finish the transaction by GO’ing, even though it will not post, it needs to be completed so that the need for a Recount will be provided.

A **recount should be performed** for the out-of-tolerance counts and the results entered, using the “Recount” transaction type in x.2. If the count is still out of tolerance, you will still receive a warning message that will read, “Warning – Count is out of tolerance.” The system still gives the warning but will update the balance of the perpetual WIP Quantity. Remember that it is for the item in a particular Site and Work Order.

3. WIP Cycle Count Results Report

The screenshot shows a terminal window titled "40.15.3 WIP Cycle Count Results Report" with a date of "03/25/02". The window contains the following text:

```
Connect Edit Terminal Help
xxdwcrp4.p SS          40.15.3 WIP Cycle Count Results Report          03/25/02

Print Site Totals: yes      Print Item Totals: yes
Print wo Totals:  yes      Print Operation Totals: yes

Minimum Variance Amt/%Qty: 0.0000

Sort Option: 1 1 - By Item, WO, Operation
              2 2 - By Variance Amount
              3 3 - By Variance %Quantity
              4 4 - By Dept, Wk Ctr, Part

Counting Complete?:

Output:
Batch ID:
```

At the bottom of the terminal window, the following function key shortcuts are listed: F1=Go 2=Help 3=Ins 4=End 6=Menu 7=Rcl 8=Clr 11=Paste

WIP Cycle Count Results Report. Report the results of today’s WIP Cycle Counting.

- After running the report first in “**Counting Complete?: No**” mode to see if the Daily WIP Cycle Count results are complete.
- When it is looking as complete as is possible, then run the report in “**Counting Complete?: Yes**” mode to build the WIP cycle count Daily Summary record for the day, and delete the set of completed day’s cycle count detail records from the detail data table.

16.xx Adv Repetitive Cycle Count Results Report											Date: 01/05/02
Simplifying Software, Inc.											Time: 16:18:55
WO ID	WkCenter	Item Number	Description	UM	ABC	Begin WIP Bal	Qty Change	WIP Qty	Var	Annual Use	
Eff Date	Operaton	Lot/Serial	Ref			Qty Counted	Amount	Change	Anl	Use	Var
124446	Elec01	22-100	CORD,POWER,UK	EA	C	700.0		0.0		0.00%	
01/05/02	15					700.0		0.0		0.00%	0.0
W0124446	ElecQA	22-100	CORD,POWER,UK	EA	C	100.0		0.0		0.00%	
01/05/02	20					100.0		0.0		0.00%	0.0

16.xx Adv Repetitive Cycle Count Results Report											Date: 01/05/02
Simplifying Software, Inc.											Time: 16:18:55
WO ID	WkCenter	Item Number	Description	UM	ABC	Begin WIP Bal	Qty Change	WIP Qty	Var	Annual Use	
Eff Date	Operaton	Lot/Serial	Ref			Qty Counted	Amount	Change	Anl	Use	Var
444456	ElecQA	30-1000	BATTERIES, ATOMIC, STD.	EA	A	550.0		0.0		0.91%	
01/05/02	20	B-0100				555.0		0.0			0.0 ERR
								0.0			
								0.0			

Items Counted	In Tolerance	Qty	In Tolerance	Pct	Items Recounted
3	2		67%		0

--- End of Report ---

16.xx Adv Repetitive Cycle Count Results Report											Date: 01/05/02
Simplifying Software, Inc.											Time: 16:18:55
REPORT CRITERIA:						Report submitted by: jetfa					
Last Count: 01/05/02						To: 01/05/02					
Item Number:						To:					
Operation:						To:					
workCenter:						To:					
New Page on Operation: no											
Show Initial: yes											
Show Recounts: yes											
Show Errors: yes											

4. WIP Cycle Count Summary Report

xxdwcrp3.p SS	40.15.4 WIP Cycle Count Summary Report	03/25/02
Show Daily Counts?: <input type="checkbox"/>		
Begin Date: <input type="text"/>	Thru Date: <input type="text"/>	Output: <input type="text"/>
		Batch ID: <input type="text"/>
Display Daily Detail Counts? <input type="checkbox"/>		

Menu Entry .4 -- WIP Cycle Count Summary Report.

- On a periodic basis, run the **Monthly** and/or **Annual summaries** using .4 on the menu.
- This report will provide you with the information needed to make a **manual GL journal entry for the change in WIP value-added** caused by the WIP Cycle Counts performed for the accounting period.