

Create Routings

Overview

A routing lists manufacturing operations required to make the item and the approximate time each operation should take to complete. Each operation will be assigned to a “work center”. A work center is an area within a CSI shop where manufacturing occurs. A work center can be defined as a machine, group of machines, a shop area or even the entire shop. Most CSI shops have only one work center that will include the entire shop. However some shops may have more than one work center. For example, the LCC wood shop will have a work center for the CNC router, a work center for the edgebander, and a work center for all other traditional shop operations. A routing for a CNC product may similar to the following

- 10 Cut parts on CNC 2.00 hours
- 20 Edgeband parts 1.75 hours
- 30 LCC wood shop 3.00 hours

Routing can be created for each item and also each Branch/Plant. For example, the same bookcase could be built in the OCC woodshop and the LCC wood shop using different processes. At OCC the bookcase may have one operation that indicates that the bookcase would be built using the traditional machinery. At LCC the routing may instruct the bookcase to first be cut in the CNC work center and final building, sanding and assembly to be completed in the general LCC wood shop work center.

NIS Policies

The tasks in this documentation provide end users with the tools to enter data and collect data in NIS. It is the responsibility of the agencies to comply with State Statutes, Federal Rules and Regulations, and State policies. For further information concerning State Statutes and policies, please refer to both internal agency resources and the Department of Administrative Services website: <http://www.das.state.ne.us/>.

Navigation

NIS State of Nebraska > CSI > Product Data Management > Daily Processes > Enter/Change Routing

Steps

This exercise will begin with the **Work with Routing Operations** screen.

Work Center	Oper Seq#	Description	Run Labor	Run Machine	Setup Labor	Effective From	Effective Thru	Typ Rtg	Ty Cd	Queue Hours	Queue Hours
No records fetched.											

1. Type in **Branch/Plant** number
2. Type in **Item Number**
3. **Batch Quantity** is normally left blank. **Batch Quantity** can be used to specify a when it is more efficient or practical or efficient to manufacture a quantity of items. For example, making one pair of boxer shorts may require 1 yard of broadcloth and take 30 minutes each to produce due to low fabric yield and increased setup time whereas producing a **Batch Quantity** of 144 may only require a total of 72 yards of broadcloth (.5 yards each) and 36 hours (15 minutes each) to produce.
4. **Routing Type** will generally be **M** – Standard Manufacturing routing or **RWK** – Rework Routing
5. Click **Find**. If one or more routings already exist they will appear in the rows on the lower half of the screen. For these instructions we will assume no routing exists.
6. Click **Add**.

Work Center	Oper Seq#	Description	Run Labor	Run Machine	Setup Labor	Queue Prod	Queue Hours	Queue Hours	Line/Cell	Effective From	Effective Thru	Queue Size	Supplier	Cost Type	Type Oper
46070129			40.00									1.0			

7. On the **Enter/Change Routing - Enter Routing Information** screen verify that the **Branch/Plant**, **Item Number**, **Batch Quantity** and **Routing Type** all populate correctly from the previous screen.
8. Enter the **Work Center**.
 - ✏ Work Centers are named using a variation of the Branch/Plant number. The sixth digit is the Work Center number. For example work center 46070129 is work center 1 in Branch/Plant 46070029.
9. **Oper Seq#** and **Description** will be defaulted in. Leave these fields blank.
10. **Run Labor** is the number of labor hours for a work center that is based on labor hours.
11. **Run Machine** is the number of machine hours for a work center that is based on machine hours.

12. Many of the fields are for more advanced functionality than what will be used. Enter information in the indicated fields and leave the remaining fields blank.
13. **Queue Hours** is the total number of hours that an item will be waiting in queue at work centers or time moving between work centers.
14. **Move Hours** is the number of hours required to move the item from this operation to the next operation in the same work center.
15. **Effective From** and **Effective Thru** will be defaulted in. They do not need to be entered unless this routing will replace an existing one.
16. **Crew Size** will normally be 1.0. This value is multiplied by the Run Labor value to determine total labor cost.
17. **PC** enter L for standard hours from the router to be used for actual hours.
18. **Time Basis** enter U.
19. Click **OK**.
20. Click **Find** to display the record for the routing you just entered.
21. Click **Close**.