

Capacity Planning in Repetitive Manufacturing



HELP.PPCRPREM

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Capacity Planning in Repetitive Manufacturing

Purpose

Repetitive manufacturing uses capacity leveling to carry out capacity planning for production lines. You use the **planning table** in repetitive manufacturing to carry out capacity planning and capacity leveling.

The planning table is laid out in periods and gives you an overview of dates and quantities for materials and production lines.

The planning table allows the planner to dispatch production quantities. He can check the production quantities at a glance as well as the current capacity load for the production line and the availability situation for the products. Flexible strategies for automatic dispatching enable you to create a production plan that optimizes use of capacities. Since planning frequently relates to shifts, the planning table for repetitive manufacturing was enhanced for Release 4.0 by adding several functions in shift planning.

In repetitive manufacturing, you have two options for executing capacity leveling:

- With the planning table
- With parallel processing using the planning table and the capacity planning table that you call up from the planning table

Changes that are made in the capacity planning table are immediately visible in the planning table and vice versa.

Integration

Scheduling levels

There are three scheduling levels in capacity planning: Detailed planning, rate-based planning and rough-cut planning. For capacity planning in repetitive manufacturing, it is rate-based planning and detailed planning that are most important. In the planning table for repetitive manufacturing, only capacity requirements can be displayed that are based on rate-based scheduling or detailed scheduling.

To display capacity requirements for scheduling lines or planned orders in the planning table, the following conditions must be fulfilled:

1. To carry out capacity planning at rate-based level, you must specify a routing in the production version under rate-based planning. This generally involves a rate routing. However, you can also select any other type of routing. To carry out capacity planning at a detailed level, you must specify a routing in the *production version* under detailed planning.
2. In the production version, you must specify a work center for the operation in the above routing as a production line. The work center is generally a "production line". However, you can also specify another work center.
If you are working with the application component **Line design**, then you must have created a [Line Hierarchy \[Ext.\]](#) for the production line and have designed a work center in the line hierarchy as the [Scheduling Work Center \[Ext.\]](#). You enter the line hierarchy in the field *Production line* and the scheduling work center in the field *Scheduling work center* in the *production version*.

Capacity Planning in Repetitive Manufacturing

3. In Customizing for capacity planning under *Operations -> Scheduling -> Scheduling parameters for planned orders*, you must define for production lines (planned orders with the order type PE) whether capacity planning is to be executed as rate-based planning or detailed planning. You must also select the following fields:

Generate capacity requirements

Date determination

4. If you want to execute capacity planning on the planning table for planned orders with the order type LA and for production orders, create entries for the corresponding scheduling levels and select the above fields.
5. You specify which planning level is to be used on the initial screen for the planning table. You can save this setting for specific users.

Layout of capacity data on the planning table

How capacity data is presented on the planning table and the strategy that is used in the capacity planning table for dispatching operations is controlled using capacity profiles. You can find these in Customizing for capacity planning under capacity leveling. There you can maintain the so-called overall profiles that are in turn made up of individual profiles. Generally there is one profile for the planning table (SAPREMG001) and one profile for parallel processing on both planning tables.

If you want to define your own profiles, you have the option of specifying a profile with the parameter-ID KP1 in the user master. This profile is then used instead of the standard profile for the planning table. If you save a profile using the parameter ID KP2, this profile is used for parallel processing.

When creating your own profile for parallel processing, you should note that for the assigned control profile, both a periodic and a continuous layout are possible. You define this layout by setting the indicator layout type 3 in the control profile.

You can find out what data is behind the profiles in Customizing for capacity planning. You should only make changes to profiles for specific purposes. The following are examples of possible changes:

- Changing the time period for capacity planning
- Changing the dispatching strategy for the capacity planning table
- Changing the display and dimension of graphical elements

Accessing the Planning Table

Use

The system displays several production lines and materials according to the selection criteria you entered on the initial screen of the planning table. If you want to narrow down this selection further before you access the planning table, you can branch into the *Material - Collective Display* or the *Line Selection Screen* first.

Prerequisites

In Customizing for the planning table, under *Maintain Entry Parameters*, you can define certain settings for the initial screen. These include, for example:

- The period of examination that is calculated from the current date - if you have entered the selection period.
- Whether the planning table is to be selected for a particular material, product group, class, MRP controller, production line or production line group.
- Which scheduling strategy is to be used.

Features

You access the planning table per plant for a certain period of time that is automatically proposed if you have made the appropriate settings in Customizing. You can also specify the time bucket, for example, shift, day, week or month or planning calendar.

The initial screen is split into several selection areas and tap pages:

Select by lines

You can select by production line or by a work center hierarchy or by a node in the work center hierarchy (this is a certain work center in a work center hierarchy).

You can limit the selection further using a planning ID or an MRP controller.

Select by materials

You can select by material, product group, class, class type or MRP controller.

You can limit the selection by MRP controller further by specifying an MRP type, an ABC indicator or a plant-specific material status.

Selection control

- Detailed material selection
If you select this field, the system first branches to the *Collective Display of the Planning Table* before accessing the planning table itself. In this collective display, the system lists all materials that correspond to your line or material selections on the initial screen, so that you can edit them further.
- Detailed line selection
If you select this field, the system first displays all production lines in a dialog box that correspond to your selections on the initial screen before accessing the planning table. Select the production lines that you want displayed in the planning table.

Accessing the Planning Table

- Further restrictions for material selection
If you select the field *Only mats with production*, the system only displays materials with production quantities in the planning table.
- If you select the field, *Only mats with reqmts*, the system only displays materials with requirements in the planning table.
- Comparison scenario
To display comparison data from long-term planning, enter the number of a planning scenario. In the planning table, the system then displays the data from long-term planning in a separate line per material which you can use for comparison.



If you want the field *Comparison scenario* to be shown in the initial screen, you must select the field *Long-term planning* in the IMG activity *Row selection* in Customizing for the *Planning Table*.

Capacity planning/scheduling

If you select the field *Capacity planning*, the system displays the capacity data of the selected lines in the planning table. The capacity requirements and the production dates are calculated using either detailed planning or rate-based planning depending on your settings.



When you are deciding to access the planning table with detailed or rate-based planning, you must make sure that the scheduling level you choose corresponds to the scheduling levels defined for the planned orders or run schedule quantities in Customizing. The scheduling and capacity parameters for planned orders are defined in Customizing for MRP.

- Production / basic dates
Here you determine whether, in the planning table, the planned orders and the run schedule quantities are sorted in the individual buckets on the basis of the order finish date or the production finish date.
- Scheduling strategy
Here you determine how scheduling is to be carried out in the planning table, for example, backward or forward scheduling.

MRP segments

You can select the MRP segments from the MRP list that are relevant for the planning table. Only the MRP results for these segments are copied to the planning table.

For example, if you select net requirements planning and make-to-order, the requirements and results of the net segment and of make-to-order planning are transferred to the planning table where they can both be processed.

Activities

When selecting the planning objects, the system proceeds as follows:

If you select production lines on the initial screen, the system searches for all materials that are produced on these lines.

Accessing the Planning Table

If you select materials on the initial screen, the system searches for all lines on which these materials can be produced.

For more information, please refer to [Accessing the Planning Table by Lines \[Ext.\]](#) and [Accessing the Planning Table by MRP Controller \[Ext.\]](#).

Scheduling in the Planning Table

Scheduling in the Planning Table

Use

If you use the planning table in conjunction with capacity planning, the system carries out a lead time scheduling for the planned orders.

In scheduling, the system calculates the production start and finish dates of the orders. The finish date determines the period to which the production quantities are assigned in the planning table. The system also calculates the dates of the planning operation (that is, the operation with the work center used for scheduling - usually the production line) which are displayed separately. If you access the planning table and capacity planning is active, the system carries out scheduling automatically.

Prerequisites

- In Customizing for Repetitive Manufacturing, under *Maintain Entry Parameters*, you must define whether production or basic dates are to be relevant for the display in the planning table and which scheduling strategy is to be used to calculate these dates. However, these settings can also be changed and saved per user in the initial screen of the planning table as well as in the planning table.
- You must enter the line to be used for production in the production version. This production line must also be used in an operation in the routing. The system then uses the operation with the production line for scheduling.

If you want to use a lower-level element of a production line (for example, a certain processing station) for planning instead of the complete production line, you must [create a line hierarchy for the production line \[Ext.\]](#).

In this line hierarchy, you must define one work center as a [planning segment \[Ext.\]](#). If you do not define a planning segment, the system automatically uses the header of the line hierarchy as the planning segment. The work center defined as the planning segment must also be used in the routing. The operation with the planning segment is then used for scheduling.



If you want the system to carry out scheduling in the planning table, you must select either rate-based planning or detailed planning on the initial screen of the planning table, depending on the settings made for the order type in Customizing.

Features

Determining production dates / basic dates

In the planning table, you can instruct the system to calculate and display either the production dates or the basic dates.

- Basic dates
To calculate the basic dates, the system uses the factory calendar.
The order finish date is the day on which the produced materials are available - however this date does not take the *goods receipt processing time* into account.
- Production dates
To calculate the production dates, the system uses the factory calendar or the number of

Scheduling in the Planning Table

workdays defined at the work center and the shift program for the calculation .
Here, the production finish date is the date on which the production of the material is finished. The material is not necessarily available on this date as it may be necessary to add a float after production to this date.

The production dates are calculated to the minute. If you have defined available capacity for a shift, the times of the capacity category relevant to scheduling are taken into account when splitting the period of examination into periods. That is, the system takes the beginning of the first shift and the end of the last shift into account.



If a planned order finishes at 02.00 am on day X, but this time falls in the third shift of the previous day then the order is assigned to the previous day.



If you access the planning table with production dates, you can convert to basic dates by selecting *View* → *Reference dates* → *Basic dates*.

Scheduling strategy

The following scheduling strategies are available:

- Forward scheduling

In forward scheduling, the system uses the beginning of the period in which the production quantities were entered as the start date. From this start date, the system calculates in a forward direction to determine the finish date. The system displays the order quantities on the production start date.

- Backward scheduling

In backward scheduling, the system uses the end of the period in which the production quantities were entered as the finish date. From this finish date, the system calculates in a backward direction to determine the start date.

- Backward / forward scheduling

In backward / forward scheduling, the system works in two steps:

In the first step, the system uses the end of the period in which the production quantities were entered as the finish date. From this finish date, the system calculates in a backward direction to determine the start date.

In the second step, the system uses the beginning of the period calculated in step one and then schedules forwards.

Order processing commences at the beginning of the start period calculated by the system and ends in the period specified by the planner.

Changing the planning segment

In the planning table, you can access the line hierarchy where you can change the planning segment.

Activities

To determine the production dates, the system proceeds as follows:

Scheduling in the Planning Table

1. The system uses the [Production Line \[Ext.\]](#) as the basis for scheduling (if no line hierarchy has been created for the production line) or the planning segment (if a line hierarchy has been created for the production line and you defined a planning segment).
2. The system searches the routing for the operation with the production line or with the planning segment.
3. The system calculates the capacity requirements using the standard values maintained in the operation and calculates the production start and finish dates according to the scheduling strategy you selected without taking the already existing capacity load into account.

Capacity Planning in the Planning Table

Use

For each production line and per period, the system displays the available capacity, capacity requirements and the capacity load as a percentage. The capacity data is recalculated after making any changes. Therefore, the planner has an overview of the capacity situation of the production lines and can react quickly to overloads.

Prerequisites

- In the standard version of Customizing for MRP and for Repetitive Manufacturing, the *Scheduling parameters* for planned orders with order type LA are set to either detailed or rate-based scheduling and to rate-based scheduling for run schedule quantities (planned orders with order type PE). Production orders are set to detailed scheduling. You have the option of changing these settings. However, the scheduling levels should be kept as consistent as possible.

For more information, please refer to the Implementation Guide (IMG) for Repetitive Manufacturing, under *Capacity Planning*.

- You must enter the line to be used for production in the production version. This production line must also be used in an operation in the routing. The system then uses the operation with the production line for scheduling.

If your production lines are subdivided into individual lower-level elements, such as processing stations, you must create a line hierarchy for the production line and define a work center as the planning segment in the line hierarchy. If you have not defined otherwise, the system automatically uses the header of the line hierarchy as the planning segment. The planning segment must also be used in the routing. The operation with the planning segment is then used for scheduling.

- In the initial screen of the planning table, you must select the *Capacity planning* indicator.
- In the initial screen of the planning table, you must select *detailed* or *rate-based planning* depending on the settings for the order type in Customizing.

Features

The system displays the capacity data for the selected lines in the upper section of the planning table. In the standard settings, if more than two lines were selected, the system initially displays only the capacity load as a percentage for one production line.

You then have the following options:

- You can display the available capacity, the capacity requirements and load for every capacity category (for example, labor) of a production line.
- You can switch between the capacity categories of a production line. However, this is only possible if you have not set the indicator *Only cap*.
- *cat.r.f.sched*.
- You can set the planning table to display the capacity requirements that have already been dispatched in the capacity planning table only.

Capacity Planning in the Planning Table

- You can branch to the capacity planning table where you can continue planning. The changes you make in the capacity planning table are immediately transferred to the REM planning table.
- If you have created a line hierarchy for the production line, you can [define capacity segments \[Page 18\]](#) in the line hierarchy. The line segments of the production line defined as the capacity segments are displayed with the capacity data in the planning table. You can display the capacity load, capacity requirements and available capacity for these selected work centers of the line hierarchy. You can also change the capacity segments from the planning table by branching to the line hierarchy. After making any changes, the system displays the newly defined capacity segments in the planning table. However, you can only select one of the capacity segments of the line hierarchy that lies in a lower level to the ones already defined as capacity segments. That is, you usually want to hide capacity segments that obscure the clarity of the planning table. This has no influence on the capacity planning table.
- If, in Customizing for Repetitive Manufacturing, in the IMG activity *Maintain row selection*, you have set the indicator *Min /max pers.*, the system displays two extra rows in the capacity data section of the screen.

Minimum number of personnel per period.

Maximum number of personnel per period.

For more information, see: [Capacity Planning Using Personnel in the Planning Table \[Page 19\]](#).

Displaying Capacity Data for the Production Line in the Planning Table

1. To access the initial screen of the planning table, start from the main menu of Repetitive Manufacturing and choose *Planning* → *Planning table* → *Change mode*.
2. Enter the following data:
 - Plant
 - Period of examination
 - Bucket, such as shift or day
3. Select the *Production line* and enter the number of the production line.

If you want to limit the selection further, choose *Detailed view (Constraints)*.
4. In the *Scheduling* tab page, select *Capacity planning*.
5. Select *Detailed or Rate-based planning* (depending on your settings for the order types of the planning orders in Customizing).
6. Define that the system is to calculate and display *Production dates* by setting the appropriate indicator. Define also which scheduling strategy is to be used.
7. Choose the *MRP segments* tab page and select the planning segments from which data is to be copied to the planning table.
8. Choose *Enter*.

The system displays a message stating that you can narrow down your selection further. You can change the parameters again.
9. By choosing *Planning table*, the system determines the planning data.

You branch to the planning table. In the upper section of the screen, you can see the capacity data for the selected production line for the capacity category set in Customizing (the capacity category, machine, is usually set).

 - Capacity load
 - Capacity requirements
 - Available capacity

In the lower section of the screen, you can see all the materials that are produced on the selected production line (perhaps with production quantities that have already been planned).
10. If you want to see all the capacity categories, such as labor, for a production line choose *Capacity planning* → *Capacity categories* → *All cap. categories* → *For one line*.
11. If you enter a production quantity for your production line, the system carries out capacity planning depending on the scheduling strategy you have selected.

For more information, see:

[Example of Capacity Planning in the Planning Table \[Ext.\]](#)

Displaying Capacity Data for the Production Line in the Planning Table

Example of Capacity Planning in the Planning Table

Assumptions:

- Your production quantity per day on the selected line 1 is 500 pieces.
- The order you want to produce is 750 pieces, that means you need 1,5 days to manufacture the whole production quantity.
- They have chosen “day” as the period and “backward scheduling” for the scheduling type.

Procedure:

1. In the planning table enter 750 pieces for line 1 in the desired period, for example on 7.30.
2. The system calculates the end of the last shift for 7.30 and schedules backwards to determine the start date.

Result:

The system generates a load of 100% for 7.30 and of 50% for the start day 7.30. The capacity load for the two days is shown as 100%/50% if no other production quantities exist. However, the production quantity of 750 pieces remains in the line for 07.30 if you selected the view *Quantity display distributed or Orders/distributed* in the menu. The production quantity is displayed as distributed if you chose either *quantity display orders* or *orders/distributed*.

If several orders already exist then the capacity requirements and capacity load are increased automatically when you increase the production quantities, for example by adding new orders. Capacity overloads are then highlighted.

Defining Capacity Segments

Defining Capacity Segments

Use

You can use this function if you work with lead time scheduling and capacity planning in conjunction with the planning table. You can define line segments as capacity segments, whose capacity data you want to display in the planning table. In the planning table, capacity data is displayed in a separate row for each capacity segment.



If you use the planning table in conjunction with the capacity planning table, you should define a maximum of one capacity segment, since the capacity planning table can otherwise give incorrect results.

Integration

You firstly define the capacity segments in the line hierarchy in *Line Design*. From the *planning table*, you can choose to hide or display capacity segments, as required.

Features

- You can access the capacity view in the line hierarchy to display all defined visualization segments in color.
- If you do not define a capacity segment, the system uses the line hierarchy header as a capacity segment.
- Each line segment, to which you have already assigned operations from the routing can be defined as a capacity segment. The capacity segments need not cover the whole production line.

Actions

1. Starting from the line hierarchy graphic, select the menu path *View* → *Capacity view*.
2. Select a line segment and choose  *Capacity segment*.

The system displays the defined capacity segment in color.

Capacity Planning Using Personnel in the Planning Table

Use

In the section of the screen entitled *Capacity data*, you can also display rows showing the *minimum* and *maximum number of employees* required per period.

The system then displays the number of employees you assigned in the routing or in the master recipe.

Prerequisites

- In Customizing for Repetitive Manufacturing in the IMG activity *Maintain row selection*, you must set the indicator for the display of the maximum / minimum number of personnel.
- You must define the number of personnel required for an operation in the operation or sub-operation of the routing or in the phase or secondary resource of the master recipe.

Features

This function is clarified in the following **example**:

A production line works two shifts per day – from 6.00 a.m. to 2.00 p.m. and from 2.00 p.m. to 10.00 p.m. Two employees work in each shift. Three orders with the following data are to be produced:

Operation 1:

Duration 12 hours, requirement in number of personnel = 1, requirement in personnel hours = 12

Operation 2:

Duration 4 hours, requirement in number of personnel = ½, requirement in personnel hours = 2

Operation 3:

Duration 4 hours, requirement in number of personnel = 1, requirement in personnel hours = 4

Planning table display

All displays refer to one period. The period may be *month*, *day* or *shift*. You may choose an alternative to the time unit “hours”.

Display:

Shift	1	2
Available capacity in hours	16	16
Capacity requirements in hours	14	4
Load in % referring to available capacity and requirements in hours	87,5	25
Minimum capacity requirements in number of employees	1	0
Maximum capacity requirements in number of employees	2,5	1

In this display, you can see that the total requirements in shift 1 can be covered, however, at certain times, there is not enough personnel available.

Dispatching Planned Orders in the Planning Table

Use

Using this function, you can dispatch planned orders in the planning table taking available capacity into account. You select the planned orders to be dispatched using the row and column selection functions. This means the system checks the current load of the production line and then dispatches the planned order(s). If it determines that no capacity is available on the required date, it uses the settings in the [strategy profile \[Ext.\]](#) to search for a suitable date in the future where it then dispatches the planned orders.

Integration

Dispatching the planned orders in the planning table is a capacity planning function.

The system uses the control profiles required (the overall profile and the strategy profile) from capacity planning. In the standard system, the strategy profile SAPREMT001 is used for the planning table. However, you can create your own strategy profile in Customizing for Capacity Planning and assign it to the overall profile. The overall profile usually used for the planning table is SAPREMG002.

Prerequisites

In the initial screen of the planning table, you must select capacity planning and either detailed planning or rate-based planning.

Features

Dispatching planned orders

- The system dispatches the planned orders you select according to the settings in the strategy profile and depending on available capacity.
- Dispatched planned orders have the indicator *Cap. disp.* (in the details screen of the planned order) or *Cap. dispatched* (in the header data of the planned orders).
- Planned orders dispatched in the planning table are displayed as *dispatched* in the capacity planning table.

Changing the strategy

You can change the settings of the strategy profile directly in the planning table if, for example, you want to change the planning direction when dispatching.

Displaying the capacity requirements of dispatched planned orders only

You can choose whether you want the system to display the capacity requirements of all planned orders or whether you only want to display the capacity requirements of the already dispatched planned orders.

Activities

To dispatch planned orders, select the ones you want to dispatch in the planning table using the row and column selection functions and choose *Capacity planning → Dispatching → Dispatch*.

If you want to change the strategy, choose *Capacity planning → Dispatching → Change strategy*.

Dispatching Planned Orders in the Planning Table

If you only want to display the capacity requirements of the already dispatched planned orders in the capacity data section of the screen, choose *Capacity planning* → *Dispatching* → *Display capa. reqmts - dispatched*.

Integration of the Capacity Planning Table

Use

You can access the capacity planning table from the planning table. The capacity planning table is used for dispatching or rescheduling planned orders or run schedule quantities. Using the capacity planning table has the advantage that dispatching planned orders is linked to checking for available capacity.

Integration

The capacity planning table is part of capacity planning.

Prerequisites

In Customizing for capacity planning under capacity leveling, you must have defined an overall profile SAPREMG002. This profile is used in the standard system for structuring the capacity planning table. You can define your own user-specific profile using the user parameter KP2. The profiles that are used for the capacity planning table must contain a profile for the capacity planning table as well as a strategy profile.

In addition, you must have set the indicator for rescheduling in the strategy profile if you want to use the function for rescheduling taking into account the production version.

The overall profile is drastically overwritten by the capacity planning table in certain places. You cannot select the grouping of charts, for example, as the capacity planning table has already been modified to accommodate interaction with the planning table.

Features

The production quantities entered in the planning table appear in the capacity planning table in the pool in the form of a bar and can be dispatched.

If a production line is overloaded, then the production quantity is automatically assigned to another production line taking the existing production version into account and the system uses it for rescheduling. The production quantity is not dispatched to the new production line but instead remains in the pool.

Planned orders that have already been dispatched can be moved from one production line to another using the drag and drop function. This rescheduling causes the system to search for the version which corresponds to the new production line and to assign it to the changed planned order. When you return to the planning table, you find the production quantity under the reassigned version.

Changes that are made in the capacity planning table are immediately visible in the planning table and vice versa. You can change from one table to another and continue planning at any time.



The planning table and the capacity planning table should always be displayed in parallel.

You can more information on “dispatching” and “rescheduling taking into account the planning version” under:

[Using Operation and Order Floats for Dispatching \[Ext.\]](#)

Integration of the Capacity Planning Table

[Planning in Period Splits \[Ext.\]](#)

Switching between the Capacity Planning Table and the Planning Table

Procedure

1. To branch to the capacity planning table from the planning table, choose *Capacity planning* → *Generate capacity planning table*.

The system generates the capacity planning table.

2. To be able to work in the capacity planning table press the button `Cap.plan.tab.active` in the planning table.

You branch to the capacity planning table. The orders to be dispatched are in the lower half of the screen in the pool.

If you want to finish working in the capacity planning table proceed as follows:

1. Press the button `Planning table` in the capacity planning table.

You return to the planning table.

2. To leave the capacity planning table choose the following menu options starting from the planning table menu *Capacity planning* → *Leave capacity planning table*.

Carrying out Capacity Leveling (REM)

Carrying out Capacity Leveling (REM)

Use

Capacity leveling can be used to level out over- and underloads on production lines.

In repetitive manufacturing the capacity requirements are generated by production quantities for materials in particular periods. Whenever the quantity is changed the capacity requirements and the capacity load is recalculated for the production line affected.

Actions

You have the following options for carrying out capacity leveling:

- Check the capacity loads of the selected production lines. If there is an overload you can reduce quantities in the planning table by overwriting them or reassign them to production lines with remaining available capacity.
- You can work with the planning table and the capacity planning table in parallel to dispatch and reschedule orders. The capacity planning table has the advantage that dispatching of planned orders is linked to a check for available capacity.

You can find more details in:

[Capacity reduction with reporting point backflushing \[Page 27\]](#)

[Capacity reduction in repetitive manufacturing with production orders \[Page 28\]](#)

Cap. Reduction with Reporting Point Backflushing

Use

Since in the case of long execution times and several confirmation points a single control point at the end of the production process is not sufficient, repetitive manufacturing provides the function “reporting point backflushing” (analogous to milestone confirmations).

The function involves backflushing of all materials that were withdrawn and used between two reporting points. The material requirements are reduced in real-time and the components are withdrawn in real-time.

The confirmation at reporting points has no effect on the reduction of capacity requirements. These are only reduced with the final confirmation.

You can find more information on confirmations in repetitive manufacturing in the SAP documentation on repetitive manufacturing.

Capacity Reduction in Repetitive Manufacturing with Production Orders

In repetitive manufacturing with production orders, when planned quantities are released for production, the planned orders are converted to production orders in the background and the latter are released. The capacity requirements generated by the planned order are automatically transferred to the production order and so are not lost. The capacity requirements are reduced when the order is complete and confirmed.