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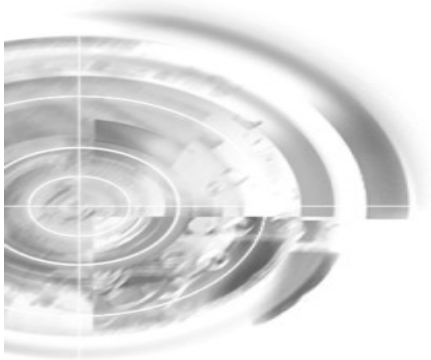

a Teamco Company

Mitrol MFG – Work Centre Control

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Work Center Control Subsystem

Introduction

The Work Center Control subsystem establishes the basic shop floor resources in MFG II — that is, the work centers, their capacities, and the work stations that make up those work centers. The resources defined by the Work Center Control subsystem provide a base for:

- Establishing routings to be used in the production of a part in the plant's work centers (using the Routing Control subsystem).
- Controlling the flow of work through each work center (using the Production Activity Control subsystem).
- Creating a capacity plan detailing the load on each work center (using the Capacity Planning subsystem).

What resources are defined?

The Work Center Control subsystem helps you define your shop floor resources, by:

- Defining work centers
- Defining the work stations that make up the work centers and assigning the work stations to their work centers
- Establishing the working hours and available capacity for each work center, including determining the method that will be used for capacity calculation

Work Center Control subsystem transactions

To define resources, use the following Work Center Control subsystem transactions:

To...	Use...
Define work centers	ADDWC
Define work stations	ADDWS
Assign work stations to the appropriate work centers	ADDWCWS
Establish working hours for each work center, after you determine the method of capacity calculation for each work center	CHCLOCK
Establish capacity data for each work center (if needed)	CHGCAP

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Defining and Maintaining Work Centers

Work center types

MFG II supports two types of work centers

- Standard work centers can be a department, a machine, or a group of machines within a department
- Subcontracting work centers identify a vendor who performs outside processing

Work center IDs

Both types of work centers are identified by a work center ID. For subcontracting work stations, you assign a vendor ID as the work center ID.

Defining work centers

You define work centers according to what type of work is performed within them.

Example: A work center may be a punch press machine. It could happen that a punch press machinist and a drill press machinist may report to the same foreman. However, since the two machines perform separate functions, they are considered to be two different work centers.

Work centers are defined according to the type of work performed within them, and not by organizational structure or personnel assignments. (However, the work center definition transactions provide a field named DEPARTMENT that can be used to indicate organizational structures or personnel assignments.)

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Adding a work center

The ADDWC (Add a Work Center) transaction used to add a work center to the system is shown below.

```
AddWc          Add a work center

      WORK CENTER: wc002        SUB-CONTRACTOR:   F

       DESCRIPTION: MACHINING 1         ACTIVE: T
     INSTALLED ON:                 RESOURCE   ID: MACH 1
       DEPATEMENT: 56           PLANNED   QUEUE: 2
          PLANNER: 12345
```

```
AddWc       Add a work center

            WORK CENTER: wc002          SUB-CONTRACTOR: F
                                             QUEUE HRS: 16
                                              MOVE HRS: 0

              SETUP LG: 2
                   RUN: LG: 1
             REWORK LG: 1
               # MACH.:  5
        NO. OF PEOPLE: 2
   STD FIX OH RATE/HR: 60              STD VAR OH%: 20
       CUR FIX RATE/HR: 60             CUR VAR OH%: 20

                                                    INPUT
```

1

2

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Work center descriptive and control data

When you add a work center, you add the following descriptive data:

In the field...	Supply...
WORKCENTER	The workcenter's unique identifier. **Note**: For subcontracting or outside processing work centers, use a valid vendor ID.
SUB-CONTRACTOR	An indication of whether or not the work center is an outside vendor. F = Internal work center T = Subcontract work center **Note**: Only screen 1 of the ADDWC transaction is displayed for subcontract work center.
DESCRIPTION	A description of the work center.
ACTIVE	A code indicating whether or not the work center is active. An inactive work center is not considered for capacity planning by the Capacity Planning subsystem.
INSTALLED ON	Date the work center was added to the system.
RESOURCEID	The identifier of the rough-cut resource into which this work center should be summarized. The rough-cut resource can be the work center or a different work center if you are summarizing several work centers under one for rough-cut capacity planning by the Master Scheduling subsystem.
DEPARTMENT	The identifier of the department that the work center belongs to.
PLANNED QUEUE	The average number of hours of backlog planned for the work center.
PLANNER	The employee ID of the person responsible for the work center.
QUEUEHRS	The average number of hours a work order will wait at the work center (used for work order scheduling).
WC MOVE HRS	The average number of hours needed to move material from this work center to another (used for work order scheduling).
#MACH	The number of machines in the work center.
NO. OF PEOPLE	The number of people in the work center.

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Work center costing data

When you add a work center, you add the following data used for product costing:

In the field...	Supply...
SETUP LG	The labor grade normally assigned to perform setup at the work center.
RUN LG	The labor grade normally assigned to perform run operations at the work center.
REWORK LG	The labor grade normally assigned to perform rework operations at the work center.
STD FIX OH RATE/HR	The standard fixed overhead value for the work center. Entered as a fixed amount per hour of work.
STD VAR OH%	The standard overhead rate variable, for the expressed as a percent of labor value.
CUR FIX OH RATE/HR	The current fixed overhead value work center. Entered as a fixed amount per hour of work.
CUR VAR OH%	The current overhead rate variable, expressed as a percent of labor value.

Maintaining work centers

Once the work center is established within the system, you can:

Use the transaction...	To...
QWC	View the work center information on your terminal.
LWC	Produce a hardcopy report on which the work center and its associated information appears.
CHGWC	Change work center information.
DELWC	Delete work center information.
CHGWACC	Update accounting information, including: • The general ledger account to which run labor should be charged • The work center's cost center. The complete General Ledger Account number is each of the ledger's account numbers (e.g., labor, overhead, setup) concatenated with the cost center number. • The general ledger account to which overhead should be charged • The general ledger account to which setup should be charged.

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Updating all work center operations

When you run the CHGWC transaction to change the work center queue and/or move hours for a work center already used in operations, you can use the SETHRS transaction to update all existing operations for the work center. (See the Routing Control Subsystem User Guide for more details.)

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Defining and Maintaining Work Stations

Introduction

This section describes how to define and maintain work stations in your work centers. If your work centers do not have work stations, you can skip this section and proceed directly to the section titled "Determining the Method of Capacity Calculation."

What are work stations?

A work station adds an additional level of detail to a work center. A work station can be a machine or an individual at a work bench performing a specific operation. It can also be a group of machines or individuals performing one specific operation.

Example: A packaging assembly line where the labor grades are all similar could be treated as a single operation, and therefore, a single work station.

Defining a workbench as a work station

In a labor-based work center, the work benches (not the machines used at the benches) should be defined as the work station. All work stations within a work center have comparable equipment and labor grades, have generally equivalent capacities, and perform the same type of work. By defining work stations, you can detail all the equipment making up a work center.

How the system views work stations

Regardless of the way the work stations are defined, the capacities of all work stations within a work center must be approximately equal because the system views and schedules them as one work center. This scheduling approach eliminates the need to differentiate between labor-based and machine-based workcenters, other than for product costing purposes.

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Adding a work station

Use the ADDWS transaction to define and enter the workstation's ID and descriptive information. When you run the transaction:

In the field...	Supply...
DESCRIPTION	The work station's description.
INSTALLED	The date the work station was established.
CLASS	A code that provides a user-defined classification for the work station. You can use this code to provide further details about the work station. **Example**: You can use CLASS to identify differences in labor grades among work stations. The information you enter in this field is not used for any system calculations; it is for documentation purposes only.

Sample ADDWS transaction

```
AddWc                    Add a work station

 01  WORK  STATION  DESCRIPTION         INSTALLED  CLASS
 => 1001        final assembly station #1          a
 => 1002          final assembly station#2         a
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
                                                  INPUT
```

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Maintaining work stations

Once the work station is established within the system, you can:

Use the transaction...	To...
QWS	View the work station information on your terminal.
LWS	Produce a hard-copy report on which the work station and its associated information appears.
CHGWS	Change work station information.
DELWS	Delete the work station from the system.

Assigning work stations to work centers

Once you have established work centers and work stations, you can then link, or assign, work stations to appropriate work centers.

Use the ADDWCWS (Assign a WS to a WC) transaction to assign a specific work station to a specific work center.

Sample ADDWCWS transaction

```
 AddWcws     Assign a work station to a work center

 01 WORK CENTER  WORK STATION
=> wc01                  1001
=> wc02                   1002
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>
=>

                                                        INPUT
```

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Detaching and reassigning work stations

If you want to detach a work station from its current work center and reassign it to a different work center, use the CHGWCWS (Reassign a WS to Another WC) transaction. If you want to detach the work station from the work center but not reassign it to a different work center, use the DELWCWS (Detach a WS from a WC) transaction.

A work station can be assigned to only one work center.

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Determining the Method of Capacity Calculation

Introduction

After you have established work centers, you should define the capacity of each. To do this, you must determine the method by which the system will calculate the work center's capacity.

Methods Available

The Work Center Control subsystem provides three methods by which work center capacities can be calculated:

- Direct Entry
- Rated Capacity
- Demonstrated Load

Each method is described on the pages that follow.

Note: For subcontracting work centers, capacity is not entered. The system sets it automatically to 8 hours a day for 4 shifts

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Direct Entry Method of Capacity Calculation

What is the Direct Entry method?

The Direct Entry method is the simplest method of capacity calculation. Using this method, you calculate the actual hours that the work center is in production by subtracting the nonproductive time (e.g., time spent on breaks, lunches, and other non-work-related activities) from the total hours the work center is in operation.

You should use this method initially, moving to the next method (Rated Capacity) only as your experience with the system grows and only when you begin to accumulate more detailed data for each work center.

Entering the clock hours

Once you have manually calculated the hours, enter them into the system, using the CHCLOCK transaction.

Example of Direct Entry

The following example illustrates the use of the Direct Entry method of capacity calculation.

The example assumes a work center in production for two shifts:

Shift...	**Which falls on day**...	**Runs**...	**From**...	**Withnon-productive time of**...
1	1 - 5	8 hrs. a day	Mon. - Fri.	.8 hrs
2	1 - 4	10 hrs. a day	Mon.-Thurs.	1.0 hrs

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Example of Direct Entry (Continued)

The following CHCLOCK transaction shows these hours entered into the system. The system then uses the hours as the work center's capacity.

```
Chclock            Change work center clock data

              WORK CENTER: wc001
                STALLED ON: 08/08/86
              DEPARTEMENT: D-47
                  PLANNER: PH

SHIFT      MON     TUE     WED     THU     FRI     SAT     SUN
1         7.20    7.20    7.20    7.20    7.20    0.00    0.00
2         9.00    9.00    9.00    9.00    0.00    0.00    0.00
3         0.00    0.00    0.00    0.00    0.00    0.00    0.00
4         0.00    0.00    0.00    0.00    0.00    0.00    0.00

                                                          INPUT
```

Notice that the CHCLOCK transaction prompts for the hours [1] by displaying the shift number and the days of the week. You can enter the hours for up to four shifts.

Using QWC to view work center hours

You can view the hours entered for each work center by using the QWC transaction. This transaction shows a series of screens containing all the information about a specific work center, including clock hours.

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[1] Do not enter clock hours for subcontracting work centers.

Rated Capactity Method of Capacity Calculation

What is the Rated Capacity method?

The Rated Capacity method is more precise than the Direct Entry method. This method should be used only after you have had experience working with the system. The Rated Capacity method requires more detailed data on the work center.

The Rated Capacity Procedure

The system uses a Rated Capacity procedure that starts with the work center's clock hours and adjusts them by a series of percentages for a more realistic figure. The clock hours are the actual time each shift is in operation — not adjusted as in the Direct Entry method.

If you select the Rated Capacity method, you first use the CHCLOCK transaction to enter each work center's clock hours and then the CHGCAP[2] transaction to enter percentages that represent the productivity percent, efficiency percent, and machine utilization factors.

Productivity Percent

Productivity percent is theis the percent of the time (e.g., 90%) that the work center is productive (entered in the PRODUCTIVE% field in the CHGCAP transaction). Time spent on breaks or other duties not related to processing a work order are considered nonproductive time and should not be included in the operational time percentage.

Example: If an 8-hour shift includes a 1/2 hour lunch break and two 15-minute breaks, its productivity percent is 87.5.

Efficiency Percent

The efficiency percent represents the work center's production efficiency (entered in the EFFICIENCY% field in the CHGCAP transaction).

If you enter...	**It indicates that the work center**...
100%	Generally processes its work in the time planned
A percentage greater than 100	Generally processes its work in less time than planned (perhaps because of an incentive program or new equipment)
A percentage less than 100	Generally takes longer than planned to process its work

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[2] Do not run the CHGCAP transactio for subcontracting work centers.

Rated Capactity Method of Capacity Calculation, Continued

Machine Utilization

Machine utilization is the percent of time that the machines in the work center are available for productive use (entered in the UTILIZATION% field in the CHGCAP transaction). This percent includes machine maintenance and end-of-shift cleanup.

Example: If it takes one hour at the beginning of the shift to set up a machine and one hour at the end of the shift to break down and clean that machine (two hours total), the machine utilization in an eight hour shift would be 75%.

Sample CHGCAP transaction

```
ChgCap              Change work center capacity data

     WORK CENTER: wc002
     DESCRIPTION: PAINTING
   INSTALLED ON: 04/05/88
    DEPARTEMENT: D-24
        PLANNER: PH
  NO. OF PEOPLE: 2.00
       CAP TYPE: r
      SJOBS (1): 1
       SJOBS(2): 1
       SJOBS(3): 0
       SJOBS(4): 0
    PRODUCTIVE%: 90
    EFFICIENCY%: 100
  UTILIZATION%: 75
  LOAD FACTOR%: 100

                                                        INPUT
```

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Rated Capactity Method of Capacity Calculation, Continued

Example of Rated Capacity

The following example illustrates how the system adjusts the clock hours when the Rated Capacity method is used.

STEP 1: Entering the weekly hours

A work center is in production for two shifts. You entered eight hours for the first shift, Monday through Friday; ten hours for the second shift, Monday through Thursday. You do not have a third and fourth shift. The weekly hours look like:

CLOCK HOURS							
SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	8.00	8.00	8.00	8.00	8.00	0.00	0.00
2	10.00	10.00	10.00	10.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

STEP 2: Entering Productivity %

A productivity percentage of 90% has been entered (using the CHGCAP transaction) for the work center for both shifts. The system multiplies this percentage (PRODUCTIVE%) by the hours entered in the CHCLOCK transaction to remove nonproductive time from the clock hours and create operational time.

The system does the calculation and provides the following information:

PRODUCTIVE TIME (90%)							
SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	7.20	7.20	7.20	7.20	7.20	0.00	0.00
2	9.00	9.00	9.00	9.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

STEP 3: Entering the efficiency %

An efficiency percent of 100%, indicating that the work is produced in the amount of time planned, has been entered for the work center.

The system multiplies the efficiency percent (EFFICIENCY%) by the productive time (calculated above) to produce the efficient time shown below:

EFFICIENT TIME (100%)							
SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	7.20	7.20	7.20	7.20	7.20	0.00	0.00
2	9.00	9.00	9.00	9.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

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Rated Capactity Method of Capacity Calculation, Continued

STEP 4: Entering the utilization %

The machines in this work center are old and break down often, requiring frequent repairs. Because of this, a utilization percent of 75% has been entered for the work center.

The system multiplies the utilization percent by the efficient time (calculated above) to produce the work center's capacity shown below:

UTILIZED TIME (75%)							
SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	5.40	5.40	5.40	5.40	5.40	0.00	0.00
2	6.75	6.75	6.75	6.75	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

Looking at the above example, you can see that the work center has 5.40 hours of capacity on each day of the first shift and 6.75 hours of capacity on each day of the second shift.

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Demonstrated Load Method of Capacity Calculation

What is the Demonstrated Load method?

For the Demonstrated Load method, the system uses the previous four weeks as the base for calculating work center capacity. Using a 4-week history, the system calculates a ratio of the hours of planned output to the actual hours necessary to produce the planned output. This ratio is called the load factor. If you choose, however, you can manually calculate and enter a load factor, overriding the system calculation. (See "Establishing Capacity Data," later in this section.)

Prerequisites for Demonstrated Load

Before you can use the Demonstrated Load method, you must have implemented the Capacity Planning subsystem input/output control techniques. (See the Capacity Planning Subsystem User's Guide for details on input/output techniques.)

How the system uses load factors

If you select the Demonstrated Load method, the system multiplies the work center's clock hours by the load factor to calculate the work center's capacity. The system compares the total number of hours available in the week to the total number of hours of standard actual output done that week. Since the system automatically determines the load factor from information maintained by the Capacity Planning subsystem, the use of this method should be deferred until well after the Capacity Planning subsystem is implemented.

If you decide to manually calculate a load factor, you should first review this information.

Example of Demonstrated Load

The following example illustrates how the system adjusts work center clock hours when the Demonstrated Load method is used.

1. A work center is in production for two shifts:

Shift...	**Runs**...	**From**...	**And can process this number of simultaneous jobs**...	**For weekly clock hours totaling**...
1	8 hrs. a day	Mon. - Fri.	2jobs	80
2	10 hrs. a day	Mon. - Thurs.	1job	40

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Example of Demonstrated Load, (continued)

2. The example below shows:

- The number of jobs that can be run simultaneously in a work center in the SJOBS column. In the example, two people work on the first shift, one on the second.
- The number of hours multiplied by the jobs in the TOTAL column.

(You enter this information using the CHGCAP transaction.)

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN	JOBS	TOTAL
1	8.00	8.00	8.00	8.00	8.00	0.00	0.00	2	80
2	10.00	10.00	10.00	10.00	0.00	0.00	0.00	1	40
3	0.00	0.0	000	0.00	0.00	0.00	0.00	0	0
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0

TOTAL HOURS: 120

3. The work center's output in hours and its total clock hours for a period of four weeks are illustrated below. (The clock hours in the 2 WEEKS AGO column are lower because a work station on the second shift was idle for two days, due to illness.)

	4 WEEKS AGO	3 WEEKS AGO	2 WEEKS AGO	1 WEEK AGO	TOTAL
ACTSTDOUTPUT	100	110	81	100	391
CLOCKHOURS	120	120	100	120	460

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Example of Demonstrated Load (continued)

4. The load factor is 85% for this work center (i.e., 391/460). The system multiplies the work center's clock hours by the load factor and produces the adjusted clockhours and capacity in hours, as shown below.

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN	SJOBCAP
1	6.80	6.80	6.80	6.80	6.80	0.00	0.00	2 68
2	8.50	8.50	8.50	8.50	0.00	0.00	0.00	1 34
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0 0
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0 0

TOTAL CAPACITY: 102

The example above shows the capacity for each shift and the total capacity for the work center. You can view the results of the system's Demonstrated Load calculation, using the QWC transaction.

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Establishing Working Hours

Introduction

Once you have determined and established the capacity method you will use, you can enter the clock hours for each shift of each work day during the week, using the CHCLOCK transaction.[3]

Specifying shifts

Using the CHCLOCK transaction, you can enter up to 4 shifts for each work center. The shifts you enter are not used until you run the CHGCAP transaction (described in "Establishing Capacity Data..")

The following figure illustrates typical working hours for a work center.

CLOCKDATA

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	8.00	8.00	8.00	8.00	8.00	0.00	0.00
2	10.00	10.00	10.00	10.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

How the system uses shift hours

For the Rated Capacity and Demonstrated Load methods, the system calculates work center capacity based on the entered hours.

For the Direct Entry method, the system uses the hours as entered for the work center capacity.

Viewing work center hours

Once the hours have been established, you can use the QWC transaction or the LWC transaction to view the work center's hours. In both transactions, the hours appear under the heading CLOCK HOURS. (The data shown in the previous figure is similar to the clock data that is part of the Work Center Query or the Work Center Report.)

Changing work center hours

You can change any of the hours by running the CHCLOCK transaction again. Since any hours you enter with the CHCLOCK transaction are not reflected in the system until the CHGCAP transaction is run, you must run the CHGCAP transaction after CHCLOCK.

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[3] Do not enter clock hours for subcontracting work centers.

Changing work center hours

Introduction

Once the appropriate hours have been entered for each work center, run the CHGCAP transaction.[4]

The CHGCAP transaction lets you specify the following information for each work center:

- The method of capacity calculation
- The number of simultaneous shifts that can run in the work center
- For the Rated Capacity method, the productive, efficiency, and machine utilization percentages
- For the Demonstrated Load method, the load factor ratio if you choose to calculate this ratio for yourself

Capacity calculation charts

Capacity charts can be displayed by the QWC query transaction or printed by the LWC report transaction.

Although the contents of the charts differ depending on the method of capacity calculation specified, each chart includes:

This information...	**In this field**...
Data that relates to the specific method of capacity calculation and includes the different clock hours	CLOCK DATA
The calculation type: blank for Direct Entry, R for Rated Capacity, D for Demonstrated Load.	CAP TYPE
The applicable percentages.	PRODUCTIVE% EFFICIENCY%, UTILIZATION% LOAD FACTOR%
The capacity chart.	HOURSDATA

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[4] Do not run the CHGCAP transaction for subcontracting work centers.

Sample capacity data for Direct Entry

CLOCK DATA

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	7.20	7.20	7.20	7.20	7.20	0.00	0.00
2	9.00	9.00	9.00	9.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

CAP	TYPE	PRODUCTIVE%	EFFICIENCY%	UTILIZATION%	LOAD	FACTOR
		100	100	100		100

HOURS DATA

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN	SJOBS	CAP
1	7.00	7.00	7.00	7.00	7.00	0.00	0.00	2	72.00
2	9.00	9.00	9.00	9.00	0.00	0.00	0.00	1	36.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0.00

TOTAL HOURS: 108.00

Sample capacity data for Rated Capacity

CLOCK DATA

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN
1	8.00	8.00	8.00	8.00	8.00	0.00	0.00
2	10.00	10.00	10.00	10.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

CAP	TYPE	PRODUCTIVE%	EFFICIENCY%	UTILIZATION%	LOAD	FACTOR%
	R		90	80	100	100

HOURS DATA

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN	SJOBS	CAP
1	5.76	5.76	5.76	5.76	5.76	0.00	0.00	1	57.60
2	7.20	7.20	7.20	7.20	0.00	0.00	0.00	1	28.80
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0.00

TOATL HOURS: 86.40

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Sample capacity data for Demonstrated Load

CLOCK DATA

SHIT	MON	TUE	WED	THU	FRI	SAT	SUN
1	8.00	8.00	8.00	8.00	8.00	0.00	0.00
2	10.00	10.00	10.00	10.00	0.00	0.00	0.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00

CAP	TYPE	PRODUCTIVE%	EFFICIENCY%	UTILIZATION%	LOAD	FACTOR%
	D	100	100	100		85

HOURS DATA

SHIFT	MON	TUE	WED	THU	FRI	SAT	SUN	SJOBS	CAP
1	6.80	6.80	6.80	6.80	6.80	0.00	0.00	2	68.00
2	8.50	8.50	8.50	8.50	0.00	0.00	0.00	1	34.00
3	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0.00
4	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0	0.00

TOTAL HOURS: 102.00

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Update transactions

TRANSACTION	PURPOSE
ADDWC	Create a work center.
ADDWCWS	Attach a specific work station to a specific work center. The work station cannot already be attached to any other work center.
ADDWS	Create a work station.
CHGCAP	Change any capacity data except clock hours for a specific work center.
CHCLOCK	Change working clock hours for a specific work center.
CHGWC	Change the values in a work center's descriptive or control fields.
CHWCACC	Change work center account data.
CHGWCWS	Detach a work station from its currently assigned work center and re-attach the work station to a different work center.
CHGWS	Change the value in any work station field.
DELWC	Detach all work stations currently assigned to a work center and then delete the work center.
DELWCWS	Detach a work station from its work center, prompting for the work center ID to verify that the work station/work center attachment is known.
DELWS	Delete a work station (detaching it from the work center to which it is attached, if necessary) and print all stored information about the work station prior to deletion.

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Work Center Control Subsystem Transactions, Continued

Update transactions (continued)

TRANSACTION	PURPOSE
SETHRS	Change work center queue hours or move hours.
ROLLWCP	Roll work center performance history into the previous year.

Query transactions

TRANSACTION	PURPOSE
QWC	Display all fields for the specified work center.
QWS	Display all fields for the specified work station and for the work center to which it is attached.
QWCLABD	Display detailed work center labor cost data.
QWCLABT	Display summarized work center labor cost data.
WCUSED	Display all routings using a work center.
NOWC	Display work stations not assigned to a work center .

Report transactions

TRANSACTION	PURPOSE
LWC	Print the Work Center Report, which lists work centers, for all, a range, or specified work centers.
LWS	Print the Work Station Report, which lists work stations and the work centers to which they are attached, for all, a range, or specified work stations.
LWCUSED	List all routings using a work center.

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