PC&C General Leger Interfaces

Using the GL Interfaces
Jim Simunek, CPIM
Jim.simunek@cistech.net

Overview

- Manufacturing Order Files
- Material Transactions (IM) – discussed in the IM GL Interface session
- Labor Transactions
- Outside Operations
- WIP Scrap
- Variances/Variance Analysis
- GL Rules/wildcard rules

Manufacturing Order Files

- When a Manufacturing Order is added, the following files are created:
  - MOMAST – summary record holds the Item ordered, quantity ordered, start/due dates, etc.
  - MODATA – component records; copy of the BOM. Updated when material transactions (IM) are entered
  - MOROUT – operation records; copy of the routing. Updated when labor is reported or earned
  - MOMISC – miscellaneous charge records; if entered with cost information will always add to the variance

MO Status Codes

- 10 – *Released:* – BOM & Routing have been copied to MODATA and MOROUT files

- 40 – *Started:* Either a material or labor transaction has been entered

- 45 – *Material Complete:* No further IM transactions allowed

- 50 – *Labor Complete:* No further labor transactions allowed

- 55 – *Both Material & Labor Complete*

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File Names

- Rules:
  - PCCACC
- Priorities:
  - PCCSEQ

Labor Reporting

- Labor can be entered manually through PC&C Shop Floor Reporting

- Labor can be passed via PM&C (Production Monitoring & Control) with bar-coded Operation On/Off transactions

- With Paperless/MES, touch screens on the shop floor can be used to report Operation On/Off transactions

Labor Valuation

- Tailoring Question C003 "Order Costing Method" determines whether labor is valued at payroll pay rate for employee (XA Payroll required) or Facility Standard

- Labor Hours reported to each operation are extended by Rate

Overhead

- Overhead is determined by the Facility
- Each facility has its own overhead "code" which determines what absorbs overhead for that facility
- Overhead can be calculated by Labor time (set-up plus run) or by Machine Time
- Overhead can be entered as a rate or a percentage

Facility

Facility (Green Screen)

Standard Rates will be used to Value labor and overhead

```
ESERVER                                                                    _|B|X|
File  Edit  View  Communication  Actions  Window  Help

DATE   5/14/06              PRODUCTION FACILITY INQUIRY              AMVD61  AM


FACILITY ID     1000        FACILITY TYPE      WORK CENTER
DESCRIPTION     WELD


DEPARTMENT              PN FAC ACTG CLS             QUEUE TIME-DAYS     .00
FOREMAN                 PRIME LOAD CODE      0      AVG QUEUE TIME      .00
LOCATION                TRACKING SIGNAL     .00     QUEUE MAD           .00
STD EFFICIENCY   1.00   AVG STD OUTPUT      .00     MACH RESOURCE NO.
AVG EFFICIENCY   1.00   AVG ACTL OUTPUT     .00     LABOR RESOURCE NO.
EXTRACT MACH BRKS   0   REPORTING METHOD      0     CLOCKING WINDOW    :00


              MACHINE    RUN LABOR   SETUP LABOR      OVERHEAD     OVERHEAD
               RATE        RATE         RATE        RATE/PERCENT     CODE
CURRENT        50.000     25.000       25.000         125.000        B
STANDARD       50.000     25.000       25.000         125.000        B


          -----LENGTH-----   ----CAPACITY----    DIRECT USAGES       13
          DESIRED  MAXIMUM    DESIRED  MAXIMUM    CALENDAR NAME
SHIFT 1     8.0      8.0        7.0      8.0      POST TO OLDEST SCHED
SHIFT 2     8.0      8.0        7.0      8.0      POST TO FUTURE SCHED
SHIFT 3     8.0      8.0        7.0      8.0      FACILITY STOCK LOC
                                                 F02 VARIABLE CAPACITY
                                                 F24 END OF JOB

MA       a              MW                                      03/017
I902 - Session successfully started
Start   2 Microsoft Outlook   Power Point Present...  Microsoft PowerPoint...  ESERVER   6 javaw        5:46 PM
```
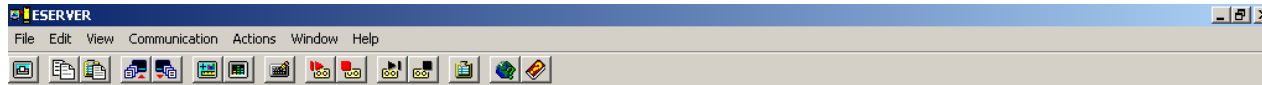
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GL Transactions

```
ESERVER                                                                    _ |B| X|
File  Edit  View  Communication  Actions  Window  Help

  AMVLIO1                         Maintain Interface Control File


  Position to transaction type . . . . . ____


  Type option; then press Enter.
    2=Change


                                                      More:    +
                                            Interface  Application
  Option  Type   Description                 Code      Indicator
    _     LMAC   Machine cost                  1           C
    _     LOHD   Overhead cost                 1           C
    _     LRAP   Outside operations cost       1           C
    _     LRPA   Run labor from Payroll        1           C
    _     LRSA   Run labor from Shop Activity  1           C
    _     LR**   Run Labor - all               2           C
    _     LSPA   Setup labor from Payroll      1           C
    _     LSSA   Setup labor from Shop Activity 1          C
    _     LS**   Labor setup - all             2           C
    _     L***   Labor - all                   2           C



  F1=Help              F3=Exit            F5=Refresh        F7=Backward
  F8=Forward
MA       a                 MW                                    11/003
  I902 - Session successfully started
Start  >  2 Microsoft Outlook  Power Point Present...  Microsoft PowerPoint...  ESERVER   6 javaw   5:47 PM
```
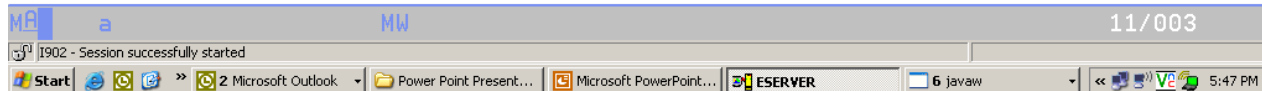
Transaction Creation

- Every time labor is reported to an operation, the following transactions will be created in the PCCTXN file:
  - Run Labor: LRSA from Shop Activity
  - Set-up Labor: LSSA from Shop Activity
  - *Charge Account:* WIP
  - *Offset Account:* Labor Earned/Absorbed

Overhead

- Each time labor or machine time is reported, an overhead transaction is also created
  - Overhead: LOHD Overhead Cost
  - *Charge:* WIP
  - *Offset:* Overhead Absorbed/Earned

Machine Costs

- If the facility has a Machine Standard Rate and Machine time is reported to the MO, XA will create a LMAC transaction

- *Charge:* WIP

- *Offset:* Machine Cost Applied or Earned Overhead

Labor & Overhead

- Questions??????

Outside Operations

- Time Basis Code "C" in a routing operation flags an operation as being performed at the vendor
- Standard Cost for the Outside Operation is stored in the routing operation record
- Create an Item Master/Revision record to buy the Service (no Item Warehouse/Balance record is required)
- PO for the service can be created automatically when MO is released
- Default PO Price is determined by PO Control file
- Difference between PO Price/Invoice and Standard Cost will be a variance

Outside Operation Costs

Outside Operation file Determines when MO costs are updated (at PO Receipt or Invoice)

```
DATE   5/14/06          CHANGE OUTSIDE OPERATION DETAILS        AMCCOD1D  R7

TYPE INFORMATION, PRESS ENTER.                              PAGE 1 OF 2

      SITE ID . . . . . . . . . . . . .  XPS
      VENDOR NUMBER . . . . . . . . .    XVEN3
      WAREHOUSE ID  . . . . . . . . .    XWH
      FINISHED ITEM NUMBER  . . . . .    X661
      ITEM REVISION . . . . . . . .
      OPERATION SEQUENCE #  . . . . .    0010
      ROUTING IDENTIFIER  . . . . . .    XVEN3
      ROUTING VERSION . . . . . . . .    1
      SERVICE ITEM NUMBER . . . . . .    X660
      QTY/COST UPDATE . . . . . . . .    2     (0 = Qty/Cost Update at Invoice)
                                               (1 = Qty/Cost Update at RP)
                                               (2 = Qty at RP/Cost at Invoice)

      PREFERRED VENDOR  . . . . . . .    1        (0=No, 1=Yes)
      P.O. CREATE AT M.O. RELEASE . .    1        (0=No, 1=Yes)
      RELEASE TIME FENCE  . . . . . .    000      (# of days in Time Fence)
      LEAD TIME PURCHASE  . . . . . .       .0    (# of days to Dock)
      LEAD TIME ADJUSTMENT  . . . . .    00       (# of days Dock to Production)

    F5=REFRESH    F8=FORWARD    F12=RETURN
```

PO Create

- Either creating the MO or reporting quantity complete at the previous operation will cause a PO to be created

- PO Price is determined by Purchasing Control file

- PO may be a single delivery PO or a release on a Blanket PO

LRAP Transaction

- Outside Operation file controls when the MO cost & Operation Quantity complete are updated

- the LRAP transaction is created when the cost in the MOROUT file is updated

- *Charge:* WIP

- *Offset:* Outside Process (AP Clearing)

AM Financials –
AP Invoice Entry

Order & Operation Nos.

Charge Type O

IFM Financials – Invoice Entry

Charge Type, Order Number & Operation
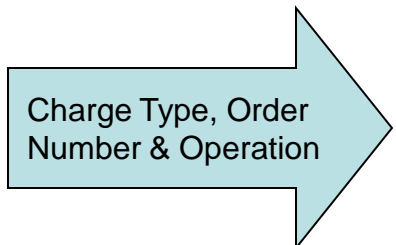
Outside Operations

- Questions????

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Scrap

- Scrap is reported at individual operations
- Reported scrap will lower the quantity to be produced
- Scrap labor & overhead costs will be pro-rated through the operation where the scrap was reported
- Material: if the bill specifies operation where first used, the material cost will be pro-rated through the operation

SCRP Transactions

- When scrap is reported, XA will create a SCRP transaction with the pro-rated value of the scrapped item
- *Charge:* Scrap
- *Offset:* WIP
- WIP Value report will show the value of scrap in WIP as a separate dollar value

WIP Reconciliation

Scrap

- Questions????

Variances

- XA will calculate a total variance as follows:
  - "Actual Cost" = Material + Machine + Set up labor + Run labor + OH
  - Receipt value = RM transaction quantity x Unit Cost Default
  - Order Variance = "Actual Cost" – Receipt Value

Variance Transactions

AMVLIO1   Maintain Interface Control File

Position to transaction type . . . . . . ____

Type option; then press Enter.
   2=Change

More: - +

Option	Type	Description	Interface Code	Application Indicator
▮	VCLO	Variances - order closeout	1	C
_	VEAC	Miscellaneous charge cost variance	1	C
_	VE**	Miscellaneous charge variances	2	C
_	VMCS	Material cost variance	1	C
_	VMUS	Material usage variance	1	C
_	VM**	Material variances	2	C
_	VOCO	Overhead cost variance	1	C
_	VOUS	Overhead efficiency variance	1	C
_	VO**	Overhead variances	2	C
_	VRCO	Run labor cost variance	1	C

F1=Help   F3=Exit   F5=Refresh   F7=Backward
F8=Forward

Variance Transactions

AMVLIO1   Maintain Interface Control File

Position to transaction type . . . . . ____

Type option; then press Enter.
  2=Change

                                                        More: -
                                              Interface Application
Option Type   Description   Code   Indicator
  _   VRCO   Run labor cost variance   1   C
  _   VRUS   Run labor efficiency variance   1   C
  _   VR**   Run variances   2   C
  _   VSCO   Setup labor cost variance   1   C
  _   VSUS   Setup labor efficiency variance 1   C
  _   VS**   Setup variances   2   C
  _   V***   Variances - all   2   C

F1=Help   F3=Exit   F5=Refresh   F7=Backward
F8=Forward

Order Closeout

- Order Close & Purge is when XA calculates and collects variance information for the MO

- Normal Close or Force Closing the order will produce the same variances – the only difference is the status of the MO when closed

- Order Close & Purge can produce the Accounting Detail report & Order Closeout Variance Analysis report

MO Accounting Report

MO Summary Info

Material Detail

Operation Detail

MO Total (Incl Variance)

```
* * OVERHEAD CALCULATIONS INCLUDE MACHINE COSTS * *                                    PAGE IN ORDER    1

ORDER    FINISHED            ST DEPT   JOB NUMBER   IAC    ORDER      * - - Q U A N T I T Y -- -*  SCHED HRS              DATES
NUMBER   ITEM NUMBER    WH   CD PLANN  REFERENCE    OAC    QUANTITY   SPLITS/COMPLETED    OPEN     REMAINING   START      4/25/06
M020620 2640070900      1   55                             5,000.000                    250.000-      .00     ACTUAL ST  4/25/06
                                1600                                  5,250.000                               LAST TRANS 4/25/06
        ORDER                                      UNIT                          PROJECTED                    DUE        4/27/06
        DESCRIPTION-- ASSY COMPLETE T              COST--         .9711           COST--        4,855.49      ACTL CMPLT 4/25/06

COMP. ITEM NO./     U/    QUANTITY                            STANDARD       COST            COST             DATE
DESCRIPTION    WH   /M    TO-DATE      UNIT COST               COST      THIS PERIOD     TOTAL TO-DATE      LAST ISSUE

054050300       1   EA    5250.000         .0433               216.50           .00          227.33
        N CORE ELECT N/P                                                                                     4/25/06
205310          1   EA    5250.000         .0224               112.13           .00          117.73
        CAP          GREY                                                                                    4/25/06
264004          1   EA    5250.000         .0413               206.40           .00          216.72
        RTPM GROMMET                                                                                         4/25/06
264006          1   EA    5250.000         .7837              3918.57           .00         4114.49
        TMP HOUSING OVERMOLD                                                                                 4/25/06

                          TOTAL STANDARD COST       4,453.60   TO-DATE COST        4,676.27

OPERATION NO./  STD  ACTUAL PROC  TOOL    TBC   START   DUE    LAST   *---QUANTITY---*  *--COST PER UNIT--*    COST
DESCRIPTION  MS FAC   FAC  SHEET  PFAC ST RWK   DATE    DATE  ACTIVE     PERIOD/          STANDARD/           ACT/ST
                                                                        TO-DATE           ACTUAL

0010           746A  746A          40 4 0  4/25/06 4/25/06 4/25/06    5,250.000              .08
                                                                      5,250.000              .06                75
Automatic Assembly

    *---- STANDARD -----* *--- THIS PERIOD ---* *-- TOTAL TO-DATE --*  VARIANCE HOURS  *--- CUMULATIVE SCRAP ---*  CUMULATIVE
         HOURS/COST           HOURS/COST            HOURS/COST                          STD COST/ACT COST    STD UNIT COST
                                                                                       QTY SCRAPPED      .000
SET          .00                  .00                  .00                 .00   SET          .00                .0000
             .00                  .00                  .00                              .00
LAB         5.49                 5.00                 5.00                -.49   LAB          .00                .0134
            66.93               60.90                60.90                              .00
OVH                                                                             OVH          .00                .0643
           321.42              292.50               292.50                              .00
OUT OP       .00                  .00                  .00                 .00   OUT          .00                .0000
             .00                  .00                  .00                              .00
TOT         5.49                 5.00                 5.00                -.49   TOT          .00                .0777
           388.35              353.40               353.40                              .00
MAC         5.49                  .00                  .00                5.49   MTL          .00                .8907
             .00                  .00                  .00                              .00

0020           744P  744P          40 4 0  4/25/06 4/25/06 4/25/06    5,250.000              .00
                                                                      5,250.000              .07                 0
Pack 4 Trays in Tote

    *---- STANDARD -----* *--- THIS PERIOD ---* *-- TOTAL TO-DATE --*  VARIANCE HOURS  *--- CUMULATIVE SCRAP ---*  CUMULATIVE
         HOURS/COST           HOURS/COST            HOURS/COST                          STD COST/ACT COST    STD UNIT COST
                                                                                       QTY SCRAPPED      .000
SET          .00                  .00                  .00                 .00   SET          .00                .0000
             .00                  .00                  .00                              .00
LAB          .19                 5.50                 5.50               5.31-   LAB          .00                .0140
            2.75                77.61                77.61                              .00
OVH                                                                             OVH          .00                .0664
           10.74               303.22               303.22                              .00
OUT OP       .00                  .00                  .00                 .00   OUT          .00                .0000
             .00                  .00                  .00                              .00
TOT          .19                 5.50                 5.50               5.31-   TOT          .00                .0804
           13.49               380.83               380.83                              .00
MAC          .19                  .00                  .00                 .19   MTL          .00                .8907
             .00                  .00                  .00                              .00
W AM-5512 NO MISC CHARGES FOR THIS ORDER

DIRECT     SETUP         LABOR        OVERHEAD     MATL & PUR   MISCELLANEOUS  TOTAL ACTUAL   RECEIPT      DIFFERENCE
ORDER
COSTS--       .00        138.51        595.72       4676.27           .00       5410.50       5098.26        312.24
```

Variances

- GL Interfaces break the variances down into Cost, Efficiency & Usage variances for each of the following categories:
  - Material
  - Set up Labor
  - Run Labor
  - Overhead (includes Machine Variances)
  - Miscellaneous Charges

Rules

- *Charge:* Appropriate Variance Account or Cost of Goods Sold

- *Offset:* WIP

- Wildcard Rules (transaction codes that include *) will allow 1 rule to assign accounts to multiple transactions

Variance Transactions

```
ESERVER                                                                    _|B|X|
File  Edit  View  Communication  Actions  Window  Help

  AMVLIO1                       Maintain Interface Control File


  Position to transaction type . . . . . ____


  Type option; then press Enter.
    2=Change


                                                          More: -
                                              Interface  Application
  Option  Type   Description                     Code     Indicator
    _      VRCO   Run labor cost variance           1         C
    _      VRUS   Run labor efficiency variance     1         C
    _      VR**   Run variances                     2         C
    _      VSCO   Setup labor cost variance         1         C
    _      VSUS   Setup labor efficiency variance   1         C
    _      VS**   Setup variances                   2         C
    _      V***   Variances - all                   2         C




  F1=Help              F3=Exit           F5=Refresh        F7=Backward
  F8=Forward
```

One Rule for V*** will assign accounts
To all variance transactions

MO Variance Report – pg. 1

```
                              ORDER NUMBER M020620
                                     ORDER            ORDER          ORDER          USAGE          COST
                                  ACTUAL COST      STANDARD COST     VARIANCE       VARIANCE       VARIANCE

MATERIAL VARIANCE DETAIL

ITEM         WHS  QUANTITY PER UNIT                  1.0000000
054050300    1    QUANTITY RECEIVED                  5250.000
                                                  ---------------
                  ISSUE QUANTITY      5250.000       5250.000
                  STANDARD COST            .04            .04
                                  ---------------  ---------------
                  EXTENDED COST         227.33         227.33         .00            .00            .00

ITEM         WHS  QUANTITY PER UNIT                  1.0000000
205310       1    QUANTITY RECEIVED                  5250.000
                                                  ---------------
                  ISSUE QUANTITY      5250.000       5250.000
                  STANDARD COST            .02            .02
                                  ---------------  ---------------
                  EXTENDED COST         117.73         117.73         .00            .00            .00

ITEM         WHS  QUANTITY PER UNIT                  1.0000000
264004       1    QUANTITY RECEIVED                  5250.000
                                                  ---------------
                  ISSUE QUANTITY      5250.000       5250.000
                  STANDARD COST            .04            .04
                                  ---------------  ---------------
                  EXTENDED COST         216.72         216.72         .00            .00            .00

ITEM         WHS  QUANTITY PER UNIT                  1.0000000
264006       1    QUANTITY RECEIVED                  5250.000
                                                  ---------------
                  ISSUE QUANTITY      5250.000       5250.000
                  STANDARD COST            .78            .78
                                  ---------------  ---------------
                  EXTENDED COST        4114.49        4114.49         .00            .00            .00

PRODUCTION FACILITY 744P  DETAIL

  OPER SEQUENCE 0020

                  SETUP LABOR HOURS        .00            .00
                  STANDARD SETUP RATE     .000           .000
                                  ---------------  ---------------
                  SETUP LABOR EXTENDED COST .00           .00         .00            .00            .00

                  UNIT RUN LABOR HOURS                   .0000
                  QUANTITY COMPLETE                    5250.000
                                                  ---------------
                  RUN LABOR HOURS         5.50            .20
                  STANDARD RUN LABOR RATE 14.110        14.110
                                  ---------------  ---------------
                  RUN LABOR EXTENDED COST 77.61          2.89        74.72          74.72           .00
                  OVERHEAD EXTENDED COST 303.22         11.29       291.93         291.91           .02
                  OUTSIDE OPERATION COST    .00            .00         .00            .00            .00
```

Order Variance =

Usage Variance + Cost Variance

Material Detail

Operation Detail
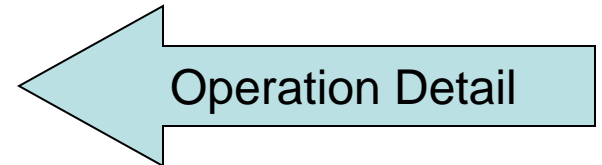
MO Variances – Pg 2

```
ORDER NUMBER M020620
                    ORDER             ORDER            ORDER          USAGE          COST
                    ACTUAL COST   STANDARD COST      VARIANCE       VARIANCE       VARIANCE

PRODUCTION FACILITY 744P  DETAIL

  OPER SEQUENCE 0010

PRODUCTION FACILITY 746A  DETAIL

  OPER SEQUENCE 0010

               SETUP LABOR HOURS          .00            .00
               STANDARD SETUP RATE       .000           .000
                                   ----------------  ----------------
         SETUP LABOR EXTENDED COST        .00            .00            .00            .00            .00

               UNIT RUN LABOR HOURS                     .0011
               QUANTITY COMPLETE                     5250.000
                                                     ----------------
               RUN LABOR HOURS           5.00           5.76
               STANDARD RUN LABOR RATE  12.180         12.180
                                   ----------------  ----------------
         RUN LABOR EXTENDED COST        60.90          70.27          9.37-          9.37-           .00
         OVERHEAD EXTENDED COST        292.50         337.51         45.01-         45.01-           .00
         OUTSIDE OPERATION COST          .00            .00            .00            .00            .00


ORDER NUMBER M020620
                    ORDER             ORDER            ORDER          USAGE          COST
                    ACTUAL COST   STANDARD COST      VARIANCE       VARIANCE       VARIANCE
COSTS:
MATERIAL            4676.27         4676.27            .00            .00            .00
SETUP                  .00             .00            .00            .00            .00
LABOR               138.51           73.16          65.35          65.35            .00
OVERHEAD            595.72          348.80         246.92         246.90            .02
MISCELLANEOUS          .00             .00            .00
                  ----------------  ----------------  ----------------  ----------------  ----------------
TOTAL COSTS        5410.50         5098.23         312.27         312.25            .02
                  ----------------
RECEIPT AMOUNT     5098.26
                  ----------------
COST LESS RECEIPT AMOUNT   312.24

LESS:
USAGE VARIANCES    312.25
COST VARIANCES        .02
                  ----------------
ORDER CLOSEOUT VARIANCE    .03-
                  ================
```
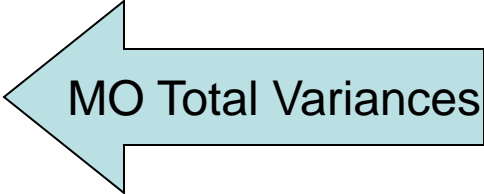
MO Total Variances

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MO Accounting Report

MO Summary Info

Material Detail

Operation Detail

MO Totals (incl Variance)

```
* * OVERHEAD CALCULATIONS INCLUDE MACHINE COSTS * *                                    PAGE IN ORDER    1

ORDER     FINISHED              ST DEPT   JOB NUMBER    IAC      ORDER      * - - Q U A N T I T Y -- -*  SCHED HRS              DATES
NUMBER    ITEM NUMBER      WH   CD PLANN  REFERENCE     OAC      QUANTITY   SPLITS/COMPLETED    OPEN     REMAINING
                                                                                                                   START       4/25/06
M020620 2640070900         1   55                                5,000.000             .000    250.000-        .00 ACTUAL ST   4/25/06
                               1600                                         5,250.000                              LAST TRANS  4/25/06
          ORDER                                     UNIT                             PROJECTED                     DUE         4/27/06
          DESCRIPTION-- ASSY COMPLETE T             COST--           .9711          COST--          4,855.49       ACTL CMPLT  4/25/06


COMP. ITEM NO./     U/    QUANTITY                               STANDARD        COST            COST              DATE
DESCRIPTION    WH   /M    TO-DATE        UNIT COST                 COST       THIS PERIOD     TOTAL TO-DATE    LAST ISSUE

054050300      1   EA     5250.000            .0433              216.50          .00            227.33
     CORE ELECT N/P                                                                                               4/25/06
205310         1   EA     5250.000            .0224              112.13          .00            117.73
     CAP           GREY                                                                                           4/25/06
264004         1   EA     5250.000            .0413              206.40          .00            216.72
     RTPM GROMMET                                                                                                 4/25/06
264006         1   EA     5250.000            .7837             3918.57          .00           4114.49
     TMP HOUSING OVERMOLD                                                                                         4/25/06

              TOTAL STANDARD COST           4,453.60   TO-DATE COST          4,676.27


OPERATION NO./   STD  ACTUAL PROC   TOOL    TBC    START   DUE     LAST    *---QUANTITY---*    *--COST PER UNIT--*          COST
DESCRIPTION   MS FAC    FAC  SHEET   PFAC  ST RWK  DATE    DATE    ACTIVE     PERIOD/             STANDARD/             ACT/ST
                                                                             TO-DATE             ACTUAL

0010          746A   746A            40  4  0  4/25/06 4/25/06 4/25/06    5,250.000              .08
                                                                         5,250.000              .06                    75
Automatic Assembly

      *---- STANDARD -----* *--- THIS PERIOD ---* *-- TOTAL TO-DATE --*   VARIANCE HOURS   *--- CUMULATIVE SCRAP ---*   CUMULATIVE
           HOURS/COST          HOURS/COST            HOURS/COST                             STD COST/ACT COST         STD UNIT COST
                                                                                           QTY SCRAPPED      .000
SET           .00               .00                  .00               .00       SET            .00    .000         .0000
              .00               .00                  .00                                        .00
LAB          5.49              5.00                 5.00               .49       LAB            .00                  .0134
            66.93             60.90                60.90                                        .00
OVH                                                                                                                 .0643
           321.42            292.50               292.50                         OVH            .00
OUT OP        .00               .00                  .00               .00       OUT            .00                  .0000
              .00               .00                  .00                                        .00
TOT          5.49              5.00                 5.00               .49       TOT            .00                  .0777
           388.35            353.40               353.40                                        .00
MAC          5.49               .00                  .00              5.49       MTL            .00                  .8907
              .00               .00                  .00                                        .00

0020          744P   744P            40  4  0  4/25/06 4/25/06 4/25/06    5,250.000              .00
                                                                         5,250.000              .07                     0
Pack 4 Trays in Tote

      *---- STANDARD -----* *--- THIS PERIOD ---* *-- TOTAL TO-DATE --*   VARIANCE HOURS   *--- CUMULATIVE SCRAP ---*   CUMULATIVE
           HOURS/COST          HOURS/COST            HOURS/COST                             STD COST/ACT COST         STD UNIT COST
                                                                                           QTY SCRAPPED      .000
SET           .00               .00                  .00               .00       SET            .00    .000         .0000
              .00               .00                  .00                                        .00
LAB           .19              5.50                 5.50             5.31-        LAB            .00                  .0140
             2.75             77.61                77.61                                        .00
OVH                                                                                                                 .0664
            10.74            303.22               303.22                         OVH            .00
OUT OP        .00               .00                  .00               .00       OUT            .00                  .0000
              .00               .00                  .00                                        .00
TOT           .19              5.50                 5.50             5.31-        TOT            .00                  .0804
            13.49            380.83               380.83                                        .00
MAC           .19               .00                  .00               .19       MTL            .00                  .8907
              .00               .00                  .00                                        .00
W AM-5512 NO MISC CHARGES FOR THIS ORDER

DIRECT     SETUP        LABOR       OVERHEAD     MATL & PUR    MISCELLANEOUS  TOTAL ACTUAL    RECEIPT       DIFFERENCE
ORDER
COSTS--       .00      138.51        595.72       4676.27             .00       5410.50       5098.26         312.24
```

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Total Variances

- **Final Page of Order Detail report has total variance dollars for all MO's closed and purged**
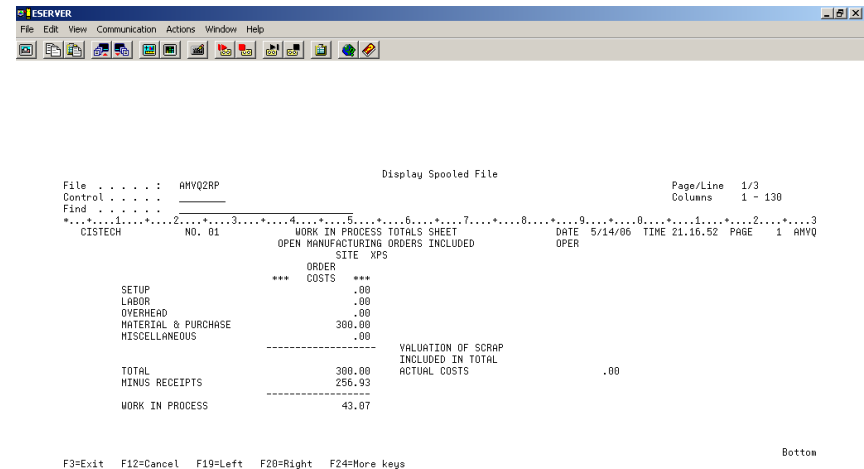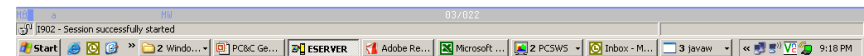
WIP Reconciliation

- After running the MO Close and Purge, you will need to run the WIP Totals Sheet from the PC&C Reports menu to get the value of WIP

- Use this to reconcile to GL WIP value

Summary

- Use GL Rules to book machine, labor & overhead to WIP

- Costs for Outside Operations are determined by the Outside Operation file

- Scrap costs are pro-rated to the operation where scrap was reported

- Variances are calculated and reported when the MO is closed and purged

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