

Resource Modeling



Applies to:

SAP R/3. For more information, visit the [Supply Chain Management homepage](#).

Summary

Client Company is in the business of manufacturing personal care items. For manufacturing plastic items, molding machines as well as molds are being used. The Business requirement of the Client was to have an insight to the Capacity situation at the mold level. Since the Classical Client processes do not have this functionality it was a pain area for them. Also for this type of scenario the Standard SAP solution recommends the molds to be used as PRT, where only the availability of the PRT is seen at the time of order processing. The client wanted to evaluate the overall Capacity situation at the planning level which gave a motivation for doing resource modeling.

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Author Bio

Hemant has about 14 years of total experience. Out of which 6 years in SAP R/3 in implementation project as a SAP MTI Team Lead, functional consultant, Functional Support, Core team member and end user. Currently a part of the SAP functional team in L&T Infotech Ltd. Education: Bachelor of Science and Master in Management Science, Pune University..

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Business Process

Client Company manufactures a wide range of consumer goods and personal care items. The Demand from the Market acts as input for Manufacturing. The Manufacturing Plant has different shops like Packaging Shop, Assembly Shop and Molding Shop. The Molding Shop manufactures mold components. The shop has 7 Injection Molding machines of the same type. Any mold can be put on any of the machines one at a time bringing in the interchangeability within the machine and mold combination. Molds are used to manufacture different plastic products like Central rod, Plug, Handle, Cap etc. There are unique molds to manufacture every product. Any mold can be put on any of the machines one at a time. This scenario is similar to the Press shop discrete manufacturing where the Press machine is common machine while as the Dies are unique for different pressed parts (i.e. Press Machine is similar to Injection molding machine and Dies are similar to Molds). The Standard Client process uses Process orders (PPPI) for all its business processes.

Clients Classical solution

In Client standard practice, the machines are considered for the Capacity Planning, Molds are not considered for the capacity planning.

The classical solution is that the Molds are treated as PRT (Production resource tools) similar to the Dies in Press shop and the Injection Molding Machines are the main machines like Press. This solution allows the capacity planning at the Machine level. The Molds are excluded from the capacity planning. Also if the Molds are treated as PRT then this allows seeing if the PRT is available for processing the process order but does not give an insight to the capacity at the mold level. This shows the availability of the Mold and not its capacity / overload in % age.

Clients pain area

The Client expects that they should be able to see the Capacity on the Injection molding machines as well as the Molds for optimum Planning. It means they should be able to see the clear situations when the Injection molding machine has the capacity but the Mold does not have the capacity OR vice versa. They should be able to see in advance whether they can fulfill a plan of a certain molded component, considering the availability of the Injection molding machine as well as the mold. Client wants to view this at the time of planning itself. I.e. before Order processing this would help in decision making of whether to adopt the plan or revise it.

This expected visibility of capacity at the Mold level was not possible and this was a major pain area for the Client.

Proposed Mapping of the customer's expectations in SAP

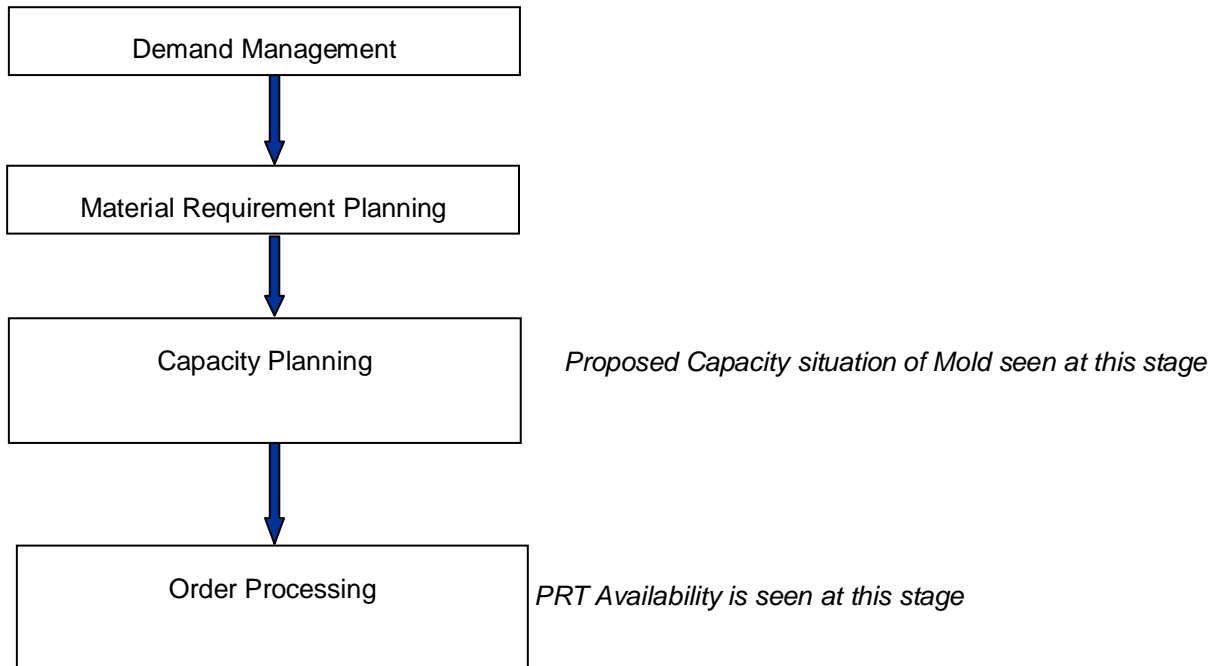
To address the above pain area it was proposed to treat the Molds as machines. But since there were 15 different types of Molds and seven Machines it would increase the Master data and the data maintenance would become difficult. So it was proposed that the seven machines of the same type to be treated as one Resource with 7 no. of individual capacities. This facility is there in the Capacity details screen in Resource. This will combine the available capacity of all the machines since they are of the same functionality. Also the recipe creation is made easy.

Every Mold is treated as single resource.

In this way there would be 15 +1 ==16 Resources.

Functioning in SAP

Process Flow



Master Data

Data used for demonstration-

Plant – 0010

Common Resource – 0010IM01 - Combined Injection Molding machine

Material – HALB1

Description - CAP

Recipe – 50000027

Resource -0010M1

Planned order – 0000006571

Material – HALB2

Description - PLATFORM

Recipe – 50000028

Resource -0010M2

Planned order- 0000006572

All the resources are given an operating time of 24 Hours. The Injection molding Resource is also given 24 hours operating time and so its available hours come to be $24 \times 7 = 168$ per day. These come to be $168 \times 5 = 840$ for a week, which is the weekly available capacity. Similarly the molds get an available capacity of $24 \times 5 = 120$ hrs per week.

In the Recipe the first operation is allotted to the Injection molding machine where the Scheduling, Capacity and Costing take place.

The second operation is allotted to the Mold where only capacity evaluation takes place.

When the Load is given to the process order it is given to the individual operation and further to the phases. If the load is less than or equal to 120 hours then in the Capacity Evaluation view for the Mold the load shown is less than or equal to 100% and for the Injection Molding machines it is still lesser (as it has 840 hours available capacity). When the load increases beyond 120 hours the Mold gets overloaded Red Colored, while as the Injection molding machine still has available capacity hours.

The common Injection molding machine Resource is designed as follows. Note that in No. of individual Capacities field 7 is put, since there are seven machines.

Change Resource Capacity: Header

Intervals and Shifts | Intervals | Available Capacity Profile | Reference Available Capacity | Short Texts

Plant: 0010 | L&T infotech, Software Park
 Resource: 0010IM01 | Combined Injection Molding machine
 Capacity category: 001

General data

Capacity planner grp: 001 | SAP example
 Pooled capacity | Grouping:

Available capacity

Factory calendar ID: IN | India
 Active version: 1 | Normal available capacity
 Base unit of meas.: H | Hour

Standard available capacity

Start: 00:00:00 | Capacity utilization: 100
 Finish: 24:00:00 | No. of indiv. cap.: 7
 Length of breaks: 00:00:00 | Capacity: 168,00 H
 Operating time: 24,00

Planning details

Relevant to finite scheduling | Overload: %
 Can be used by several operations | Long-term planning

The two Mold resources are a Single individual Capacity as follows.

Mold 1

Resource Edit Goto Extras System Help

Change Resource Capacity: Header

Intervals and Shifts Intervals Available Capacity Profile Reference Available Capacity Short T

Plant 0010 L&T infotech, Software Park
 Resource 0010M1 Mold 1
 Capacity category 001

General data
 Capacity planner grp 001 SAP example
 Pooled capacity Grouping

Available capacity
 Factory calendar ID IN India
 Active version 1 Normal available capacity
 Base unit of meas. H Hour

Standard available capacity
 Start 00:00:00
 Finish 24:00:00 Capacity utilization 100
 Length of breaks 00:00:00 No. of indiv. cap. 1
 Operating time 24,00 Capacity 24,00 H

Planning details
 Relevant to finite scheduling Overload %
 Can be used by several operations Long-term planning

Mold 2

Resource Edit Goto Extras System Help

Change Resource Capacity: Header

Intervals and Shifts Intervals Available Capacity Profile Reference Available Capacity Short Texts

Plant 0010 L&T infotech, Software Park
 Resource 0010M2 Mold 2
 Capacity category 001

General data
 Capacity planner grp 001 SAP example
 Pooled capacity Grouping

Available capacity
 Factory calendar ID IN India
 Active version 1 Normal available capacity
 Base unit of meas. H Hour

Standard available capacity
 Start 00:00:00
 Finish 24:00:00 Capacity utilization 100
 Length of breaks 00:00:00 No. of indiv. cap. 1
 Operating time 24,00 Capacity 24,00 H

Planning details
 Relevant to finite scheduling Overload %
 Can be used by several operations Long-term planning

For the Trial run two materials (Halb1 and Halb2) with planned orders are considered. Following are the screenshots. These orders are taken from the 26 th week of 2009 (ending on 1 st day of 27 th week).

HALB1

[List](#) [Edit](#) [Goto](#) [Settings](#) [Environment](#) [System](#) [Help](#)

Stock/Requirements List as of 12:18 hrs

[Show Overview Tree](#)

Material: CAP
 Plant: MRP type: Material Type: Unit:

	A	Date	MRP e	MRP element data	Rescheduli	E	Receipt/Reqmt	Available Qty
		29.05.2009	Stock					0
		08.06.2009	PldOrd	0000006580/STCK		52	100.000	100.000
		08.06.2009	IndReq	VSF			100.000-	0
		15.06.2009	PldOrd	0000006581/STCK		52	100.000	100.000
		15.06.2009	IndReq	VSF			100.000-	0
		22.06.2009	PldOrd	0000006582/STCK		52	100.000	100.000
		22.06.2009	IndReq	VSF			100.000-	0
		29.06.2009	PldOrd	0000006579/STCK		52	100.000	100.000
		29.06.2009	IndReq	VSF			100.000-	0
		06.07.2009	PldOrd	0000006583/STCK		52	100.000	100.000
		06.07.2009	IndReq	VSF			100.000-	0
		13.07.2009	PldOrd	0000006584/STCK		52	100.000	100.000
		13.07.2009	IndReq	VSF			100.000-	0
		20.07.2009	PldOrd	0000006585/STCK		52	100.000	100.000
		20.07.2009	IndReq	VSF			100.000-	0
		27.07.2009	PldOrd	0000006586/STCK		52	100.000	100.000
		27.07.2009	IndReq	VSF			100.000-	0

HALB2

Stock/Requirements List as of 11:31 hrs

Material: HALB2 PLATFORM
 Plant: 0010 MRP type: PD Material Type: HALB Unit: EA

A	Date	MRP e	MRP element data	Rescheduli	E	Receipt/Reqmt	Available Qty
	01.06.2009	Stock					0
	08.06.2009	PldOrd	0000006587/STCK		52	100.000	100.000
	08.06.2009	IndReq	VSF			100.000-	0
	15.06.2009	PldOrd	0000006588/STCK		52	100.000	100.000
	15.06.2009	IndReq	VSF			100.000-	0
	22.06.2009	PldOrd	0000006589/STCK		52	100.000	100.000
	22.06.2009	IndReq	VSF			100.000-	0
	29.06.2009	PldOrd	0000006578/STCK		52	100.000	100.000
	29.06.2009	IndReq	VSF			100.000-	0
	06.07.2009	PldOrd	0000006590/STCK		52	100.000	100.000
	06.07.2009	IndReq	VSF			100.000-	0
	13.07.2009	PldOrd	0000006591/STCK		52	100.000	100.000
	13.07.2009	IndReq	VSF			100.000-	0
	20.07.2009	PldOrd	0000006592/STCK		52	100.000	100.000
	20.07.2009	IndReq	VSF			100.000-	0

The Recipe of the orders have the Injection Molding machine as a common Resource- 0010IM01 while as the Molds are different – Resource 0010M1 for CAP And 0010M2 for PLATFORM. The Control keys PI01 considers Capacity, Scheduling and Costing.

Display Master Recipe: Recipe

Recipe Group: 50000027 Deletion Flag: Long Text Exists:
 Recipe: 1 CAP
 Plant: 0010 L&T infotech, Software Park

Recipe header | Operations | Materials | Administrative data

Ops	Opera	Ph	Sup.	De	Resource	Co	Lo	Standar	Description	Lan	Rel	Cla	Obj	Base Qty	Act/
	0010	<input type="checkbox"/>			0010IM01	PI01	<input type="checkbox"/>		TEST 1			<input type="checkbox"/>	<input type="checkbox"/>	110.000	EA
	0020	<input checked="" type="checkbox"/>	0010	01	0010IM01	PI01	<input type="checkbox"/>				X	<input type="checkbox"/>	<input type="checkbox"/>	110.000	EA
	0030	<input type="checkbox"/>			0010M1	PI01	<input type="checkbox"/>					<input type="checkbox"/>	<input type="checkbox"/>	110.000	EA
	0040	<input checked="" type="checkbox"/>	0030	01	0010M1	PI01	<input type="checkbox"/>				X	<input type="checkbox"/>	<input type="checkbox"/>	110.000	EA

And

Recipe Group: 50000028 Deletion Flag Long Text Exists
 Recipe: 1 PLATFORM
 Plant: 0010 L&T infotech, Software Park

Recipe header | **Operations** | Materials | Administrative data

Opera	Ph	Sup	De	Resource	Co	Lo	Standar	Description	Lan	Rel	Cla	Obj	Base Qty	Act/
0010	<input type="checkbox"/>			0010IM01	PI01	<input type="checkbox"/>		TEST1			<input type="checkbox"/>	<input type="checkbox"/>	21.000	EA
0020	<input checked="" type="checkbox"/>	0010	01	0010IM01	PI01	<input type="checkbox"/>				X	<input type="checkbox"/>	<input type="checkbox"/>	21.000	EA
0030	<input type="checkbox"/>			0010M2	PI01	<input type="checkbox"/>					<input type="checkbox"/>	<input type="checkbox"/>	21.000	EA
0040	<input checked="" type="checkbox"/>	0030	01	0010M2	PI01	<input type="checkbox"/>				X	<input type="checkbox"/>	<input type="checkbox"/>	21.000	EA

After the MPS run the orders get certain Capacity load which is seen in the Capacity Evaluation screen. T code CM01.

Combined injection molding machine

Planning | Edit | Goto | **Settings** | Environment | System | Help

Cap. details/period

Work center: 0010IM01 Combined Injection Molding mac Plant: 0010
 Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22.2009	0,00	168,00	0 %	168,00	H
<input type="checkbox"/> 23.2009	80,76	840,00	10 %	759,24	H
<input type="checkbox"/> 24.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 25.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 26.2009	122,94	840,00	15 %	717,06	H
<input checked="" type="checkbox"/> 27.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 28.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 29.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 30.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 31.2009	42,18	840,00	5 %	797,82	H
Total >>>	983,55	7.728,00	13 %	6.744,45	H

Mold 1

Planning Edit Goto Settings Environment System Help

Cap. details/period

Work center 0010M1 Mold 1 Plant 0010
Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22.2009	0,00	24,00	0 %	24,00	H
<input type="checkbox"/> 23.2009	0,00	120,00	0 %	120,00	H
<input type="checkbox"/> 24.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 25.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 26.2009	18,18	120,00	15 %	101,82	H
<input checked="" type="checkbox"/> 27.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 28.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 29.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 30.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 31.2009	18,18	120,00	15 %	101,82	H
Total >>>	145,45	1.104,00	13 %	958,55	H

Mold 2

[Planning](#) [Edit](#) [Goto](#) [Settings](#) [Environment](#) [System](#) [Help](#)

Capacity Planning: Standard Overview

Cap. details/period

Work center: 0010M2 Mold 2 Plant: 0010
 Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22.2009	0,00	24,00	0 %	24,00	H
<input type="checkbox"/> 23.2009	80,76	120,00	67 %	39,24	H
<input type="checkbox"/> 24.2009	104,76	120,00	87 %	15,24	H
<input type="checkbox"/> 25.2009	104,76	120,00	87 %	15,24	H
<input type="checkbox"/> 26.2009	104,76	120,00	87 %	15,24	H
<input checked="" type="checkbox"/> 27.2009	104,76	120,00	87 %	15,24	H
<input type="checkbox"/> 28.2009	104,76	120,00	87 %	15,24	H
<input type="checkbox"/> 29.2009	104,76	120,00	87 %	15,24	H
<input type="checkbox"/> 30.2009	104,76	120,00	87 %	15,24	H
<input type="checkbox"/> 31.2009	24,00	120,00	20 %	96,00	H
Total >>>	838,10	1.104,00	76 %	265,90	H

Now we will gradually increase the load on the Injection molding Machine and mold by changing the Quantity of the planned order for HALB1.

List Edit Goto Settings Environment System Help

Stock/Requirements List as of 14:24 hrs

Show Overview Tree

Material: HALB1 CAP
 Plant: 0010 MRP type: PD Material Type: HALB Unit: EA

A	Date	MRP e.	MRP element data	Reschedul...	E	Receipt/Reqmt	Available Qty
	29.05.2009	Stock					0
	08.06.2009	PldOrd	0000006580/STCK		52	100.000	100.000
	08.06.2009	IndReq	VSF			100.000-	0
	15.06.2009	PldOrd	0000006581/STCK		52	100.000	100.000
	15.06.2009	IndReq	VSF			100.000-	0
	22.06.2009	PldOrd	0000006582/STCK		52	100.000	100.000
	22.06.2009	IndReq	VSF			100.000-	0
	29.06.2009	PldOrd	0000006579/STCK		52	200.000	200.000
	29.06.2009	IndReq	VSF			100.000-	100.000
	06.07.2009	PldOrd	0000006583/STCK		52	100.000	200.000
	06.07.2009	IndReq	VSF			100.000-	100.000
	13.07.2009	PldOrd	0000006584/STCK		52	100.000	200.000
	13.07.2009	IndReq	VSF			100.000-	100.000
	20.07.2009	PldOrd	0000006585/STCK		52	100.000	200.000
	20.07.2009	IndReq	VSF			100.000-	100.000
	27.07.2009	PldOrd	0000006586/STCK		52	100.000	200.000
	27.07.2009	IndReq	VSF			100.000-	100.000

Refresh the Capacity situation and check.

Planning Edit Goto Settings Environment System Help

Capacity Planning: Standard Overview

Cap. details/period

Work center: 0010M1 Mold 1 Plant: 0010
 Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22.2009	0,00	24,00	0 %	24,00	H
<input type="checkbox"/> 23.2009	0,00	120,00	0 %	120,00	H
<input type="checkbox"/> 24.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 25.2009	18,18	120,00	15 %	101,82	H
<input checked="" type="checkbox"/> 26.2009	30,55	120,00	26 %	89,45	H
<input checked="" type="checkbox"/> 27.2009	24,00	120,00	20 %	96,00	H
<input type="checkbox"/> 28.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 29.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 30.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 31.2009	18,18	120,00	15 %	101,82	H
Total >>>	163,64	1.104,00	15 %	940,36	H

Check that the load increases from 15% to 20% for the 27 th week and 26% for the 26 th week for Mold 1. And it increases from 15 %to 16% on the Common Injection Molding Machine 0010IM01.

Planning Edit Goto Settings Environment System Help

Cap. details/period

Work center 0010IM01 Combined Injection Molding mac Plant 0010
Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22.2009	0,00	168,00	0 %	168,00	H
<input type="checkbox"/> 23.2009	80,76	840,00	10 %	759,24	H
<input type="checkbox"/> 24.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 25.2009	122,94	840,00	15 %	717,06	H
<input checked="" type="checkbox"/> 26.2009	135,31	840,00	16 %	704,69	H
<input checked="" type="checkbox"/> 27.2009	128,76	840,00	15 %	711,24	H
<input type="checkbox"/> 28.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 29.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 30.2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 31.2009	42,18	840,00	5 %	797,82	H
Total >>>	1.001,73	7.728,00	13 %	6.726,27	H

Again increase the Quantity.

List Edit Goto Settings Environment System Help

Stock/Requirements List as of 15:31 hrs

Show Overview Tree

Material HALB1 CAP
Plant 0010 MRP type PD Material Type HALB Unit EA

A	Date	MRP e	MRP element data	Reschedul.	E	Receipt/Reqmt	Available Qty
<input type="checkbox"/>	29.05.2009	Stock					0
<input type="checkbox"/>	08.06.2009	PldOrd	0000006580/STCK		52	100.000	100.000
<input type="checkbox"/>	08.06.2009	IndReq	VSF			100.000-	0
<input type="checkbox"/>	15.06.2009	PldOrd	0000006581/STCK		52	100.000	100.000
<input type="checkbox"/>	15.06.2009	IndReq	VSF			100.000-	0
<input type="checkbox"/>	22.06.2009	PldOrd	0000006582/STCK		52	100.000	100.000
<input type="checkbox"/>	22.06.2009	IndReq	VSF			100.000-	0
<input type="checkbox"/>	29.06.2009	PldOrd	0000006579/STCK		52	600.000	600.000
<input type="checkbox"/>	29.06.2009	IndReq	VSF			100.000-	500.000
<input type="checkbox"/>	06.07.2009	PldOrd	0000006583/STCK		52	100.000	600.000
<input type="checkbox"/>	06.07.2009	IndReq	VSF			100.000-	500.000
<input type="checkbox"/>	13.07.2009	PldOrd	0000006584/STCK		52	100.000	600.000
<input type="checkbox"/>	13.07.2009	IndReq	VSF			100.000-	500.000
<input type="checkbox"/>	20.07.2009	PldOrd	0000006585/STCK		52	100.000	600.000
<input type="checkbox"/>	20.07.2009	IndReq	VSF			100.000-	500.000
<input type="checkbox"/>	27.07.2009	PldOrd	0000006586/STCK		52	100.000	600.000
<input type="checkbox"/>	27.07.2009	IndReq	VSF			100.000-	500.000

Check the Capacity situation

Planning Edit Goto Settings Environment System Help

Cap. details/period

Work center: 0010M1 Mold 1 Plant: 0010
Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22.2009	0,00	24,00	0 %	24,00	H
<input type="checkbox"/> 23.2009	0,00	120,00	0 %	120,00	H
<input type="checkbox"/> 24.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 25.2009	18,18	120,00	15 %	101,82	H
<input checked="" type="checkbox"/> 26.2009	103,27	120,00	86 %	16,73	H
<input checked="" type="checkbox"/> 27.2009	24,00	120,00	20 %	96,00	H
<input type="checkbox"/> 28.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 29.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 30.2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 31.2009	18,18	120,00	15 %	101,82	H
Total >>>	236,36	1.104,00	21 %	867,64	H

Again Increase the Quantity and check the Capacity situation.

List Edit Goto Settings Environment System Help

Stock/Requirements List as of 15:35 hrs

Show Overview Tree

Material: HALB1 CAP
Plant: 0010 MRP type: PD Material Type: HALB Unit: EA

A	Date	MRP e	MRP element data	Rescheduli	E	Receipt/Reqmt	Available Qty
<input type="checkbox"/>	29.05.2009	Stock					0
<input type="checkbox"/>	08.06.2009	PldOrd	0000006580/STCK		52	100.000	100.000
<input type="checkbox"/>	08.06.2009	IndReq	VSF			100.000-	0
<input type="checkbox"/>	15.06.2009	PldOrd	0000006581/STCK		52	100.000	100.000
<input type="checkbox"/>	15.06.2009	IndReq	VSF			100.000-	0
<input type="checkbox"/>	22.06.2009	PldOrd	0000006582/STCK		52	100.000	100.000
<input type="checkbox"/>	22.06.2009	IndReq	VSF			100.000-	0
<input type="checkbox"/>	29.06.2009	PldOrd	0000006579/STCK		52	700.000	700.000
<input type="checkbox"/>	29.06.2009	IndReq	VSF			100.000-	600.000
<input type="checkbox"/>	06.07.2009	PldOrd	0000006583/STCK		52	100.000	700.000
<input type="checkbox"/>	06.07.2009	IndReq	VSF			100.000-	600.000
<input type="checkbox"/>	13.07.2009	PldOrd	0000006584/STCK		52	100.000	700.000
<input type="checkbox"/>	13.07.2009	IndReq	VSF			100.000-	600.000
<input type="checkbox"/>	20.07.2009	PldOrd	0000006585/STCK		52	100.000	700.000
<input type="checkbox"/>	20.07.2009	IndReq	VSF			100.000-	600.000
<input type="checkbox"/>	27.07.2009	PldOrd	0000006586/STCK		52	100.000	700.000
<input type="checkbox"/>	27.07.2009	IndReq	VSF			100.000-	600.000

Capacity situation

Planning Edit Goto Settings Environment System Help

Cap. details/period

Work center: 0010M1 Mold 1 Plant: 0010
 Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22. 2009	0,00	24,00	0 %	24,00	H
<input type="checkbox"/> 23. 2009	0,00	120,00	0 %	120,00	H
<input type="checkbox"/> 24. 2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 25. 2009	18,18	120,00	15 %	101,82	H
<input checked="" type="checkbox"/> 26. 2009	121,45	120,00	101 %	1,45-	H
<input checked="" type="checkbox"/> 27. 2009	24,00	120,00	20 %	96,00	H
<input type="checkbox"/> 28. 2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 29. 2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 30. 2009	18,18	120,00	15 %	101,82	H
<input type="checkbox"/> 31. 2009	18,18	120,00	15 %	101,82	H
Total >>>	254,55	1.104,00	23 %	849,45	H

Here the Mold becomes overloaded 101 % . Now check for the combined Injection Molding machine.

Planning Edit Goto Settings Environment System Help

Cap. details/period

Work center: 0010IM01 Combined Injection Molding mac Plant: 0010
 Capacity cat.: 001 Machine

Week	Requirements	AvailCap.	CapLoad	RemAvailCap	Unit
<input type="checkbox"/> 22. 2009	0,00	168,00	0 %	168,00	H
<input type="checkbox"/> 23. 2009	80,76	840,00	10 %	759,24	H
<input type="checkbox"/> 24. 2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 25. 2009	122,94	840,00	15 %	717,06	H
<input checked="" type="checkbox"/> 26. 2009	226,22	840,00	27 %	613,78	H
<input type="checkbox"/> 27. 2009	128,76	840,00	15 %	711,24	H
<input type="checkbox"/> 28. 2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 29. 2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 30. 2009	122,94	840,00	15 %	717,06	H
<input type="checkbox"/> 31. 2009	42,18	840,00	5 %	797,82	H
Total >>>	1.092,64	7.728,00	14 %	6.635,36	H

It is still not overloaded. This is because it is having a combined weekly capacity of 7 machines i.e. $120 \times 7 = 840$ hrs.

In this way by doing proper Resource modeling at Client site we can do the capacity planning at Injection Molding Machine as well as Molds. Thus the customer's expectations are fulfilled.

Related Content

Reference (site) 1 – Capacity Planning

http://help.sap.com/saphelp_47x200/helpdata/en/8a/a5a3154adc11d189740000e8322d00/frameset.htm

Reference (site) 2 – Capacity Evaluation

http://help.sap.com/saphelp_47x200/helpdata/en/db/f2f33419ec8d44e10000009b38f844/frameset.htm

Reference (site) 3 - Production Resource Tools

http://help.sap.com/saphelp_47x200/helpdata/en/a5/63198843a211d189410000e829fbbd/frameset.htm

For more information, visit the [Supply Chain Management homepage](#).

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