

structura



The ERP solution for

Plastics processing

Scope Of Features

RGU Expert GmbH

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1 General introduction

structura is a modern software solution, especially designed for process production. It covers all business areas starting with sales and production planning up to procurement. *structura* uses the modern user interface, based on the Windows Standard, as the client/server system.

structura was developed for usage in medium-sized to group-sized companies. The system is multi-client capable.

structura is internationally competent. Parallel working in multiple languages and different currencies eases the co-operation in the era of globalization.

structura is a modular structured system. This structure enables a user-oriented application, which is highly customizable to every customer's needs.

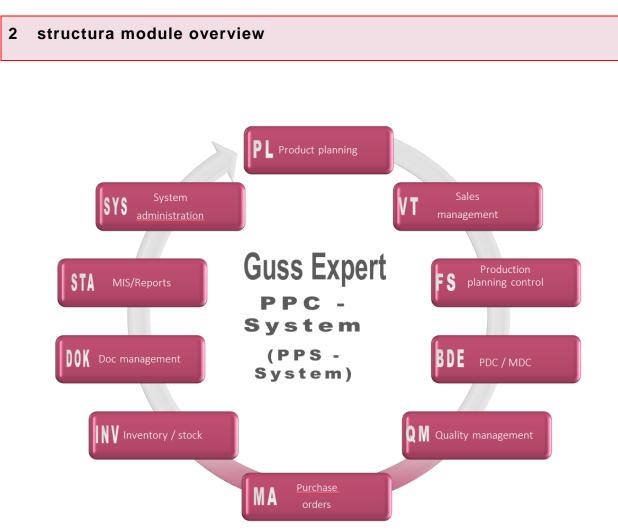
structura support a comprehensive report system base on the different modules.

structura is high-performing. The system support the user with a high-performing data base system and integrated text management an list generators, resulting in an easy operation despite it's high complexity.

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3 System administration

Comprehensive, customer-specific and system-overarching features are an integrated part in the *System Administration* module.

Access rights management

For guaranteeing the necessary transparency and system security, *structura* of fers management of individual users and user groups.

Access rights can be specifically assigned to individual users or user groups for



modules and programs in structura.

Parameter management

All daily business processes can be managed by using the so-called "*FIP*" parameters (Foundry Integrated Parameters), which are customer-oriented. By populating data fields, customer requests can be managed and incorporated without the need of extensive programming effort. Parameters can also be changed and added by the users themselves.

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Document management

Internal and external documents and files (e.g. pictures, technical drawing, MS-Office and PDF files) can be attached and saved using the *Document management system*. Further information see Chapter 7 Document management.

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4 Sales

All business areas are involved and business processes handled on the system level in the Sales module, starting with customer inquiry, quotation work and order processing up to invoicing. Sales communicates with *Production planning and control* for scheduling and *Product planning* for the costing of quotations and orders.

Scope of features

- Quotation management
- Order management
- Dispatch management with dispatch papers and the management of empties
- Invoicing
- Credit note management
- Complaint management
- Up to date customer master data
- Up to date of representative master data
- Price tables and standard prices
- Commission accounting
- Collection of form design layouts for company-heads (can be integrated)
- Evaluation and reports (with possible future additions)
- Comprehensive information system with connection to other modules
- EDI
- Quantity variants

Customer master data dialogues

Comprehensive information can be entered and created in the *Customer master data*.

The creation of multiple addresses (invoices address, delivery address etc.) and contacts can be done in a practical way, as well as the pre-determination of costing data and the management of customer-specific price tables.

The data created in the *Customer master data* is transferrable and can be used in all the other modules of *structura*.

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Customer data - Addresses (Delivery and invoices addresses)

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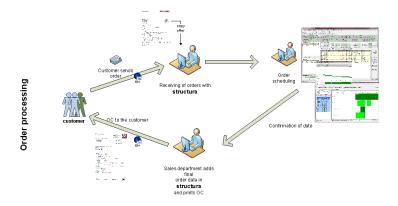
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Order management

Process of booking of orders, check of schedule and order confirmation



Example route of receving orders, checking of schedules and order confirmation

Individual and framework orders can be managed in *structura*.

In accordance with customer's procurement order a planned order is created in the *structura* system. Customer number and procurement order date and others, are basic data that is entered in the order header data. Each article of equipment of an order gets an own order item assigned. Order items contain, among other things, the requested quantity of articles, the requested date and the confirmed delivery date.

The following shows a few example dialogues of the order managing process in *structura*. Example dialogues for scheduling are covered in chapter *Production planning*.

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Order management in an example

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Order header- Possible input of pre-defined text blocks and internal/external texts

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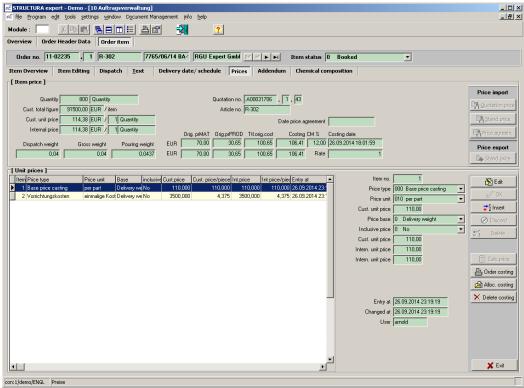


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structura – The ERP solution for Plastics processing

Order items - delivery schedule with quantities and deadlines

Incoming order schedules with EDI system can be viewed in the tab "EDI-View".



Order items - Prices

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Print of order confirmation

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Delviery notes, Invoices, Credit notes, Complaints

The creation of delivery notes, invoices and credit notes is based on the order data.

An interface for transferring invoices and credit notes to Finance and Accounting software can be created for any such software.

Capturing and evaluation of internal/external complaints with multiple defect reasons is also part of the *structura* system.

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Extract of a weekly dispatch schedule (example)

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Production order	r I I Partial delivery Booked 4/11 //80/06/14-	Soventoi
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Delivery note items

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Delivery note for empties (transferred from the master data, but can still be changed)

RGU expert Gm	DH	Schweir 97080 1 Telefon Telefax e-mail: i	kpert Gmb H nfurterstræsse 25 Wildraburg I: +49 (0) 931 / 30980 - 0 I: +49 (0) 931 / 30980-22 info @rguexpert.de age: uwur.rguexpert.de	RGL
RGU expert GmbH · Schweinfurterstra	le 25 · D-97080 Würzburg			expe
RGU Expert GmbH Schweinfurterstr. 28 97076 Würzburg	C	elivery address:	RGU Expert Gmb Schweinfurterstr. 97076 Würzburg	
Tel.: 0931-30980-0			Tel.: 0931-30980-	0
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		secure with date of 5		
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Model-No.	: 4711			
Drawing-No. / Drawing i	ndex: 8976		Date: 0	
Delivery condition	:			
Agreement to take	: None			
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Banken Volksbank Würzburg	Sparkasse Würzburg	Geschäftsführer Stefan Throm		TÜV
BLZ 684 922 00	BLZ 684 522 90 Konto-Nr. 07-002 678	Amtsgericht Wür UstId Nr. DE 25	zburg HRB 701671 57304457	GERT
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Example of a VDA-Label (Packaging slip)

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
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5 Product planning

Work and method plans are the base data for costing and production planning and are managed here in the module called *Product planning*.

A method plan will always be created without reference to a production order.

Work and method plans list and describe the necessary work steps and sequences for the production of the article.

Characteristics, like weight and overall production time, will then get assigned to each article for costing.

Scope of features of Product Planning

- Master data for work steps, for machines and machine groups, pattern and equipment management
- Deep knowledge data base, characteristics, tables and formulas
- Article master data including characteristics and technical specifications
- Method plans and characteristics
- Article master card
- Quotations for costing
- Orders for scheduling
- Management of technical drawings
- Pattern and equipment master data
- Pattern and equipment for costing

Article master data

All necessary data for costing and working documents are created in the *Article master data*.

Existing technical drawings plus revision can be attached for each article in a document history, for which a document management system can be used. The *Article master data* also allows for entering instructions, technical specifica-

tions and internal/external texts.



	Demo - [58 - Article master data] ools settings window Document Management info help	
erview Article n	aster	
Article no. R-0	00 Similar article C Pr Display zum Präsentieren Mode:	[E dit]
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Article master data - Gerneral data

Method plan

The *Method plan* is created without reference to a production order and serves as the base for costing. The method plan contains all work steps, sub work steps and materials, which are required for production.

Existing method plans for similar articles can be duplicated, as well.

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Example of a method plan for injection moulding, machining and assembling

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10011110	10011110	10011110	10011110	10011110	10011110



Costing

Finally, costing for an article can be done after the creation of the method plan, entering characteristics, machine cost rates, material recipes and costs and the entering of surcharges.

Cost can be summed up in multiple pool of costs.

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Costing for different quantity and article variants

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10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



Print preview of costing

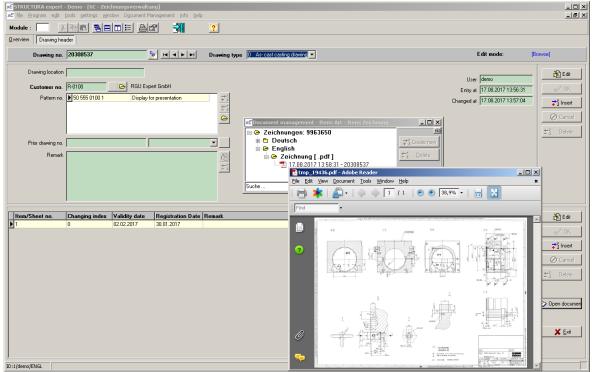
Article no. + variant Designation	R-302 / std 7765/06/14 BA-Soer			Validity of	ate costs	26.09.2014		
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Pattern no. Customer article no.	4711					1 - F		
Customer article no. Customer	R-0100 RGU Expert	Gmb				• 7 • 7 •		
Material	R-0001 PStranspare					• ~ •		
Drawing no. + Revision	001-1009R 0					• •		
Delivery weight	0,0398							
Gross weight	0,0398							
Moulding line	general							
Article family	general							
Lot size	600							
Lot size set up	600							
Classification								
Colour	white	Length		126 mm				
Material thickness	1,0 mm	Width		234 mm				
Work/Mat. Designation	<u>1</u> !	Machine	Qty./time	Setup time	<u>Unit</u>	Cost rate	Prop. costs	Total costs
10809 Holzkiste 11	96×1196×610 mm IPP	c	1,0	0	piece	70,00	70,00	70,00
Subtotal 00 - Material							70,00	70,00
R-0105		R-103		100,00	min	1,60	0,27	0,27
R-0004		R-103	12,0	0	min	1,50	18,00	18,00
Sub total 04-Forge/Dra	w						18,27	18,27
R-0104		R-100		45,00	min	0,58	0,04	0,04
R-0001		R-100	10,0	0	min	0,58	5,83	5,83
R-0104		R-101		30,00	min	0,58	0,03	0,03
R-0002		R-102	10,0	0	min.	0,58	5,83	5,83
R-0003		R-104			min	1,08		
R-0003		R-104	0,6	0	min	1,08	0,65	0,65
Sub total 10 - Mechanica	al						12,38	12,38
Total					min		100,65	100,65
Scrap		0,00 % von	94,8	2 EUR			0,00	0,00
Total production cos	ts	39,55 % Materi	ial 2528,8	9 EUR/kg			100,65	100,65
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-				5 EUR 8 EUR				1,53 2,13

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10011110	10011110	10011110	10011110	10011110	10011110



Drawing management

Different types of technical drawings (As-cast drawing, finished part drawing, premachined drawing..) and their revisions for articles can be managed and documented in the *Drawing management*.



Drawing management

Pattern management

The management of all important equipment data, like number of cavities, interchangeable inserts, number of shots can be entered in the *Pattern management*. A equipment number is assigned to each article.

The *Pattern management* also allows for documenting all transactions, like changes, repairs and maintenance.

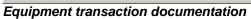
010011	1011010011	1011010011	1011010011	1011010011	1011010011
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10011110	10011110	10011110	10011110	10011110	10011110



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Pattern no. 50 555 0100 1	Display for presentation		Editing mode:	[Edit]
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		7.08.2017 10:20:28 17.08.2017 10:20:28	demo 1 Yes	
Items Transaction				
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Description Display for presentation	Limit mould no.	11041/001	17.08.2017 10:20:28	
Alternative description Display for presentation	Total mouldings		17.08.2017 10:20:28	<u> </u>
Marking 50 555 0100 1	Perc. of mouldings [%]	0		, ‡ r [insert
Construction mat. 3001 Die-Steel	· · · · · · · · · · · · · · · · · · ·	Pattern plate type 0002	Plate G II	🖉 Discard
Pattern status 0010 Pattern ready	Time for pattern m	aking 0 Bottom no.		±: Delete
Pattern active 1 Yes		te-no.		T Delete
Pattern storage location 0001 none				
Core box storage locat. 0001 none	Storage area			
No. mould joints 0				
Loose parts 0				
Gates 0				
Gauge 0		Reason		
Core boxes 0				
Template 0				🗶 <u>E</u> xit
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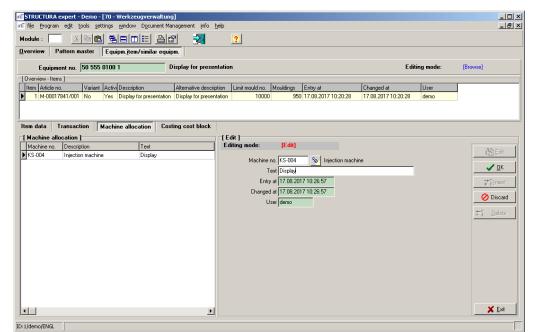
Equipment item data

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Pattern no.	50 555 0100 1	Display for	presentation			Edi	ing mode:	[Browse]
verview · Positions]	(- (I-	[m	<u>[</u>		
	Description Display for presentation		imit mould no. Moulding. 10000	s Entry at 950 17.08.2017 10:20:28	Changed at 17.08.2017 10:22:31	User demo	Pattern active	
ns Transaction	.el							
Date	Reason	Remark			Entry at	Changed at	User	💦 Edit
17.08.2017	Pattern blocked	Blocked for testing only			17.08.2017 10:22:31	17.08.2017 1	0:22:31 demo	QK
								⇒5 Insert
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								<mark>⊉ insert</mark> ⊘ Discard



010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110





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Allocation of machines to equipment

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



6 Production planning

The base of *Production planning* module is the method plan, which is created in the Product planning module. In the *Production planning* module production orders are generated from incoming sales order. Production can be generated manually, if needed.

Each production order gets a production work plan, on the basis of the method plan, assigned. A production lead time can be calculated incorporating utilization and parallel work steps.

Feedback of each work step in production then lowers the utilization of production.

Scope of features

- Shift calenders
- Capacity utilization
- Graphical display of the utilization profile
- Management of production lots
- Management of production orders
- Printing of working documents
- Work step feedback
- Scrap management and evaluation
- Import and processing of PDC (Production Data Capturing)
- Feedback information

Capacity management

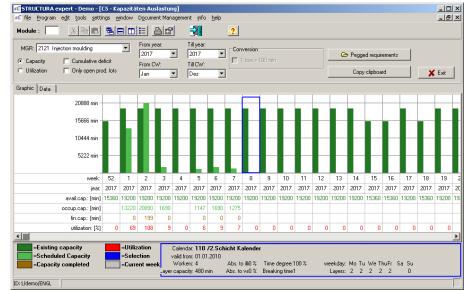
Comprehensive planning of existing machine and personnel capacity results in a detailed scheduling of production orders, which is all managed in *Capacity management*.

Scheduled capacity is shown for a time period of one week.

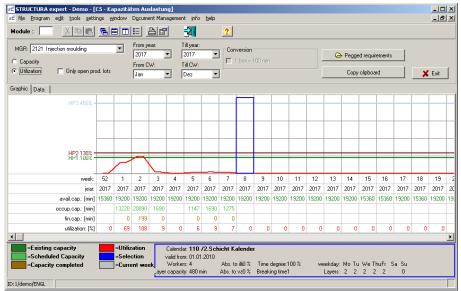
An example of the graphical capacity and utilization display is shown below:

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110





Exemplary display of capacity of a machine group



Exemplary display of utilization of a machine group

Production orders/Lot division/Scheduling

Production orders are automatically created from a sales order. Production lots can be created equally to customer requested delivery lots or split and combined arbitrary for individual orders.

Another possibility is using the "Article account" and apply scheduling in regard of existing production orders, current stock and existing sales orders.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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Module : 📉 🕺 🖻 💼 🔁 🖬 🛐 😗 😗	
Dverview Prod. order Prod. order lots	
Prod. order no. IF11-00149.001 Customer no. 0000 Customer no. Customer no. Edit mode: Edit mode: <t< th=""><th>t]</th></t<>	t]
General Dispatch Texts Plan	
Manul. proc. 0 General (material, additives) • Article family 0 General • Status: Changed at User Ordered Schedult Accep. toleran Dispatch wght, [kg] 0.0338 2 weighted • 23.06.2014 16.42.33 amold Poured Dispatch re: Scrap • 0 0 0 Gross weight [kg] 0.0338 2 weighted • 23.06.2014 16.42.33 amold •	Cancel
Casting weight [kg] 0.0437 1 calculated 23.06.2014 16.43.09 annold Order type [F] Inhouse production Cust. article descr. Display full'Softwarepräsentation Call order 1 Yes Description Display zum Präsentieren von CDs Changing index 23.06.2014 16.27.37 Call order 1 Yes	_] Delete
Qty. of nests/mould 0 Casting-Length (mm) 0 S • Material no. R-0001 Qty. of cores 0 Casting-width (mm) 0 S • Share of mould 0 Casting-Height (mm) 0 S • Drawing no. int. Avg. wall thickness (mm) 0	
Moulding box type Image: Constraint of the sector of the	
Max. daily lot size (Pc) 0 Scrap machining% 0 Casting Signature T Casting date Day/Month/Year 💌	Exit

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Example of an internally created production order

Scheduling of individual orders in compliance with delivery plans

STRUCTURA expert - Demo - [D5 - Terminie	rupal			-0)
	Document Management info help			
		<u></u> 1		
Module : 🚺 🔏 🖶 🛄		?		
Overview Scheduling Graph. lead time	sched. Gantt-diagram			
Prod. order no. IF11-00149.001 😂	Order type IF Inhouse production	n 💌 Dispatch wei	ight 0,0398 Gross weight 0,03	398 Status 3 Scheduled 💌
Customer no. 0000	Purch. order no.	Pouring wei	ight 0,0437 Ret. scrap wght. 0,00)39 Del. sched. order 1 Yes 💌
Article no. B-0100	Description Display zum Präsentier	ren von C No. pattern/mo	ould 0 Max. daily lot size	0 Entry at
Pattern no. 245-14	Material no. R-0001	% Scrap machin	ning 0 % Scrap casting	0 Changed at 17.08.2017 11:05:30
[Lot overview]	[Lot information]			10
Lot Date Piece Status	Lot no. 1 Start date	e 22.08.2017 Lot type 0 Se	erial delivery Poured 0	Changed at 17.08.2017 11:11:
1 25.08.2017 500 Scheduled	Piece 500 End date	e 25.08.2017 Status Scher	duled Rdy. for delivery 0	Entry at 17.08.2017 11:06:
	Mode: schedule Need item	n 0 Start date 17.08	.2017 11:11:42 Scrap 0	User demo 🖉 Reject
	Sched. dates Scheduli	ling 📑 Sub order/BOM		
	Start End Trans. per Ove	erl, time Davly lot Utili,% Nee	ed% Seg Process Description	Machine Unit F Start date
	▶ 25.08.17 25.08.17 16	0 0 0,00	0,00 90 R-0008 Ready for dispatch	Assembly min End set up
	24.08.17 24.08.17 2	0 0 0,00	0,00 70 R-0006 Glue on rubber base	Assembly EUR/Stú End mach.
	24.08.17 24.08.17 1	0 0 0,00	0,00 60 R-0005 Glue hinges	Assembly EUR/Stu
	24.08.17 24.08.17 2	0 0,00	0,00 50 R-0003 Lasern	Laser min Cancelation
Tinsert Delete	24.08.17 24.08.17 1	0 0,00	0,00 40 R-0002 Sawing	Belt saw min
[Delivery lots]	22.08.17 24.08.17 4		0,00 30 R-0002 Sawing	Circular saw min 🛨 Delete
Lot Date Piece Prod.plan. d	22.08.17 22.08.17 0		0,00 10 R-0004 Pulling	Big pulling machine min
	22.08.17 22.08.17 0	0 0 0,52	0,52 5 KS-400 Injection moulding	Injection moulding mac min
	22.08.17 22.08.17 0	0 0	1 R-0001 PS transparent	kg C All works © Open ones
				Reschedule
				Ext. process.
				01 A
Ord.no.item				
Status				
				× Exit
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Example of basic scheduling

Scheduling module using the article account

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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Overview Schedule header Schedule ite		_						
[Disposition-header data]								
Schedule no.	Status 0 Record	ied 💌					Editing mode:	[Insert]
Procurement indic. 0 Inhouse produc	tion 🔻 [Determin	e type of schedul	e]					🗟 Edit
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	Verbrauc	chsgesteuert	Period in weeks	12 into the	e past			·
Changed at						1		‡7∰ [nsert
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Article no. Description 1	Pattern no. DN 500 / AT 200 F HG	Type of disposit F		level Max.: 0			ekly deman Demand pe 🔺	1 ()
▶ 12 0003 0051 1 Hintergehäuse AT 200 Feststoff 12 0016 0003 1 Hintergehäuse AT100 S HG	DN 500 / AT 200 F HG	demand-driven demand-driven	0	10	0	0	0	Check workplan
12 0016 0005 1 Hintergehäuse AT 100 S Hd	DN 1507AT 100 S HG	demand-driven	15	10	0	0	0	
12 0016 0007 1 Vordergehäuse AT 200 S	DN 125 / AT 200 S VG	demand-driven	15	10	0	0	0	1
12 0016 0013 1 Vordergehäuse AT100 S	DN 150 / AT 100 S VG	demand-driven	15	10	0	0	0	
12 0016 0016 1 Vordergehäuse AT 200 S PN16	DN 200 / AT 200 S VG PN16	demand-driven	15	10	0	0	0	
12 0016 0017 1 Hintergehäuse AT 200 S PN16	DN 200 / AT 200 S HG PN16	demand-driven	15	10	0	0	0	
12 0016 0018 1 Vordergehäuse AT 200 F	DN 300 / AT 200 F VG	demand-driven	15	10	0	0	0	
12 0016 0019 1 Hintergehäuse AT 200 F	DN 300 / AT 200 F HG	demand-driven	15	10	0	0	0	
12 0016 0022 1 Vordergehäuse AT 200 Standard	DN 150 / AT 200 S VG	demand-driven	15	10	0	0	0	
12 0016 0027 1 Vordergehäuse AT100 S	DN 200 / AT 100 S VG	demand-driven	15	10	0	0	0	
12 0016 0028 1 Hintergehäuse AT100 S	DN 200 / AT 100 S HG	demand-driven	15	10	0	0	0	
12 0016 0031 1 Vordergehäuse AT200 S	DN 065 / AT 200 S VG	demand-driven	15	10	0	0	0	
12 0016 0032 1 Hintergehäuse AT200 S	DN 065 / AT 200 S HG	demand-driven	15	10	0	0	0	
							Þ	🖌 🔀 <u>E</u> xit
-1 SOL 1								
Article overview Delete not registered production lots	Redispose UE-stock in current week	Automatic proces	\$					
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Creation of new production schedules

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Module : 💦 🕅 📾 📾 🖽 🗮 🔮		
Overview Schedule header Schedule items		
[Article overview]	[Plann. order overview] [Pegged requirement]	
Article no. Description 1 Pattern no.	CK Date Quantiti Planning ord Status Prod. order item 🔺 Item/Quantity Date Order no. Item Lot Ordered deliver	ed Pn
W-101042-1 Halter APS VAL AU33X KS-0262	201705 01.02.2017 13454 P-00000640 Scheduling dc 11-02258.001	0
	201706 10.02.2017 20000 P-00000641 Scheduling dc 11-02260.001	
	201707 15.02.2017 15000 P-00000642 Scheduling dc 11-02258.001	
		▶
	[Controlling] [Edit plann. order]	
	Editing mode: [Browse]	
	Article no. W-101042-1	
	Date 01.02.2017 Prod. order item 11-02258.001	
	Guarny 19434 Lot no. 1 47 p. r	
	Print capacity utilization in protocol Planin. Uter no. Protocol Order proposal no.	
		ut
	Disposition level 0 Order item	
	Entry at 22.12.2016 14:25:10 Order	
	Changed at 22.12.2016 14:31:06 × Cance	lation
	User amold	at
ID:1/demo/ENGL		

Overview of production order and demand producers

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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📧 STRUCTURA expert - Demo - [65 - Scheduling data]	
sE file Brogram egit tools settings window Document Management info belo	
Nodule: State Bennie Bar 📲 ?	
Overview Article schedule data Account - Overview Account - External processing	
Article no. 8-0100 II 4 b b Podoction stock Aquisition stock	
Description Display zum Präsentieren von CDs Inventory Stock Date User Inv. Stol	- 1
Unit st Quantity V Cating inventory 3000 03.08.201713.45.45 demo	
Schedule inde. T Demand driven scheduling Updatch inventory 498 (2709.2014.13.2357) amold 12 (2018.2017.14.31.31) demo	
Recorder level Min. order qty. FF Freier Bestand 0 0308 2017 135617 demo	
Safety stock 0 Max.ord.qty.	
Max stock 0	
Procurement period(weeks) Sched weeks 8 B	
Weekly demand 0 Free cycle 0 K	
Account Overview [] Veekly overview [Inished atticles Overview gross atticles	
Week Bequijement Planned order P-Order Ordered available	
33 2014 0 0 3000 0 3498	A
49.2015 17998 0 14500 0 0	
	F
ID:1/demo/EMGL Korko-Ubersicht	

Display of the "Article account"

Detailed planning - Planning board

Based on created production orders and defined shifts, a detailed planning is possible. The order of planned production orders for each machine is visualized in a Gantt diagram.

<pre>structura expert - Demo - [DT - Tagesplanung]</pre>	
sE file Program edit tools settings window Document Manageme	ent info help
Module : 🗾 🔏 🖻 🕮 🔚 🖼 🖴 😭	- <u>?</u>
Overview Day.sched. Graphic- Lead time with utilization	
Plan.board no. 601 Kunststoff Spritzmasc Date 15.05.2015	5 ▼ < > Shift Early shift 🕒 < ▶ 15.05.2015 05:30:00 - 15.05.2015 14:00:00 CW 201520 🗙 Exit
Shifts Daily sched.	
Customer 🗽 🗸 Search	Shift schedule Plan.board
Date from 23.04.2015 V to 12.06.2015 V	✓ Modus: ● Anzeigen O Ändern O Verschieben Terminierung: O Rückwäits O Mittelpunkt ● Vorwärts
[Filter] Machines	Datum: 17.05.15 18.05.15 19.05.15 20.05.15
Worksteps V	8:00 16:00 8:00 16:00 8:00 16:00 8:00 16:00 16:00 16:00
🔽 Incorp. pces. in day. sched 🔲 Mix. frames only 🔽 Darg&Drop	11-02231.0010101.1
Check avail. pieces Prod. orders only Split W Customer Art. no. Plan. date Piece Qtyred Qty. d Q	
W customer parcino. Fran. date Prece digitite digit. d d	9001 B0Y90
	9002 ARBURG 570 S
	KS-001 ARBURG 570 H
Worklist prod.orders	🖌 Save plan. board data 🔗 Discard plan. board data Timebase in days 10 🜩 Days backwards 2 🜩 🔽 Fill autom. 🕻 Exit
workinst produciders	

Scheduling of production orders with the help of Daily scheduling

Production work documents with special work instructions, as well as single working papers, can be created with the help of *structura*. Customization according to customer requirements is doable anytime with the help of a form generator.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011 10011110	10001101011 10011110	10001101011 10011110	10001101011 10011110	10001101011 10011110	100011 10011110



structura – Th	ie ERP so	lution for	Plastics	processing
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EMO	DEMO Work instruction – Dispatch ready/193001 Dispatch										
Customer:				uction order 11-02231.001	/lot 5	Serial			qu.Works KS-009	step	
Article no. : ks 0106 Article des : Cassette Pattern no. : 00043315 Drawing no. : Acceptance: none			Gross Delive	ial: ng weight weight ery weight f. Process	: 4 estm. : 4 estm. : 4 estm. : Injection	mo ul din g		c	Quantity Ordered Prod.lot	: 10290 : 3500	
Cost centre Wage grp. Machine grp.	: : 2121	Standard time Set up : 0 Prod time : 5		Method plan of work step To work step	: K :	S-003	Assembly		Deadli 27.11.2		
Order/item/Prod lot/Sequ 11-02231/1/5/60	1.:	BARCODE:	225125								

Pers. no	Name	Date	Quantity	Actual time	G/N/ A	Reason Nr. Text	Superv.

Example of work instructions

L	Daily schedule						Date: 29.06.2017 User: rex
			Mac	hine: SPC	50		
			Planning b	oard no.: li	njcetion 5		
M-00478/001							
Equipment/Com	bi 6180003K1	KK1	Cavity Pa			eight (kg)	
Injection moulding equipment	1180003 180003K01		4 BV	VTS 5303 10	1 4965	0,4	
Period from 04.1	2.2013 05:30	:00 to	04.12.2013 15:39	:24			
	Term&Con	dit.	Planned qty.	Plan.cycle	s		
	Set up						
	Produce		668	16	D.674T 67	267,2	\$.575T
	Work instr 180003K01		I.				5.9751
	Set up	see	AA-6180003 K1	-C			
	Production	see	AA-6180003 K1	-c			
M-00479/001							



Feedbacks - PDC and optional MDC

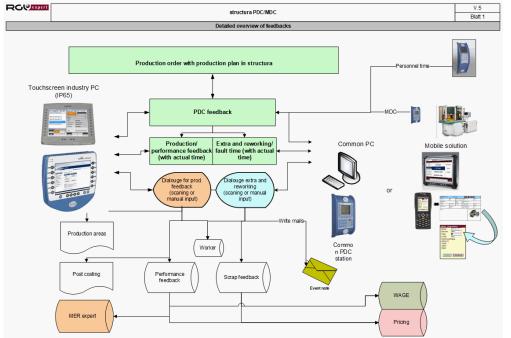
Capturing of feedback of tasked work steps can be done in multiple ways and customized for every company.

Multiple options exist for entering data at a PC, PDC station or via an barcode scanner.

This feedback is used for lowering current machine utilization and information of the current production and order progress.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110





structura – The ERP solution for Plastics processing

Feedback information integration for PDC/MDC in structura

As shown in the above overview, feedback-stations are possible in multiple locations in the system and feedback can be entered on a normal PC workstation, on Touch-screen and even mobile devices.

Following feedback stations might be of importance in production (detailed specification is decided on by each company):

- Feedback on equipment delivery (including admission and withdrawal of equipment from a warehouse)
- Feedback on delivery of production materials including pre-heating of each material (automatic system feedback)
- MDC (Machine Data Capturing) and evaluation of injection moulding machines for monitoring production cycles and production and fault times
- Management of external processing using the *structura* system (Feedback on transport of material)
- Optional feedback of further work steps by the system, e.g. testing and assembling, end of production with determination of produced quantities via counting scales (connection of counting scales has to be checked)

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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Module : X 🖻		E 86 🐔	?		
Overview report Edit rep					
Document no.	53251	Report type N Norn	nal feedback 💌	Mode:	(Edit)
Barcode-no.	227967		Record data status	0 not booked 💌	👸 Edit
Production order no. 11-	02257 💊 🕞		🕞 Entry at	21.12.2016 11:01:45	ок
PO Pos.: 001	·		👝 Changed at	21.12.2016 11:01:45	UK
Lot number 01			User	bde	⊋1§ Insert
Seq. 🚺	30 📎	kg gross weight		Period Planned	🖉 Discard
Work step no. KS-	-001	Spritzen	Setup	0 0	
Cont. cast no.	\$		Edit	0 0,083	±¶ Delete
Date 21.		Poured	Time edited from	unti	
Piece		Manufactured 2360	Pause time	0	
Personnel-no.	<u>></u>		Batch no.		
_			Production ID	_	
Remark GX-	Belegni 15		Article no. from	until	
			Week no.		
Warehouse Stock Date	e User	InvStock InvDate	Sample no.	Quantity	
			Equipment	M-00017840/004	
					🗶 Exit
:1/demo/ENGL					

Standard feedback in structura

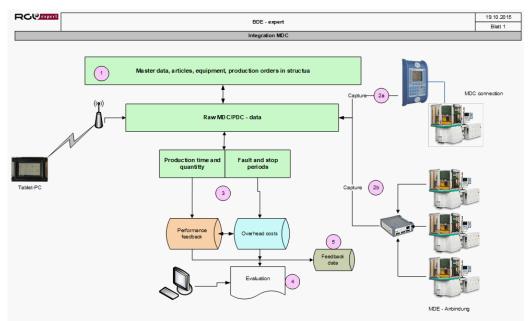


Example of feedback dialogue on a touch screen

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



MDC integration



The following shows an exemplary integration of MDC data in structura.

MDC integration

All master data is already present (#1) since MDC is already an integrated part in *structura*.

Solution #2a: A PDC terminal is assigned to every machine. These terminal are used for starting production orders. The PDC terminal captures the MDC signals (machines with time stamps) and saves them in the raw MDC/PDC data. Upon a new production process, a signal will be send. The PDC terminal send a fault signal, if the standard production time is exceeded (optical solutions using LED lights work as well). The worker then has to enter a fault reason and the machine can be cleared for production again.

Solution #2b: The production unit are connected via a IO-BOX V4 to a network. Starting and ending of the production order and machine allocation is done on a tablet PC with a touch screen. The IO-box V4 capture the MDC signals (machines with time stamps) and saves them in the raw MDC/PDC data. Upon a new production process, a signal will be send. The PDC terminal send a fault signal, if the standard production time is exceeded (optical solutions using LED lights work as well). The worker then can use the tablet PC to enter a fault reason and the machine can be cleared for production again.

Started production orders and the raw MDC data are joined on a time axis. PDC production and fault notes are generated from this (#3).

The system offers a variety of evaluations and it's own reporting tool allows for the creation of own evaluations and reports (#4).

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011 10011110	10001101011 10011110	10001101011 10011110	10001101011 10011110	10001101011 10011110	1000110 10011110



Menu options on a PDC terminal for feedback (Example for #2a)

The menue can be individually configured by RGU Expert. The assignment of buttons (F-buttons) with special functionality improves the operation for the worker.

	Main	n menue		
	Demo Demosystem	254 19.10.15, 11 tmenü	:58	F6 End
F1 Info	Info	Ende Justage	6	Alignment
F2 Start set up	Start Rüsten	Störung	0	F7 Fault
F3 End set up	Ende Rüsten	Nester schließ	60	F8 Close nests
F4 Start production	Start Produkt.	Nester öffnen	6	F9 Open nests
F5 Start Alignment	Start Justage			

PDC terminal menue

Set up, production and alignment processes are created as start/stop messages. Pressing F1 shows information to the current order.

In this example, the production process starts with setting up the machine. The start message begins with a scan process of a bar code, input of an order number using the keypad or with the selection of a production order of the displayed list. The lead time of the production order starts with the start message "Set up".

	G up time Start Set up	-
F1	Select order	F6
	Demosystem 30.06.15, 10:01	
F2	Start Rüsten	F7
	Auftrag wählen	
F3	B15-00301	F8
	A15-00222	
E1	A15-00223	
F4	B15-01000	F9
	GAbbruch OOSelekt RAuswahl	
F5		F10
	0000	

Selection of production orders

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



faults

structura – The ERP solution for Plastics processing

Machine

Every product and order has a pre-determined cycle period assigned to it, which is send to the terminal via the start message "Production". A fault signal is send out, when the cycle period exceeds a certain waiting period. The PDC terminal will then switch to the fault setting and awaits the input of a fault reason. Faults are visible, when the connected LED lamp switches from green to red (down time). Bigger lamps can be connected as well, which is why a own port is already integrated in the PDC terminal. Fault time periods and reasons are documented in a feedback table and can be analyzed later on.

	Demo Fault F7 254
	Demosystem Select Fault 19.10.15, 12.01
	Störung
	12 Störung wählen
F1 End production	Ende Produktion
F2 Maintenance	@Wartung
F3 Electric.repair	BELektr.Reparatur
F4 Mech. repair	Mech.Reparatur
F5 Cleaning	🔁 Sauberfahren 🗸
	EstAbbruch OSelekt EAuswahl

Example of fault selection

Fault reasons are parameters in *structura* (MDC) and can be individually adjusted.

Aboves input "End production" can be selected at the end of production and the equipment can be taken down.

Menu options on a tablet PC for feedback (Example for #2b)

The menu on a tablet PC can be designed for an easy and clear operation of the required features.

Selecting a task, e.g. "Injection moulding", can be done after the worker's log in. Then a machine for this task can be selected and finally the feedback program like normal feedback, fault feedback or work list.

The set up and production process are designed as start/stop messages.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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		Fault Feedback
		Work list
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Do 29.06.17 12:34		VM-ARNOLD-EC/00aaa

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Menu on a tablet PC and start of production

Just like in the PDC solution #2a, the production is designed as start/stop messages. The production starts with selecting a production order on the display (see below), input of an order number or via a scan process of a bar code. Cycle periods of connected MDC connection start with the start message for production and the system starts counting the machine cycles. This process can be interrupted, if a machine fault occurs.

Max, Müller	Laser			1	
Part	Description	Amount	Done	Begin	
R-0100	Display zum Präsentieren v		14	08.12.15	
R-99999	7785/06/14- Soventol	505		21.03.16	
R-99999	7785/06/14- Soventol	510		11.04.16	
					•
ok					discard
29.06.17 13:45			^	AV / VM-ARN	OLD-EC/0

Selection of orders from a work list

010011	1011010011	1011010011	1011010011	1011010011	1011010011
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10011110	10011110	10011110	10011110	10011110	10011110



7 Quality control system

The QM module in *structura* supports all QM requirements for a seamless integration in the production process. The QM module starts with the product planning, where specific product and process related target parameters are determined for test plans. This is the base requirement for the QM module and for production and test planning. Customer complaints can be captured and compared with production parameters as well.

Prompt feedback of processes requiring testing allows for a prompt recognition of deviations and mistakes in the production process. A comprehensive reporting keeps the status of test process up to date.

Interfaces to third-party programs for quality management are possible.

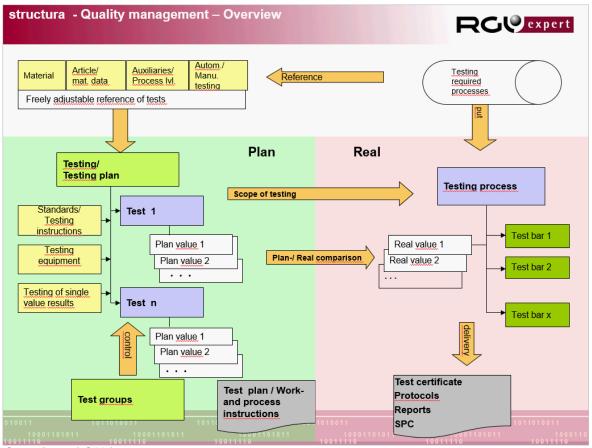
Scope of features

- Material management
- Management of norms and standards
- Production defect management
- Approval/blockage of production batches
- Management of chemical and mechanical test parameters
- Test plan management
- Creation of test certificates
- Complaint management

010011	1011010011	1011010011	1011010011	1011010011	1011010011
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Overview of QM features



Overview of QM features

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Test planning

Test plans consist of test values and test work steps. All values and steps are adjustable. Test plan are assigned to articles or materials and contain target values (min/max) to each test work step.

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0	030	A5	Elongation at breack	%	N4.1		Mechanical		
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Example of mechanical test values

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Test plan example

Warning ranges, minimum and maximum limits for test values can be defined for each test process data.

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6001 8 6003 8 6005 8 6015 8 6017 8 6017 8 6019 8	Härteprüfung Härteprüfung Kerbschlagwerte Kerbschlagwerte	ohne Angabe -20 °C -20 °C -20 °C	KV 1 KV 2 KV 3	J	0 0 0	0 0 0 12		0 Nicht bearbeitet 0 Nicht bearbeitet		🗶 Exit

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Example of mechanical test value capturing with actual test values

Test value can be captured using the actual testing equipment or data capturing and transferred into the system.

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Dialogue for creating test certificates

Test certificates are generally created for articles or orders. The system summarizes all relevant data for the test certificate. Here, texts and additions can be made.

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10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110

RG expert

structura – The ERP solution for Plastics processing

Werkszeugnis Test Report 2.2 DIN EN 10204

Seite/Page : 1 / 1

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RGU Expe	rt GmbH, Würzburg						Herst. Kennzeichen	Mark of the manufacturer	ιü.	
							Zeugnis Nr.	/Cert. No.	15-P20000	33
Metallbe	earbeitung						Zeug. Datum	/Cert. Date	27.07.2015	5
							Lieferschein-N	r. /Shipping No.	15-L \$0052	25
Im Gew	erbegebiet 12						LieferschDat.	/Shipping Date	26.02.2015	5
							WerkstNr.	/Material No.		
							Werkst-Bez	/Material Name	AlSi10Mg	(a)
Artikel-Nr.	rtikel-Nr. /Article No.		73				WerkstNorm	/Material Norm		
Artikel-Nr.	Knd. /ArticleNo.Cust.	873 153 05 05			Wärmebehand	llung	Gusszust	and		
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260115	9,3	0,29	0,01	0,16	0,36	0,002	0,00	0,01	0,01	0,00	80,0	

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	100011
10011110	10011110	10011110	10011110	10011110	10011110



Complaint management, 8D-Reports

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Overview of complaints in the complaint management

STRUCTURA expert - Demo - [MODUL 40_APPS Reklamationen Vertrieb]								
Module : X Complaint header Complaint items								
Complaint no. 11-00543	Status 0 Recorded	▼ from 04.08.2017	Editing mode: [Edit]					
Customer data Customer no. R-0100 S RGU Expe Complaint addr. R-0100 S Customer contact person Customer complaint no. Cum. yearly rev. 0 EUR Customer credit Value crdt.note 0	Name 1 RGU Exper Name 2 Street Schweinfur	terstr. 28) Würzburg		Clearance for - QN				
Complaint data Complaint date 04.08.2017 V Complaint form 0 Via letter Internal costs EUR External costs EUR	Manuf. site			Cencel clearence				
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Complaint header data

010011	1011010011	1011010011	1011010011	1011010011	1011010011
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structura - The	e ERP solution	for Plastics	processing
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Complaint item data

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Document management

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10011110	10011110	10011110	10011110	10011110	10011110



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structura – The ERP solution for Plastics processing

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-6D Implementation of activities and monitoring effects		
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8D report dialogue





Example of an 8D report

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8 Aquisition and material management

Stock, storage areas and prices for inventory managed articles are managed in the *Aquisition and material management* module in *structura*. The module offers dialgoues for capturing stock ingress and withdrawal.

Incoming invoices can be captured with *structura* and transferred to a finance and accounting system.

Invoice data can be used for the automatic creation of transfer prices subject to change.

The *Aquisition* part of the module manages master data of suppliers with corresponding supplier price lists and article master data for procurement articles.

Scope of features

- Supplier master data
- Procurement article master data
- Inventory and account management
- Stock management
- Consignment stocks
- Immediate consumption
- Inquiry management
- Purchase management
- Pricing for prices subject to change
- Management of standard prices
- Stock ingress
- Stock withdrawal
- Invoice control
- Article information
- Interfaces to third-party finance and accounting solution

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10001101011	10001101011	10001101011	10001101011	10001101011	1000110	
10011110	10011110	10011110	10011110	10011110	10011110	



Supplier master data/Article data

In the *supplier master data* all global supplier data is documented. The master data includes information about addresses, accounts and further specifics like branch, revenue classification, currency and tax type.

The *article data* documents all important data for procurement articles. It offers the options of creating internal and external texts.

Allocations of articles to specific suppliers is possible and each supplier may have their own price tables documented. Upon opening the article data, information on current and open order stock and value is displayed immediately.

Articles for costing are assigned to corresponding pool of costs and the costs for the costing is documented.

STRUCTURA expert - Demo - [NO - Supplier master data] E file Program egit tools settings window Document Mana	gement jufo beb	
Overview Supplier data		
Supplier no. 555 555 55 📝 🖂 🕨 👀	Search name REX	
Address Classification Bank account Delivery ad	dress All articles of supplier Supplier assessment Contact person	
Short name REX	Entry at 18.08.2017 13.26.52 Mode: [Edit]	
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Name 2	User demo	
Name 3	Tilmet	
ZIP code / street 97076 Schweinfurter Str. 28	New number	
ZIP code / P0 box		
City Wuerzburg	O Discrad	
Country ID D Deutschland	Company supplier no. 55 55 55	
Country Germany		
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	Phiothy 2 high supplies priority	Ø Discard
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-denotes house	Distance 570 Finance transfer date	
	Suppler customer no. 1111111	±fi0elete.
	Form 0 Standard form Tax no. tax office	
	Copy Inquity Entry trade register	
	Copy order Copy delivery note spies - consignment note Account data]	
	Status 1 Approved by QM	
	Bank name	
	Currency EUR Account no.	
	Turnover tax ID BIC	
	Tax type (VAT) 1 Input tax 131; Tax type (VAT) 1 Input tax type (VAT)	
	Delivery condition	
	Term of payment 0 None	
	Revenue group 0 General	
	Net target	
	Reminder succharge Reminder period	
	Durning indic. 0 No overdue notice	
	Reseve	🗶 Exit
	ID:1/demo/ENGL	

010011 1011010011 10001101011 10001101011		1011010011	1011010011	1011010011	1011010011
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10011110	10011110	10011110	10011110	10011110	10011110



Article master data

All articles in use are assigned an unique number and are managed in the *article master data*. Pseudo articles have to be created for some process, e.g. services. Following data has to be entered for each article:

- Designation and quantity units
- Stock per inventory and total
- Supplier from which the article is bought
- Prices for each supplier
- imputed accounting costs
- Scheduling data

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Article no.	Short descr.	Designation	Add. design.	Int. unit	Status	Article group Block indic	Exit
10044	Blockmaterial	Pro Lab 65 1550x500x50	riuu. uooigin	Quantity	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	
10045	Blockmaterial	Pro Lab 65 1550x500x75		Quantity	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	
10031	Blockmaterial 651	Necuron 651 1500x600x50		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	
10032	Blockmaterial 651	Necuron 651 1500x600x75		dm ^a	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10033	Blockmaterial 651	Necuron 651 1500x600x100		dm²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10034	Blockmaterial 651	Necuron 651 1500x500x75		dm ³	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10035	Blockmaterial 651	Necuron 651 1500x500x100		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10040	Blockmaterial 770	Necuron 770 1500x500x75		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10036	Blockmaterial 770	Necuron 770 1500x500x100		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10037	Blockmaterial 770	Necuron 770 1500x600x50		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10038	Blockmaterial 770	Necuron 770 1500x600x75		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10039	Blockmaterial 770	Necuron 770 1500x500x50		dm ²	0 Inquiry article	0036 Erzeugnisse der B 0 Approved	08.0
10279	Boden 5010	5010		Quantity	0 Inquiry article	0037 Verpackungsmate 0 Approved	04.1
10020523	Buchse	Buchse		Quantity	0 Inquiry article	9000 REWE 0 Approved	27.*
10721	Buchse A 906 155 00 50 Merc	Buchse A 906 155 00 50, 20x46-1.0718		Quantity	0 Inquiry article	0085 Mech. Bearbeitun; 0 Approved	01.(
10011177	Buchsenaufnahme oben	Buchsenaufnahme oben		Quantity	0 Inquiry article	9000 REWE 0 Approved	27.*
10011176	Buchsenaufnahme unten	Buchsenaufnahme unten		Quantity	0 Inquiry article	9000 REWE 0 Approved	27.*
10073	Compact-Dichtung 15x9 FPM 75	Compact-Dichtung 15x9 FPM 75+5 S		m	0 Inquiry article	0082 Schamotterohre 0 Approved	25.0
10777	Curucast Pfannenmasse	Curucast 80-07 im Sack à 25 kg		kg	0 Inquiry article	0003 Ferrolegierungen 0 Approved	29.0
	Dämpfungsring	PneumDämpfungsring 35 * 5		Quantity	0 Inquiry article	0082 Schamotterohre 0 Approved	14.(
10130	Dämpfungsring	PneumDämpfungsring 30 * 5		Quantity	0 Inquiry article	0082 Schamotterohre 0 Approved	14.0

Overview of all articles in the article master data for procurement articles

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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Module : 🔣 🔏 📾 🛤 🗧 🖶 🖬 🔛 🔛 🛃 🕺 🕐	
Overview Article master data	
Article RGU-100 RGU Material RGU-100	Status 0 Inquiry article
General add./Dispo/Texts Suppliers Price Inventory Costing	
Short description RGU Material	ode: [Edit]
Designation ndu-100	at 03.08.2017 09.33.53
Add. designation Change	d at 11.08.2017 10.13.46 demo OK
	‡ [™] Insert
Block indic. 0 Approved	r New number
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Unit kg < Kg > kilogram ▼ Stock va	
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[Fin. art - Info at purch.dpt. castings]	
L Fin. art - Info at purch.dpt. castings Slidingscale pri Art. no. Image: Comparison of the purch.dpt. castings 0.00 EUF	
Designation	
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Urawing no.	_
Material Status	
Gross weight Disp. wgth.	
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Article measter data Ocrarel data	

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Article master data - General data

010011	1011010011	1011010011	1011010011	1011010011	1011010011	
10001101011	10001101011	10001101011	10001101011	10001101011	1000110	
10011110	10011110	10011110	10011110	10011110	10011110	



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Module : 🔣 📓 🖪 🖪 🖽 🔚 🖀 😭 🛃	
Overview Article master data	
Article RGU-100 RGU Material RGU-100 Status 0 Inquiry article 💌	
General add./Schedule/Texts Suppliers Price Inventory Costing	
[Add. article master data]	
Character-key 4 Aquisition article Schedule indic. 1 Demand-driven schedul 🗨	E dit
Procurement indic. 1 Aquired article Stock 0,000 Procurement period in days 0	ОК
ABC - indic. C Priority C 🗨 Backup stock 0,000 Demand date 💌 🛓	Discard
Charge indic. Max. stock 0,000 Specific weight	
Method plan - article Min. order quantity 0,000 Sand recipe indic.	-
Max. order quantity 0,000 Status 0 Inquiry article	_
OP site Veek demand 0,000 Change status 07.12.2000	-
Cust. no. S	
Material no. So Demand period 0	
	💦 Internal text
Status: Changed at User	
Dispatch weight (kg) 0.000 0 unknown ✓ 03.08.2017 demo Gross weight (kg) 0.000 0 unknown ✓ 03.08.2017 demo	🖹 External text
[Internal text]	Delete int. text
	± Delete ext. text
	Exit
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Article master data - Scheduling

Control of scheduling, using the scheduling indicator, can be manual, demanddriven or stock-driven (see red square)

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Article master data - Supplier prices

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10001101011 10011110	10001101011 10011110	10001101011 10011110	10001101011 10011110	10001101011 10011110	1000110 10011110



Standard prices can be created for each article and supplier. The currently valid standard price can be imported into Prices and Price items.

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Overview Article master data	
Article RGU-100 RGU Material RGU-100 Status 0 Inquiry article 💌	
General add./Schedule/Texts Suppliers Price Inventory Costing	
Article group 0029 General Recorder level 0,000	🕅 Edit
Internal unit kg < Kg > kilogram Min. stock 0,000	
Inventory no. Inventory Current stock Value Main inventor Entry at Changed at Edit mode: [Edit]	, , , , , , , , , , , , , , , , , , ,
▶ 009 Materiallager 0,000 0,00 No 03.08.2017 12.53.13 03.08.2017 Inventory no. 009	Ø Discard
Designation Materiallager	
Current stock 0,000 ?(±'į́ Delete
Value 0,00 EUR	
Main stock indie. 🗵 🔽	
Consi. inventory 0 No	
Entry at 03.08.2017 12.53.13	
Changed at 03.08.2017 12.53.13	
User demo	
IG-account	
Expense account	
Point of use	
	🗶 Exit
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Article master data - Article inventory

Purchase requisition/Inquiry/Quotation

Authorized personnel is allowed to create purchase requisitions and to place them with Aquisition department, which start requesting for tenders from suppliers. A procurement order can then be created out of an inquiry.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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Requester 999999 Not Changed at 18.08.2017 demo	🗸 ОК
Requesting unit 0 Undefined Text	‡ ∱ Insert
Cost centre	🖉 Discard
[Approval of cost centre responsible] [Approval Aquisition]	1 Löschen
Name 00003 📎 Köstler, Ralf Name 📎	
Approved Approved Approval date	QM approval
	Storno Freigabe
Titems] Item Article no. Designation Quantity Unit Appr.costcentre[Appr.Aqui.] Demand date Requested supplier 🔺 Editing mode: [Browse]	-
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Text	
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Purchase requisition

Material scheduling, MRP, Purchase requisition

Monitoring material stock, consumption and procurement orders for each article can be done manually, as well as automatically via scheduling and MRP (Material Resource Planning) by the system.

There are two type of basic scheduling types to decide on:

- demand-driven scheduling
- consumption. and stock-driven scheduling

Demand-driven disposition checks the availability of articles based on sales and production demands. If necessary, an automatic order proposal can be started.

Base for automatic order proposals is the article account for each article. The accounts check the following numbers on a weekly base:

- Quantity needed by sales and production orders
- Quantity in order proposals
- Quantity in orders

Procurement periods, recorder levels and ordered quantities are taken into account.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110

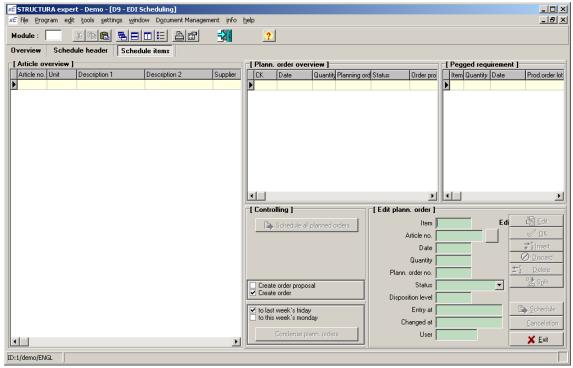


Consumption and stock driven scheduling checks for future demands on the base of previous consumption and current stocks. If current stock is below a minimal stock level, an automatic purchase proposal can be created.

Purchase proposals are processed by material controllers who then create procurement orders.

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Scheduling header



Scheduling items

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10011110	10011110	10011110	10011110	10011110	10011110



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Module : X The R TH III A B B TH ?	
Overview Article schedule data Account - Overview Account - External processing	
Article no. RGU-100 Production stock Aquisition stock	✓ <u>B</u> ack
Description RGU Material Inventory no Inventory Current stock Value M	
Unit st Quantity 🔽 D09 Materiallager 0 0 0	
Schedule inidic. 1 Demand-driven scheduling	
Recorder level 0 Min. order qty. 0	
Safety stock 0 Max.ord.qty. 0	
Max. stock 0	
Procurement period(weeks)	
Weekly demand 0	🗶 Exit
[Account - Overview] Overview Overview Greekly overview Coverview Greekly overview Greekly	articles
Week Requirement Planned order P. Order Ordered available	Qty. done
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35,2017 0,000 0 0 0 0,000	
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Article account

The cause for demand is shown next to the article's quantity in the article account. The system automatically assigns demand-driven material to production orders using the article account. A direct connection to each process (Production or procurement order) is possible.

Procurement order management

Procurement orders can be created from inquiries or purchase requisitions, as well as a direct input of a procurement order.

Each procurement order consists of header and item data. Item data are corresponding articles or services. Required dates and price agreements can be entered at the procurement items. Upon order confirmation by the supplier, the delivery date can be entered to the corresponding item data.

Internal and external forms and texts can be entered into the header and item data.

The following shows some examples of dialogues in the system:

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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	d dev. dates		
Order no.	Status 0 Recorded 💌 Items 0	Edit mod	le: [Insert]
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Order type 0 Material procurement order 💌 Supplier no. 555 555 55 💊 😂	Address]	[Delivery addr.] Delivery address 555 555 55	Edit
Offer no.	Addresse name 1 RGU Expert	Addresse name 1 RGU Expert	🗸 ОК
Inquiry no.	Addresse name 2	Addresse name 2	‡r¶ Insert
Language English	itreet + house no. Schweinfurter Str. 28	Street address Schweinfurter Str. 28	Ø Discard
Our Reference	ZIP code/city 97076 Wuerzburg	ZIP code/city 97076 Wuerzburg	Uiscard
Order date 21.08.2017	Country ID D Germany	Country ID D Germany	Copy
Currency EUR	Target print date 21.08.2017		
Exch. rate date 01.09.2008	Actual print date		45.044
Exch. rate 1 (zu EUR)	Booking date		± Delete
Buyer no. 004 🔊	Entry at		
Buyer Mr. Burger	Changed at		<u>Printrea</u>
Contact person	User		Cancellat
To the attention of			
Delivery to			
[Conditions]	[Framework contract]		Preview
Delivery conditons 1 Free of charge			🕒 Print
Term of payment 0 None			
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Form no. 0 Standard form	J L		
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Procurement header dialogue

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Module : 🗾 🔉 🖻 🖻 🖽 🔚 🖬 🚼 👔 🕐	
Overview Purchase header Purchase item Confirmed dev. dates	
Order no. 11M01016 .001 RGU-100 RGU Material REX II IN Status O Recorded V	
Item overview Edit item Texts Prices Lots/dates	
[Item price]	Price import
Order item 1001 H + + H	
Quantity 0,000 < Kg > kilogram Article no. RGU-100 RGU Material	Export Price
Supplier total price .00 EUR / Item RGU-100	Import Price
Total price ext. 78,00 EUR / 1 < kg > kilogram Disptach weight (kg) Gross weight (kg)	
Total price int. 78,00 EUR / 1 < Kg > kilogram 0,000 0,000	
Item Price type Price unit Base Inclusive Price Unit price Int. unit price Entry at Edit mode: [Edit]	10 a.c. 1
1 Price /kg Delivery weight No 78,00 78,00 78,000 21.08.2017	🚵 Edit
Price type 10000 Price	🗸 ОК
Price unit 020 /kg	⊋ ⁺ £ Insert
Price 78.00 EUR	Ø Discard
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Price/unit 78.00 EUR	
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Procurement item data - Prices

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10011110	10011110	10011110	10011110	10011110	10011110



	expert Gmb		Company ad	dress RGU expert GmbH Schweinfurter Strasse 28 97076 Würzburg Telefon: +49 (0)931 / 30980 - Telefax: +49 (0)931 / 30980 - 2 e-mail: info@jpsexpert.de Homepage: www.ipsexpert.de	2	RGL
Schwe	xpert GmbH sinfurter Str. 28 076 Wuerzburg		Your supp	lier no.	: 0003	
ocurement	t order 15M0000	13 from 21.08.2017		Contact: Mustermann, Max Tel. : Fax : EMail :		
<u>ltem: 001</u>	Our article no Designation Designation 2	: R-0100 : REX material				
	Delivery lot	Quantity		Date		
		10,00 Qty.		10.10.2017		
Price		78,000	EUR /piece		EUR	780,00
Item figure (Ne	L	EUR	780,00 780,00
Banken Volksbank BLZ 684 92		Sparkasse Würzburg BLZ 684 522 90	Stefan T	tsführer: hrom icht Wüzburg HRB 701871		Seite 1 von 1

Example of a form design layout for procurement orders

Stock ingress + withdrawal/Stock overview

After delivery of the ordered article a goods entry is documented and booked. The quantity of the stock ingress is added to the existing stock.

Rejected goods can be documented here as well.

In this process, a new average price is determined by calculating the arithmetic mean between the current stock and quantity of new stock. The new price is then attached to the article master data.

Material withdrawal is done by documenting and booking of the quantity taken. Material withdrawal booking can be done automatically with feedbacks for articles in method plan.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



The timely and quantitative development is displayed in the article's stock history.

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Module :		<u>X B E </u>			<u>1</u>	?									
[Selectio	-				[Stock]				1	L		- 1-		• •	
		no. RGU-100	<u>></u>		Invento	ry-no. Descripti Materialla		Stock	Unit 90 kg	Invdate		Inv.	-quantity Chang	ed at 017 12:53:13	User demo
	Design	ation RGU Material			009	Materialia	yer		50 Kg				03.06.2	017 12:55:15	demo
B	ezeichn	ing 2 RGU-100			•										Þ
History by			by process dat												
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		Booking date				Process type				Process no.	_	Supplier	Delivery note	Order t	
22.11.20		22.11.2013 13:10:15 22.11.2013 13:08:22	90	5 95		Stock withdrawal Stock ingress				11-0001143	1	0202			
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Article history

Stock ingress invoices

After booking of the stock ingress the incoming invoice can be documented under an internal number. The creation of invoice items from the purchase order or the stock ingress is possible.

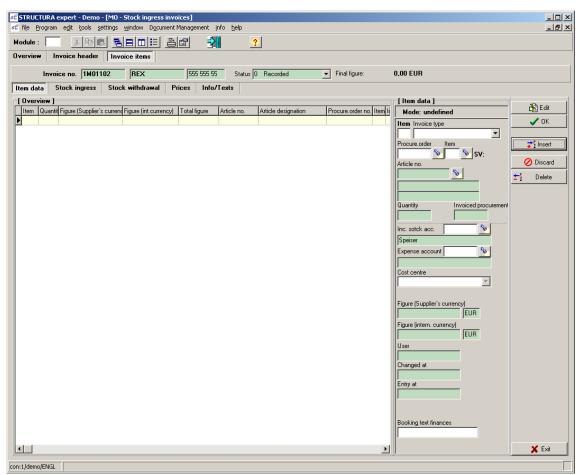
After invoice verification, the invoice transfers to financing and accounting, the personnel account and the corresponding incoming goods account.

010011	1011010011	1011010011	1011010011	1011010011	1011010011
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Overview Invoice header Invoice items	
Invoice no. 1M01102 II I II Status 0 Record	ed Edit mode: [Edit]
General	
Invoice type 0 Material Address no. 555 555	555 💊 🕅
Invoice date 21.08.2017 RGU E	xpert VK
Supplier 555 555 55 📎 REX	
Creditor 555 555 55 Se REX/ 97076	Wuerzburg 文립 Insert
Supplier invoice no. Currency EUR	Discard
Tax tpe (VAT) 1 Input tax 19% Rate date 01.09.2	
Delivery condition 1 Free of charge Exc.rate	·
term of payment of terms	k account] Bank no. 1 %
Payment date 21.08.2017	Bank no. Bank of Wuerzburg
Net goal suppl.	
Incoming invoice date 21.08.2017	BIC WUERZUE1WZB
Service date 21.08.2017 Due date 21.08.2017	IBAN DE06762300000061 [Generate]
Due date 21.08.2017	SWIFT/BIC
Status O Recorded	al price]
since 21.08.2017 09:12:01	Net figure 0,00 EUR Transfer date 🔻
Entry at 21.08.2017 09:12:43	X Discount 0,00 EUR Cash discount 0,00 EUR
Changed at 21.08.2017 09:13:20	Freight 0,00 EUR
User demo	Packaging 0,00 EUR
Transfer date finances	Toll 0,00 EUR
Remark 19.0	0 % VAT 0,00 EUR
<u>****</u>	Final figure 0,00 EUR
	🗶 Exit
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Invoices - Stock ingress



Stock ingress - Item data

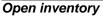
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Material inventory

Inventory across all article groups or just single articles is executable. After counting of the articles, documentation of current and correction of booked stock takes place. The inventory difference in value for each account is transferred then to financing and accounting.

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0000 allgemein	Proc	curement sto	ck					
0001 Stahlschrott 0002 Stahlroheisen							Open inventory	
0002 Stanioneisen								
0004 Metalle							Last movement > 2 years	
0005 Isoliermaterial 0006 Aufkohlungsmittel							-	
0006 Aurkonlungsmitter							Auswahl	
0008 Aufstreugemische	Proc	urement art	icle				O All	
0009 Zuschlagstoffe	Inv.		Stock	Designation	Long designation	Stock Unit	O None	
0011 Technische Gase		Ait no.	1 3100K	Designation	Long designation		U None	
0012 Sand	<u> </u>						C Reverse	
0013 Formereihilfsmaterial	<u> </u>							
0014 Formüberzugsstoffe 0015 Speiser	<u> </u>							
0016 Feuerfestmaterial								
0017 Walzmaterial								
0018 Brennstoffe 0019 Schmierstoffe	<u> </u>							
0020 Schienenkupol	<u> </u>							
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0022 Schmelzofenzubehör 0023 Elektromaterial	<u> </u>							
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0025 Meßgeräte	<u> </u>							
0026 Werkzeuge								
0027 Laborbedarf 0028 Giessfilter								
0029 General	<u> </u>							
0030 Kernkasten								
0034 Chemie 0035 Arbeitsschutz								
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0002 Stahlroheisen		-								
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0006 Aufkohlungsmittel										
🔲 0007 Grafitelektroden 🦳										
0008 Aufstreugemische 0009 Zuschlagstoffe	Arcticle Aquis	ition								
0010 Strahlmittel	Article no.	Inventory	Designation	Long designation	Stock	Inv. sotck	Unit			
0011 Technische Gase	70002001	009	102 SABIC PP-Compound	R91102 SABIC PP-Compound	115.786,000	90.000.000	g			
0012 Sand	70002002	009	19 Sabic PP 108MF10 Natur	B92219 Sabic PP 108MF10 Natur		120.000.000	g			
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0015 Speiser										
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Inventory - Recording and booking

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10011110	10011110	10011110	10011110	10011110	10011110



Finance and Accounting interfaces

After finishing all necessary process in *structura*, following data can be transferred to Finance and Accounting:

- Stock ingress invoices
- Stock withdrawal and stock ingress Aquisition
- Inventory

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Transfer data									
[Interface]				[Options]					
Path to finance interface									
Last transfer date User									
	date_last_run_i								
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Stock ingress invoice Goods wit	hdrawal Stock in	ngress-Return material	Stock ingress	for consi-storage	Stock ingress from consi-storage				
		igroot frotuin indicinal	otoott ingroot	tor contractingo					
Date from	Date to			Invoice no.		13- Search			
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Invoice no. Invoice date	Supplier no. S	earchname	Pers.account		_				
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1000085 15.02.2010	0001 G	TP							
1000047 09.04.2010		TP							
1000046 09.04.2010		TP							
1000024 18.03.2010		TP							
1000070 24.02.2010		TP							
0900002 31.07.2009	0001 G	TP]	•				
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Data transfer from Aquisition to Finance and Accounting

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10011110	10011110	10011110	10011110	10011110	10011110



9 Document management

structura possesses a comprehensive document management.

In the document management system, external documents like technical drawing (as pdf.files), various pictures and office files, customer and supplier documents etc. can be saved in various modules of *structura*.

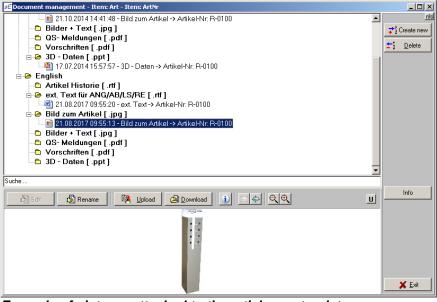
Documents can be saved in the system internal data base.

On top of that, internal and external additions in text form can be created. For these texts, external templates can be used and adjusted, if necessary.

structura verfügt über ein umfangreiches Dokumentenmanagement.

Scope of features

- Saving of following documents and types:
 - external customer and supplier documents
 - o Pictures and technical drawings in the article master data
 - Quality instructions
 - o various MS-Office files
 - pdf-files (Acrobat Reader not included)
 - o texts created with *structura*
- Creation of standard texts like introduction, greetings and finish texts, which can be printed on forms.
- Internal and external texts for master and transaction data



Example of pictures attached to the article master data

010011	1011010011	1011010011	1011010011	1011010011	1011010011
10001101011	10001101011	10001101011	10001101011	10001101011	1000110
10011110	10011110	10011110	10011110	10011110	10011110



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English		
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Various texts can be entered here		
For changes and revisions of the article, a full article history can be put here.		
Also additional text for tests and such are possible.		
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External texts in the article master data

010011	1011010011	1011010011	1011010011	1011010011	1011010011
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10011110	10011110	10011110	10011110	10011110	10011110