NETWORK BUSINESS SYSTEMS
SOFTWARE SYSTEM DOCUMENTATION

MANUFACTURING SYSTEM

FEATURES

WORK ORDERS

- Standard Mfg. vs. Full Mfg./MRP Manufacturing
- Target date, open date, closed date
- You can make and buy the same part
- Quantity projected, quantity built
- Tracks standard cost
- Tracks true actual cost
- Edit live work order routing
- Edit live work order bill of materials
- Partial completions allowed
- Status code control for projected, active, production closed, cost closed, and on hold work orders
- Various viewer programs for module integration
- Automatic pieces per hour calculation
- Search by part number or work order number
- Custom work order processing
- Direct cost attach to specific order vs. FIFO allocation
- Production control program for journalized editing of work orders
- Cost closing utility that checks for cost closed supporting data within a work order, such as purchase orders and sub-work orders (cost closed means paid thru Accounts payable)
- Warehouse picking slip routine for allocating materials to a work order. You have full control of materials location
- Tracks status of needed materials in open work orders and forecasted work orders
- Can transfer materials from one work order to another

BILL OF MATERIALS

- Search by part number
- Options menu for movement into other modules
- Unlimited indentation
- Part explosion
- Part implosion
- Copy utility to easily duplicate

SHOP FLOOR ROUTING

- Search by part number
- Options menu for movement into other modules
- Each step in routing consists of sequence #, work center #, Machine category, operation #, pieces per hour, time, move time, queue hours, yield percent, set up
- Copy utility to easily duplicate

WORK CENTER

- Work center file (3 digit code) w/description, direct labor costs, indirect labor costs, factory overhead costs, available hours for forecasting
- Machine category file (3 digit code) with name and description
- Machine detail file (3 digit code) with name, serial number, machine category, description
- Operation file (3 digit code) w/description and default note code
- Note code file (3 digit code) for use with operations, can be printed or not, edited or not
- Copy utility to easily duplicate

REPORTS

- Percentage of completion report
- Full audit data reports
- Needed parts per work order
- Needed parts by part number
- Open work order reports with status
- Labor piece rate efficiency reports up to the minute using non-updated time batches
- Labor utilization reports
- Range selectable printouts of all parts with BOM
- Print Bill of materials out to lowest level
- Print Value added/Non value added cost detail
- Range selectable printouts of all parts with Routing
- Print out of all work centers and supporting databases
- Standard Costs vs. Actual Costs
- Average Costs per defined time range

INTEGRATED WITH:

- Inventory system
- Retail/wholesale/telemarketing systems
- Purchase order system
- Automatic Time Entry system
- Payroll system
- Estimating system
- MRP system

SYSTEM OVERVIEW

GENERAL

IBS's Manufacturing module is an extension of the inventory system, for any size manufacturing operation requiring materials management at any level. IBS Manufacturing can provide detailed cost control and basic or full functional MRP tools. Combined with other IBS software, this module is an amazingly powerful system that provides true seamless integration between almost all IBS modules. The user interface simplifies the sophisticated data management and extensive data tracking that is going on behind all phases of the manufacturing process.

True cost detail with audit proven traceability is automatic. Costs can be analyzed between standard vs. actual comparison for budgeting purposes. The IBS Manufacturing System creates a cost record the same as the IBS Purchasing System does, making the item

available for sale either directly linked to an order or a part of the perpetual supply of inventory available for sale or possibly further manufacture into a higher level.

MANUFACTURING

The manufacturing process consists of assembling or fabricating materials from either raw materials, finished good, sub- assemblies, or any combination thereof. There may be added value from subcontractors also.

You can operate the IBS manufacturing system in either a standard cost method or in an actual cost method.

STANDARD COST METHOD

The Standard Cost Method consists of generating work orders using the program "Standard W.O. Entry:REQASSY2". This would usually be performed when the units have been completed. This method will cost all labor and factory overhead at standard cost, because there will be no direct labor input into these work orders. Materials cost will be standard also.

ACTUAL COST METHOD

The Actual Cost Method consists of generating work orders using the program "Enter Work Orders:WOTENTR", applying time either from the shop floor time keeping system or by time card input. Inventory will be stored in the actual work order with full cross-reference to detailed purchases and manufacture cost data. This method allows you to take full advantage of the MRP system with all the capacity planning tools available.

A **WORK ORDER** is the hub of the manufacturing system. The fundamental components of a **WORK ORDER** are inventory parts, direct labor, indirect labor, subcontractor services, and factory overhead. The concept of the WORK ORDER is that it develops data that can virtually drive or influence almost all decisions made by the Company. This goes way beyond just product information. The end result of a work order is to take something and make it into something else, such as a raw material into a finished good. It is also valid to make a finished assembly that consists of other finished parts and assemblies, of which that further level down also is made up of parts and/or assemblies. There is no limit to the depth of assemblies in the IBS Manufacturing System.

The typical **WORK ORDER** represents a part, sub-assembly, or a final assembly, and can be broken down into two primary elements of what we call the **BILL OF RESOURCES**. The **BILL OF RESOURCES** two elements are the **BILL OF MATERIALS** and the **ROUTING.**

BILL OF MATERIALS

This is the list of materials both direct and indirect that makes up the final part. The Bill of materials identifies and quantifies the amount of materials required to manufacture into a higher-level subassembly or finished good. You can have a bill of materials that has a sub part that is actually an assembly having it's own bill of materials and so on and so on. This condition is totally valid and is called an "Indented Bill of Materials". There is no limitation to the level of indentation in IBS Manufacturing. NOTE: Although you can do it, IBS does not advise making a part into itself. Meaning, making a part from raw to finished as the same identical part number. This can cause complications when using the MRP software. A general rule of thumb is that the master part number should be different than the sub part number.

EXAMPLE: You purchase a casting as a raw material, part number CAST1. You machine this casting into a finished part. The part number for the finished part could be FINCAST1 and should not be CAST1, the same as the raw material. They are essentially two distinct and separate components and you will want to track cost and other data separately instead of combining them. Following the recommended procedure of using separate part numbers, you would have a Bill of Materials for the master part "FINCAST1" which would have a one level bill of materials consisting sub part "CAST1".

When IBS Manufacturing issues a work order you will have a choice to modify the standard bill of materials or use even another part's bill of materials. This is an extremely powerful feature, which allows you to modify without changing the standard. This is a real world situation in which case IBS Software will be able to tell you as you go and upon completion the difference in cost due to the modified bill of materials in the actual work order.

As materials are posted to the work order by the "Picking Slip" routine, they are linked by a newly created cross reference file that tells each work order exactly where it got its materials, no matter how many times materials are issued to the work order! This cross-reference file is how IBS work orders can tell you exactly where the materials came from and how much. Further, it will be able to tell you the standard cost vs. the actual cost in full detail.

This brings up a major item of consideration. There are times when you are forced to use goods that have been allocated to a specific work order, for another higher priority work order. IBS Manufacturing Software allows you to exactly this. However, you must be aware that if you are going to transfer goods from one Active work order to another active work order, then you must use the program "Transfer Parts from WO to WO:WOINVCN1" in order to maintain proper costing cross reference data.

NOTE: You can also edit the work order bill of materials while the work order is in process.

ROUTING

This is the manner by which the part, sub-assembly, or final assembly is made. This can include subcontractors' services.

The Routing dictates the method of manufacture, utilizing flexible work cells and including subcontractors. Work order centers are totally user defined. (person, group of people, machine, group of machines, subcontractor, or department, etc.) Online help provides user assistance and options menus provide movement into all related data, such as part information, purchasing, and more. All information can be found by direct input or search by multiple fields.

When IBS Manufacturing issues a work order you will also have a choice to modify the standard routing or use even another part's routing. This is an extremely powerful feature that allows you to modify without changing the standard. This is a real world situation in which case IBS Software will be able to tell you as you go and upon completion the difference in cost due to the modified routing in the actual work order. Just like the bill of materials, the work order stores the modified routing and the standard so that you will be able to determine where the difference in cost and time occurred.

NOTE: You can also edit the work order routing while the work order is in process.

What comes from a **WORK ORDER** is a tremendous amount of information that can be broken down into two categories, accounting and production. The two are directly related by being driven by the **WORK ORDER**, as discussed above.

a. **ACCOUNTING**

1. Cost of goods manufactured
2. Cost of goods sold
3. Department/cell/personnel/machine/subcontractor cost
4. MRP purchasing/cash requirements w/cost projections
5. Standard vs. Actual cost
6. Automated payroll costs for manufacturing personnel
7. Inventory value (finished, WIP, raw)
8. Operational costs (costs by WORK ORDER operations)
9. Rework and defective costs
10. Unit sales margin analysis with costs
11. Customer sales margin analysis with cost

b. **PRODUCTION**

1. Labor efficiency
2. Operational efficiency
3. Department/cell/personnel/machine/subcont. eff.
4. MRP load requirements **ROUTING**
5. MRP part requirements thru **BILL OF MATERIALS**
6. Material shortages per work orders
7. Automatic time keeping
8. MFG. needs from received items, thru receiving
9. Materials on hand not required in **BILL OF MATERIALS**
10. Forecasting of sales and related production req.
11. Rework and defective materials tracking
12. Unit production analysis

TYPES OF WORK ORDERS

IBS has incorporated a status code intelligence that applies to all work orders according to several different basic conditions. They are as follows:

PROJECTED WORK ORDER....Status #1, this means time cannot be logged against this work order and no inventory has been assigned or moved into this inventory as of yet.

ACTIVE WORK ORDER....Status 2,3, and 4, an active work order is one that has been issued for work and time can now be logged against this work order. Progressive active status codes provide additional information such as when a work order has been issued all of the calculated goods necessary to complete the projected amount, based on the bill of materials in the work order. This would be status 4. Status 2 and 3 indicate that the work order is in process and may be short materials. You can determine this status very easily by viewing the work order bill of materials "Edit Act. Work Orders B.O.M.:WOBOMED", or by running the parts needs programs under the W.O. PICKING SLIPS" menu.

WORK ON HOLD....Status 7, means that you have placed a hold for some reason and do not wish time to be allocated against the work order until further action is taken.

PRODUCTION CLOSED WORK ORDER....Status 8, means that production quantities have been finalized on a work order. A work order can be "Production" closed regardless of the quantity. This means you can cut a work order off or possibly reverse it.

COST CLOSED WORK ORDER....Status 9, means that not only is the work order "Production Closed", but all detailed cost referencing to the work order is complete with actual verified costs. This goes as far down the bill of materials and lets you know that all costs are in and updated and you are now capable of generating the work order audit report that lists the detail of the work order costs, from labor to materials to subcontractors or indirect materials purchased against the work order directly.

DELETING A WORK ORDER

If you have created a work order to the point of status three and realized that you are not going to run the order, then you must update the picking slip with nothing on it and then close the work order with zero quantity produced. The system will clear all data records and the work order will be gone completely. There are some rules however. You cannot delete a work order with active materials. You can only return the materials to the warehouse and close the work order at a quantity of zero. This will not delete the work order from the history. You also cannot delete a work order that has had time accrued against it. You can only return the materials to the warehouse and close the work order at zero quantity. This also will not delete the work order from the history.

MATERIALS HANDLING

IBS Manufacturing Software processes materials into a work order utilizing a warehousing mentality. This will work if you actually warehouse your inventory and issue to the work order, or if you store the inventory at the work cell. Regardless of your logistics, IBS has provided you with the ability to place a logical control on the inventory issued to the work order and also the ability to over ride computer calculated inventory availability. Another benefit of this programming logic is that you get the opportunity to make corrections to inventory on hand. The Picking Slip Update routine will not update materials that are not on hand. You must have goods on hand in order to be updated to a work order successfully.

When the work order is first issued, it is automatically placed in a projected state. This is occurring during the very first part of starting a work order "Enter Work Orders:WOENTR". Within the program you can move the work order immediately into a live state by continuing to process. If you choose to not process further, then the work order will be in a projected state and can be selected in the MRP system to be included or not included in calculations and projections. This work order will be automatically flagged as "Status 1" and has no inventory posted against it as of yet.

If you choose to move the work order into the live state, then you will re-enter the projection in "Enter Work Orders:WOENTR" and convert the work order to an active state, allowing time to be collected and inventory to be posted to the work order accordingly. At this time, all subparts per the Bill of Materials, will be assigned in each respective part inventory master. The master part will have the work order projected quantity added to the Work In Process (WIP field). A picking slip will be generated, along with the actual work order and work order routing master.

PICKING SLIPS

When the initial picking slip is generated, remember...inventory has only been assigned at the bill of materials level. This allows you to "GO TO THE WAREHOUSE" so to speak and get the materials needed for the job. Remember also that when you moved the work order from the projected state (Status 1) to the active state, you now allow time to be accrued against this job and can start right from the beginning and track materials acquisition time if you want to. If that is the case, then you should have an operation set up for materials acquisition time on your standard Bill of Materials.

Now, when you activated the work order and it went out looking for the parts as per the Bill of Materials, it did not just necessarily have those parts available. In this instance, a work order works exactly like a sales order...first come first serve. The work order material acquisition intelligence looks at the net stock of parts per the Bill of Materials. The picking slip will show you not only what you need to fill the work order but also what you are short according to the current data. This is the exact point where you would be going to the warehouse to acquire the goods to fill the work order, if you operate a warehouse style inventory management.

You can reprint the picking slip with the program "Print Picking Slips:WOPIKPRT". This next capability is a real POWER TOOL.

Since we have only initially requested the goods for the work order and determined that some of them are actually spoken for...we have the opportunity to over ride the allocated materials and post all available inventory to the work order. This allows you to make that sometimes necessary decision to "Rob Peter to Pay Paul!". You will use the program "Enter/Edit Picking Slips:WPIKED" to tell what inventory you will be allocating to this work order.

Once you decide what materials you are allocating to the work order, you will update the picking slip. This program will now recalculate the part master assigned and reduce the inventory of the sub parts per the bill of materials in their own part master file, and finally create a cross reference data record to tell the work order where the materials came from, either purchase order or another work order. The update program is called "Update Pulled Parts:WOPULLUP". NOTE: You are not allowed to update parts that are not on hand. You can take parts that are assigned, but you cannot take parts that are not on hand.

After you update parts to a work order you can now add more parts, change operations, complete partial quantities, print various reports of work orders with calculated value of Work in Process.

TIME INPUT INTO WORK ORDER

Time can be entered to the work orders either directly from the shop floor collection system "Time Entry System:WOSHOP", or typed in from time cards "Time Entry Direct Input:WOTIMSCR". You will want to read the IBS Automated Time System Manual.

Here are some rules of thumb you will need to consider in order to effectively use any MRP system.

1) All inventory must received in the with proper part numbers.

2) All manufacturing must be controlled by accurate routing masters and bills-of-materials. (Bill of resources)

3) All bill-of-materials standard times, parts, and subcontractors' costs must be maintained accurately.

4) All time collected from the manufacturing cells must be perpetually managed for accurate and timely input. (WHEN USING THE IBS JOB COST SYSTEM)

5) All materials movements other than work in process must be governed by inventory requisition paperwork. You can use the reserve system for many of these transactions.

6) All inventory items not electronically adjusted through the bill of materials, such as an indirect material, must be adjusted prior to each month end, via a manual system.

7) All new parts entered into the system must have accurately estimated costs.

8) FOLLOW THE WORK ORDER ROUTING! If it is incorrect, tell your supervisor! This must be done! (WHEN USING THE IBS COST SYSTEM)

9) Attempt to release work orders when all the parts or a high majority of the parts are available.

10) All manufacturing work must have a work order, or a manual card should be used for input later. The latter should be an exception!

11) Isolate the list of components that should be visually counted once per month, such as all pins, springs, and other small parts.
COUNT THEM! COUNT THEM! COUNT THEM!

12) Track machine down time by setting up a part number for each machine, identifying the proper general ledger manufacturing overhead expense account in each part number, and then activating a work order for a downed machine when the need occurs!

BASIC SYSTEM OPERATIONAL FLOW
1. **Manufacturing Cell File:WOLOCGUT**....Create new manufacturing work cells as your company expands and changes. Maintain the costs on at least an annual basis if not on a quarterly or semi- annual update.

2. **Machine Category File Maint:WOMACGUT**, **Note Codes File Maintenance:WOMNGUT**, **Operation Codes File Maint:WOOPGUT**, **Machine Detail File Maint.:WOMCDGUT**,....Create new operations and machines as needed. Note: You can automatically create the note to go along with the newly created operation. The program "Operation Codes File Maint:WOOPGUT" does this.

3. **Enter/Edit STD B.O.M.:INENTBOM**. **Enter/Edit Routing Masters:WOTEMPLT**....Create new and maintain existing Routing Masters and Bills of

Materials. If you make a change to either on an existing part, or are creating a new routing or bill of material, both programs will automatically recalculate the cost of goods manufactured. They will also give you the choice to save or ignore the new total. You can return past the "MASTER PART NUMBER" in the program "Enter/Edit STD B.O.M.:INENTBOM", and type in a "SUB PART NUMBER" and find all the master parts this "SUBPART" is used in. This makes a great tool for looking at what effect exchanging a part would have before you make it!

4. **Print Part Standard Cost:WOLSTDTL**....Print the cost of a manufactured part with the bill of materials and routing costs detailed. This information is also on line in a variety of options menus programmed throughout the IBS Manufacturing System.

5. **"Enter Work Orders:WOENTR"**....Enter in either projections or fully active work orders. You may want to have your printer on line and ready to go. This will print out the work order, the bill of materials, the routing, and the picking slip. You can use the F7 key to gain access to a tremendous amount of information.

6. **"Enter Act. Work Orders B.O.M.:WOBOMED", Enter Active W.O. Routing:WOEDIT"**....Use these programs to view or edit a live work order Bill of Materials or Routing. "WOBOMED" will always tell you if you have a shortage when you view a live work order Bill of Materials. You can view all work order data by using the F7 key in these programs.

7. **Time Entry System:WOSHOP"**....Record time directly interfaced with the work order and payroll system.

8. **Time Entry Direct Input:WOTIMSCR**....If you are not using the shop floor time input system or if you are making corrections to time batches, use this program to input directly or modify existing time.

9. **Recalc. Std Cost One Part:WOCLCFIN, Recalc Std Cost All Parts:YECLCSTD**....Recalculate your standard costs as you know time estimates, material costs, and manufacturing work cell costs change.

SYSTEM SETUP REQUIREMENTS

We will assume you have installed and set up the IBS Inventory Module prior to this installation. If you have not done so, please complete the IBS Inventory set up before proceeding.

Further, if you will be operating the full IBS Manufacturing System with actual Job costing and MRP planning, then you will need to set up and operate the IBS Payroll Module as well. You will be required to at least have the Employee file set up and maintained currently with all manufacturing employees in order to achieve actual cost. Obviously if you operate the IBS Payroll, you will accomplish this objective as a normal activity instead of an extra responsibility!

The IBS Manufacturing Time Keeping System in directly integrated into the IBS Payroll system, which links all employees to the work order as they log time against job work orders. This provides the ultimate in cost tracking and automatically creates true labor cost detail per

work order operation as daily time clocking occurs. You will want to read the IBS Time Keeping Manual after you read this document.

After you have completed the IBS Inventory and IBS Payroll set up, you will need to set up the following:

Manufacturing Cell File:WOLOCGUT
Machine Category File Maint:WOMACGUT
Note Codes File Maintenance:WOMNGUT
Operation Codes File Maint:WOOPGUT
Machine Detail File Maint.:WOMCDGUT
Work Order Note Maint.:NOTENTRY
Enter/Edit Time Keeping Depts:WODEPART (optional)
Enter/Edit STD B.O.M.:INENTBOM
Enter/Edit Routing Masters:WOTEMPLT

MENU STRUCTURE/PROGRAM DOCUMENTS

2. INVENTORY/MFG. MENU #1
    5. WORK ORDERS FUNCTIONS MENU #1
        1. W.O. MAINTENANCE MENU #1
            1. Manufacturing Cell File:WOLOCGUT
            2. Machine Category File Maint:WOMACGUT
            3. Note Codes File Maintenance:WOMNGUT
            4. Operation Codes File Maint:WOOPGUT
            5. Machine Detail File Maint.:WOMCDGUT
            6. Work Order Note Maint.:NOTENTRY
            7. WORK ORDERS MAINT. MENU #1
                1. WOBOMGUT:WOBOMGUT
                2. WODTLGUT:WODTLGUT
                3. WOHDRGUT:WOHDRGUT
                4. WOXRFGUT:WOXRFGUT
        2. W.O. ROUTING MENU #1
            1. Enter/Edit Routing Masters:WOTEMPLT
            2. Print Routing Masters:WOTMPPRT
            3. Print Routing Masters by Loca.:WOTMPPR2
            4. Copy Routing Masters:WOTMPCPY
            5. List of parts with routing:WOROTLST
            6. Parts with Routing by Group:WOROTLS2
            7. Recalc. PCS/HR in Actual W.O.:WO_WOPCS
            8. Recalc. PCS/HR in Standard Rt:WOSTDPCS
        3. W.O. B.O.M. MENU #1
            1. Enter/Edit STD B.O.M:INENTBOM
            2. View B.O.M.:SUBVIEW
            3. Parts w/o BOM, Routing or Both:YECLCCOM
            4. Copy STD B.O.M.:INCPYBOM
            5. Global Delete/Replace B.O.M.
            6. Print STD B.O.M.:INPRTBOM
            7. Prt Multi-Lvl BOM:SUBEXPLD
            8. Prt Multi_Lvl BOM w /cost roll:SUBEXPL2

9. Prt Multi_Lvl BOM NO cost roll:WOLSTDT3

4. W.O. PROCESSING MENU #1
    1. Enter Work Orders:WOENTR
    2. Enter W.O. Projections Only:WOENTR NOINV
    3. Standard W.O. Entry:REQASSY2
    4. Print Work Orders:WOPRT
    5. Edit Active W.O. Routing:WOEDIT
    6. Edit Act. Work Orders B.O.M.:WOBOMED AD
    7. Release, QTY Close Work Orders:WOCLOS
    8. Parts releases to Inventory:WORELS
    9. W.O. PROCESSING MENU #2
        1. Transfer Parts from WO to WO:WOINVCN1
        2. Transfer Pts from WO to Stock:WOINVCN3
        3. View W.O. List By W.O. #:WOVW1
        4. View W.O. List By W.O.# scroll:WOVW4
        5. Change Dates on Proj W.O.:WOPRJ2
        6. Change Order # on W.O.:WOINVCN7
        7. Change Active W.O. Quantity:WOCHANGE
        8. Delete W.O. w/No cost $ labor:WODELBAD
        9. Custom Work Order Process.:WOENTQK

5. W.O. PICKING SLIPS MENU #1
    1. Print Picking Slips:WOPIKPRT
    2. Enter/Edit Picking Slips:WOPIKED
    3. Update Pulled Parts:WOPULLUP
    4. Print Pick Slips:WOINVCN2
    5. Print Pulled Parts Review:WOPULTMP
    6. Needed Parts By W.O. #:WOPIKGEN
    7. Needed Parts By PartNum:WOSHORT3
    8. W.O.'s With Open Pick Slip:WOPIKLST

6. W.O. TIME TRACKING MENU #1
    1. Time Entry System:WOSHOP
    2. Time Entry Batch:WOTIMLOG
    3. Time Entry Update:WOTMUPDT
    4. Time Entry Direct Input:WOTIMSCR
    5. View W.O. Time Entries:WOTIMVW
    6. Time Entry Guts:WOTIMGUT
    7. Enter/Edit Time Keeping Depts.:WODEPART
    8. Purge Time Data:WOTIMDEL
    9. W.O. TIME TRACKING REPORTS MENU #1
        1. Payroll Time Reports:WOCLOCK
        2. Work Order Labor:WOCURRNT
        3. Work Order w/G.L. Accounts:WOLABRGL
        4. Labor Efficiency:WOLABOR
        5. Pieces Per Hour:WOPCSHR
        6. Actual vs. Standard Time:WOCOMPAR
        7. Transfer Time to Payroll:PRWOTIME

7. W.O. REPORTS MENU #1
    1. W.O. Status By W.O. #:WORPT5
    2. Work Order Status:WOMSTAT

3. W.O. By Customer Order#:WORPT7
4. Work Orders Shop Report:WORR
5. Work Order Hit List:WOHITLST
6. Work In Process (no $$$):WOWIPRP2

8. W.O. COST SYSTEM MENU #1
1. Print Part Standard Cost:WOLSTDTL
2. View Work Order Costs:WOVWSTAT
3. Cost Close Work Orders:WOCSTCL
4. Work Order Cost Detail:WODETCST
5. Print Work Order Cost Audit:WOAUDIT
6. Recalc. Act. Mat. Cost on W.O.:WOCSTONE
7. Edit & Recalc. Act. W.O. Costs:WORECOST
8. W.O. COST SYSTEM MENU #2
1. W.O. Std vs. Actual Costs:WOSTDACT
2. W.O. Act. Cost Avg. vs. Std.:WOAVGCMP
3. Recalc. Std. Cost One Part:WOCLCFIN
4. Recalc. Std. Cost All Parts:YECLCSTD
5. Store Avg. W.O. Costs in Parts:WOAVGNEW
6. BOM COST PROGRAM//MOVE:INCSTBOM