

# HOW TO: Work Order Nesting

Work order nesting is used to allocate material cost properly. It allows you to combine multiple work orders with the same work centers and/or different work centers so that the least amount of material goes to waste. The system will take a sheet and issue material based on the number of percentage that's assigned to each job. The system will then update raw material inventory and job costing based on the percentage of the sheet each nest job uses.

## CREATING A NEW NEST JOB

Click on the plus sign on the top to create a new nest. Then click on the plus sign on the lower left to add work orders to the nest. You can pick single or multiple work centers and sort it by work order status, customer, due date, and etc.

W.O. No.	Rout No.	Part No.	Sequence	%	Est/Hrs	Quantity

Work Order Nesting

**Work Order Nesting** **Query Results**

Date Range : // To 12/31/2020

Due Date Range

Work Center : NC-PUNCHING

BOM Sorting

Work Order Status : QUERY : Status All Current and Not Started

Cell Number : 0

Sort By : SORT BY : Customer

And SORT BY : Due Date

And SORT BY : Priority

All  
 Single W.O. Query

Include Already Nested Jobs

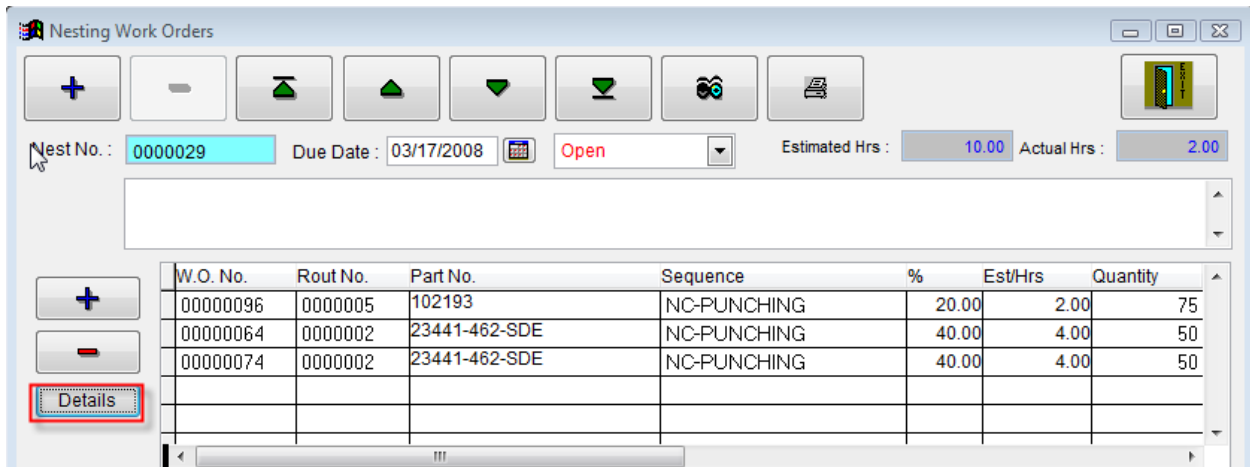
Click on Query Results tab to query the work orders. You can then select the work orders by checking the Pick column.

Work Order Nesting **Query Results**

Pick	Sequence	SEQ #	W.O. #	Customer	Router No.	Part No.	Due Date	Qty Fab	Nest Job
<input type="checkbox"/>	NC-PUNCHING	3	00000084	EMPIRE TOOL CO	0000002	23441-462-SDE	10/05/1999	50	
<input type="checkbox"/>	NC-PUNCHING	3	00000092	EMPIRE TOOL CO	0000002	23441-462-SDE	10/19/1999	50	
<input type="checkbox"/>	NC-PUNCHING	3	00000164	EMPIRE TOOL CO	0000002	23441-462-SDE	02/01/2000	25	
<input type="checkbox"/>	NC-PUNCHING	3	00000166	EMPIRE TOOL CO	0000002	23441-462-SDE	02/03/2000	25	
<input type="checkbox"/>	NC-PUNCHING	2	00000183	EMPIRE TOOL CO	0000009	9847-8293-UJE	10/06/2000	150	
<input type="checkbox"/>	NC-PUNCHING	2	00000183	EMPIRE TOOL CO	0000012	79874-GHT	10/06/2000	50	
<input type="checkbox"/>	NC-PUNCHING	3	00000183	EMPIRE TOOL CO	0000006	101385	10/06/2000	75	
<input type="checkbox"/>	NC-PUNCHING	2	00000195	EMPIRE TOOL CO	0000009	9847-8293-UJE	01/17/2001	150	

The work orders you have selected will display on the first grid. You can clock in and out of the job and issue materials from the screen.

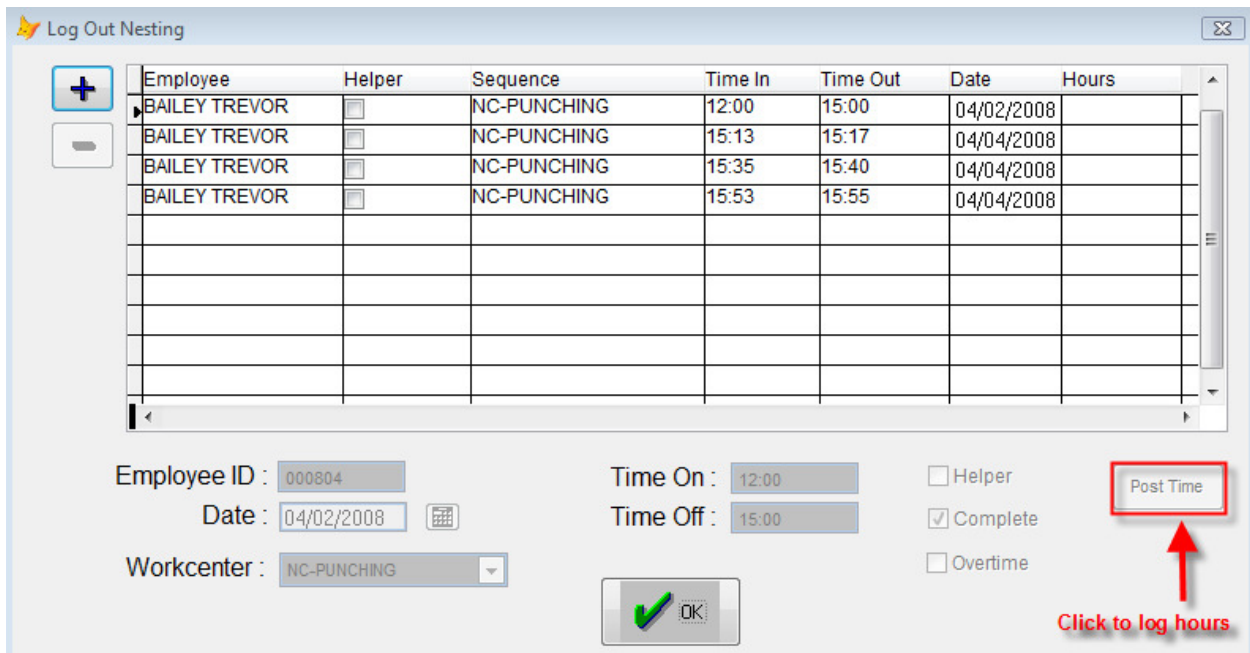
Click on the Details button and the following screen will come up. You can log in and out of jobs from that screen.



Click on the plus sign to add an entry.

Type in the employee ID, select the work center, and type in the time on and off. You can select Helper, Complete, or Overtime checkbox.

The hours will not be posted until you click on Post Time.



If the work orders you have selected above have materials, they will be listed on the second grid. You can also add a new material by clicking on the plus sign. This grid shows the total BOM requirements.

The Clean Reqs button allows you to delete the requirements in the work order transactions. If you do not clear the requirements, the material will still be in the work order Bill of Material screen with “Released” status.

Sheet	Material	Remnant	Stock Width	Stock Length	Issued	Quantity
1	CRS 16 GAGE (0.0598)	<input type="checkbox"/>	48.000	120.000	0.000	5.00
2	CRS 16 GAGE (0.0598)	<input type="checkbox"/>	36.000	96.000	0.000	2.00
3	CRS 16 GAGE (0.0598)	<input checked="" type="checkbox"/>	20.000	20.000	0.000	1.00

Remnant checkbox allows you to issue material without taking it out of inventory. Use this if the item is not in the inventory yet.

The Issue button allows you to issue materials from the screen. The issued quantities will show on the Issued column.

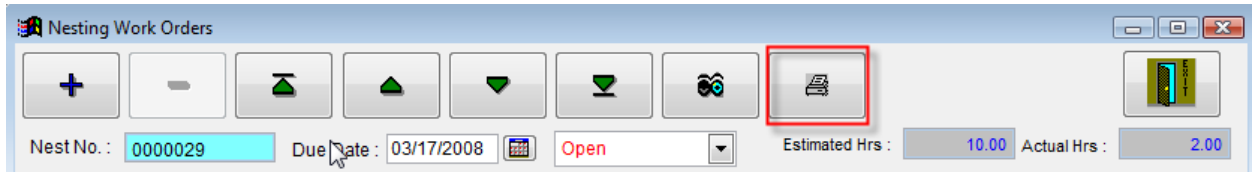
Sheet	Material	Remnant	Stock Width	Stock Length	Issued	Quantity
1	CRS 16 GAGE (0.0598)	<input type="checkbox"/>	48.000	120.000	5.000	5.00
2	CRS 16 GAGE (0.0598)	<input type="checkbox"/>	36.000	96.000	2.000	2.00
3	CRS 16 GAGE (0.0598)	<input checked="" type="checkbox"/>	20.000	20.000	1.000	1.00

The last grid on the screen allows you to assign sheets to different work orders. It shows the BOM distribution based on the quantity on each sheet. The example below shows that sheet 1 is being used 20% on work order number 96 and 80% on work order number 64. And sheet 2 is being used only 50%.

To add the entry, click once on the work order on the first grid and click once on the sheet number on the second grid. Then click on the plus sign.

Sheet	W.O. No.	Part Number	Quantity	Percentage
1	00000096	102193	5.000	20.00
1	00000064	23441-462-SDE	10.000	80.00
2	00000074	23441-462-SDE	5.000	50.00

To log in and out of jobs or issue materials from the scanning gun, click on the printer button to print out the job.



# Nesting Job

Nest Number : 0000006

Total Estimated Hours : 1.493

SHEARING

Scan Into Nest



Log Out Complete From Nest



Scan Into Nest Helper



Scan Into Nest Helper OT



Log Out Incomplete From Nest



W.O. No.	Part Number	Percent	Quantity	Estimated Hours
00000153	17277371	55.79	25	0.833
00000095	1494-1625	20.76		0.310
00000095	1494-1625	23.44		0.350

Sheet	Material	Quantity
1	ALUMINIZED STEEL 20GA	48.000 120.000 25.000
2	CRS 16 GAGE (0.0598)	14.000 14.000 12.000
3	CRS 13 GAGE (0.0897)	48.000 120.000
4	ALUM 6061 T6 .063	48.000 144.000

Issue B.O.M.










Issue B.O.M. Actual



Issue B.O.M. Actual (Drop)



<p><b>Scan Into Nest</b></p>  <p>* N I N N 0 0 2 0 0 0 0 0 0 0 6 *</p>	<p>Used to scan into Work Order Nesting</p> <ul style="list-style-type: none"> <li>• Scan 'Scan Into Nest' barcode</li> <li>• Scan or enter Employee ID</li> </ul>
<p><b>Log Out Complete From Nest</b></p>  <p>* N O C 0 0 0 2 0 0 0 0 0 0 0 6 *</p>	<p>Logs out complete from Work Order Nesting</p> <ul style="list-style-type: none"> <li>• Scan 'Log Out Complete From Nest'</li> <li>• Scan or enter Employee ID</li> </ul>
<p><b>Scan Into Nest Helper</b></p>  <p>* N I N H 0 0 2 0 0 0 0 0 0 0 0 6 *</p>	<p>Scan if helper is being used in Work Order Nesting</p> <ul style="list-style-type: none"> <li>• Scan 'Scan Into Nest Helper'</li> <li>• Scan or enter Employee ID</li> </ul>
<p><b>Scan Into Nest Helper OT</b></p>  <p>* N I N H 0 0 0 2 0 0 0 0 0 0 0 6 *</p>	<p>Scan if helper will be working overtime</p> <ul style="list-style-type: none"> <li>• Scan 'Scan Into Nest Helper OT'</li> <li>• Scan or enter Employee ID</li> </ul>
<p><b>Log Out Incomplete From Nest</b></p>  <p>* N I I N 0 0 2 0 0 0 0 0 0 0 0 6 *</p>	<p>Scan if logging out incomplete from W.O. Nesting</p> <ul style="list-style-type: none"> <li>• Scan 'Log Out Incomplete From Nest'</li> <li>• Scan or enter Employee ID</li> </ul>
<p><b>Issue B.O.M.</b></p>  <p>* N I S S 0 0 0 0 0 0 0 6 *</p>	<p>Scan to Issue B.O.M Will issue Material to W.O. order costing ( If Bottom grid is not filled out it will not do job costing)</p> <ul style="list-style-type: none"> <li>• Scan 'Issue B.O.M.'</li> <li>• Scan or enter Employee ID</li> </ul>
<p><b>Issue B.O.M. Actual</b></p>  <p>* N I S S N 0 0 0 0 0 0 0 6 *</p>	<p>Issue B.O.M. Actual will only issue from the W.O. as well as deplete inventory</p> <ul style="list-style-type: none"> <li>• Scan 'Issue B.O.M. Actual '</li> <li>• Scan or enter Employee ID</li> </ul>

**Issue B.O.M. Actual (Drop)**



\* N D R O P 0 0 0 0 0 0 6 \*

Issue B.O.M. Actual (Drop) Will issue from the W.O. and will deplete Inventory

- Scan 'Issue B.O.M. Actual (Drop)
- Scan or enter Employee ID