

# Dynamics GP Insights to Manufacturing

Dynamics GP includes powerful distribution functionality that will help you more easily and effectively manage your distribution operations. This book covers some of the more important and effective aspects of the Dynamics GP distribution solution.

This book contains explanations and directions for using specific functions within Dynamics GP. It also includes links to videos that support specific functionality.

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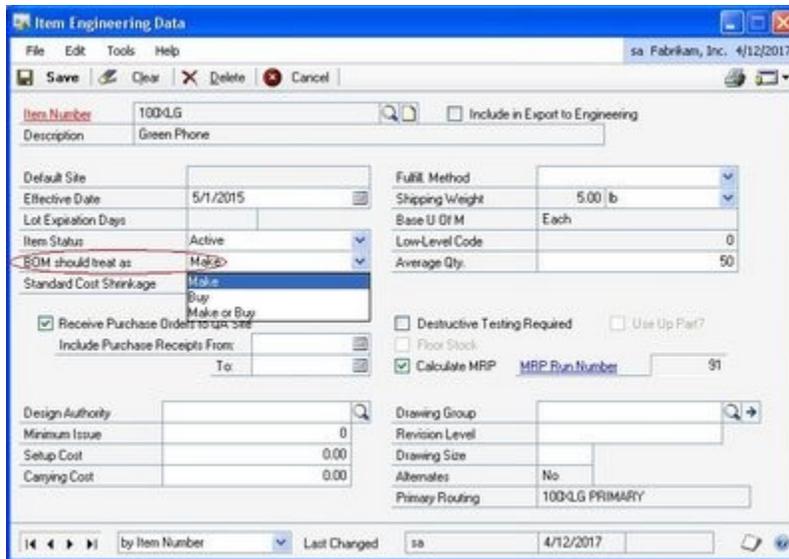
## Bills of Material

### Simple Manufacturing BOM in Dynamics GP

The manufacturing BOM is a sophisticated bill of materials application, and can be a bit intimidating to use, at first. But here are the steps to create a simple, functional BOM, to give you the feeling of the system; assuming you have your items all set up:

First we want to set up the finished good item so that it is identified as a "Make" or a "Make or Buy" item.

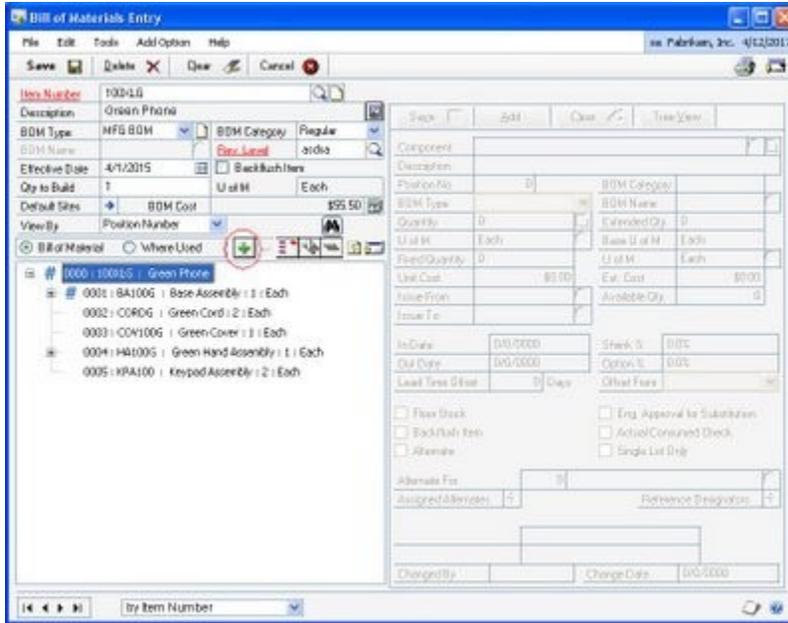
Navigate to: Cards >> Inventory >> Item >> Item Engineering Data, and select "Make" for the "BOM should treat as" value.



Navigate to the Bill of Materials Entry screen: Cards >> Manufacturing >> Bill of Materials

Enter your finished good item.

Click on the Green + to add components. This will activate the component entry area of the screen.

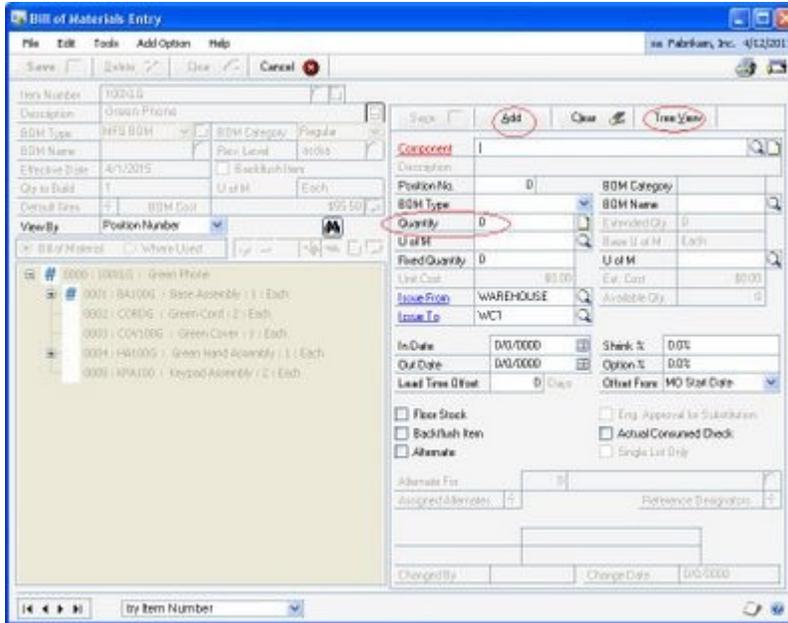


Look up the component you want to add.

Enter the quantity.

Click on the "Add" button to add an additional component item.

When you're done adding components, click on the "Tree View" button to return to the finished good portion of the screen.



Not too bad.

For clients that have the Advanced Management BRL license, I almost always recommend that they use the manufacturing BOM, instead of the other BOM in the Inventory Control module. It takes a bit longer to learn, but has much more functionality to accommodate future needs.

Is There a GP BOM Import Tool?

When doing a Great Plains manufacturing implementation, I'm often asked to import manufacturing bills of material from another system. Clients are sometimes very surprised to hear that GP does not have a built in BOM import tool. We do BOM imports using SQL inserts from Excel spreadsheets for clients during an implementation so some clients think that they should have a tool to import BOMs too.

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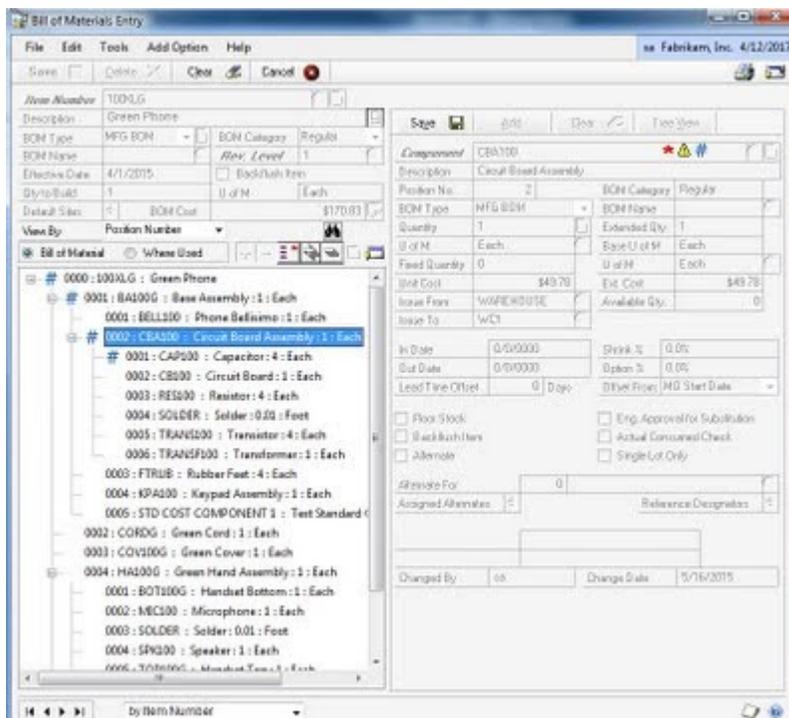
I think there is a need for such a tool and we could develop one but there are some big issues for both the implementation team and the client. Let me try to explain.

There are 3 GP tables that hold BOM related data.

- BOM Header table
- BOM Detail table
- Reference designator table

The data in each of these tables has to be formatted and organized correctly. If not formatted and organized correctly, the import may not work or bad data may be imported. This leaves quite the liability for the implementation team and if users are not getting the results they expect, they do not have a useful tool.

The BOM Header table is fairly straight forward as the import would have to list only the finished good or sub-assembly items. Just think of the upper left quadrant of the GP Bill of Material Entry window.



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The BOM Detail table is much more complex. Think of the right half of the Bill of Material Entry window. In order to get all the data imported correctly the source document would have to list each finished good and its components (including subassemblies) and each subassembly and its components. Each of these rows would have to include the correct position number and relationship to the appropriate subassembly and final assembly. This takes a long time to do. Try taking an indented BOM from another system, export it to Excel, and then put all the rows in the proper sequence and keep all the columns straight. It takes time to do this.

The formatting issue is worse for the reference designators. Most systems will export the reference designators in one long string. GP requires that the string be broken into 21 character segments (including spaces and punctuation). I have had to format these strings into as many as 10, 21 character segments (a column for each one in Excel) and it takes a lot of time.

Users also have to know what the field values mean in these tables. For example what is a BOM Type = 1? What is a BOM Category of 2? SQL requires the use of numerics to identify these rather than 'Phantom or Regular as you see on the front end. Did you also know that these two fields are flipped in the SQL tables? What the GP Bill of Material Entry window calls BOM Category is BOM Type in SQL.

Users also have to know the field formats that SQL uses and the field lengths. If you exceed the field length in your data source, you will not get the desired results in the front end.

In order to have an effective tool, you should validate the import with the Great Plains business logic. Do all the items exist in the Item Master, are the items setup in Item Engineering Data, are all the sites and work centers setup, does the BOM already exist, etc., etc., etc. The fact that Microsoft has not exposed a BOM API via eConnect would require complete reverse engineering or specialist Dexterity knowledge (to invoke manufacturing calls in the correct order). Business logic would also need to include handling of BOM revisions and revision levels.

So what am I trying to say here? It is my belief that using SQL imports for BOMs does not save users any time, really. By the time you get done with all the formatting, import verification, error correction, user acceptance and sign-off, you could have created these BOMs using the GP Bill of Material Entry functionality. Many BOMs are similar to each other in many organizations and the BOM Copy functionality saves users time and reduces errors.

It is fairly easy to create a SQL BOM import to get the data into GP manufacturing once you understand the table structure and have a basic understanding of SQL statements. The real issue is getting the data in the correct format for the import and then validating the data once it is in.

With the many BOM export formats being used today (single level, multilevel, CSV, XML, etc.) it is time consuming and costly to write interfaces for each. Custom adapters or complex mapping tools may be needed to handle these various formats. So it becomes a costly issue for the client or the partner.

With that said, there are some pretty nice tools available to import items and BOMs from CAD software such as Solid Works and Autocad. If clients are using these tools, we generally recommend they buy one of the integration tools that are available to export items and BOMS from the CAD software and import it to the GP item master and BOM tables. These integration tools act as a middleman and take the data from one system and format for GP.

I know that creating BOMs is no fun, but Great Plains functionality does a pretty good job entering BOMs and using business logic to validate the entry of BOM data. There just really are no shortcuts if you want accurate BOMs and manufacturing functionality. Manufacturing is complex because of all the interrelationships involved. Everything (BOMs, routers, work centers, MO's, picklists et. al.) works together and if business logic is not followed, it most likely will not and you will end up with a bad result. So take your time and do it right the first time.

## Manufacturing Order

### Manufacturing Order Entry in Dynamics GP

Here's a simple example of creating a manufacturing order in GP. This will give you an idea of how the process works.

You will need two things in order to create a manufacturing order transaction:

- 1.) Bill of Material. For this example make the BOM a "Backflush" BOM
- 2.) Routing

Let's make the routing first. Create a simple one that has one sequence. Navigate to: Cards >> Manufacturing >> Routings >> Routing Entry.

Look up your finished good item number.

Create a Routing Name.

When the Routing Header Creation screen comes up, check, "Primary Routing" and save.

Enter "100" for the sequence number.

Select a work center. If you don't have any, they're simple to create.

Save, and you're done.



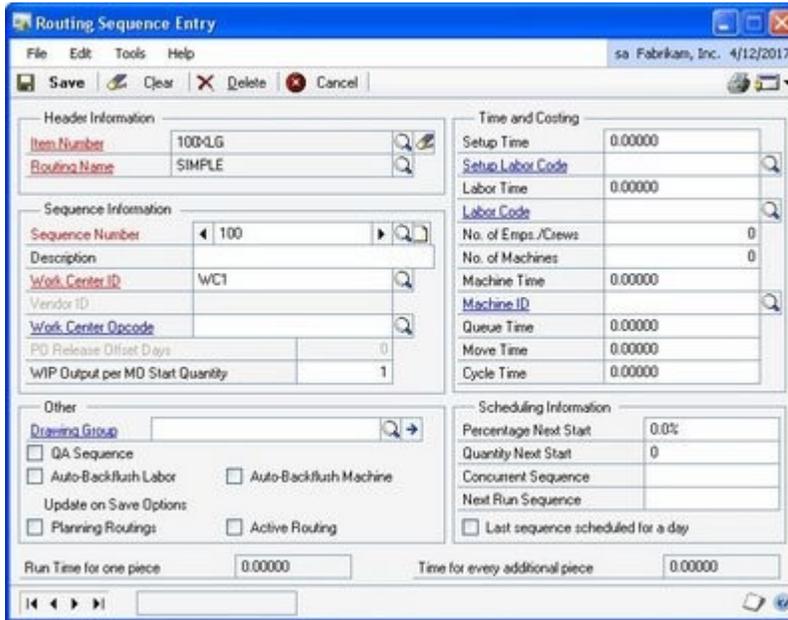
**Routing Header Creation**

File Edit Tools Help sa Fabrikam, Inc. 4/12/2017

Create Header Record

Item Number	100XLG	
Routing Name	SIMPLE	
Revision Level		<input checked="" type="checkbox"/> Primary Routing
Routing Type	Released	

Save Clear Cancel



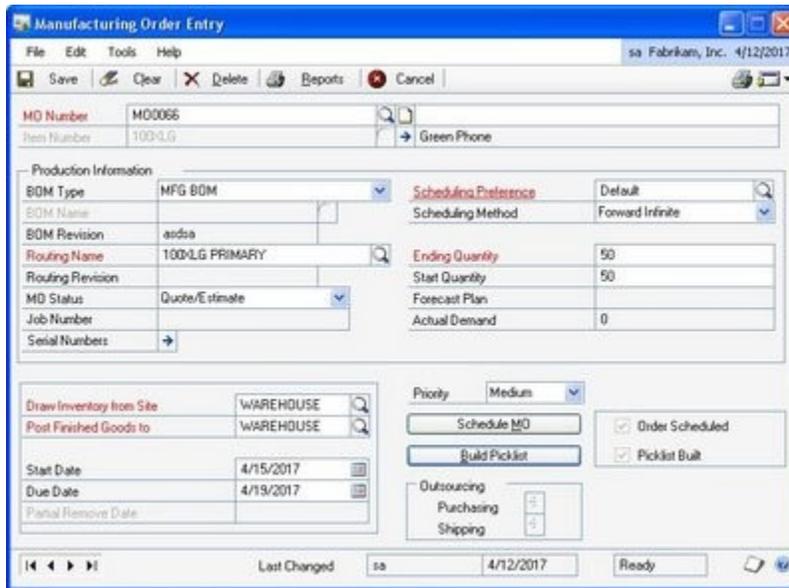
**Routing Sequence Entry**

File Edit Tools Help sa Fabrikam, Inc. 4/12/2017

Save Clear Delete Cancel

Header Information		Time and Costing	
Item Number	100XLG	Setup Time	0.00000
Routing Name	SIMPLE	Setup Labor Code	
Sequence Information		Labor Time	0.00000
Sequence Number	100	Labor Code	
Description		No. of Emps./Crews	0
Work Center ID	WC1	No. of Machines	0
Vendor ID		Machine Time	0.00000
Work Center Drcode		Machine ID	
PO Release Offset Days	0	Queue Time	0.00000
WIP Output per MD Start Quantity	1	Move Time	0.00000
Other		Cycle Time	0.00000
Drawing Group		Scheduling Information	
<input type="checkbox"/> QA Sequence		Percentage Next Start	0.0%
<input type="checkbox"/> Auto-Backflush Labor	<input type="checkbox"/> Auto-Backflush Machine	Quantity Next Start	0
Update on Save Options		Concurrent Sequence	
<input type="checkbox"/> Planning Routings	<input type="checkbox"/> Active Routing	Next Run Sequence	
Run Time for one piece		<input type="checkbox"/> Last sequence scheduled for a day	
0.00000	Time for every additional piece		
	0.00000		

- Create a Manufacturing Order Transaction.
- Navigate to: Transactions >> Manufacturing >> Manufacturing Orders >> Entry
- Look up your finished good item.
- Create a default Scheduling Preference if you don't have one.
- Enter an Ending Quantity amount.
- Assuming a "Forward Infinite" Scheduling Method, enter a "Start Date".
- Click on "Schedule MO" button.
- Click on "Build Picklist" button.
- You are done entering the manufacturing order transaction.



To proceed, change the "MO Status" field to, "Released", and save.

Create a Manufacturing Order Receipt transaction to add the finished good item and relieve the component items from inventory.

Navigate to: Transactions >> Manufacturing >> Manufacturing Orders >> Entry  
Look up your manufacturing order, and enter the quantity of the finished good created.

The Quick MO offers an alternative to the Manufacturing Order, but I like this best, and don't feel it's much more complicated than the Quick MO.

Try this out in the Fabrikam sample company, and you'll see that basically, it's fairly straight forward.

There are significantly more options and functionality, but this will help you get over the initial feeling of being overwhelmed.

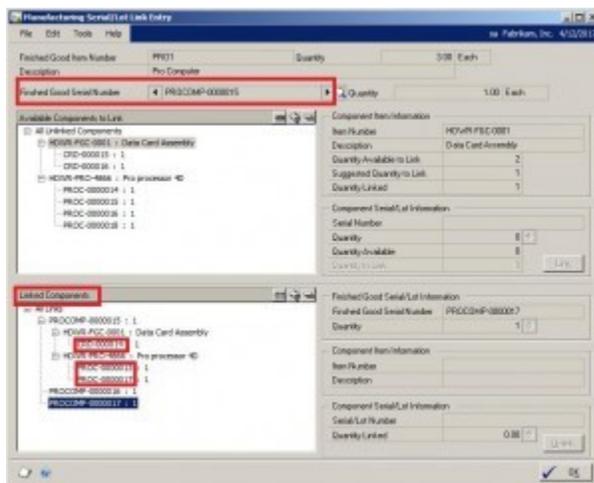
Serial Number Tracking in Dynamics GP

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Dynamics GP includes the functionality to track serial numbers from inventory receipt, through manufacturing, and to the customer. You can track forward and back. You can track component serial numbers in a manufactured item. This functionality is also available for lot tracked items. This is handy if you ever need to execute a product recall or track down the source of a defective product.

To track component serial numbers through the manufacturing process, you need to link the component serial numbers to the finished good serial number. You can easily do this from the Manufacturing Order Receipt Entry screen.

In this example the component item serial numbers, CRD-000014, PROC-000013, and PROC-000017, are linked to the finished good, PROCOMP-000015.

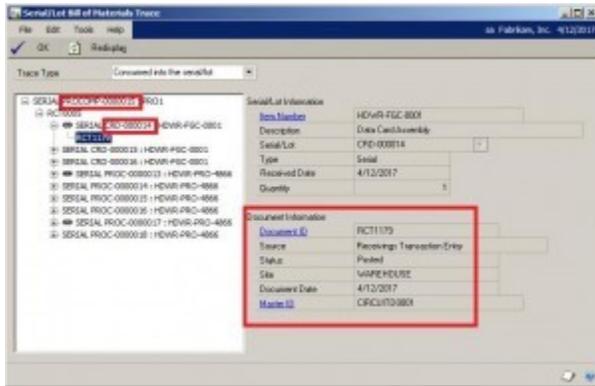


This can be a confusing screen, but if you can select the correct finished good item, the available component serial numbers and the already linked component serial numbers will properly present themselves.

The manufacturing order process is then continued as it normally would be.

To trace serial number throughout the system, use the Serial/Lot trace Inquiry screen. To see the linked component in a manufactured item, click on the View BOM Trace button.

Here you can see the linked component serial number, CRD-000014, and the related receiving transaction where it first came into the inventory.



Related Video: <http://youtu.be/8xjT54QFzwE>

How to Make a Martini in Dynamics GP

Here's a fun video that shows you how easy it can be to use these modules:

<http://youtu.be/62Rea9GV0kg>

MRP

MRP Example

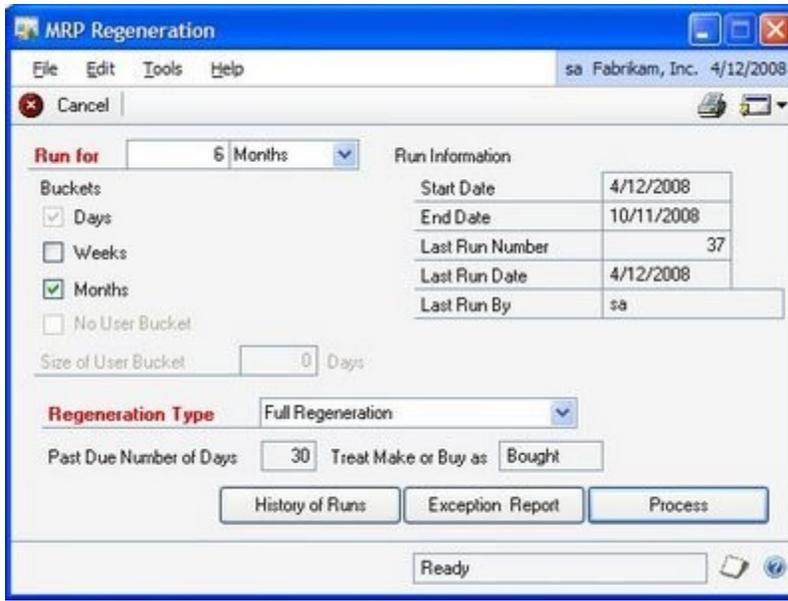
This shows you how to set up a simple MRP run, so you can get the idea of how it works. I'll add a new item, and go through the setup necessary to have MRP pick it up and generate a PO.

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- 1.) Add an item or select an existing one: Cards >> Inventory >> Item
- 2.) Go to the Item Quantities Maintenance screen and assign it to a Site ID, make that Site ID the default site, and select a vendor for the Order Vendor ID.
- 3.) Go to the Item Purchasing Options Maintenance screen and select a Default Purchasing U of M.
- 4.) Go to the Item Vendors Maintenance screen and make sure there is a Vendor Item Number
- 5.) Go to Item Resource Planning. With the Site ID radio button selected, select the Site ID you defined as the default for the item. Check the "Calculate MRP for this item/site". And for Order Policy, select "Lot for Lot". Make sure the Replenishment Method is set to, "Buy".

Done with setup.

Add some demand for the item by creating a sales order for the new item. Run the MRP: Transactions >> Manufacturing >> MRP >> MRP Regeneration Click on "process".

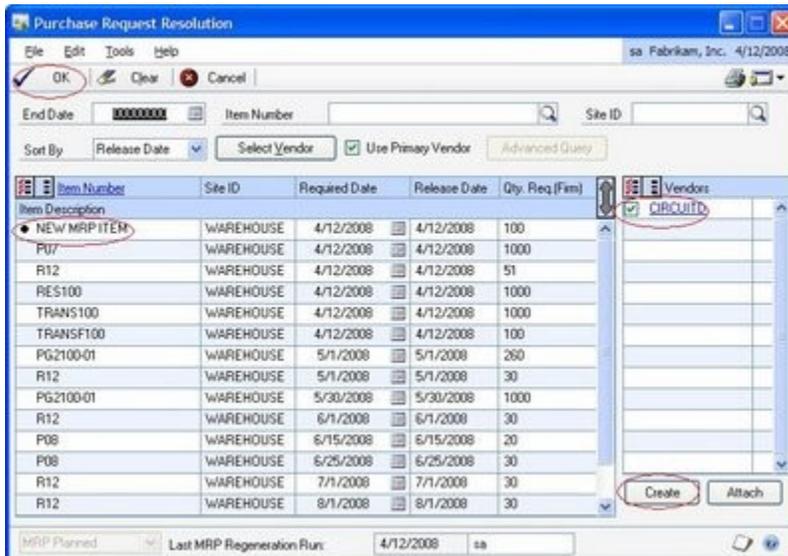


Open the Purchase Request Resolution screen: Transactions >> Purchasing >> Request Resolution

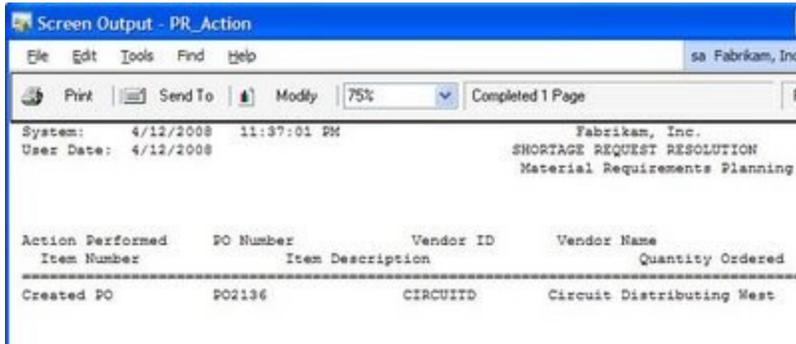
Highlight the "Qty. Req." value for your item, and click on "Select Vendor".

Click on "Create".

Click on "OK".



A purchase order will be created and you'll see a report like this:



The screenshot shows a window titled "Screen Output - PR\_Action" with a menu bar (File, Edit, Tools, Find, Help) and a user name "sa Fabrikam, Inc.". Below the menu bar is a toolbar with icons for Print, Send To, and Modify, along with a zoom level of 75% and a page indicator "Completed 1 Page". The main content area displays system and user information:

System: 4/12/2008 11:37:01 PM Fabrikam, Inc.  
User Date: 4/12/2008 SHORTAGE REQUEST RESOLUTION  
Material Requirements Planning

Below this is a table with the following data:

Action Performed	PO Number	Vendor ID	Vendor Name
Created PO	PO2136	CIRCUITD	Circuit Distributing West

Go to Purchase Order Entry to see the new PO.

There are so many options and screens that can become a factor in how you use MRP, but this will give you a start.

[Unsure About How Dates Are Calculated for MRP Planned Orders?](#)

I find that many Great Plains manufacturing users do not use MRP effectively, or at all, because the release and due dates never seem to make sense. I realize that managing dates and then trusting the release and due dates from an MRP run can be a daunting task. That should not be a good excuse for not using a very powerful and effective tool.

Many users just use the default dates when creating documents that affect inventory and the manufacturing process because it is "too much work" to enter and manage the dates in Purchase Order Processing, Sales Order Processing and Manufacturing. I would argue that it costs users more in time and costs to not manage the dates up front and throughout the purchasing, sales and manufacturing.

How many times have you, as a user, had to track down a shortage, reallocate items to more urgent orders and correct errors? It is my belief as a former Controller and a current GP implementation consultant, that it cost you and your

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organization much more on the back end to deal with incorrect release and due dates than it does to enter and maintain meaningful dates in Dynamics GP manufacturing. In fact, I feel so strongly about it, that I believe the savings would more than pay for an additional head or heads that may be required in your organization to maintain accurate dates.

When dates are used and managed effectively, issues that affect manufacturing and eventually shipping are identified quickly during an MRP run and MRP will even make suggestions on how to deal with the issues. MRP will include suggestions on moving orders in or out and cancelling orders that are oversupplied. Why should you study inventory levels via GP inquiries, reports and SmartLists when MRP will do it for you? Seems like a great time saver to me.

So where does MRP get the data to suggest release and due dates?

The due date is the date an order is due in house to meet the demand that created it. Due dates come from many sources including MO's, MRP suggested MO's, Sales Documents, Sales Forecasts, etc. The release dates suggested by MRP start with the due date of the document or MRP suggestion the item fulfills and works backwards, based on lead times and calendar down days.

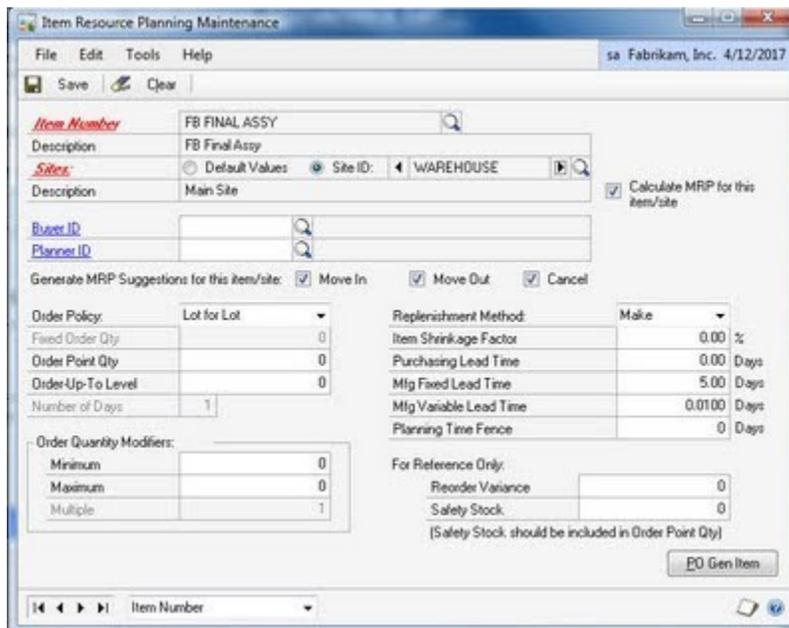
### MRP-Planned Manufacturing Orders

Let's look at MRP-Planned manufacturing orders first. MRP looks at the lead times in the Item Resource Planning windows. The lead times can be entered here manually or generated from routers using the Calculate Mfg Lead Times utility. MRP will look to the item-site combination in Item Resource Planning. Since MRP suggests manufacturing orders for make item only, enter the lead times in days or fractions of days in either the Mfg Fixed Lead Time field or the Mfg Variable Lead Time field or both. MRP uses these fields differently as you might suspect.

- Mfg Fixed Lead Time – does just that, adds a fixed number of days to the MO when calculating the release date. The formula is Due Date – Mfg Fixed Lead Time. For example, if your forecast shows a suggested MO with a due

date of 8/1/2010, the release date would be 5 days earlier or 7/27/2010 as long as 7/27/2010 is not a down day on your work center calendar.

- Mfg Variable Lead Time – is variable based on the quantity suggested. The formula is Mfg Variable Lead Time \* quantity, rounded up to the next whole day. For example, if I have a Mfg Variable Lead Time = .01 and a quantity of 500, my lead time is 5 days.
- Total Manufacturing Lead Time for a make item is Mfg Fixed Lead Time + Mfg Variable Lead Time, rounded up to the next whole day. Mfg Fixed Lead Time & Mfg Variable Lead Time in Item Resource Planning.

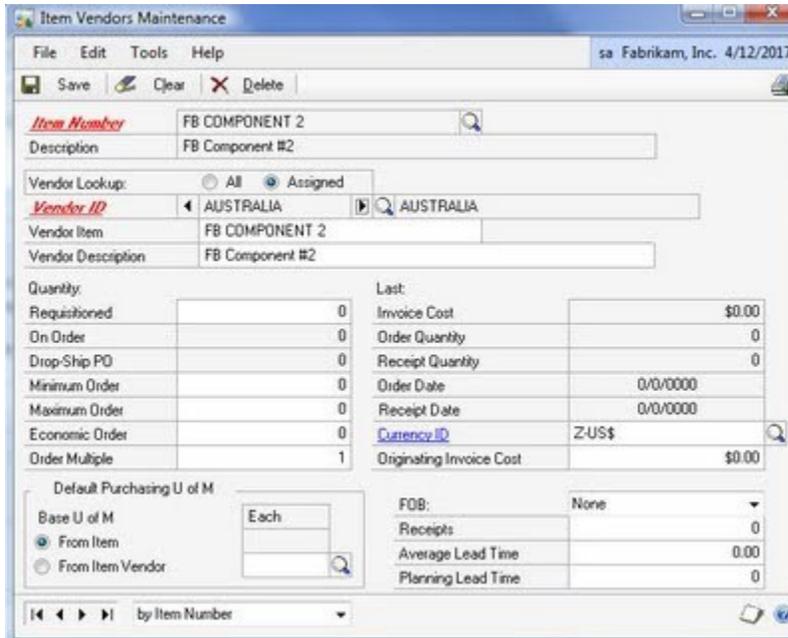


## MRP-Planned Purchase Orders

If the item does not have a default site set in Item Quantities Maintenance, MRP will use the Purchasing Lead Time from the Item-Site combination in Item Resource Planning.

If the item has a default site set in Item Quantities Maintenance, MRP has two choices to select from.

- No Primary vendor selected for the default site – Purchasing Lead Time is from the specified default site in Item Resource Planning Maintenance window.
- Primary vendor has been selected for the default site – Purchasing Lead Time is selected from the item and vendor in the Item Vendors Maintenance window (Planning Lead Time).



I hope that this takes some of the mystery out of the MRP release dates and due dates.

#### Using Routings to Calculate Mfg Lead Times

In a previous post, we discussed how to enter manufacturing lead times in Item Resource Planning manually. Great Plains Manufacturing will calculate the manufacturing lead times for you from the routings you create to manufacture your items. GP Mfg provides a utility that will calculate the manufacturing lead times based on entries you make in your routings.

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As we discussed earlier, there are two types of manufacturing lead times, Mfg Fixed Lead Time and Mfg Variable Lead Time. The entries made in Routing Sequence Entry dictate how these lead times are calculated. The Mfg Fixed Lead Time in Item Resource Planning is determined by the entries made in the Setup Time and the Queue Time on the right hand side of the Routing Sequence Entry window. The Mfg Variable Lead Time in Item Resource Planning is determined by the entry made in the Move Time and the Cycle Time in the Routing Sequence Entry window (see the example below).

The entries made in Routing Sequence Entry are made in hours or fractions of hours. Don't get confused with the entries made in Item Resource Planning that are made in hours. When you run the Calculate Mfg Lead Times utility, it will convert the hours entered in Routing Sequence Entry to days and display them in Item Resource Planning.

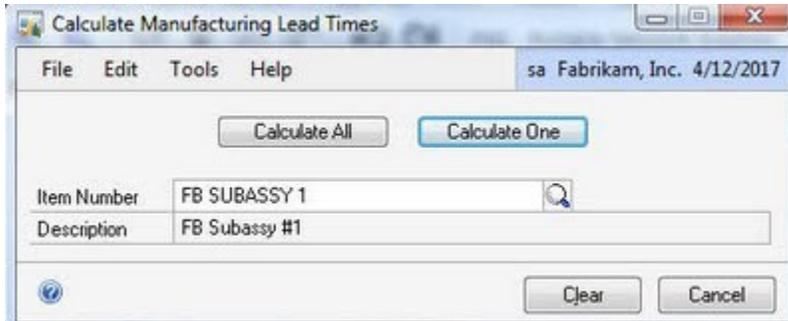
Repeat entering times for each sequence in your routing and the Calculate Mfg Lead Times utility will include entries made in all of your sequences.

The screenshot shows the 'Routing Sequence Entry' window for 'sa Fabrikam, Inc. 4/12/2017'. The window is divided into several sections:

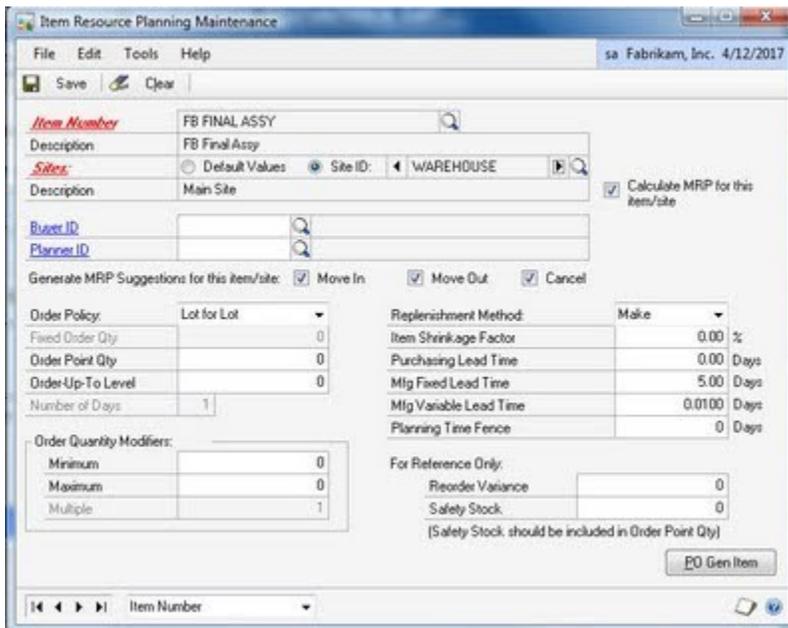
- Header Information:** Item Number: FB SUBASSY 1; Routing Name: FB SUBASSY - PRIMARY.
- Sequence Information:** Sequence Number: 10; Description: Subassembly; Work Center ID: CRP; Vendor ID: ; Work Center Dpcode: ; PO Release Offset Days: 0; WIP Output per MO Start Quantity: 1.
- Time and Costing:** Setup Time: 0.50000; Setup Labor Code: ; Labor Time: 0.25000; Labor Code: LC1; No. of Emps./Crews: 0; No. of Machines: 0; Machine Time: 0.00000; Machine ID: ; Queue Time: 0.10000; Move Time: 0.10000; Cycle Time: 0.10000.
- Other:** Drawing Group: ; QA Sequence: ; Auto-Backflush Labor: ; Auto-Backflush Machine: ; Update on Save Options: Planning Routings: ; Active Routing: .
- Scheduling Information:** Percentage Next Start: 0.0%; Quantity Next Start: 0; Concurrent Sequence: ; Next Run Sequence: ; Last sequence scheduled for a day: .
- Run Time:** Run Time for one piece: 0.80000; Time for every additional piece: 0.20000.

Once you have made your entries in Routing Sequence Entry, you will need to run the Calculate Manufacturing Lead Times utility to convert the hours to days and

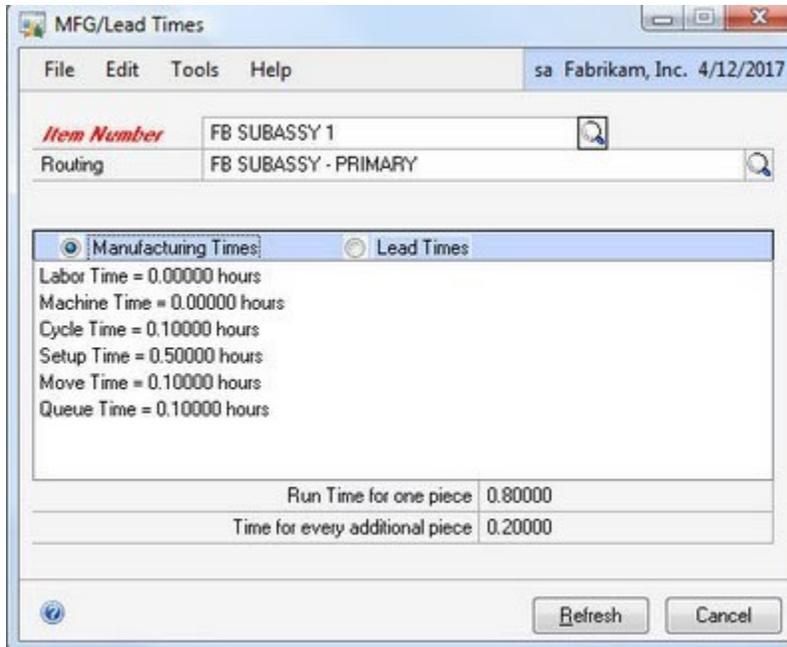
display them in Item Resource Planning. You can run the utility for all items in your item master or just for one item. Click Calculate All for run for all items. To run for one item, enter the item number and click Calculate One.



After running the utility, go to Item Resource Planning. You will see that the Default Values have not been updated, but the sites assigned to the item now reflect the new values calculated by the utility. Also, be aware that running the utility will overwrite and values manually entered in the Item Resource Planning item-site combinations.



You will be able to see all the lead times for an item by doing an inquiry in manufacturing under routings as in the example below.



I would suggest trying this for one item at a time until you get familiar with how Great Plains calculates lead times and you get the results you are expecting.

Multiple Site MRP Calculations in Dynamics GP

Dynamics GP can easily be used to manage inventory demand and supply for multiple inventory locations. By using separate sales forecasts, the MRP functionality in GP can separately analyze forecasted demand, and suggest manufacturing orders and purchase orders to fulfill the demand.

This video shows this functionality in action: <http://youtube.com/v/bHtvHGoHUps>

SmartList Builder for MRP Results

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There are many ways to use SmartList Builder and many reasons why you should check it out. SmartList Builder allows you to create your own SmartLists and to enhance existing SmartList views.

You can easily create a new SmartList to compliment the ones that are provided with GP. And they are very easy to build.

Here's an example of a simple SmartList I built to look at the MRP results from Manufacturing:

<http://youtu.be/-KHervsWrMA> <http://youtu.be/JC3PQ8pSOZM>

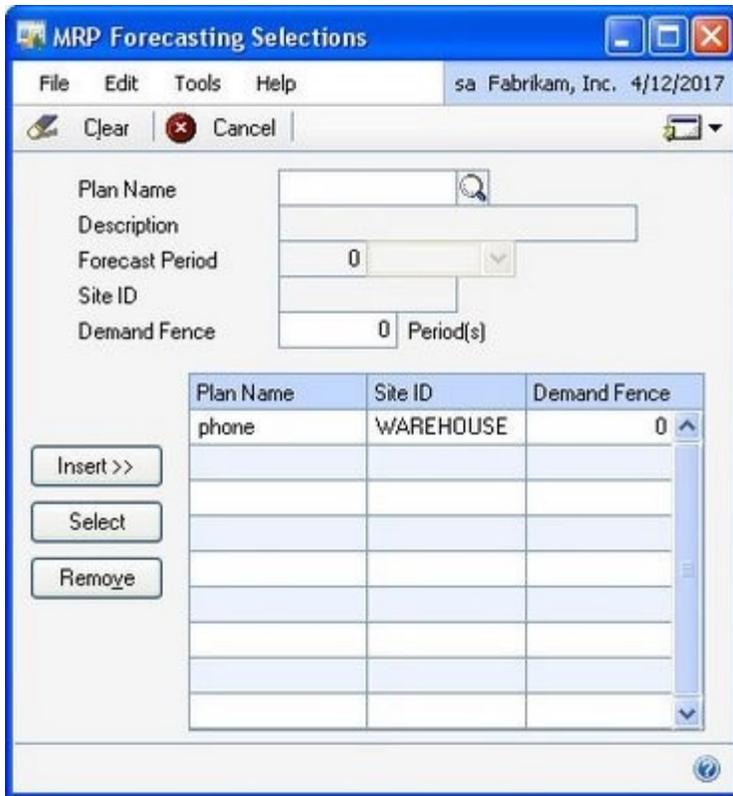
## Forecasting

### Sales Forecast to MRP

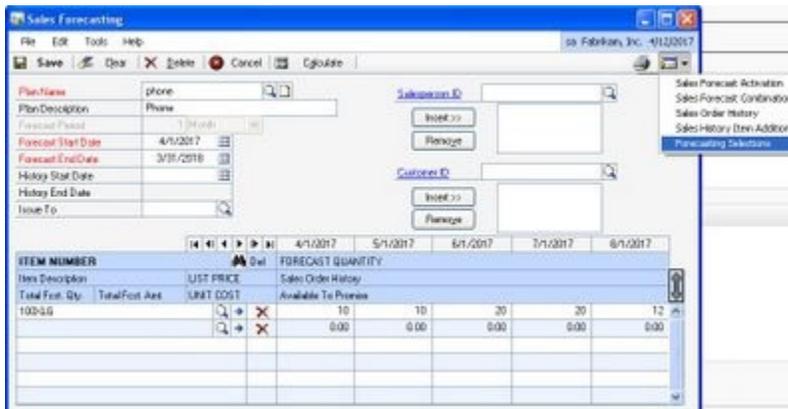
This happens every time I try to include a Sales Forecast in MRP. I cannot find the MRP Forecasting Selections screen. I know exactly what I'm looking for, but for me it has proven to be the most elusive screen in the whole system.

You need to get to this screen if you want to include one or more sales forecasts into the MRP regeneration process.

And here is the shy little screen:



So how do you get to it? This is one way, if not the only way, to get to it. Navigate to: Transactions >> Manufacturing >> Forecasting >> Sales Forecasting. Click on the "GoTo" dropdown and select, "Forecasting Selections", and voila!





Type	Type ID	Document Number	Date	Amount	Batch ID
Quote	STD	QUOTE000001	7/1/2011	\$75,625.00	QUOTES
Quote	STD	QUOTE000002	8/1/2011	\$18,500.00	QUOTES
Quote	STD	QUOTE000003	9/1/2011	\$22,750.00	QUOTES
Quote	STD	QUOTE000004	10/1/2011	\$17,750.00	QUOTES
Quote	STD	QUOTE000005	11/1/2011	\$16,500.00	QUOTES

Here's a Pivot Table easily created from a refreshable Excel report that shows the forecasted quantities by item and date:

Sum of QTY	July-11	August-11	September-11	October-11	November-11	Grand Total
FG 1	18,000	12,000	15,000	12,000	10,000	59,000
FG 2	2,500	2,800	3,200	2,200	3,200	13,900
Grand Total	22,500	14,800	18,200	14,200	13,200	72,900

Here's the setting to check to make sure that MRP looks at Quotes when the MRP regeneration is executed:

MRP Preference Defaults

General MRP Options:

- Calculate Items with no Activity
- Show Items with no Activity
- Activate Planning Time Fence
- Down Day Constraints: None
- MRP Sched. Plan: Standard
- Test Make or Buy Items on:  Made  Bought

MRP Display Quantities:

- 1st MRP Quantity: On Hand Total
- 2nd MRP Quantity: Required Planned
- 3rd MRP Quantity: Acquired Planned
- 4th MRP Quantity: On Hand Firm
- 5th MRP Quantity: Required Firm
- 6th MRP Quantity: Acquired Firm

Bucket Options:

- Default MRP Bucket: Weeks
- User-Defined Bucket Size: Days
- Name of Bucket:

Generate MRP Suggestions for Supply Orders:

- Move In
- Move Out
- Cancel

Security Options:

- Allow Net Change from P&B Inquiry

Quantities to Include:

- Include MD Quotes
- Include SD Quotes
- Put SU Back Orders in Firm Buckets
- Include Past Due for prior: Days

Buttons: Rerdefine MRP Labels, Schedule MRP, OK, Cancel

Related Video: <http://youtu.be/PwDQayepDm8>

Sales Forecasting and MRP in Dynamics GP

[www.amllp.com](http://www.amllp.com) 11512 El Camino Real, Suite 311; San Diego, CA 92130 (858) 207-5139

This video shows a simple example of how to use Sales Forecasting and MRP.

I used Sales Forecasting to set up the demand in GP. The finished good item has estimated sales volume out 12 months into the future. I could have easily added other items, or changed the forecast bucket size and period. The sales forecast is set up to be included in the MRP calculation.

I ran the MRP regeneration and showed the suggested Manufacturing Orders and suggested Purchase Orders that are generated by the MRP process.

Related Video: <http://youtube.com/v/89K-FWrnhFk>

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