

As the Wrench Turns

CPMS User's Journal

Getting Control of Inventory

Where do you Start?

Not an easy task. Some plants make the mistake of setting unrealistic goals when they decide to "finally get control of their spare parts". Here are some tips to avoid that pitfall:

1. Determine the current status of your inventory control, where you would like it to be, and what is required in getting there.
2. A reasonable goal is to be able to pick up any spare part and easily determine the manufacturer, the manufacturer's part number, a complete and accurate part description, the vendor

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"I'm not sure when I can help you.
It's not easy getting parts for you anymore."

(supplier), the location in the parts room, and what equipment the part is used on.

3. In order to find out the quality of your existing parts room, select a half dozen part numbers at random in CPMS and make a note of the part location and

quantity on hand. Now go check if the parts you selected are at the correct location with the right quantity.

I was recently at a plant where they were six for six! First time that has happened in more than twenty years!

Potholes in your Parts

- Parts with no prices.
- Vendor and Supplier part numbers instead of, or in addition to, Manufacturer part numbers.
- The same part in CPMS with multiple part numbers.
- Vendor/Supplier shown as the Manufacturer and/or the Manufacturer shown as the Vendor.
- Invalid, non existent, or poorly designed part location codes.
- Invalid characters in the part number and/or the description. This will cause problems with bar codes for the part numbers and when unloading or searching for data with part descriptions. Examples are quotes, commas, and parentheses.
- Invalid Quantity on Hand or Quantity on Order. Open Part transactions are not being processed in a timely manner or invalid transactions are left in the Open Transaction file. Or, the orders and receipts are being kept up to date in the Purchasing module but parts are not being checked out (Issues).
- Some plants change their part quantities by using Inventory Utilities, Inventory Quantity Adjustment. This function should be used to correct quantity errors found when performing a physical inventory. You will lose all part usage history (pricing, vendors, dates, etc.) if you don't enter and process part transactions. And, your part tags will be missing important part info.

Check Quality of Your Data

A handy utility to check for errors in your CPMS tables is, Supervisor, Data Base Analyzer, Check Quality of Your Data. The example on the next page shows a portion of the results for the Parts table.

Count is the number of non blank values for this column. **Rows** is the total number of rows in the



"GOODNESS, THE POTHOLES ARE DEEP THIS YEAR, AREN'T THEY?"

table. **Minimum** is the smallest value and **Maximum** is the largest value for this column.

Note that for Part Location (PR_LOC) the rows and count are 9588 and 9321 respectively. This would indicate that 267 parts have a blank location. Also, the Part Number (PR_NBR) has a quotation mark as the first character of part number CO1267 which makes it the Maximum part number. (The quotation mark will result in an invalid bar code.) And lastly, note that for Part Description (PR_DES) the Minimum description begins with seven spaces and the Maximum begins with a bracket in "[GEAR]".

The Check Quality of Your Data function is a quick way for you to determine if all the values for a particular column in a table fall between a valid range of values. This is very useful for checking import values such as dates, dollars, and quantities.

Category	Count	Rows	Minimum	Maximum	Sum	Average	Std Dev	Variance
PR_NBR	9588	9588	0	`C01267				
PR_DES	9588	9588	BELT PULLEY FOR DOBOY S	[GEAR] SPEED REDUCER				
PR_MNF	9588	9588	00001	YAMATO				
PR_UNITP	9588	9588			\$0.00	\$36,102.47	\$1,870,588.91	\$195.10
						\$751.11	\$564,160.65	
PR_ISSUE	9588	9588	0	ZZZ				
PR_LOC	9321	9588	NEW	ZZZZ				

At a number of plants over the years we found parts where a very large number was accidentally entered into a quantity or unit price which resulted in the total value of inventory shown as \$1 million more than it should have been. In other cases an invalid date was entered into an equipment failure, work order, or part transaction, which caused the data to not be included in reports where it should have appeared.

And the Winner is...

OK. I guess we need to increase the prize money because no one has won for the past two newsletters and we feel the CPMS Quiz is quite

easy. It is usually based on a problem we just solved for one of the plants or a recent topic we have discussed in our newsletters

The last CPMS Quiz was:

What is the best/easiest way to determine the total PM time your crew is/was scheduled to work on "Line 1" for next month and for last month? Assume that only your "Line 1" equipment begins with "L1".

To see the total PM scheduled time for last month you would run Print, Work History (Detail) and enter the desired date range and equipment selection (L1*). And to see the total PM scheduled time for next month you would need to

generate a schedule for next month and then go to Print, Work Cards, Supervisors Schedule, and enter the desired date range. The total time in hours is shown on the last page of the schedule.

CPMS Quiz

For \$100, if you run the Check Quality of Your Data utility on your Parts table and the Last Transaction date has the following values:

Minimum =	11/25/00
Maximum =	03/28/08
Average =	06/05/58

it shows the lowest date is November 25, 2000 and the highest date is March 28, 2008. How could the average date be June 5, 1958?

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