

## Route Module

The Route Module details the method of manufacture of a particular item. It includes the operation steps to be performed, their sequence, the work centers that will be used, and the standards for setup and run. To all intents and purposes, ALERE will allow you to create as many different routes as are required. Routes are one of the three key elements, including material lists (BOM's) and product configurations, that are appended to work orders as they are created.

Routes support revision tracking to help you manage significant changes. Each route can have up to 999 separate operation steps that can be built from an "Operations Library" or manually created as needed. Each operation step can contain:

- The preferred work center to be used
- A shrink factor to account for increases or decreases in the WIP quantities
- A batch size to set how many of the item are processed per cycle time
- The option to overlap steps by specifying whether or not partial quantities completed on a step will be immediately started on the next step
- Unlimited space to write up the instructions for the step
- A field to record the set up time required to prepare for the job
- A field to record the cycle time to complete each item or batch of items
- The labor grades required to perform the set up work and run the job
- The ability to account for split labor when a person runs more than one machine at a time

Op No	Description
10	Build Handlebars
20	Attach to frame
30	Install Shifter & Pedals
40	Mount tires to Wheels, don't for
50	Mount wheels & seat to bike
60	Install Options
70	Quality Control Inspection

Fields that can be defined by the user can be used to "customize" routes to match the particular requirements of an industry. Hyperlinks can be embedded in the notes fields of each step. This makes drawings, data sheets, pictures, and a host of supporting information readily available in one document.

Assigned Item Number	Quantity
MBRE01	1.0000
MBSP01	1.0000
MBTT01	2.0000
MBWH01	2.0000
MBXH01	1.0000
MBYB01	1.0000
MBYD01	1.0000
MBYF01	1.0000

Unassigned Item Number	Description	Quantity
MBCH01	Chain Assy	1.0000
MBLU01	Lubricant, Moly Grease	0.0010
MBPD01	Pedal Assembly	2.0000

Manufactured items can have their bill of material distributed over the operation steps that make up a route. In this manner a work order can be printed to show the list of material required for each step of the route. The material planning process (MRP) can then be synchronized with the actual production floor when work orders are scheduled. This approach permits a very sophisticated management tool for coordinating material requirements throughout the factory.