

**SAP Manufacturing Execution
How-To Guide**



How To Set Up and Use the SAP ME Time Sensitive Material Feature

Applicable Release: ME 6.0

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SAP ME How-To-Guide for Time Sensitive Material

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Document History

Document Version	Description	Author
1.0	Initial version	Chet Moutrie
1.1	Minor correction in Usage Scenario	Chet Moutrie

Table of Contents

1	Introduction.....	1
1.1	Purpose.....	1
1.2	Scope.....	1
1.3	Glossary	1
2	TSM Feature Overview.....	1
2.1	Description and Applicability	1
2.2	Business Purposes / Functions	1
2.3	High-Level Process Flows	2
2.4	High Level Data Model.....	2
2.5	Best Practices	2
3	TSM Functions.....	2
3.1	Definition of Time Constraints	2
3.1.1	Description and Applicability	2
3.2	Check-In and Check-Out	3
3.2.1	Description and Applicability	3
3.2.2	Purpose / Effects	3
3.2.3	Best Practices	4
3.3	Validation of Time Sensitive Components	4
3.3.1	Description and Applicability	4
3.4	Stopping Time Sensitive Clocks	4
3.4.1	Description and Applicability	4
4	Integration.....	4
5	TSM Setup	5
5.1	Maintenance Activities	5
5.1.1	Activity Rules	5
5.1.2	Activity Hooks	5
5.1.3	Product Configuration.....	6
5.1.4	Other Maintenance Activities	7
6	TSM Usage Scenario / Example	7
6.1	Time Sensitive Sealant Scenario.....	7
6.1.1	Purpose / Goal.....	7

SAP ME How-To-Guide for Time Sensitive Material

6.1.2	Scenario Specific Settings.....	7
6.1.3	Scenario Steps.....	7
6.2	Time Sensitive Composite Material Scenario.....	10
6.2.1	Purpose / Goal.....	10
6.2.2	Scenario Specific Settings.....	10
6.2.3	Scenario Steps.....	10
7	Links to Additional Information	13
8	Other Reference Material.....	13
9	Overview of Changes.....	13

1 Introduction

1.1 Purpose

This SAP ME How-To-Guide for the Time Sensitive Material (TSM) feature is intended to provide sufficient information to enable the user to easily configure and readily utilize the Time Sensitive Material feature making use of available best practices.

1.2 Scope

This How-To-Guide covers all aspects of the Time Sensitive Material feature.

1.3 Glossary

Floor Life	The length of time that the material will retain its quality and effectiveness while out of storage and on the shop floor
Shelf Life	The length of time that the material will retain its quality and effectiveness while being stored (usually in a controlled environment)
TSM	Time Sensitive Material – Items whose quality or effectiveness degrade over time and which are often kept in a controlled environment when not being used on the shop floor

2 TSM Feature Overview

This overview provides a high level description of the Time Sensitive Material feature.

2.1 Description and Applicability

This feature addresses materials which have physical or process characteristics that degrade over time, thereby affecting end product viability. Examples are composite and moisture-sensitive materials used during various assembly and fabrication processes in the high-tech, aerospace, automotive, and life sciences industries. This feature is applicable to any manufacturing company who has time-sensitive materials which require special management and monitoring.

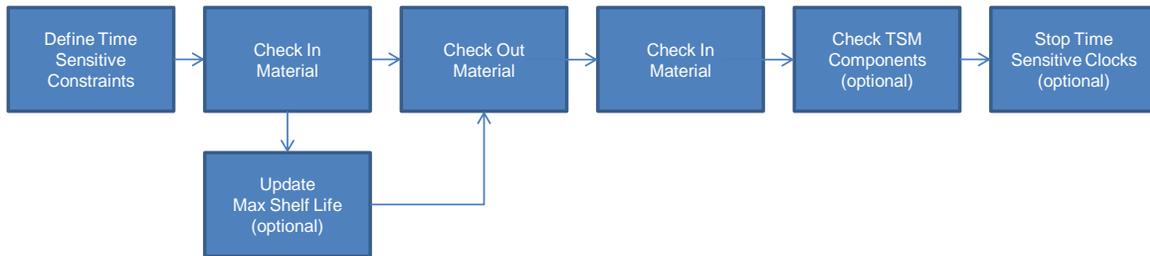
2.2 Business Purposes / Functions

This feature is aimed at capturing and tracking the time associated with the shelf life and floor life of materials that are time sensitive. The TSM feature includes the following functions:

- Definition of Time Constraints
- Check-In and Check-Out of Material
- Validation of Time Sensitive Components
- Stopping Time Sensitive Clocks

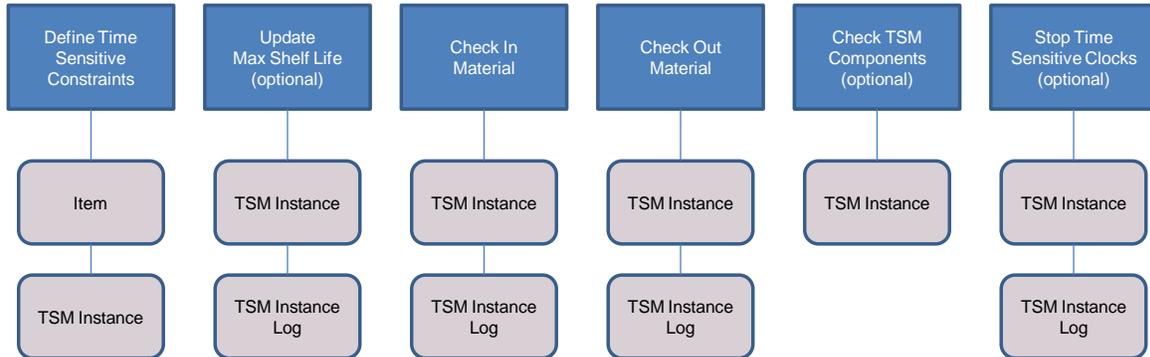
2.3 High-Level Process Flows

This figure illustrates the primary flow of the setup and use of the TSM feature.



2.4 High Level Data Model

The following figure shows the relationship between some of the TSM functions and ME database tables.



2.5 Best Practices

3 TSM Functions

3.1 Definition of Time Constraints

3.1.1 Description and Applicability

The Material Maintenance activity provides the capability to specify that the material is time sensitive and to define its maximum shelf life. This is the maximum time over which a material may be stored without a loss of quality or effectiveness that would make it unusable. It also provides the capability to define the maximum floor life, the maximum time that an exposed material can remain usable while outside of a controlled environment. See [Material Maintenance](#) in this document for more details.

When a material is received via the Floor Stock Receipt activity, a TSM record is created for it and the material is automatically checked in.

SAP ME How-To-Guide for Time Sensitive Material

The Maintain Floor Stock activity (MAINT_INV) provides the capability to update the maximum shelf life for an inventory item, if the activity rule ALLOW_UPDATE_FLOOR_LIFE is set to YES. This is applicable to situations where the material has been renewed or reconditioned to extend its shelf life. See [Maintain Floor Stock](#) in this document for more details.

3.2 Check-In and Check-Out

3.2.1 Description and Applicability

The Time Sensitive Material Check-In/Out activity (TSM_CHECK_IN_OUT) provides the capability to check material into or out of a storage environment. The material is identified by an SFC number or an inventory ID. The storage environment is typically a refrigerated unit or some other container that provides a controlled environment to maximize shelf life.

3.2.2 Purpose / Effects

The material items to be checked out or checked in can be found by specifying an SFC number, an inventory ID or a shop order ID. A material / version and an operation can be specified to assist in the search for the needed SFC numbers and/or inventory IDs.

The following screenshot shows the Time Sensitive Material Check-In / Check-Out plug-in.

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out

Current Time Out is the current elapsed time since the item was last checked out. For an SFC which has time sensitive components, it is the maximum current elapsed time of any single active component assembled into this parent SFC.

Cumulative Time Out is the total of all elapsed times during which the item has been checked out. For an SFC which has time sensitive components, it is the maximum total elapsed times of any single active component assembled into this parent SFC.

3.2.2.1 Check-Out

As soon as a check-out is performed, TSM captures the checkout date and time and starts decreasing the *Remaining floor life* (starts / restarts the floor life clock) for the SFC number or inventory ID. Check-out does not stop the shelf life clock. The shelf life clock starts as soon as the item is checked in the first time and it does not stop until the

Stop Time Sensitive Clock activity stops it, the *Remaining Shelf Life* reaches zero or the *Remaining Floor Life* reaches zero.

If an attempt is made to assemble a time sensitive component that is not checked out, the operator will be prompted to perform the check-out.

3.2.2.2 Check-In

As soon as a check-in is performed, TSM captures the check-in date and time and stops consumption of floor life units for the selected SFC number or inventory ID. Check-in resets the *Current Time Out* clock to zero for the selected SFC number or inventory ID. TSM starts the shelf life clock when the SFC number or inventory ID is received via the Shop Floor Receipt activity.

3.2.3 Best Practices

Since each piece, or unit of material, that will be checked in and out of storage must have its own unique identifier (SFC number or inventory ID), each one should be received into floor stock separately even if they were provided in a single lot by the vendor.

3.3 Validation of Time Sensitive Components

3.3.1 Description and Applicability

The Check Time Sensitive Components activity can be used to prevent the processing of an SFC if all available units for any needed TSM component have expired. Checking out a TSM component is not permitted if the maximum shelf life has been exceeded. To avoid this error while an operator is working in the POD, the Check Time Sensitive Components activity can be attached at a PRE_START hook point for an operation or resource. It can determine if all available units, for one or more needed TSM components, have exceeded their shelf or floor life and can keep the SFC(s) from being started.

3.4 Stopping Time Sensitive Clocks

3.4.1 Description and Applicability

To stop time measurement clocks for all TSM components assembled for an SFC at a particular operation, the Stop Time Sensitive Clock activity can be attached at the PRE_COMPLETE hook point for the operation. This activity stops both shelf life and floor life clocks for each SFC and all of its assembled components that are time-sensitive materials. This causes time accumulation to stop and causes the SFC number and its assembled components to no longer be considered time-sensitive.

This can be used for normal processing, where the installed component is no longer time sensitive, and for exception processing, where the SFC is being scrapped.

4 Integration

Not applicable

5 TSM Setup

5.1 Maintenance Activities

5.1.1 Activity Rules

5.1.1.1 Allow Update Floor Life

Setting the activity rule ALLOW_UPDATE_FLOOR_LIFE to YES for the Maintain Floor Stock (MAINT_INV) activity, enables editing of the *Max Floor Life* field. When the user edits the *Maximum Floor Life* value for any inventory ID, the *Maximum Floor Life* value is checked to ensure that the new floor life expiration date would not exceed the shelf life expiration date.

5.1.2 Activity Hooks

5.1.2.1 Check Time Sensitive Components

5.1.2.1.1 Purpose / Effects

The Check Time Sensitive Components activity can be used to prevent the processing of an SFC if all available units for any needed TSM component have expired. Checking out a TSM component is not permitted if the maximum shelf life has been exceeded. It can determine if all available units, for one or more needed TSM components, have exceeded their shelf or floor life and can keep the SFC(s) from being started.

5.1.2.1.2 Hook Points

The Check Time Sensitive Components activity can be attached at a PRE_START hook point for an operation or resource.

5.1.2.1.3 Example

The following screenshot provides an example of attaching the activity at the PRE_START hook point for an operation.

Operation Maintenance

Retrieve Save Clear Delete

* Site: BOBJ

* Operation: ASSEMBLY_PREP * Version: A

Main Certifications **Activity Hooks** System Rules Custom Data

Insert New Insert Before Insert After Remove Selected Remove All

Sequence	Hook Point	* Activity	Enabled	User Argument
10	PRE_START	CHECK_TSM_COMPONE	<input checked="" type="checkbox"/>	

5.1.2.2 Stop Time Sensitive Clock

5.1.2.2.1 Purpose / Effects

This activity stops both shelf life and floor life clocks for each SFC and all of its assembled components that are time-sensitive materials. This causes time accumulation to stop and causes the SFC number and its assembled components to no longer be considered time-sensitive. This can be used for normal processing, where the installed component is no longer time sensitive, and for exception processing, where the SFC is being scrapped.

5.1.2.2.2 Hook Points

The Stop Time Sensitive Clock activity can be attached at the PRE_COMPLETE or POST_COMPLETE hook point for an operation.

5.1.2.2.3 Example

The following screenshot provides an example of attaching the activity at the PRE_COMPLETE hook point for an operation.

Operation Maintenance

Retrieve Save Clear Delete

* Site: BOBJ

* Operation: SCRAP * Version: A

Main Certifications **Activity Hooks** System Rules Custom Data

Insert New Insert Before Insert After Remove Selected Remove All

Sequence	Hook Point	* Activity	Enabled	User Argument
10	PRE_COMPLETE	STOP_TIME_SENS_CLO	<input checked="" type="checkbox"/>	

5.1.3 Product Configuration

5.1.3.1 Material Maintenance

The following table describes the time sensitive material related fields.

Field	Description
Main tab	
<i>TSM</i>	Selecting this checkbox specifies that the material is time sensitive
TSM tab	
<i>Max Shelf Life</i>	The maximum length of time the material can be stored without degrading its quality or effectiveness to an unacceptable level. Required field
<i>Units</i>	Units value for the maximum shelf life of the material: <i>Days</i> (default), <i>Months</i>
<i>Max Floor Life</i>	The maximum length of time the material can be exposed to an uncontrolled environment without degrading its quality or effectiveness to an unacceptable level. The <i>Maximum Floor Life</i> value must not exceed the <i>Maximum Shelf Life</i> value. Required field
<i>Units</i>	Units value for the material's maximum floor life: <i>Minutes</i> , <i>Hours</i> , <i>Days</i> (default), or <i>Months</i>
<i>Note</i>	A free-form note concerning the time sensitive nature of the material.

The TSM checkbox is only enabled for materials that have a *Type of Purchased* or *Manufactured/Purchased*.

5.1.4 Other Maintenance Activities

5.1.4.1 Floor Stock Receipt

When a purchased material is received via the Floor Stock Receipt activity, the Shelf Life Expiration Date is set to a date and time based upon the current date and the *Max Shelf Life* value and units defined in Material Maintenance. The *Shelf Life Expiration Date* is always set to the end of the day in local time (in the time zone specified in Site Maintenance).

5.1.4.2 Maintain Floor Stock

The Maintain Floor Stock activity provides the capability to update the maximum shelf life for an inventory item. This is applicable to situations where the material has been renewed or reconditioned to extend its shelf life. This capability is only available if the activity rule `ALLOW_UPDATE_FLOOR_LIFE` is set to YES for this activity (`MAINT_INV`).

6 TSM Usage Scenario / Example

6.1 Time Sensitive Sealant Scenario

6.1.1 Purpose / Goal

A time sensitive material, a sealant, is used in an operation but is not consumed at the operation. The material is not included in the BOM for the material being assembled.

6.1.2 Scenario Specific Settings

The material, SEALANT, is designated as a time sensitive material with a shelf life of 1 month and a floor life of 3 hours.

6.1.3 Scenario Steps

1. A Lot of 8 cans of sealant arrives from the vendor
2. Each can of sealant is processed separately and receives a unique inventory ID in Floor Stock Receipt
3. Each inventory ID is automatically checked in as it is received
4. When preparing for the assembly operation, where the sealant will be used, one of the sealant inventory IDs is checked out using the TSM Check-In/Out plug-in in a POD
5. Check out will be successful as long as neither the shelf life nor the floor life has expired
6. After the sealant is used, the inventory ID needs to be checked in

SAP ME How-To-Guide for Time Sensitive Material

7. An example screenshot of the TSM Check-In/Out plug-in is shown below

The screenshot shows the 'TSM Check In/Check Out' window. The 'Site' is set to 'BOBJ'. The 'Material' field is empty, and the 'Version' is 'A'. There are fields for 'Shop Order', 'SFC', 'Inventory ID' (containing 'SEALANT-000031'), and 'Assembly Operation'. Below these fields are 'Retrieve' and 'Clear' buttons. A table below shows the following data:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	SEALANT-000031	SEALANT/A	30.49 Days	2.94 Hours	0.06 Hours	

At the bottom, there are 'Check out', 'Check In', and 'Return to POD' buttons.

8. The inventory ID is checked in

9. The next time this inventory ID is checked out, the information will be as shown in the screenshot below

The screenshot shows the 'TSM Check In/Check Out' window. The 'Site' is 'BOBJ'. The 'Material' field is highlighted in yellow. The 'Inventory ID' is 'SEALANT-000031'. The table below shows the following data:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	SEALANT-000031	SEALANT/A	30.48 Days	2.84 Hours	0.00 Hours	0.16 Hours

At the bottom, there are 'Check out', 'Check In', and 'Return to POD' buttons.

10. A few minutes later, retrieving this inventory ID again will show the information in the screenshot below. Note: the cumulative time out is only updated upon check in.

The screenshot shows the 'TSM Check In/Check Out' window. The 'Site' is 'BOBJ'. The 'Material' field is empty. The 'Inventory ID' is 'SEALANT-000031'. The table below shows the following data:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	SEALANT-000031	SEALANT/A	30.48 Days	2.78 Hours	0.06 Hours	0.16 Hours

At the bottom, there are 'Check out', 'Check In', and 'Return to POD' buttons.

SAP ME How-To-Guide for Time Sensitive Material

11. After checking in the inventory ID a few seconds later and then checking it back out again, the information will be as shown in the screenshot below

The screenshot shows the SAP TSM Check In/Check Out interface. The title bar reads "TSM Check In/Check Out". Below the title bar, there is a status bar that says "Time-Sensitive Material Checked Out". The main area contains the following fields:

- Site: BOBJ
- Material: [Yellow highlighted field]
- Version: A
- Shop Order: [Field]
- SFC: [Field]
- Inventory ID: SEALANT-000031
- Assembly Operation: [Field]

Below these fields are two buttons: "Retrieve" and "Clear". At the bottom of the main area is a table with the following data:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	SEALANT-000031	SEALANT/A	30.47 Days	2.77 Hours	0.00 Hours	0.23 Hours

At the bottom of the interface are three buttons: "Check out", "Check In", and "Return to POD".

12. The screenshot below shows the information after leaving the inventory ID checked out for three hours

The screenshot shows the SAP TSM Check In/Check Out interface. The title bar reads "TSM Check In/Check Out". Below the title bar, there is a status bar that says "Time-Sensitive Material Checked Out". The main area contains the following fields:

- Site: BOBJ
- Material: [Field]
- Version: [Field]
- Shop Order: [Field]
- SFC: [Field]
- Inventory ID: SEALANT-000031
- Assembly Operation: [Field]

Below these fields are two buttons: "Retrieve" and "Clear". At the bottom of the main area is a table with the following data:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	SEALANT-000031	SEALANT/A	30.35 Days	0 Hours	3.07 Hours	0.23 Hours

At the bottom of the interface are three buttons: "Check out", "Check In", and "Return to POD".

13. The following screenshot shows the results when trying to check in the inventory ID

The screenshot shows the SAP TSM Check In/Check Out interface. The title bar reads "TSM Check In/Check Out". Below the title bar, there is a red error message: "Time-sensitive life limit for components SEALANT/A expired (Message 15363)". The main area contains the following fields:

- Site: BOBJ
- Material: [Yellow highlighted field]
- Version: [Field]
- Shop Order: [Field]
- SFC: [Field]
- Inventory ID: SEALANT-000031
- Assembly Operation: [Field]

Below these fields are two buttons: "Retrieve" and "Clear". At the bottom of the main area is a table with the following data:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	SEALANT-000031	SEALANT/A	30.35 Days	0 Hours	3.07 Hours	0.23 Hours

At the bottom of the interface are three buttons: "Check out", "Check In", and "Return to POD".

6.2 Time Sensitive Composite Material Scenario

6.2.1 Purpose / Goal

A time sensitive material, a roll of composite material for an aircraft wing, is partially consumed at an operation.

6.2.2 Scenario Specific Settings

- The material, COMPOSITE_WC22, is designated as a time sensitive material with a shelf life of 5 days and a floor life of 10 hours. The unit of measure is FEET.
- A material WING is defined, with a BOM that contains COMPOSITE_WC22 as a component
- A routing is created with an operation LAY_COMPOSITE
- The routing is assigned to material WING
- An SFC is created and released for WING

6.2.3 Scenario Steps

1. A roll of 200 feet of composite material WC-22 arrives from the vendor
2. The roll is processed and is received as a quantity of 200 with one inventory ID (COMP-000046)
3. The inventory ID is automatically checked in as it is received
4. The SFC (BOBJ49) is started at the operation LAY_COMPOSITE in the POD
5. The Assembly Point activity is started
6. The operator selects the component COMPOSITE_WC22/A
7. The operator selects the inventory ID BOBJ46
8. The operator selects the Add button
9. The error message “One or more selected materials is not checked out” is displayed
10. The operator selects the Activities button, the TSM Check-In/Out activity and the OK button
11. The TSM Check-In/Out plug-in is displayed in a pop-up window
12. The operator selects the Retrieve button

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
	BOBJ49	COMPOSITE_WC22/A				

SAP ME How-To-Guide for Time Sensitive Material

- The operator selects the browse icon in the SFC | Inventory ID column and selects BOBJ46

TSM Check In/Check Out

Site: BOBJ
Material: WING Version: A
▲ Shop Order:
▲ SFC: BOBJ49
▲ Inventory ID:
Assembly Operation: LAY_COMPOSITE
Retrieve Clear

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
	BOBJ49					
	BOBJ46	COMPOSITE_WC22/A	2.51	10.00		

Check out Check In Return to POD

- The operator selects the row containing BOBJ46 and selects the Check out button

TSM Check In/Check Out

Time-Sensitive Material Checked Out

Site: BOBJ
Material: WING Version: A
▲ Shop Order:
▲ SFC: BOBJ49
▲ Inventory ID:
Assembly Operation: LAY_COMPOSITE
Retrieve Clear

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
	BOBJ49					
		COMPOSITE_WC22/A				

Check out Check In Return to POD

- The operator selects the Return to POD button
- The operator selects the Add button
- A quantity of 125 feet of the composite is successfully assembled
- The operator selects the Activities button, the TSM Check-In/Out activity and the OK button
- The TSM Check-In/Out plug-in is displayed in a pop-up window

SAP ME How-To-Guide for Time Sensitive Material

20. The operator selects the Retrieve button

The screenshot shows the SAP TSM Check In/Check Out interface. At the top, a message states "No records found (Message 12213)". The search criteria are as follows:

- Site: BOBJ
- Material: WING
- Version: A
- Shop Order: (empty)
- SFC: BOBJ49
- Inventory ID: (empty)
- Assembly Operation: LAY_COMPOSITE

Buttons for "Retrieve" and "Clear" are visible. Below the search criteria is a table with the following columns: Out, SFC | Inventory ID, Material/Version, Rem. Shelf Life, Rem. Floor Life, Cur. Time Out, and Cum. Time Out. The table is currently empty.

Buttons for "Check out", "Check In", and "Return to POD" are located at the bottom of the screen.

21. The material WING no longer has a time sensitive component since the composite has now been assembled

22. The operator clears the screen, enters BOBJ46 in the Inventory ID field and selects the Retrieve button

The screenshot shows the SAP TSM Check In/Check Out interface. The search criteria are:

- Site: BOBJ
- Material: (empty)
- Version: (empty)
- Shop Order: (empty)
- SFC: (empty)
- Inventory ID: BOBJ46
- Assembly Operation: (empty)

Buttons for "Retrieve" and "Clear" are visible. The table below has one record:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
X	BOBJ46	COMPOSITE_WC22/A	2.49 Days	9.69 Hours	0.31 Hours	

Buttons for "Check out", "Check In", and "Return to POD" are located at the bottom of the screen.

23. The operator selects the row containing BOBJ46 and selects the Check In button

The screenshot shows the SAP TSM Check In/Check Out interface. The search criteria are:

- Site: BOBJ
- Material: (empty)
- Version: (empty)
- Shop Order: (empty)
- SFC: (empty)
- Inventory ID: BOBJ46
- Assembly Operation: (empty)

Buttons for "Retrieve" and "Clear" are visible. The table below has one record:

Out	SFC Inventory ID	Material/Version	Rem. Shelf Life	Rem. Floor Life	Cur. Time Out	Cum. Time Out
	BOBJ46	COMPOSITE_WC22/A	2.49 Days	9.64 Hours		

Buttons for "Check out", "Check In", and "Return to POD" are located at the bottom of the screen.

24. The remainder of the roll of composite material has been checked back in

25. The operator selects the Return to POD button

SAP ME How-To-Guide for Time Sensitive Material

26. By using the Floor Stock Report activity, a user can verify that the quantity of the composite material now available for the inventory ID is only 75 feet
27. The user enters BOBJ46 in the Inventory ID field and selects Search

Floor Stock Report

Main | Floor Stock Location

* Site: BOBJ ▲ Date Range: Not Used

Material Type: All * 02/06/2012 12:00:00 AM

▲ Material Group: * 02/06/2012 11:59:59 PM

▲ Material: Version:

▲ Inventory ID: BOBJ46 Inventory ID Status: All

▲ SFC:

Search Clear Show Results in New Window

FLOOR STOCK REPORT

Site: BOBJ Material Type: All Inventory ID: BOBJ46 Graphical View

Inventory ID Status: All

MATERIAL/VERS.	TYPE	RECEIVE QTY	QTY ON HAND	INFO
COMPOSITE_WC22/A	Purchased	200	75	Floor Stock Detail

End of Data

28. The remaining 75 feet of composite material is now checked in and available
29. The 125 feet of composite material used on the wing is no longer being tracked as time sensitive

7 Links to Additional Information

8 Other Reference Material

9 Overview of Changes

For SAP ME 6.0, the TSM Check-In/Out activity was implemented in the new POD framework, but no functional changes were made.