

# Job Nesting

SYSPRO 8

Reference Guide

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# Job Nesting

## Exploring

### Where it fits in?

The **Job Nesting** feature lets you combine several small jobs into one larger nested job process. This lets you view and select combinations of work orders that can be batched together into larger processes (e.g. you can nest multiple jobs using the same raw material or components).

The result is a reduction of waste and operational costs, optimized use of raw material and resources, and improved efficiencies.

Nested-based machining typically involves placing a single sheet of material on a CNC router table. The router is programmed to process components based on the machine's capabilities, in a single setup without any material handling required, other than loading and unloading.

The Production Planner typically chooses any combination of work orders to nest together based on their sharing a commonality (such as the same raw material or the same work center) to create a combined job nest.

The components in a nested-based process are positioned in a pattern that will achieve the best possible material utilization.

#### FOR EXAMPLE:

When making a pair of denim jeans, the fabric is laid out and the pattern cut based on the different parts of the jeans (e.g. front, back, pockets and waist).

## Terminology

### **Job nest**

A group of jobs, processed together as a percentage of the material and labor used.

### **Nest (a.k.a. project nest)**

The result of an ability to view and select combinations of worksorders that can be batched together. The nest or project nest is the aggregate single view of the batch.

### **Nesting interface**

This is the integration interface that provides a link between ERP systems and a dedicated nesting software.

### **Nesting (process)**

Nesting refers to the process of efficiently manufacturing shaped and non-symmetrical parts from flat raw material.

The components in a nested-based process are positioned in a pattern that will best use the materials and minimize waste.

### **Nesting software**

External generic or machine-specific software that performs the optimization of the nest against the raw materials.

### **Remnant**

A part or quantity that is left over after the greater part has been used, removed or destroyed. Remnants are receipted back into stock for future use.

### **Scrap**

Scrap is material that falls outside of specification and which has characteristics that make it impractical to rework. Within SYSPRO, you can associate a description to a code that describes the reason you need to scrap the material.

# Starting

## Prerequisites

To use this feature, the following setup option(s) must be enabled:

### Setup Options

*Setup Options > Configuration > Distribution > Inventory*

- Associate serials by bin

## Security

You can secure this feature by implementing a range of controls against the affected programs. Although not all these controls are applicable to each feature, they include the following:

- You can restrict operator access to *activities* within a program (configured using the **Operator Maintenance** program).
- You can restrict operator access to the *fields* within a program (configured using the **Operator Maintenance** program).
- You can restrict operator access to *functions* within a program using passwords (configured using the **Password Definition** program). When defined, the password must be entered before you can access the function.
- You can restrict access to the eSignature *transactions* within a program at operator, group, role or company level (configured using the **eSignature Setup** program). Electronic Signatures provide security access, transaction logging and event triggering that gives you greater control over your system changes.
- You can restrict operator access to *programs* by assigning them to groups and applying access control against the group (configured using the **Operator Groups** program).
- You can restrict operator access to *programs* by assigning them to roles and applying access control against the role (configured using the **Role Management** program).

## Restrictions and Limits

### General

- A valid nest job will only have one operation for the specified work center and only one allocation linked to that operation.
- Non-stocked jobs can only be added to a nest, if the non stock job has an operation linked to a stocked material allocation.
- Operations must be linked to the material allocation via the operation/offset.

- Quantities must be in the stocking unit of measure.
- If you have a multi-level BOM, you must create sub-jobs for the made-in items.
- If you issue a quantity of more than one for a stock code to a nest (without a sheet number) then when you capture the percentage utilization for that item, it will be of the total, not per sheet.

This is useful for punch cutting where multiple sheets are used, but the same items are cut per sheet.

## Job linking

- Once jobs are linked to a nest, you can't modify the job. Material and labor can still be posted to non-linked allocations.
- When a job is linked to a nest, the date calculation method is set to Manual, so that the job will be excluded from any MRP calculations.

If you add a job to a nest and then subsequently remove it from the nest while in the planning phase, you will need to revert the job date calculation method manually.

- All jobs linked to a nest must have a common work center.

A job can be linked to multiple job nests, but an allocation can only be linked to one nest.

## Traceability

- The job nest stock code (i.e. the raw material) cannot be a manual serialized item.
- If you want to trace an item back to an individual sheet, then you need to supply a sheet number that is unique per job nest.
- You can only issue one lot (or one serial) per raw material, so that the parts can be tracked correctly back to the raw material.

## Configuring Setup Options

The **Setup Options** program lets you configure how SYSPRO behaves across all modules. These settings can affect processing within this program.

### Inventory Configuration

*Setup Options > Configuration > Distribution > Inventory*

- Associate serials by bin

# Solving

## FAQs

### How do I create a job nest?

1. Open the **Job Nest Capture** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Capture the job nest information.
3. Add jobs to the nest using the **Job Nest Review**.
4. Add raw materials to the nest.



This is the raw material from which the parts will be cut. It doesn't have to match the material allocation on the job.

*For example:* Grade A steel could be used instead of Grade B, as it is a suitable substitute.

5. Assign which raw material will be used for the job nest (i.e. which sheet will be used).
6. Confirm the job nest.
7. Save your changes.

When saving the nest, new jobs are created for BOMs that were added.

### How do I process a nest?

1. Open the **WIP Nest Processing** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Select the job nest you want to process.
3. Issue all the required raw materials to the nest.



Once you have issued material, the nest status is set to **I - IN PROGRESS** and you can't edit the nest using the **Job Nest Capture** program.

4. Process the job nest, entering the stock utilization, remnant or scrap percentages.
5. Complete the job nest.

This sets the status to **F - FINISHED/COMPLETE**.

### How to define an export nest format

1. Open the **WIP Nest Format Maintenance** program.
2. Capture the relevant information in the **Format Header**.
3. Once the header fields have been captured, the **Format Fields** pane is populated.
4. Select **Save** and exit the program.

## How do I query the details of a job nest?

1. Open the **WIP Nest Cost History Query** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Select the stock code and warehouse.

You can view the following information:

- The status of a job nest.
- All transactions linked to a job nest.
- Values and costs of a job nest.

## Why can't I edit the job nest?

A job nest can only be edited when the status is **P - PLANNING** or **C - CONFIRMED**.

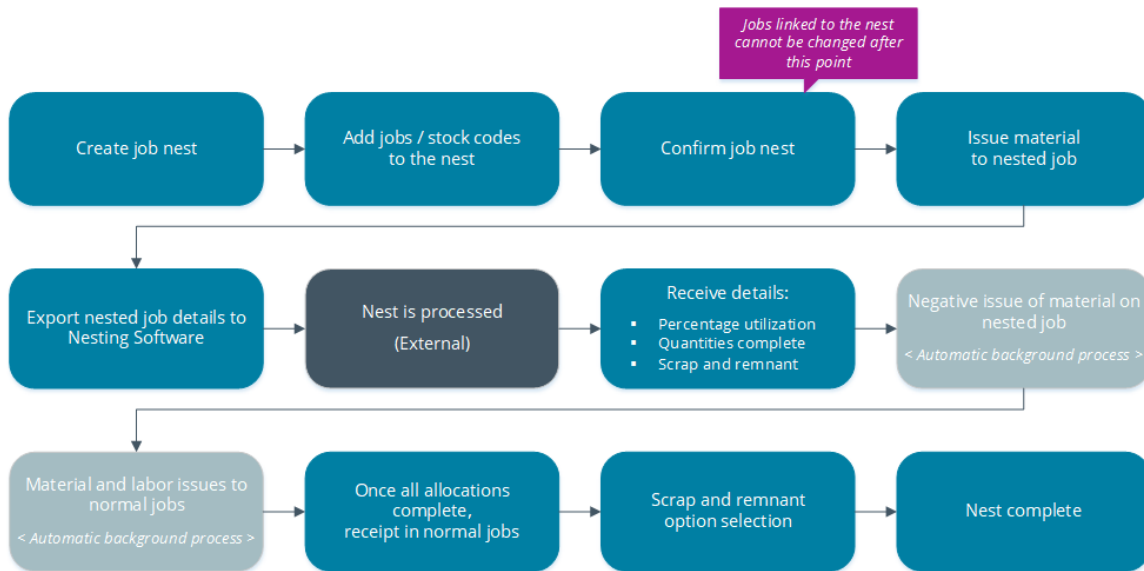
It can't be edited once the status is **I - IN PROGRESS**.

## Why can't I edit the job that is part of a job nest?

You can't maintain a job once it has been allocated to a job nest. You must remove the job from the nest, then perform the required maintenance, and then re-add the job to the nest.



# Using Process



The programs related to this feature are accessed from the **Program List** pane of the SYSPRO menu:

- *Program List > Work in Progress > WIP Job Nesting*
- *Program List > Work in Progress > Setup*

1. Create and confirm a job nest using the **Job Nest Capture** program.  
Once jobs are linked to a job nest, they can't be modified.
2. Assign raw material to the job nest using the **Job Nest Capture** program.
3. Process the job nest and issue material and labor using the **WIP Nest Processing** program.
4. Export the job nest to the external nesting software using the **Job Nest Capture** program.  
The nest is processed and information sent back to SYSPRO.
5. Import the job nest details to update information such as percentage utilization, quantities complete and scrap / remnant amounts.

After the import, the following occurs automatically in SYSPRO:

- issuing of negative material and labor on jobs to distribute costs in the nest.
- issuing of material and labor to jobs using the WIP **Job Issues** and WIP **Labor Posting** programs.

- depending on the option selected at the **Scrap from job nest** field in the **Work Centers** program, the remaining materials will be either scrapped (posted to the GL account) or received back into stock (in a remnant bin).
6. Complete the job nest using the **WIP Nest Processing** program.

# Job Nest Capture

## Exploring

### Where it fits in?

This program lets you create and maintain job nests (i.e. job groupings) to optimize costing and the use of resources.

When you move a job to a nest, the material is effectively taken out of stock and moved from the warehouse to the work center. As a job may need different raw materials, it can be linked to multiple nests.

You can specify whether the remainder of the material should be allocated to a remnant bin or scrapped (**Scrap from job nest** setup option in the **Work Centers** program). If the remainder is scrapped, you can decide to either distribute the scrap over the jobs or to write it off at the **Scrap handling** field in the **Job Nest Capture** program.

Things you can do in this program include:

- Create and maintain a job nest.
- Assign the materials you plan to use to a nest.
- Link jobs and/or BOMs to a nest.
- Confirm the nest.

## Navigation

- This program is accessed from the **Program List** pane of the SYSPRO menu:  
*Program List > Work in Progress > WIP Job Nesting*

# Starting

## Prerequisites

- The **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*) must be enabled.

## Configuring

The following configuration options in SYSPRO may affect processing within this program or feature, including whether certain fields and options are accessible.

### Setup Options

The **Setup Options** program lets you configure how SYSPRO behaves across all modules. These settings can affect processing within this program.

### Inventory Configuration

*Setup Options > Configuration > Distribution > Inventory*

- Associate serials by bin

## Restrictions and Limits

- All jobs linked to a nest must have a common work center.
- Only confirmed jobs and made-in stocked items can be added to a nest.
- A valid nest job will only have one operation for the specified work center and only one allocation linked to that operation.
- Although a job can be linked to multiple job nests, an allocation can only be linked to one nest.
- Although you can't modify jobs once they are linked to a nest, you can still post material and labor to non-linked allocations.
- A non-stocked job can only be added to a nest if it has an operation linked to a stocked material allocation.
- Quantities must be in the stocking unit of measure.
- For a multi-level bill of materials, you must create sub-jobs for the made-in items.
- If you issue a stock code quantity of more than 1 to a nest (without a sheet number) then when you capture the percentage utilization for that item, it will be of the total, not per sheet.

This is useful for punch cutting where multiple sheets are used, but the same items are cut per sheet.

# Solving

## Error messages

### Associate serials by bin is not switched on

#### Cause

A prerequisite to using the **Job Nesting** feature is that the **ASSOCIATE SERIALS BY BIN** setup option is enabled.

#### Solution

Enable the **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*).

## FAQs

### How do I create a job nest?

1. Open the **Job Nest Capture** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Capture the job nest information.
3. Add jobs to the nest using the **Job Nest Review**.
4. Add raw materials to the nest.



This is the raw material from which the parts will be cut. It doesn't have to match the material allocation on the job.

*For example: Grade A steel could be used instead of Grade B, as it is a suitable substitute.*

5. Assign which raw material will be used for the job nest (i.e. which sheet will be used).
6. Confirm the job nest.
7. Save your changes.

When saving the nest, new jobs are created for BOMs that were added.

### Why can't I edit the work center of the job nest?

You can only maintain the work center at the time of creating the job nest. Once the job nest is saved, you won't be able to edit the work center details.

# Referencing

## Menu and Toolbar

### Nest Entry

This lets you create a new job nest.

### Nest Maintenance

This lets you maintain an existing job nest.

### Work Center

This selects the work center for which you want to create a job nest.

### Job Nest

This selects the existing job nest.

### Save

This saves your changes. When saving the nest, new jobs are created for BOMs that were added.

### Delete

This deletes the highlighted data record.

### Export

This generates an export file that can be imported in the nesting software.

## Job Nest Header Details

Field	Description
<b>Work center</b>	This indicates the selected work center.
<b>Job nest</b>	This identifies the unique job nest. Enter a new job nest.
<b>Description</b>	Enter a description for the job nest.
<b>Nest confirmed</b>	This lets you confirm the nest. A job nest can be confirmed and un-confirmed at any stage. However, you cannot select an unconfirmed job nest in the <b>WIP Nest Processing</b> program to issue material or labor.

Field	Description
<b>Scrap handling</b>	<p>This specifies how the system handles the scrap.</p> <p><i>Apportion</i> This distributes the scrap over all the jobs in the nest.</p> <p><i>Write off</i> This writes off the scrap.</p>

## Job Nest Details

Field	Description
<b>Job Nest Selections</b>	<p>This lets you select jobs and bill of materials for the nest.</p> <p>The <b>Job Nest Review</b> screen will be displayed.</p>
<b>Assign Raw Material</b>	<p>This lets you assign the raw material you plan to use for the job nest. This is not necessarily the material that will be used as you use the <b>WIP Nest Processing</b> program to issue the actual material used.</p> <p>Select <b>Edit</b> to split the job across multiple sheets.</p>
<b>Remove Raw Material</b>	This lets you remove assigned raw material.
Job	This indicates the job included in the job nest.
Parent stock code	This indicates the parent stock code of the finished part included in the job nest (i.e. the stock code on the job).
Quantity to make	This indicates the quantity that needs to be made.
Stock code	This indicates the stock code of raw material included in the job nest.
Warehouse	This indicates the warehouse where the stock is located.
Uom	This indicates the stock code's unit of measure.
Raw material	This indicates the stock code of raw material included in the job nest.
Assign raw material	<p>This lets you pre-assign a job to a specific raw material or sheet.</p> <p>You can also split a job between several sheets (if one is insufficient).</p>

Field	Description
Exists on nest	This indicates whether the data record was just added or previously saved.
Error message	This displays the description of the error message, if a part couldn't be added to the nest.


## Raw Material Details

This lets you add raw materials for the job nest from which parts will be cut.

Field	Description
Stock code	Indicates the stock code of raw material included in the job nest.
Sheet number	Indicates the sheet number of the selected raw material.
Warehouse	Indicates the warehouse where the stock is located.
Uom	Indicates the stock code's unit of measure.
Revision	Indicates the revision, if the item is ECC-controlled.
Release	Indicates the release, if the item is ECC-controlled.

## Job Nest Review

This screen is displayed when you select the **Job Nest Selections** button on **Job Nest Details** pane. It lets you select jobs for the nest.

Field	Description
<b>Start Review</b>	<p>Select this to accept your <b>Review Criteria</b> selections and display the data accordingly.</p> <p>This option is enabled when you initially access the program but, thereafter, is only re-enabled when you select the <b>Change Criteria</b> option.</p> <p>The results are displayed in the <b>Job Nest Review</b> list view.</p>
<b>Change Criteria</b>	<p>Select this to change the previously selected review criteria.</p> <div style="border: 1px solid #0070C0; border-radius: 10px; padding: 10px; margin-top: 10px;">  This function is only enabled after you select the <b>Start Review</b> function.         </div>



Field	Description
<b>Options</b>	<p><i>Include jobs</i></p> <p>This includes all jobs for the selected work center in the review. This field is enabled by default.</p> <p><i>Include BOMs</i></p> <p>This includes all bill of materials for the selected work center in the review.</p>
<b>Component stock codes</b>	Indicate the range of stock codes to include in the job nest review.
<b>Component warehouses</b>	Indicate the range of warehouses to include in the job nest review.
<b>Jobs</b>	Indicate the range of jobs to include in the job nest review.
<b>Parent stock codes</b>	Indicate the range of parent stock codes to include in the job nest review.
<b>Machines</b>	Indicate the range of machines to include in the job nest review.

# WIP Nest Processing

## Exploring

### Where it fits in?

This program lets you process a job nest.

Things you can do in this program include:

- Process a job nest.
- Issue the actual material and labor to the job nest.

## Navigation

- This program is accessed from the **Program List** pane of the SYSPRO menu:

*Program List > Work in Progress > WIP Job Nesting*

# Starting

## Prerequisites

- The **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*) must be enabled.

## Configuring

The following configuration options in SYSPRO may affect processing within this program or feature, including whether certain fields and options are accessible.

### Setup Options

The **Setup Options** program lets you configure how SYSPRO behaves across all modules. These settings can affect processing within this program.

### Inventory Configuration

*Setup Options > Configuration > Distribution > Inventory*

- Associate serials by bin

# Solving

## Error messages

### Associate serials by bin is not switched on

#### Cause

A prerequisite to using the **Job Nesting** feature is that the **ASSOCIATE SERIALS BY BIN** setup option is enabled.

#### Solution

Enable the **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*).

### Nest is still in planning status

#### Cause

This message is displayed in the **WIP Nest Processing** program when the status of the job nest still needs to be **CONFIRMED** before it can be processed.

#### Solution

Use the **Job Nest Capture** program to confirm the job nest.

## FAQs

### Why is the job nest not available for selection at the Job Nest field?

If the status of the job nest is not **C - CONFIRMED** it is unavailable for selection. Use the **Job Nest Capture** program to confirm the job nest before processing it.

### How do I process a nest?

1. Open the **WIP Nest Processing** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Select the job nest you want to process.
3. Issue all the required raw materials to the nest.



Once you have issued material, the nest status is set to **I - IN PROGRESS** and you can't edit the nest using the **Job Nest Capture** program.

4. Process the job nest, entering the stock utilization, remnant or scrap percentages.
5. Complete the job nest.

This sets the status to **F - FINISHED/COMPLETE**.

## How do I complete a job nest?

You would typically use this procedure once the material and labor required for the job nest has been recorded.

1. Open the **WIP Nest Processing** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Select the job nest you want to complete.
3. Select **Set to complete** from the **Job Nest Header** pane.

A tick mark is inserted in the **Nest complete** field indicating that the status has been updated to **F - FINISHED/COMPLETE**.

# Referencing


## Menu and Toolbar

### Job Nest



Select the job nest that you want to process.

You can only select job nests that are in a status of **C - CONFIRMED**.

### Job Nest Header

Field	Description
<b>Job nest details</b>	
Job Nest	This indicates the job nest.
Nest description	This indicates the job nest description.
Status	This indicates the job nest status (which must be <b>C - CONFIRMED</b> in order to be processed). Once processed, the nest status will be set to <b>C - CONFIRMED</b> .
Work center	This indicates the work center of the job nest.
Work center description	This indicates the description of the work center.
Nest complete	A tick mark indicates that all raw material has been accounted for and the job nest is complete.
Set nest to complete	Select <b>Set to complete</b> to complete the nest.  <div style="border: 1px solid #0070c0; border-radius: 10px; padding: 10px; margin-top: 10px;">  <p>If all raw material has been accounted for, the nest will be set to complete automatically. However, you can also set the nest to complete manually.</p> </div>

## Nest Materials

Field	Description
<b>Issue new material</b>	<p>This issues the actual material that will be used for the job nest. This may not be the same material that was assigned to the job code using the <b>Job Nest Capture</b> program.</p> <div style="border: 1px solid #0070c0; padding: 10px; margin-top: 10px;">  <p>The material is taken out of stock and when the jobs are processed, even if this differs from the assigned material that was planned for the job nest.</p> </div>
Stock code	This indicates the stock code of the issued material.
Description	This indicates the description of the stock code.
Sheet	This indicates the sheet that is issued for the job nest.
Qty required	This indicates the quantity of material that is required for the job nest.
Qty issued	This indicates the quantity of material that was issued for the job nest.
Issue to nest	<p>Either <b>Issue material</b> or <b>Issue done</b> is displayed at this field. When material has not been issued, select <b>Issue material</b> and enter the materials in the <b>Issue Materials</b> pane.</p> <div style="border: 1px solid #0070c0; padding: 10px; margin-top: 10px;">  <p>Once material has been issued:</p> <ul style="list-style-type: none"> <li>■ <b>Issue material</b> changes to <b>Issue done</b> and can no longer be selected.</li> <li>■ The job nest status is set to <b>I - IN</b> <b>PROGRESS</b> and can't be changed using the <b>Job Nest Capture</b> program.</li> </ul> </div>
Process jobs	<p>Either <b>Issue first</b>, <b>Process jobs</b> or <b>Complete</b> is displayed at this field.</p> <ul style="list-style-type: none"> <li>■ If material has not been issued, <b>Issue first</b> is displayed.</li> <li>■ Once material has been issued, select <b>Process jobs</b> and enter the job details on the <b>Process Nested Jobs for Stock code</b> screen.</li> <li>■ Once the job is processed, <b>Complete</b> is displayed.</li> </ul>

## Issue Materials

The fields on this pane become available when you select **Issue material** on the **Nest Materials** pane.

Field	Description
<b>Post</b>	This posts the issued materials.
<b>Issue to the nest</b>	
Stock code	This indicates the stock code for of the material that will be issued to the nest.
Warehouse	This indicates the warehouse from which stock will be issued to the nest.
Description	This indicates the stock code description.
Sheet	This indicates the sheet number of the material that will be issued to the nest.
Quantity	This indicates the quantity of stock that will be issued to the nest.
Unit of measure	This lets you select the stocking unit of measure. This lets you select the unit of measure required (i.e. stocking, alternate, manufacturing or other).
Ledger code	This indicates the ledger code against which the issued material will be billed.
Bin location	This indicates the location of the bin for the stock that will be issued.
Lot	This indicates the lot from which the stock will be issued.
Serial	This indicates the serial from which the stock will be issued.

## Process Nested Jobs for Stock code xxx

This screen is displayed when you select **Process jobs** option from the **Nest Materials** pane.

Jobs that are linked to the selected raw material (as well as unprocessed jobs not linked to any raw material) will be listed.


Field	Description
<b>Process nested jobs (labor and material)</b>	This processes the nest jobs, applies utilization percentages, as well as the labor and material issued.



Field	Description
<b>Add scrap</b>	This specifies that the remainder of the raw material or sheet will be scrapped.
<b>Add remnant</b>	This specifies that the remainder of the raw material or sheet will be returned to the remnant bin for re-use.
<b>Nest Labor Details</b>	
<b>Labor details</b>	This lets you record the labor details in the unit of measure defined against the <b>Work Centers</b> .
Machine	Select the machine that was used to complete the job nest.
Total runtime	Enter the amount of time the machine required to complete the job nest..
Total startup time	Enter the amount of time the machine required to start up.
Total setup time	Enter the amount of time required to set up the machine.
Total teardown time	Enter the amount of time the machine required to shut down.
Rate indicator	Indicate the machine rate.
Employee	Indicate the employee who operated the machine.
Employee rate indicator	Indicate the employee rate.

## Nested job details

Field	Description
<b>Job</b>	This indicates the job code.
<b>Stock code</b>	This indicates the stock code used.
<b>Stock description</b>	This indicates the description of the stock code.
<b>Raw material stock</b>	
<b>Sheet</b>	This indicates the specific sheet or raw material that will be used for the job nest.
<b>Qty to make</b>	This indicates the expected quantity for the job nest.

Field	Description
<b>Percentage utilization</b>	<p>Enter a percentage utilization.</p> <p><b>FOR EXAMPLE:</b> Part 1 took up 20% of the sheet.</p> <div style="border: 1px solid #0070C0; padding: 10px; margin-top: 10px;">  <ul style="list-style-type: none"> <li>■ You don't need to add a percentage for each job.</li> <li>■ The total utilization and scrap/remnant percentage must equal 100%.</li> </ul> </div>
<b>Qty manufactured</b>	Optionally enter the manufactured quantity, which will be used as a default when receipting the job.
<b>Qty scrapped</b>	Enter the quantity that was scrapped for the job nest. These are typically items with defects that haven't passed quality control.
<b>Material reference</b>	
<b>Bin</b>	Enter the bin into which the remnant stock is placed.
<b>Scrap reason</b>	Enter the reason for scrapping items. This relates to the items in the <b>Qty scrapped</b> field.

# WIP Nest Format Maintenance

## Exploring

### Where it fits in?

This program lets you create the layout of the file that will be used for exporting the job nesting data to external nesting software.

Things you can do in this program include:

- Create the export mapping format.
- Define fields to include in the export.
- Define custom fields to include in the export.

## Navigation

- This program is accessed from the **Program List** pane of the SYSPRO menu:  
*Program List > Work in Progress > WIP Job Nesting*

# Starting

## Prerequisites

- The **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*) must be enabled.

## Configuring

The following configuration options in SYSPRO may affect processing within this program or feature, including whether certain fields and options are accessible.

### Setup Options

The **Setup Options** program lets you configure how SYSPRO behaves across all modules. These settings can affect processing within this program.

### Inventory Configuration

*Setup Options > Configuration > Distribution > Inventory*

- Associate serials by bin

# Solving

## Error messages

### Associate serials by bin is not switched on

#### Cause

A prerequisite to using the **Job Nesting** feature is that the **ASSOCIATE SERIALS BY BIN** setup option is enabled.

#### Solution

Enable the **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*).

## FAQs

### How do I create a job nest mapping format for exporting?

1. Open the **WIP Nest Format Maintenance** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Create the export file header.
  - a. Select **Define fields**.  
The **Field Selector** screen is displayed.
  - b. Select the fields you want to include in the export file.
3. Apply and save the changes.

You can now export job nesting data to external nesting software.

### How do I remove fields from the job nest mapping format?

1. Open the **WIP Nest Format Maintenance** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Select the export file format.
3. Select **Define fields**.
4. From the **Field Selector** screen, indicate the fields you want to remove from the export mapping format and select **Apply**.  
The selected fields will be removed.
5. Apply and save the changes.

# Referencing

## Menu and Toolbar

### New

This lets you capture a new data record.

### Delete

This deletes the highlighted data record.

### Save

This saves your changes.

### Format

This lets you select an existing mapping format.

## Format header

Field	Description
<b>Format details</b>	
Format	Enter a unique export format code.
Description	Enter a description for the export format.
Format type	This defaults to <b>Export</b> and can't be edited.
File type	Select the type of export file you want to create ( <b>ASCII</b> or <b>CSV</b> ).
Format fields	Select the fields you want to include in the export file. Select <b>Define fields</b> to display the <b>Field Selector</b> screen.
<b>Format fields</b>	
Field	Indicates the field names that are included in the export.
Description	Indicates a description of the field that is included in the report.
Field length	Indicates the length of the field.

### Field Selector

This screen is displayed when you click on **Define** at **Format fields**.

Field	Description
<b>Company</b>	This displays the selected company.
<b>Include</b>	This lets you select fields you want to include in the file that will be exported to the external nesting software.
<b>Apply</b>	This includes the selected fields in the file that will be exported to the external nesting software.
<b>Save</b>	This saves the details you entered or changed.
Include	Select the fields you want to include in the export. A tick mark in the box indicates that the field is selected.
Field	This indicates the table name and field name.
Description	This displays a short description of the field, making it easier to select the required field.

# WIP Nest Cost History Query

## Exploring

### Where it fits in?

This program lets you query the details of a job nest.

Things you can do in this program include:

- View the status of a job nest.
- View all transactions linked to a job nest.
- View values and costs of a job nest.

## Navigation

- This program is accessed from the **Program List** pane of the SYSPRO menu:  
*Program List > Work in Progress > WIP Job Nesting*



# Starting

## Prerequisites

- The **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*) must be enabled.

## Configuring

The following configuration options in SYSPRO may affect processing within this program or feature, including whether certain fields and options are accessible.

### Setup Options

The **Setup Options** program lets you configure how SYSPRO behaves across all modules. These settings can affect processing within this program.

### Inventory Configuration

*Setup Options > Configuration > Distribution > Inventory*

- Associate serials by bin

# Solving

## Error messages

### Associate serials by bin is not switched on

#### Cause

A prerequisite to using the **Job Nesting** feature is that the **ASSOCIATE SERIALS BY BIN** setup option is enabled.

#### Solution

Enable the **ASSOCIATE SERIALS BY BIN** setup option (*Setup Options > Configuration > Distribution > Inventory*).

## FAQs

### How do I query the details of a job nest?

1. Open the **WIP Nest Cost History Query** program (*Program List > Work in Progress > WIP Job Nesting*).
2. Select the stock code and warehouse.

You can view the following information:

- The status of a job nest.
- All transactions linked to a job nest.
- Values and costs of a job nest.

# Referencing

## Menu and Toolbar

### Stock code

Select the stock code for which you want to view job nest cost history.

### Warehouse

Select the warehouse for which you want to view job nest cost history.

## Nest Cost Details

Field	Description
<b>Nest cost Details</b>	
Stock code	This indicates the selected stock code.
Description	This indicates the description of the selected stock code.
Warehouse	This indicates the selected warehouse.
Number of buckets	This indicates how many times the item has been receipted.
Total receipted	This indicates the total quantity of the item receipted.
Overall average	This indicates the total unit cost for the total quantity receipted.
<b>Calculate</b>	<p>This lets you calculate a price for quotations, based on the last receipts.</p> <p>This is calculated as follows:</p> <ul style="list-style-type: none"> <li>■ Total unit cost / total quantity + markup % defined</li> </ul>
Number of most recent receipts	<p>Specify the number of most recent receipts you would like to include in the calculation of the average.</p> <p>This is used to calculate an average cost based on the number of receipts.</p>
Markup percentage	This indicates the mark-up percentage of the stock code.
Calculate average	Select <b>Calculate</b> to calculate the average cost and cost plus markup.
Average cost	Once calculated, displays the average cost of the stock item.
Average cost + markup	Once calculated, displays the average cost plus markup of the stock item.



## Nest Cost History

Field	Description
Receipt date	This indicates the date when the stock items have been received.
Receipt quantity	This indicates the quantity of stock items received.
Unit cost	This indicates the unit cost of the stock items.



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