

Reviewing Cycle Time with MCPW (and MCPU)

One of the first things I do when I go into a site is to check how the site is performing against its manufacturing cycle times. Routings are important, and the Tcode MCPW is insanely easy to use, so why not check it?

When you go into MCPW it looks like this. You enter the plant, and if you want to you can change the date range.

The screenshot shows the SAP 'Material Analysis: Lead Time: Selection' screen. It features a header bar with a search icon and a dropdown menu. Below the header is a toolbar with various icons for navigation and actions. The main content area is divided into three sections: 'Characteristics', 'Period to analyze', and 'Parameters'. The 'Characteristics' section has input fields for 'Plant', 'MRP controller', and 'Material', each with a 'to' field and a selection icon. The 'Period to analyze' section has input fields for 'Month' with the values '04/2019' and '05/2019', and a selection icon. The 'Parameters' section has an 'Exception' input field.

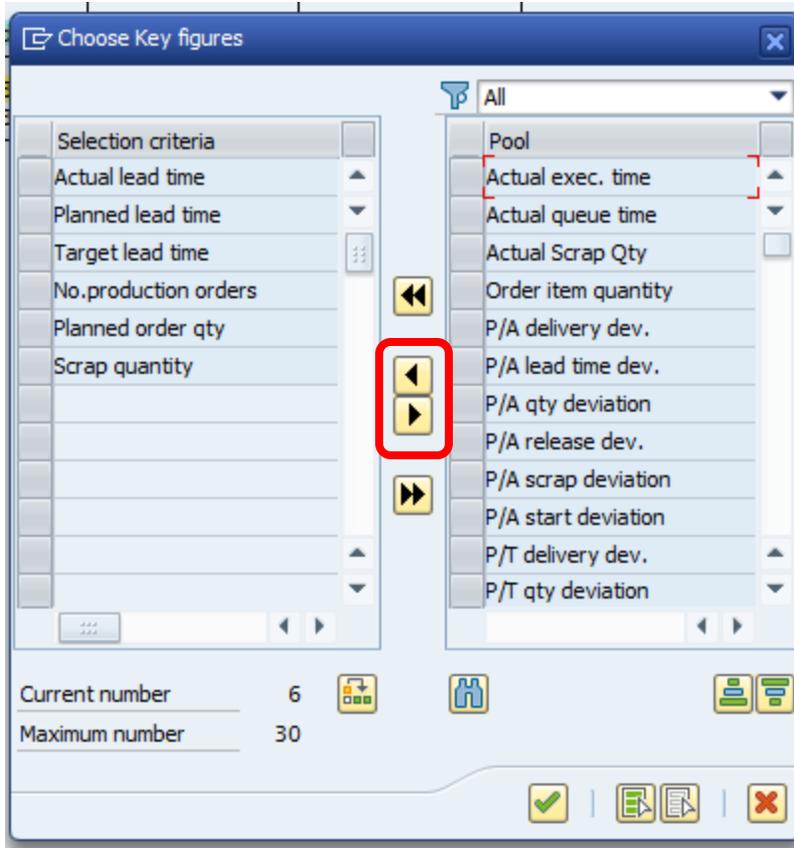
When you run the transaction, you won't get this unless you have set it up.

To set it up you go into the key figures icon and select them.

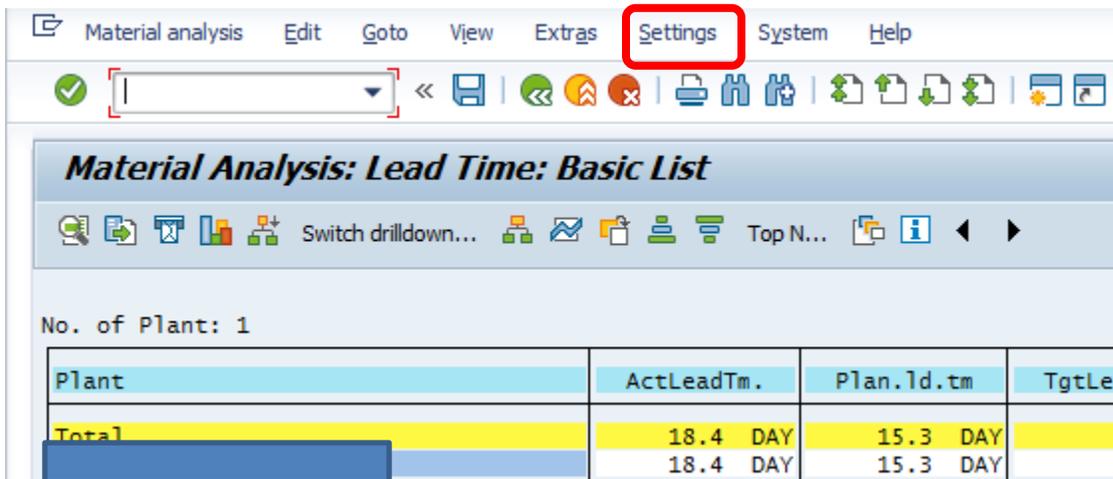
The screenshot shows the SAP 'Material Analysis: Lead Time: Basic List' screen. It features a menu bar with 'Material analysis', 'Edit', 'Goto', 'View', 'Extras', 'Settings', 'System', and 'Help'. Below the menu bar is a toolbar with various icons. The main content area is divided into two sections: 'No. of Plant: 1' and a table. The table has columns for 'Plant', 'ActLeadTm.', 'Plan.l.d.t.m', 'TgtLeadTm.', 'No.prod. orders', 'Order quantity', and 'Scrap quantity'. A red box highlights the 'Key Figures' icon in the toolbar, with a red arrow pointing to it. A white box with the text 'Key Figures' is positioned next to the icon.

Plant	ActLeadTm.	Plan.l.d.t.m	TgtLeadTm.	No.prod. orders	Order quantity	Scrap quantity
Total	18.4 DAY	15.3 DAY	14 DAY	8,071	36,094 EA	40 EA
	18.4 DAY	15.3 DAY	14 DAY	8,071	36,094 EA	40 EA

Use the little sideways triangles to move dimensions around.



You can then go under settings and select save settings, and click the green check marks to save them as your basic default lay out.



So what is this now telling me?

At the plant level, I can see how we are performing to actual cycle time, planned cycle time at the order header level, and at the operation level. It does not tell me if I started on time, but it does tell me once I have started, how long it takes.

Material Analysis: Lead Time: BASIC LIST

Switch drilldown... Top N...

No. of Plant: 1

Plant	ActLeadTm.	Plan.l.d.tm	TgtLeadTm.	No.prod. orders	Order quantity	Scrap quantity
Total	18.4 DAY	15.3 DAY	14 DAY	8,071	36,094 EA	40 EA
	18.4 DAY	15.3 DAY	14 DAY	8,071	36,094 EA	40 EA

I can also drill down into it. Double click on the Plant number (hidden here to protect the guilty), and it takes you to the MRP Controller. I can sort using the icons for sorting by clicking into the white space of the key figures, and move the highest volume in pieces or in orders to the top.

Material Analysis: Lead Time: Drilldown

Switch drilldown... Top N...

Plant 2735 PRO Electronics

No. of MRP controller: 17 Order quantity

Sorting icons

MRP controller	ActLeadTm.	Plan.l.d.tm	TgtLeadTm.	No.prod. orders	Order quantity	Scrap quantity
Total	18.4 DAY	15.3 DAY	14 DAY	8,071	36,094 EA	40 EA
207	20.8 DAY	16.5 DAY	15.1 DAY	2,194	17,049 EA	0 EA
	17.5 DAY	15.8 DAY	14.5 DAY	717	4,268 EA	0 EA
	10.9 DAY	14.1 DAY	13 DAY	1,299	3,242 EA	40 EA
	14.7 DAY	14.7 DAY	13.3 DAY	622	3,239 EA	0 EA
	10.8 DAY	13.2 DAY	11.9 DAY	1,431	2,649 EA	0 EA
	12.5 DAY	13 DAY	11.6 DAY	556	1,713 EA	0 EA
	32.1 DAY	23.6 DAY	22.3 DAY	385	1,344 EA	0 EA
	27.7 DAY	16.8 DAY	15.5 DAY	264	783 EA	0 EA
	66.3 DAY	10.2 DAY	9.2 DAY	197	558 EA	0 EA
	48.4 DAY	23.2 DAY	22 DAY	145	536 EA	0 EA
	5.1 DAY	11.9 DAY	10.7 DAY	165	430 EA	0 EA
	38.2 DAY	18.3 DAY	17.1 DAY	82	270 EA	0 EA
	11.3 DAY	5 DAY	4.3 DAY	8	11 EA	0 EA
	104 DAY	3 DAY	1 DAY	1	2 EA	0 EA
	106 DAY	0 DAY	0 DAY	1	0 EA	0 EA
	163 DAY	0 DAY	0 DAY	2	0 EA	0 EA
	126.5 DAY	0 DAY	0 DAY	2	0 EA	0 EA

I can double click on the MRP Controller and get to the part number level.

Prd.orders

Prd.orders	Item quantity	Plan.l.d.tm	TgtLeadTm.	Act. lead time
717	3,792 EA	15.8 DAY	14.5 DAY	17.5 DAY
37	272 EA	22.9 DAY	21.6 DAY	16.4 DAY
35	203 EA	12.3 DAY	11.1 DAY	9.4 DAY
33	145 EA	9.3 DAY	8.1 DAY	5 DAY
31	126 EA	8.2 DAY	7 DAY	3.6 DAY
29	232 EA	14 DAY	12.8 DAY	7.4 DAY
27	84 EA	13.5 DAY	12.3 DAY	16.4 DAY
26	243 EA	7.1 DAY	5.8 DAY	4.1 DAY
21	168 EA	5.7 DAY	4.1 DAY	2.4 DAY
19	116 EA	38.6 DAY	37.1 DAY	24.2 DAY
18	136 EA	23.6 DAY	22.3 DAY	14.6 DAY
17	152 EA	25 DAY	23.6 DAY	13.1 DAY
17	125 EA	6.9 DAY	5.4 DAY	4.1 DAY
16	92 EA	19.6 DAY	18.1 DAY	16.8 DAY
15	97 EA	18.1 DAY	16.7 DAY	12.3 DAY
14	86 EA	22.9 DAY	21.6 DAY	18.4 DAY
13	78 EA	19.5 DAY	18.4 DAY	25.6 DAY
13	63 EA	12.3 DAY	11.2 DAY	7 DAY
13	55 EA	10.8 DAY	9.6 DAY	5.8 DAY

Part Number

By double clicking on the part number, we can see how that part has performed over the period selected.

Prd.orders	Item quantity	Plan.l.d.tm	TgtLeadTm.	Act. lead time
37	272 EA	22.9 DAY	21.6 DAY	16.4 DAY
19	136 EA	22.1 DAY	21.1 DAY	17.1 DAY
18	136 EA	23.9 DAY	22.1 DAY	15.7 DAY

MCPU is another transaction very similar to this, but it allows you to get more discrete with regards to the date range. These are very easy and quick transactions so really there is no reason to not try them out.