



What's New in TS 5.3

Infinite Capacity Machines: Infinite Capacity Machines (ICMs) are a new type of Machine within the Taylor Scheduler (TS). As the name suggests, ICMs allow the modeling of machines and operation steps that do not adhere to the finite capacity constraints of standard Machines. Infinite Capacity Machines can model multi-order batch processes such as heat treating, baking, annealing, etc. In addition ICMs can be used to model outsourced operations. ICMs can also model steps within certain processes with unknown or inaccurate run times.

Schedule Logging: Schedule Logging provides a new level of scheduling traceability and accountability. With Schedule Logging enabled, the Taylor Scheduler records a log of key scheduling events that allows the User to “see” inside the scheduling engine’s decision making. The Schedule Log provides the User with concrete reasons why particular orders and operation steps were sequenced the way they were by the Taylor Scheduler. Logging can be filtered by both a selection set of orders and also by the level of warning severity.

Event Logging for Active Users: Event Logging is a new feature that is focused on recording the actions and choices made by active Users in the Taylor Scheduler. Actions such as Load, Save, Reschedule, etc. are recorded along with the date-time stamp for the action for each active User.

Push-Mode Scheduling: Push-Mode Scheduling is an entirely new scheduling algorithm in the Taylor Scheduler. The strategy in Push-Mode Scheduling is to balance the due-date adherence and capacity utilization inherent with forward scheduling with the resource leveling and WIP reduction found in JIT scheduling. In essence, Push-Mode Scheduling forward-schedules and “pushes” orders or operations that aren’t late out in time, to start nearer to their due date. Push-Mode Scheduling is not compatible with all features and configurations in the Taylor Scheduler. Please consult with your Taylor Consultant before implementing Push-Mode Scheduling in your model.

New Schedule Save Options: Key metrics can now be saved when the schedule is saved. These metrics include order start-and-end times, machine utilization and resource usage. With this new feature, split details are captured and saved as well as the complete current schedule. This data can then be easily extracted for reporting purposes.

Run Rate Modified by the Number of Operators: This enhancement relates the number of operators for an operation step to the duration of that operation step. With this new feature, operation run times can be changed for a specific operation without affecting other operations that are based on the same routing. Operation durations can now be based on the number of operators assigned to that operation step. In addition, the number of operators will also be considered during production updates – if an operation step is marked complete the calculated run time will be dependent on the operators assigned to that operation step.

Setting to Consume as many Resources as are Available: For operations steps in which the number of operators assigned to that step can vary, this new feature ensures that TS will consume all of the available operators for that step. This yields a more accurate profile of operator utilization. When using this new feature in conjunction with **Run Rate Modified by the Number of Operators**, operation run durations vary based on the operators available as specified in the calendar settings.



Operations May Now Stretch Around Machine Blocks: This new optional feature allows the User to change a setting within the Machine Blocks tab that will in turn allow splits to stretch around machine blocks. So, for instance, an order on a particular Machine can be stopped in the middle due to machine downtime and then will be scheduled to start back and complete the operation step immediately after the down time is completed.

Active Status Equations on Machines: Active Status Equations are attached to Machines within TS and provide a new level of refinement to the process of accurately assigning operation steps to the right machine. Active Status Equations checks for each Machine in the Available machine table to determine the best fit – based on attributes of the Order and the Part. With this new feature in conjunction with the Available Machines feature, almost any Routing can be configured to accurately match the best Available Machine to the Operation being scheduled.

Machine Descriptions on the Gantt Chart: Users are no longer limited to displaying only the Machine Name on the Gantt chart. Included with this new feature is the ability to resize the bar width for the machine column.

Tooling Resource – Operator Assignments: This new feature is for TS Users that would like to gain a new level of coordination & control between the manufacturing schedule and individual operator assignments. Operators can be assigned to particular Machines/Work Centers and operation splits.

Improved Resource Usage Visualization: This enhancement allows multiple tooling resources to be seen at the same time in a single window. With this feature, tooling usage is visualized in a common graphical timeframe – much like orders in the Gantt Chart.

Improved Order Scheduler: The Order Scheduler interface is now much more powerful and provides the User a scheduling alternative to the traditional Gantt chart within TS. Users may now easily select/unselect Orders from the Order Scheduler screen and perform a full range of standard TS scheduling operations on that selection set – including Reschedule, Unschedule, Freeze, Unfreeze, etc. In addition, new filtering capabilities allow the User to precisely define the Order selection set. For instance, the User could select Orders by Customer, Due Date, Part, etc. and then reschedule just that filtered Order set.

Plus.....

New TMS_CONTROL Commands – Provides more capability for remote & automated scheduling.....

New Equation Keywords – Further enriching the modeling environment for changeover and cost equations.....

Vertical full-height time-now-line optional on the Gantt chart - Providing an easier way to see “time-now” information for the entire Gantt chart.....

New Archive/Delete Order Utility – A new utility provides a screen to select orders by date range & other characteristics and either delete them or archive the data in another database.

Order Splitting – Users can now split orders with a right click on the Gantt Chart. Orders are split by quantity or number of splits and then a new order is automatically generated.....

New ESC key Functionality – ESC key clears all in one keystroke.....