

# Backflushing

What is backflushing? Backflushing is when you want raw material, hardware or finished goods subcomponents (routers) to be issued to the work order in a more automated fashion. When items are issued to a work order, work in process increases and your inventory is relieved. This eliminates having to specifically issue bill of material items to a work order because its done when either the sequences is complete or the work order shipments have been made.

## Setting Up Backflushing Using System Parameters

### Option 1

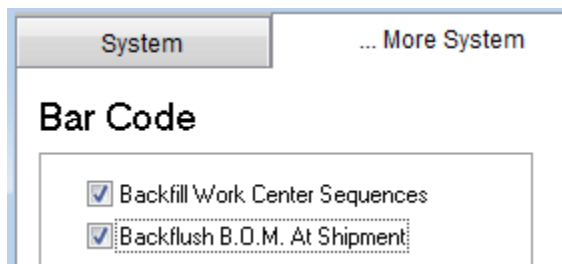
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Backflushing when sequences are scanned completed with quantities. This is both completed and incomplete but the key is the quantity needs to be entered. If this is the option you want to use do not check the **Backflush BOM At Shipment** system parameter. This is the most common method.

### Option 2

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Backflushing using **Backflush BOM At Shipment** from the System Parameters Backflushes at completions.



To get into System Parameters

1. Go Utility from the taskbar
2. Scroll down to System Parameters and select
3. Once in System Parameters select More System
4. Under the Bar Code section you will find Backflush B.O.M At Shipment

## Backflushing from Routers

Routers		Workcenters		Attachments		Products		Inventory		Serial Numbers	
P.O. History	Where Used	P/N Status	Supply Demand	Invoice History	Attachments Used						
<b>EMPIRE TOOL COMPANY</b>										Router No. : 0000002	
Part No. : 23441-462-SDE11										Rev :	
Standard Cost : \$16.0000		Labor Stnd : \$1.0000		Levels		Price		Approval Date : 10/12/1999		Quote # :	
Average Cost : \$16.1388		Overhead Stnd : \$2.0000		1		\$448.4649		Qty In Box : 0		Rev Revision :	
Last Cost : \$16.0000		Material Stnd : \$3.0000		25		\$86.8790		Good Until : //		User Def Num 1 : \$1.2000	
On Hand : 56		Product Stnd : \$4.0000		100		\$74.7018		User Def Num 2 : \$1.2000		User Def Str 1 :	
Allocated : 761		Established : //		500		\$72.5260		User Def Str 2 :		Weight : 18.8585	
W.I.P. : 842		Upper Cost Limit : \$0.0000		0		\$0.0000		Historic Gross Weight :		Last Sell Date : 01/10/2001	
Item :		WIP Component : 0		0		\$0.0000		Price : \$28.7600			
Class : ABC		Planner Code :									
<input checked="" type="checkbox"/> History		<input type="checkbox"/> IsForecastPart		<input checked="" type="checkbox"/> Serial Number		<input type="checkbox"/> Inactive					
<input type="checkbox"/> Default Pull		<input checked="" type="checkbox"/> Master Level Item		<input checked="" type="checkbox"/> Backflush							
Adjust Inventory		Currency Price		Locations		Stock Inquiry		Inventory Transactions			

Routers backflush product attachments which are pulls

To Backflush from the Router

1. Go to Routers
2. Click on Inventory Tab
3. Check the Backflush check box

## Backflushing from Maintenance (MATERIAL, HARDWARE)

Material Maintenance : ALUMINIZED STEEL 20GA (0.36)

Material: ALUMINIZED STEEL 20GA (0.36)

ID: 00303

Group Pick List:  FabriWin Group

- ALUMINIZED STEEL
- ALUMINUM ANGLES
- ALUMINUM RECT BAR
- ALUMINUM SHAPES
- ALUMINUM SQUARES
- ALUMINUM TUBING RECT
- ALUMINUM TUBING ROUND
- ALUMINUM TUBING SQUARE
- ALUMINUM-3003-H14
- ALUMINUM-5052 H32

Other Description:

S/N: 456 789 Vendor P/N: A-STEEL

Lead Time: 2 Thickness: 0.3600

Tolerance: 0.0000 Weight Factor: 0.0000000

Sell Unit: LBS Safety Zone Width:

Ship Unit: Shts Safety Zone Length:

Grain Direction: NONE

Type: Sheet  Backflush Inventory

Calculation Type: Calc Include Scrap  Default Pull

GL Link Code:

Vendor:

Comments: Additional paperwork

Change Group Where Used

Backflushing from Maintenance backflushes at completion with quantity

To get to backflush in Maintenance

1. From the Taskbar select Maintenance
2. Scroll down to Hardware or Material
3. In Material backflush will be in the Material tab in Hardware it will be located in the Inventory Tab.

**There are a few keys to make backflushing work.**

1. The hardware or material item must have the BACKFLUSH box checked.
2. You can backflush product attachments which are pulls. You must check BACKFLUSH on the routers which you wish to backflush.
3. You must have enough parts in inventory. If you do not have enough parts in inventory the system will not backflush the item.
4. You must have the bill of material item associated to a sequence on the router
5. You must clock out with QUANTITY or backflushing does not work, unless you are using the Backflush B.O.M At Shipment system parameter.
6. Backflushing does not work when clocking in/out from the GUI