



Global Edge® Integrated Manufacturing



Global Edge® Integrated Manufacturing **Configurator Guide (QUOTING)**

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Configurator Outline

Global Edge® Integrated Manufacturing includes a powerful “**Configuration Engine**” that provides an automated method to configure parts and assemblies, CAD model generation, and sales quote generation. The following outlines the setup steps for the **Global Edge® Integrated Manufacturing** configuration engine:



Section 1: Part Numbers / Dimension Parameters

- 1.1 – Define Master Configuration Part Numbers
- 1.2 – Define Dimension Parameters



Section 2: Assembly / BOM Structures

- 2.1 – Define Assembly / Bill of Materials Structures



Section 3: Manufacturing Processes / Routing Structures

- 3.1 – Define Manufacturing Processes
- 3.2 – Define Routing Structures

Section 1: Part Numbers / Dimension Parameters

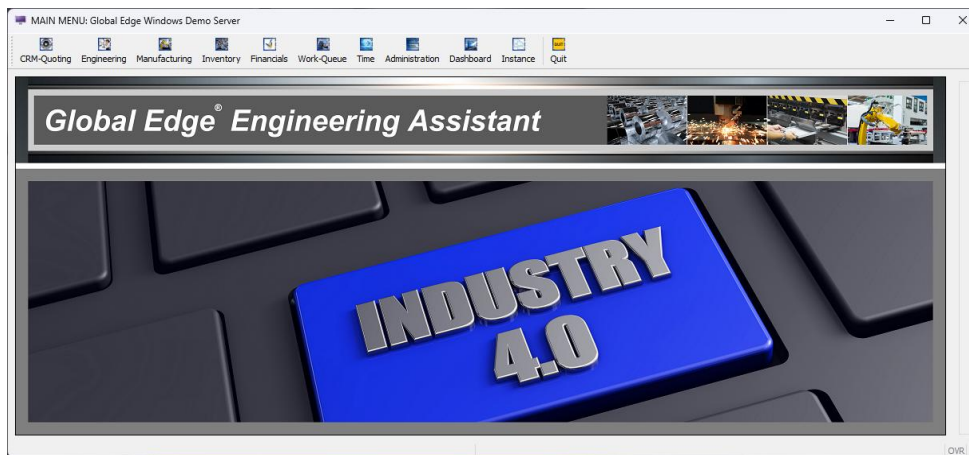
This section provides an explanation of the first steps to set up the **Global Edge Configuration Engine** that starts with the definition of Master Configuration Part Numbers. Master Configuration Part Numbers are template part numbers that are the base part numbers that are used to create a configurator structure.

1.1 – Define Master Configuration Part Numbers

This section includes the steps to define Master Configuration Part Numbers. These steps include the following:

Steps

1. Launch the **Global Edge Engineering Assistant** to display the following screen:



2. Select **“Engineering > BOM / Product Configuration”** option to display the following screen form and menu options:

3. Select **“Add”** option to define the following Template Part Numbers:

Template Part Numbers

PART #	DESCRIPTION	TYPE	MASTER	CAT.	STYLE	ORIGIN	STD. COST	UOM
ROUTING	ROUTING CONFIGURATION	Product	Yes	SHT	DEM	Mfg	\$0.0000	EA
QUOTING	QUOTE CONFIGURATION	Product	Yes	SHT	DEM	Mfg	\$0.0000	EA
DEMO-01-STOCK-OP	DEMO STOCK OPTIONS LIST	Option	Yes	STK	-	Purc	\$0.0000	EA
DEMO-02-HARDWARE-OP	DEMO HARDWARE OPTIONS LIST	Option	Yes	HDW	-	Non-Invt	\$0.0000	EA
DEMO-03-COMPONENTS-OP	DEMO COMPONENTS OPTIONS LIST	Option	Yes	CMP	-	Purc	\$0.0000	EA
DEMO-04-OTHER-CHARGES-OP	DEMO OTHER CHARGES OPTIONS LIST	Option	Yes	CMP	-	Mfg	\$0.0000	EA
SLD-001-CABINET-BODY	CABINET BODY	Assembly	Yes	TUB	-	Mfg	\$0.0000	EA
SLD-002-CABINET-BODY-WRAP	CABINET BODY WRAP	Component	Yes	TUB	KLR	Mfg	\$0.0000	EA
SLD-003-CABINET-BOTTOM	CABINET BODY BOTTOM	Component	Yes	TUB	B	Mfg	\$0.0000	EA
SLD-004-CABINET-TOP	CABINET BODY TOP	Component	Yes	TUB	T	Mfg	\$0.0000	EA
SLD-015-FILL-PANEL	CABINET FILL PANEL	Component	Yes	CAB	FLL	Mfg	\$0.0000	EA
SLD-016-HORZ-DIVIDER	CABINET HORIZONTAL DIVIDER	Component	Yes	CAB	DVD	Mfg	\$0.0000	EA
SLD-017-SPINE-CENTER	CABINET SPINE - CENTER	Component	Yes	CAB	SPN	Mfg	\$0.0000	EA
SLD-018-SPINE-CORNER-LT	CABINET SPINE - CORNER - LEFT	Component	Yes	CAB	SPN	Mfg	\$0.0000	EA
SLD-019-SPINE-CORNER-RT	CABINET SPINE - CORNER - RIGHT	Component	Yes	CAB	SPN	Mfg	\$0.0000	EA
SLD-020-VERT-DIVIDER-BOT	CABINET VERTICAL DIVIDER - BOTTOM	Component	Yes	CAB	DVD	Mfg	\$0.0000	EA
SLD-021-VERT-DIVIDER-TOP	CABINET VERTICAL DIVIDER - TOP	Component	Yes	CAB	DVD	Mfg	\$0.0000	EA
SLD-022-SHELF	SHELF	Component	Yes	CAB	SHF	Mfg	\$0.0000	EA
SLD-023-BACK	REMOVABLE BACK	Component	Yes	CAB	BK	Mfg	\$0.0000	EA
SLD-046-STOCK-OPT	MATERIAL STOCK OPTIONS LIST	Option	Yes	OPT	STK	Purc	\$0.0000	EA
304-4	304-4-STAINLESS STEEL	Raw	No	STK	SHT	Purc	\$2.5000	lbs
304-2B	304-2B STAINLESS STEEL	Raw	No	STK	SHT	Purc	\$2.1000	lbs
CRS	COLD ROLLED STEEL	Raw	No	STK	SHT	Purc	\$0.8500	lbs
316-2B	316-2B STAINLESS STEEL	Raw	No	STK	SHT	Purc	\$2.6700	lbs
5052-H32	ALUMINUM	Raw	No	STK	SHT	Purc	\$1.9500	lbs
G60	G60 GALVANIZED STEEL	Raw	No	STK	SHT	Purc	\$2.7500	lbs
832316	8-32 SELF TAPPING SCREWS	Component	No	CMP	FST	Purc	\$0.0300	EA
BAG28-4-599	U-LINE S-2366 20IN X 30IN FLAT BAG	Component	No	CMP	PKG	Purc	\$0.2500	EA
BOX-30X24X20	U-LINE BOX S-4961	Component	No	CMP	PKG	Purc	\$4.0100	EA
BOX-32X24X24	BOX, 32 X 24 X 24 (S-4453)	Component	No	CMP	PKG	Purc	\$4.3700	EA
MATERIAL-MARKUP	MATERIAL MARKUP	Component	No	CMP	MMU	Purc	\$0.2400	EA
PACKAGING	PACKAGING	Component	No	CMP	PKG	Purc	\$0.0100	EA
SP-032-1	10-32 PEM NUTS	Component	No	CMP	FST	Purc	\$0.3400	EA
PEM-NUT	PEM NUT	Component	No	HDW	-	Purc	\$0.0500	EA
PEM-STUD	PEM STUD	Component	No	HDW	-	Purc	\$0.0700	EA
RIVET	RIVET	Component	No	HDW	-	Purc	\$0.0500	EA
SCREW	SCREW	Component	No	HDW	-	Purc	\$0.0300	EA
STANDOFF	STANDOFF	Component	No	HDW	-	Purc	\$0.2000	EA
TAPE	TAPE CHARGE	Component	No	OTH	TPE	Mfg	\$35.0000	EA

1.2 – Define Dimension Parameters

This section includes the steps to define Dimension Parameters to the Template Part Numbers that were defined in “Section 1.1 – Define Master Configuration Part Numbers”. These steps include the following:

Steps

1. Retrieve the “**ROUTING**” part number:

Part-Master

PART #: **ROUTING** ROUTING CONFIGURATION

REV #:

TYPE: Product MST: Yes

PART UOM: EA

LIST: \$0.00

ALIAS OF:

ORIGIN: Manufactured

MFR. PART #: MFR: LDC Manufacturing

CATEGORY: SHT SHEET METAL SERIAL: None STATUS: Active

STYLE: DEM DEMO SHIP WEIGHT: 0.0 REBUILT: No

MATERIAL:

PART ADDED: 04/10/2023 TRANSFER:

MODIFIED: 04/10/2023 COST QTY: 1.0000

STANDARD PART COST: \$0.0000

QUOTE PART COST: \$0.0000

PROCESS COST: \$0.0000 MFR. SET-UP COST: \$303.00 ROLL-UP COST: \$0.0000

COMPONENT COST: \$0.0000 ONE TIME CHARGE: \$0.00 ROLL-UP DATE:

CAD PART FILE NAME:

INDUSTRY 4.0

(# 1 of 1)

BO01

Find Part(s)

OVR

2. Select “**Options > Dimensions**” option to display the following screen form and menu options:

Dimension-Parameter

PART #: **ROUTING** ROUTING CONFIGURATION

NUM	DIMENSION	METHOD	VALUE	MIN VALUE	MAX VALUE	CAD ATTRIBUTE	ACTIVE
1	Sheet_Length	Standard	inches	0.000000		Sheet_Length	Yes
2	Sheet_Width	Standard	inches	0.000000		Sheet_Width	Yes
3	Blank_Length	Standard	inches	0.000000		Blank_Length	Yes
4	Blank_Width	Standard	inches	0.000000		Blank_Width	Yes
5	Material_Thickness	Standard	inches	0.000000		Material_Thickness	Yes
6	Perimeter	Standard	inches	0.000000		Perimeter	Yes
7	Flat_Length	Standard	inches	0.000000		Flat_Length	Yes
8	Flat_Width	Standard	inches	0.000000		Flat_Width	Yes
9	Round_Holes	Standard		0.000000		Round_Holes	Yes
10	Round_Sizes	Standard		0.000000		Round_Sizes	Yes
11	Oround_Holes	Standard		0.000000		Oround_Holes	Yes
12	Oround_Sizes	Standard		0.000000		Oround_Sizes	Yes
13	Rectang_Holes	Standard		0.000000		Rectang_Holes	Yes
14	Rectang_Sizes	Standard		0.000000		Rectang_Sizes	Yes
15	Other_Holes	Standard		0.000000		Other_Holes	Yes
16	Other_Sizes	Standard		0.000000		Other_Sizes	Yes

16 Dimensions Found

BO01

Add Variable Dimension to Part

OVR

DIMENSION

Add

Update

Standard

View

Report

Inspection

Delete

QUIT

Last Update: Friday, April 03, 2026

ROUTING (Dimensions 1 through 51)

PART #	DIM. #	TYPE	DIMENSION NAME	UOM
ROUTING	1	N	Sheet_Length	inches
ROUTING	2	N	Sheet_Width	inches
ROUTING	3	N	Blank_Length	inches
ROUTING	4	N	Blank_Width	inches
ROUTING	5	N	Material_Thickness	inches
ROUTING	6	N	Perimeter	inches
ROUTING	7	N	Flat_Length	inches
ROUTING	8	N	Flat_Width	inches
ROUTING	9	N	Round_Holes	
ROUTING	10	N	Round_Sizes	
ROUTING	11	N	Obround_Holes	
ROUTING	12	N	Obround_Sizes	
ROUTING	13	N	Rectang_Holes	
ROUTING	14	N	Rectang_Sizes	
ROUTING	15	N	Other_Holes	
ROUTING	16	N	Other_Sizes	
ROUTING	17	N	Num_Cutouts	
ROUTING	18	N	Cutout_Perimeter	inches
ROUTING	19	N	Min_Bend_Length	inches
ROUTING	20	N	Max_Bend_Length	inches
ROUTING	21	N	Min_Bend_Angle	inches
ROUTING	22	N	Max_Bend_Angle	inches
ROUTING	23	N	Min_Flange_Width	inches
ROUTING	24	N	Max_Flange_Width	inches
ROUTING	25	N	Min_Pem_Gap	inches
ROUTING	26	N	Min_Dn_Pem_Gap	inches
ROUTING	27	N	Min_Emboss_Gap	inches
ROUTING	28	N	Min_Dn_Emboss_Gap	inches
ROUTING	29	N	Min_Louver_Gap	inches
ROUTING	30	N	Min_Dn_Louver_Gap	inches
ROUTING	31	N	Min_Taper_Bl_Gap	inches
ROUTING	32	N	Min_Die_Cutout	inches
ROUTING	33	N	Up_Bends	
ROUTING	34	N	Int_Up_Bends	
ROUTING	35	N	Max_Up_Bend	inches
ROUTING	36	N	Down_Bends	
ROUTING	37	N	Int_Down_Bends	
ROUTING	38	N	Max_Down_Bend	inches
ROUTING	39	N	Fold_Count	
ROUTING	40	N	Hem_Count	
ROUTING	41	N	Extrude_Count	
ROUTING	42	N	Bend_Radius	inches
ROUTING	43	C	Cutting_Method	
ROUTING	44	C	Cutter_Ref_Num	
ROUTING	45	C	Certified_Mtrl	
ROUTING	46	C	Material	
ROUTING	47	N	Cutout_Distance	inches
ROUTING	48	N	Part_Distance	inches
ROUTING	49	C	Blank_Before_Cut?	
		1	Yes	
		2	No	
ROUTING	50	C	Embossed_Part?	
		1	Yes	
		2	No	
ROUTING	51	C	Turret_Laser_Water	
		1	Turret	
		2	Laser	
		3	WaterJet	
		4	Open	

Last Update: Friday, April 03, 2026

ROUTING (Dimensions 52 through 66)

PART #	DIM. #	TYPE	DIMENSION NAME	UOM
ROUTING	52	C	PressBrake	
		1	Yes	
		2	No	
ROUTING	53	C	PanelBend	
		1	Yes	
		2	No	
ROUTING	54	C	PressBrk_PanelBend	
		1	Press-Brake	
		2	Panel-Bender	
		3	Water-Jet	
		4	Both	
		5	None	
ROUTING	55	C	Hardware:	
		1	PEM-NUT	
		2	PEM-STUD	
		3	STANDOFF	
		4	RIVET	
		5	SCREW	
		6	None	
ROUTING	56	C	Grain_Part?	
		1	Yes	
		2	No	
ROUTING	57	C	Weld_Part?	
		1	Yes	
		2	No	
ROUTING	58	C	Deburr_Part?	
		1	Yes	
		2	No	
ROUTING	59	C	Paint_Part?	
		1	Yes	
		2	No	
ROUTING	60	C	Assembly?	
		1	Yes	
		2	No	
ROUTING	61	C	Gasketing?	
		1	Yes	
		2	No	
ROUTING	62	C	Rivet?	
		1	Yes	
		2	No	
ROUTING	63	C	General_Labor?	
		1	Yes	
		2	No	
ROUTING	64	C	Final_Inspect?	
		1	Yes	
		2	No	
ROUTING	65	C	Package?	
		1	Yes	
		2	No	
ROUTING	66	C	Shipping?	
		1	Yes	
		2	No	

3. Return to PART menu, then select **“Find > BOM”** option to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Part-Master

PART #: DEMO-01-STOCK-OP DEMO STOCK OPTIONS LIST

REV #:

TYPE: Option-List MST: Yes

PART UOM: EA

LIST: \$0.00

ALIAS OF:

ORIGIN: Purchased

MFR. PART #: MFR: Logic Design Corporation

CATEGORY: STK STOCK SERIAL: None STATUS: Active

STYLE: SHIP WEIGHT: 0.0 REBUILT: No

MATERIAL:

PART ADDED: 04/10/2023 TRANSFER:

MODIFIED: 04/10/2023 COST QTY: 1.0000

STANDARD PART COST: \$0.0000

QUOTE PART COST: \$0.0000

PROCESS COST: \$0.0000 MFR. SET-UP COST:

COMPONENT COST: \$0.0000 ONE TIME CHARGE: \$0.00 ROLL-UP COST: \$0.0000

ROLL-UP DATE:

CAD PART FILE NAME:

OPTIONS LIST

(# 1 of 1)

BO01

Find Part(s)

OVER

PART

Add

Find

Next

Previous

Goto

Update

BOM

WhereUsed

reVisions

Mfr-Test

documEnt

Configurator

workQueue

Options

Long

RollUp

category

print

Delete

QUIT

4. Select **“Options > Dimensions”** option to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Dimension-Parameter

PART #: DEMO-01-STOCK-OP DEMO STOCK OPTIONS LIST

NUM	DIMENSION	METHOD	VALUE	MIN VALUE	MAX VALUE	CAD ATTRIBUTE	ACTIVE
1	Flat_Length	Formula	inches	0.000000			Yes
2	Flat_Width	Formula	inches	0.000000			Yes
3	Material_Thickness	Formula	inches	0.000000			Yes
4	Material	Formula		0.000000			Yes

4 Dimensions Found

BO31

Add Variable Dimension to Part

OVER

DIMENSION

Add

Update

Standard

View

Report

Inspection

Delete

QUIT

5. Retrieve the **“QUOTING”** part number followed by selecting **“Options > Dimensions”** option to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Dimension-Parameter

PART #:

NUM	DIMENSION	METHOD	VALUE	MIN VALUE	MAX VALUE	CAD ATTRIBUTE	ACTIVE
1	Sheet_Length	Standard	inches	0.000000		Sheet_Length	Yes
2	Sheet_Width	Standard	inches	0.000000		Sheet_Width	Yes
3	Blank_Length	Standard	inches	0.000000		Blank_Length	Yes
4	Blank_Width	Standard	inches	0.000000		Blank_Width	Yes
5	Material_Thickness	Standard	inches	0.000000		Material_Thickness	Yes
6	Perimeter	Standard	inches	0.000000		Perimeter	Yes
7	Flat_Length	Standard	inches	0.000000		Flat_Length	Yes
8	Flat_Width	Standard	inches	0.000000		Flat_Width	Yes
9	Round_Holes	Standard		0.000000		Round_Holes	Yes
10	Round_Sizes	Standard		0.000000		Round_Sizes	Yes
11	Obround_Holes	Standard		0.000000		Obround_Holes	Yes
12	Obround_Sizes	Standard		0.000000		Obround_Sizes	Yes
13	Rectang_Holes	Standard		0.000000		Rectang_Holes	Yes
14	Rectang_Sizes	Standard		0.000000		Rectang_Sizes	Yes
15	Other_Holes	Standard		0.000000		Other_Holes	Yes
16	Other_Sizes	Standard		0.000000		Other_Sizes	Yes
17	Num_Cutouts	Standard		0.000000		Num_Cutouts	Yes
18	Cutout_Perimeter	Standard	inches	0.000000		Cutout_Perimeter	Yes

166 Dimensions Found

BO31

Add Variable Dimension to Part

OVR

DIMENSION

Add

Update

Standard

View

Report

Inspection

Delete

QUIT

Last Update: Friday, April 03, 2026

QUOTING (Dimensions 1 through 48)

PART #	DIM. #	TYPE	DIMENSION NAME	UOM
QUOTING	1	N	Sheet_Length	inches
QUOTING	2	N	Sheet_Width	inches
QUOTING	3	N	Blank_Length	inches
QUOTING	4	N	Blank_Width	inches
QUOTING	5	N	Material_Thickness	inches
QUOTING	6	N	Perimeter	inches
QUOTING	7	N	Flat_Length	inches
QUOTING	8	N	Flat_Width	inches
QUOTING	9	N	Round_Holes	
QUOTING	10	N	Round_Sizes	
QUOTING	11	N	Obround_Holes	
QUOTING	12	N	Obround_Sizes	
QUOTING	13	N	Rectang_Holes	
QUOTING	14	N	Rectang_Sizes	
QUOTING	15	N	Other_Holes	
QUOTING	16	N	Other_Sizes	
QUOTING	17	N	Num_Cutouts	
QUOTING	18	N	Cutout_Perimeter	inches
QUOTING	19	N	Min_Bend_Length	inches
QUOTING	20	N	Max_Bend_Length	inches
QUOTING	21	N	Min_Bend_Angle	inches
QUOTING	22	N	Max_Bend_Angle	inches
QUOTING	23	N	Min_Flange_Width	inches
QUOTING	24	N	Max_Flange_Width	inches
QUOTING	25	N	Min_Pem_Gap	inches
QUOTING	26	N	Min_Dn_Pem_Gap	inches
QUOTING	27	N	Min_Emboss_Gap	inches
QUOTING	28	N	Min_Dn_Emboss_Gap	inches
QUOTING	29	N	Min_Louver_Gap	inches
QUOTING	30	N	Min_Dn_Louver_Gap	inches
QUOTING	31	N	Min_Taper_Bl_Gap	inches
QUOTING	32	N	Min_Die_Cutout	inches
QUOTING	33	N	Up_Bends	
QUOTING	34	N	Int_Up_Bends	
QUOTING	35	N	Max_Up_Bend	
QUOTING	36	N	Down_Bends	
QUOTING	37	N	Int_Down_Bends	
QUOTING	38	N	Max_Down_Bend	
QUOTING	39	N	Fold_Count	
QUOTING	40	N	Hem_Count	
QUOTING	41	N	Extrude_Count	
QUOTING	42	N	Bend_Radius	inches
QUOTING	43	C	Cutting_Method	
QUOTING	44	C	Cutter_Ref_Num	
QUOTING	45	C	Certified_Mtrl	
		1 Yes		
		2 No		
QUOTING	46	C	Material	
QUOTING	47	N	Cutout_Distance	inches
QUOTING	48	N	Part_Distance	inches

QUOTING (Dimensions 49 through 58)

PART #	DIM. #	TYPE	DIMENSION NAME	UOM
QUOTING	49	C	Hardware:	
		1	PEM-NUT	
		2	PEM-STUD	
		3	STANDOFF	
		4	RIVET	
		5	SCREW	
		6	None	
QUOTING	50	C	Part_Status:	
		1	New	
		2	Revised	
		3	Existing	
QUOTING	51	C	Program_Part:	
		1	Simple Change	
		2	Simple Part	
		3	Medium Part	
		4	Hard Part	
		5	Very Hard Part	
		6	Extremely Hard Part	
QUOTING	52	C	Setup_Master_File?	
		1	Yes	
		2	No	
QUOTING	53	C	Shear_Punch:	
		1	Shearing	
		2	Punching	
		3	Laser	
		4	WaterJet	
QUOTING	54	C	Pre-Form:	
		1	Shake-Out	
		2	Tumble-Debur	
		3	Graining	
QUOTING	55	C	Pem_Options:	
		1	1-Man	
		2	2-Man	
		3	None	
QUOTING	56	C	Form_Options:	
		1	Form	
		2	Jog	
		3	Form-2	
		4	Flatten	
		5	Straighten	
		6	None	
QUOTING	57	C	Machine_Shop:	
		1	Whitney	
		2	AIDA	
		3	Bench Work	
		4	None	
QUOTING	58	C	Welding:	
		1	MIG Weld	
		2	TIG Weld	
		3	Stud Welding	
		4	Spot-Weld	
		5	Dress	
		6	None	

QUOTING (Dimensions 59 through 66)

PART #	DIM. #	TYPE	DIMENSION NAME	UOM
QUOTING	59	C	Assembly:	
			1 Pop Rivet	
			2 General Assembly	
			3 None	
QUOTING	60	C	Inspection:	
			1 Inspect	
			2 Inspect-100	
			3 None	
QUOTING	61	C	Finishing:	
			1 Masking	
			2 Inspect-Finish+De-masking	
			3 Powder Coat	
			4 Batch Oven	
			5 Wash Only	
			6 Screen Printing	
			7 Chromating-Etching	
			8 None	
QUOTING	62	C	Shipping:	
			1 Pack-for-Shipment	
			2 None	
QUOTING	63	C	Turret_Laser_Water	
			1 Turret	
			2 Laser	
			3 WaterJet	
			4 Open	
QUOTING	64	C	PressBrake	
			1 Yes	
			2 No	
QUOTING	65	C	PanelBend	
			1 Yes	
			2 No	
QUOTING	66	C	PressBrk_PanelBend	
			1 Press-Brake	
			2 Panel-Bender	
			3 Water-Jet	
			4 Both	
			5 None	

DEMO-01-STOCK-OP (Dimensions 1 through 4)

PART #	DIM. #	TYPE	DIMENSION NAME	UOM
DEMO-01-STOCK-OP	1	N	Flat_Length	inches
DEMO-01-STOCK-OP	2	N	Flat_Width	inches
DEMO-01-STOCK-OP	3	N	Material_Thickness	inches
DEMO-01-STOCK-OP	4	C	Material	

6. Select **“Update”** option followed by selecting **“51 Program_Part:”** dimension to display the following screen form and menu options:

Dimension-Edit

Update Part Dimension, then Press [OK]:

PART #: QUOTING QUOTE CONFIGURATION

DIMENSION #: 51 Program_Part:

DIM. TYPE: Character MTL. DIM: No DISPLAY WIDTH: 3

UOM: DESCRIPTION: No UNIT STRING:

CONSTR. TYPE: None CUSTOM NUMBER: None

OPTIONS LIST: Yes UOM REL: None TOLERANCE +: 0.000000

QUOTE DISPLAY: No FACTOR: 0.000000 TOLERANCE -: 0.000000

MIN. LIMIT: MIN. VALUE: 0.000000

MAX. LIMIT: MAX. VALUE:

INTERVAL:

DIMENSION VALUE METHOD: Formula

DESCRIPTION: CFG PARAM: CAD ATTRIB: Program_Part: ROUTING SEQ:

PARAMETER TYPE: REQUIRED ENTRY: No ACTIVE: Yes DEBUG: No

BO43

Enter Variable Part Dimension: OVR

7. Select **“Formula”** option to display the following screen form and menu options:

Configuration-Formula

FORMULA

Update

View

QUIT

TYPE: DIMENSION DIM: Program_Part:

TRANS: 0 LINK:

CURRENT LINE: SCREEN: TOTAL: 15

ROW	ACTION	DESCRIPTION
1	IF	IF
2	(	START SUB EXPRESSION
3	DIM	[QUOTING (DIM)Part_Status:]
4	=	EQUAL TO
5	A	ALPHA New
6	)	END SUB EXPRESSION
7	OR	OR
8	(	START SUB EXPRESSION
9	DIM	[QUOTING (DIM)Part_Status:]
10	=	EQUAL TO
11	A	ALPHA Revised
12	)	END SUB EXPRESSION
13	THEN	THEN
14	PRMT	PROMPT FOR INPUT
15	FI	END IF

BO40

Update Formula OVR

QUOTING (Dimension Number 51 “Program_Part:”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
0			D	QUOTING	51	1	IF		
0			D	QUOTING	51	2	(		
0	QUOTING	50	D	QUOTING	51	3	DIM	Part_Status:	
0			D	QUOTING	51	4	=		
0			D	QUOTING	51	5	A	New	
0			D	QUOTING	51	6	)		
0			D	QUOTING	51	7	OR		
0			D	QUOTING	51	8	(		
0	QUOTING	50	D	QUOTING	51	9	DIM	Part_Status:	
0			D	QUOTING	51	10	=		
0			D	QUOTING	51	11	A	Revised	
0			D	QUOTING	51	12	)		
0			D	QUOTING	51	13	THEN		
0			D	QUOTING	51	14	PRMT		
0			D	QUOTING	51	15	FI		

QUOTING (Dimension Number 52 “Setup_Master_File?”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
0			D	QUOTING	52	1	IF		
0			D	QUOTING	52	2	(		
0	QUOTING	50	D	QUOTING	52	3	DIM	Part_Status:	
0			D	QUOTING	52	4	=		
0			D	QUOTING	52	5	A	New	
0			D	QUOTING	52	6	)		
0			D	QUOTING	52	7	OR		
0			D	QUOTING	52	8	(		
0	QUOTING	50	D	QUOTING	52	9	DIM	Part_Status:	
0			D	QUOTING	52	10	=		
0			D	QUOTING	52	11	A	Revised	
0			D	QUOTING	52	12	)		
0			D	QUOTING	52	13	THEN		
0			D	QUOTING	52	14	PRMT		
0			D	QUOTING	52	15	ELSE		
0			D	QUOTING	52	16	A	No	
0			D	QUOTING	52	17	FI		

QUOTING (Dimension Number 63 “Turret_Laser_Water”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
0			D	QUOTING	63	1	IF		
0	QUOTING	43	D	QUOTING	63	2	DIM	Cutting_Method	
0			D	QUOTING	63	3	I=		
0			D	QUOTING	63	4	A	Open	
0			D	QUOTING	63	5	THEN		
0	QUOTING	43	D	QUOTING	63	6	DIM	Cutting_Method	
0			D	QUOTING	63	7	ELSE		
0			D	QUOTING	63	8	A	Turret	
0			D	QUOTING	63	9	FI		

QUOTING (Dimension Number 64 “PressBrake”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
0			D	QUOTING	64	1	IF		
0	QUOTING	35	D	QUOTING	64	2	DIM	Max_Up_Bend	
0			D	QUOTING	64	3	<=		
0			D	QUOTING	64	4	K		6.000000
0			D	QUOTING	64	5	THEN		
0			D	QUOTING	64	6	A	No	
0			D	QUOTING	64	7	ELSE		
0			D	QUOTING	64	8	IF		
0			D	QUOTING	64	9	(		
0	QUOTING	7	D	QUOTING	64	10	DIM	Flat_Length	
0			D	QUOTING	64	11	>=		
0			D	QUOTING	64	12	K		11.220000
0			D	QUOTING	64	13	)		
0			D	QUOTING	64	14	AND		
0			D	QUOTING	64	15	(		
0	QUOTING	7	D	QUOTING	64	16	DIM	Flat_Length	
0			D	QUOTING	64	17	<=		
0			D	QUOTING	64	18	K		78.543000
0			D	QUOTING	64	19	)		
0			D	QUOTING	64	20	AND		
0			D	QUOTING	64	21	(		
0	QUOTING	8	D	QUOTING	64	22	DIM	Flat_Width	
0			D	QUOTING	64	23	>=		
0			D	QUOTING	64	24	K		7.480000
0			D	QUOTING	64	25	)		
0			D	QUOTING	64	26	AND		
0			D	QUOTING	64	27	(		
0	QUOTING	8	D	QUOTING	64	28	DIM	Flat_Width	
0			D	QUOTING	64	29	<=		
0			D	QUOTING	64	30	K		59.055000
0			D	QUOTING	64	31	)		
0			D	QUOTING	64	32	AND		
0			D	QUOTING	64	33	(		
0	QUOTING	5	D	QUOTING	64	34	DIM	Material_Thickness	
0			D	QUOTING	64	35	>=		
0			D	QUOTING	64	36	K		0.024000
0			D	QUOTING	64	37	)		
0			D	QUOTING	64	38	AND		
0			D	QUOTING	64	39	(		
0	QUOTING	5	D	QUOTING	64	40	DIM	Material_Thickness	
0			D	QUOTING	64	41	<=		
0			D	QUOTING	64	42	(		
0			D	QUOTING	64	43	IF		
0	QUOTING		D	QUOTING	64	44	MTLG		
0			D	QUOTING	64	45	=		
0			D	QUOTING	64	46	A	Aluminum	
0			D	QUOTING	64	47	THEN		
0			D	QUOTING	64	48	K		0.118000
0			D	QUOTING	64	49	ELSE		
0			D	QUOTING	64	50	IF		
0	QUOTING		D	QUOTING	64	51	MTLG		
0			D	QUOTING	64	52	=		
0			D	QUOTING	64	53	A	Stainless	
0			D	QUOTING	64	54	THEN		
0			D	QUOTING	64	55	K		0.049000
0			D	QUOTING	64	56	ELSE		
0			D	QUOTING	64	57	IF		
0	QUOTING		D	QUOTING	64	58	MTLG		
0			D	QUOTING	64	59	=		
0			D	QUOTING	64	60	A	Steel	
0			D	QUOTING	64	61	THEN		
0			D	QUOTING	64	62	K		0.079000
0			D	QUOTING	64	63	ELSE		
0			D	QUOTING	64	64	K		0.079000
0			D	QUOTING	64	65	FI		
0			D	QUOTING	64	66	FI		
0			D	QUOTING	64	67	FI		
0			D	QUOTING	64	68	)		
0			D	QUOTING	64	69	)		
0			D	QUOTING	64	70	AND		
0			D	QUOTING	64	71	(		
0	QUOTING	36	D	QUOTING	64	72	DIM	Down_Bends	
0			D	QUOTING	64	73	>=		
0			D	QUOTING	64	74	K		0.000000
0			D	QUOTING	64	75	)		
0			D	QUOTING	64	76	AND		
0			D	QUOTING	64	77	(		
0	QUOTING	39	D	QUOTING	64	78	DIM	Fold_Count	
0			D	QUOTING	64	79	>		
0			D	QUOTING	64	80	K		0.000000
0			D	QUOTING	64	81	)		
0			D	QUOTING	64	82	THEN		
0			D	QUOTING	64	83	A	Yes	
0			D	QUOTING	64	84	ELSE		
0			D	QUOTING	64	85	A	No	
0			D	QUOTING	64	86	FI		
0			D	QUOTING	64	87	FI		

QUOTING (Dimension Number 65 “PanelBend”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
0			D	QUOTING	65	1	IF		
0			D	QUOTING	65	2	(		
0	QUOTING	7	D	QUOTING	65	3	DIM	Flat_Length	
0			D	QUOTING	65	4	<=		
0			D	QUOTING	65	5	K		120.000000
0			D	QUOTING	65	6	)		
0			D	QUOTING	65	7	AND		
0			D	QUOTING	65	8	(		
0	QUOTING	8	D	QUOTING	65	9	DIM	Flat_Width	
0			D	QUOTING	65	10	<=		
0			D	QUOTING	65	11	K		60.000000
0			D	QUOTING	65	12	)		
0			D	QUOTING	65	13	AND		
0			D	QUOTING	65	14	(		
0	QUOTING	36	D	QUOTING	65	15	DIM	Down_Bends	
0			D	QUOTING	65	16	>		
0			D	QUOTING	65	17	K		0.000000
0			D	QUOTING	65	18	)		
0			D	QUOTING	65	19	AND		
0			D	QUOTING	65	20	(		
0	QUOTING	39	D	QUOTING	65	21	DIM	Fold_Count	
0			D	QUOTING	65	22	>		
0			D	QUOTING	65	23	K		0.000000
0			D	QUOTING	65	24	)		
0			D	QUOTING	65	25	THEN		
0			D	QUOTING	65	26	A	Yes	
0			D	QUOTING	65	27	ELSE		
0			D	QUOTING	65	28	A	No	
0			D	QUOTING	65	29	FI		

QUOTING (Dimension Number 66 “PressBrk_PanelBend”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
0			D	QUOTING	66	1	IF		
0			D	QUOTING	66	2	(		
0	QUOTING	65	D	QUOTING	66	3	DIM	PanelBend	
0			D	QUOTING	66	4	=		
0			D	QUOTING	66	5	A	Yes	
0			D	QUOTING	66	6	)		
0			D	QUOTING	66	7	AND		
0			D	QUOTING	66	8	(		
0	QUOTING	64	D	QUOTING	66	9	DIM	PressBrake	
0			D	QUOTING	66	10	=		
0			D	QUOTING	66	11	A	Yes	
0			D	QUOTING	66	12	)		
0			D	QUOTING	66	13	THEN		
0			D	QUOTING	66	14	A	Both	
0			D	QUOTING	66	15	ELSE		
0			D	QUOTING	66	16	IF		
0			D	QUOTING	66	17	(		
0	QUOTING	65	D	QUOTING	66	18	DIM	PanelBend	
0			D	QUOTING	66	19	=		
0			D	QUOTING	66	20	A	Yes	
0			D	QUOTING	66	21	)		
0			D	QUOTING	66	22	THEN		
0			D	QUOTING	66	23	A	Panel-Bender	
0			D	QUOTING	66	24	ELSE		
0			D	QUOTING	66	25	IF		
0			D	QUOTING	66	26	(		
0	QUOTING	64	D	QUOTING	66	27	DIM	PressBrake	
0			D	QUOTING	66	28	=		
0			D	QUOTING	66	29	A	Yes	
0			D	QUOTING	66	30	)		
0			D	QUOTING	66	31	THEN		
0			D	QUOTING	66	32	A	Press-Brake	
0			D	QUOTING	66	33	ELSE		
0			D	QUOTING	66	34	A	None	
0			D	QUOTING	66	35	FI		
0			D	QUOTING	66	36	FI		
0			D	QUOTING	66	37	FI		

DEMO-01-STOCK-OP (Xxxxxxxx)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
13	QUOTING	7	D	DEMO-01-STOCK-OP	1	1	DIM	Flat_Length	
13	QUOTING	8	D	DEMO-01-STOCK-OP	2	1	DIM	Flat_Width	
13	QUOTING	5	D	DEMO-01-STOCK-OP	3	1	DIM	Material_Thickness	
13	QUOTING	46	D	DEMO-01-STOCK-OP	4	1	DIM	Material	

Section 2: Assembly / BOM Structures

This section provides an explanation of setting up the **Global Edge Configuration Engine** by defining an assembly / bill of materials structure based on the Template Part Numbers defined in Section 1. This assembly / bill of materials structure includes all the available components that comprise a configured product or assembly.

2.1 – Define Assembly / Bill of Materials Structures

This section includes the steps to define Master Assembly / Bill of Materials structures. These steps include the following:

Steps

1. Retrieve “**QUOTING**” part number:

BILL OF MATERIALS: Global Edge Windows Demo Server

Part-Master

PART #: QUOTING QUOTE CONFIGURATION

REV #:

TYPE: Product MST: Yes

PART UOM: EA

LIST: \$0.00

ALIAS OF:

ORIGIN: Manufactured

MFR. PART #:

MFR: LDC Manufacturing

CATEGORY: SHT SHEET METAL SERIAL: None STATUS: Active

STYLE: DEM DEMO SHIP WEIGHT: 0.0 REBUILT: No

MATERIAL:

PART ADDED: 04/10/2023 TRANSFER:

MODIFIED: 04/10/2023 COST QTY: 1.0000

STANDARD PART COST: \$0.0000

QUOTE PART COST: \$0.0000

ROLL-UP COST: \$0.0000

PROCESS COST: \$0.0000 MFR. SET-UP COST: \$625.75 ROLL-UP DATE:

COMPONENT COST: \$0.0000 ONE TIME CHARGE: \$0.00

CAD PART FILE NAME:

Get QUOTE

[# 1 of 1]

BO01

Find Part(s)

OVR

PART

Add

End

Next

Previous

Goto

Update

BOM

WhereUsed

Revisions

Mfr-Test

DocumEnt

Configurator

WorkQueue

Options

Long

RollUp

category

Print

Delete

QUIT

2. Select **“BOM > Level”** (enter “5”) options to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

BOM-Assembly-List

PART NUMBER: QUOTING TYPE: Product

QUOTE CONFIGURATION

MAXIMUM BOM LEVELS (1 to 99): 5 LEAD TIME >: DAYS

INDENT SPACES PER LEVEL (1 to 3): 3 OVERRIDE EXPLOSION CONTROL (Y/N): No

ITEM	LEVEL	PART #	DESCRIPTION	QTY REQD	UOM	MATES	TRANS#
1	1	DEMO-01-STOCK-OP	DEMO STOCK OPTIONS LIST	1.0000	EA	0	13
2	2	304-2B	304-2B STAINLESS STEEL		lbs	0	7
3	2	304-4	304-4 STAINLESS STEEL		lbs	0	8
4	2	316-2B	316-2B STAINLESS STEEL		lbs	0	9
5	2	5052-H32	ALUMINUM		lbs	0	10
6	2	CRS	COLD ROLLED STEEL		lbs	0	11
7	2	G60	G60 GALVANIZED STEEL		lbs	0	12
8	1	DEMO-02-HARDWARE-OP	DEMO HARDWARE OPTIONS LIST	1.0000	EA	0	14
9	2	PEM-NUT	PEM NUT		EA	0	17
10	2	PEM-STUD	PEM STUD		EA	0	18
11	2	STANDOFF	STANDOFF		EA	0	19
12	2	RIVET	RIVET		EA	0	20
13	2	SCREW	SCREW		EA	0	21
14	1	DEMO-03-COMPONENTS-OP	DEMO COMPONENTS OPTIONS LIST	1.0000	EA	0	15
15	2	PACKAGING	PACKAGING		EA	0	22
16	2	BOX-32X24X24	BOX, 32 X 24 X 24 (S-4453)		EA	0	23
17	2	BAG28-4-599	U-LINE S-2366 20IN X 30IN FLAT BAG		EA	0	24
18	2	BOX-30X24X20	U-LINE BOX S-4961		EA	0	25
19	2	SP-032-1	10-32 PEM NUTS		EA	0	26
20	2	832316	8-32 SELF TAPPING SCREWS		EA	0	27
21	2	MATERIAL-MARKUP	MATERIAL MARKUP		EA	0	28
22	1	DEMO-04-OTHER-CHARGES-OP	DEMO OTHER CHARGES OPTIONS LIST	1.0000	EA	0	16
23	2	TAPE	TAPE CHARGE		EA	0	29

BO67

Change Level & Other Search Criteria

OVR

BOM

Add

Update

View

Level

Routings

Dimensions

Gen-Row

NC-Program

CAD-Export

reOrder

delete

QUIT

QUOTING (Assembly / BOM Structure)

PART #	TRANS #	ORDER #	FORMULA	QTY. REQ.	TYPE	UOM
QUOTING						
DEMO-01-STOCK-OP	13	1	Standard	1.0000	E	EA
304-2B	7	1	Formula		E	lbs
304-4	8	2	Formula		E	lbs
316-2B	9	3	Formula		E	lbs
5052-H32	10	4	Formula		E	lbs
CRS	11	5	Formula		E	lbs
G60	12	6	Formula		E	lbs
DEMO-02-HARDWARE-OP	14	2	Standard	1.0000	E	EA
PEM-NUT	17	1	Entry		E	EA
PEM-STUD	18	2	Entry		E	EA
STANDOFF	19	3	Entry		E	EA
RIVET	20	4	Entry		E	EA
SCREW	21	5	Entry		E	EA
DEMO-03-COMPONENTS-OP	15	3	Standard	1.0000	E	EA
PACKAGING	22	1	Entry		E	EA
BOX-32X24X24	23	2	Entry		E	EA
BAG28-4-599	24	3	Entry		E	EA
BOX-30X24X20	25	4	Entry		E	EA
SP-032-1	26	5	Entry		E	EA
832316	27	6	Entry		E	EA
MATERIAL-MARKUP	28	7	Entry		E	EA
DEMO-04-OTHER-CHARGES-OP	16	4	Standard	1.0000	E	EA
TAPE	29	1	Entry		O	EA

3. Select **“Update”** option and select **“DEMO-01-STOCK-OP”** part number, then select **“OK”** to display following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Assembly-Edit

LINE #: 1 TRANS #: 13

PART #: DEMO-01-STOCK-OP DEMO STOCK OPTIONS LIST

QTY: Standard 1.0000 UOM: EA

ACCURACY: Exact MTRL YIELD: % REMNANT YIELD: %

REF: TYPE: Option

DIMENSIONS/PARAMETERS METHOD VALUES UOM

Flat_Length Formula inches

Flat_Width Formula inches

Material_Thickness Formula inches

Material Formula

STD/OPT: Standard Part

ALT: No

EXPLODE: Yes

LINE: OF: 4

BILL TYPE: S STANDARD MAX. BOM LINES: DIM. PARAM: No

SHIP WEIGHT: 0.0 NOTE LINES: 0 CAD GROUND: No

CURRENT LIST PRICE: \$0.00 / EA CFG MODEL COPY: No

CURRENT STD. COST: \$0.0000 / EA DEBUG MODE: No

BO09

Update Component Information

COMPONENT

Update

Instances

Reference

Notes

Cost

Documents

QUIT

4. Select **“Update”** option and tab to METHOD fields:

Assembly-Edit

Enter Component Information, then Press [OK]:

LINE #: 1 TRANS #: 13

PART #: DEMO-01-STOCK-OP DEMO STOCK OPTIONS LIST

QTY: Standard 1.0000 UOM: EA

ACCURACY: Exact MTRL YIELD: % REMNANT YIELD: %

REF: TYPE: Option

DIMENSIONS/PARAMETERS METHOD VALUES UOM

Flat_Length Formula inches

Flat_Width Formula inches

Material_Thickness Formula inches

Material Formula

STD/OPT: Standard Part

ALT: No

EXPLODE: Yes

LINE: 1 OF: 4

BILL TYPE: S STANDARD MAX. BOM LINES: DIM. PARAM: No

SHIP WEIGHT: NOTE LINES: 0 CAD GROUND: No

CURRENT LIST PRICE: \$0.00 / EA CFG MODEL COPY: No

CURRENT STD. COST: \$0.0000 / EA DEBUG MODE: No

BO09

METHOD: [S]-tandard, [D]-efault, [E]-ntry, [F]-ormula

OK Cancel Insert Append Delete F6-Formula

5. Select **“F6-Formula”** option to display **“Configuration-Formula”** screen form and menu options:

Dimension #13 – Flat_Length

Configuration-Formula

TYPE: DIMENSION DIM: Flat_Length

TRANS: 13 LINK: ASSEMBLY

CURRENT LINE: 13 SCREEN: 1 TOTAL: 1

ROW ACTION DESCRIPTION

1 DIM [QUOTING (DIM)Flat_Length]

BO40

Update Formula

FORMULA

Update View Quit

Dimension #13 – Flat_Width

Configuration-Formula

TYPE: DIMENSION DIM: Flat_Width

TRANS: 13 LINK: ASSEMBLY

CURRENT LINE: 13 SCREEN: 1 TOTAL: 1

ROW ACTION DESCRIPTION

1 DIM [QUOTING (DIM)Flat_Width]

BO40

Update Formula

FORMULA

Update View Quit

Dimension #13 – Material_Thickness

Configuration-Formula

TYPE: DIMENSION DIM: Material_Thickness

TRANS: 13 LINK: ASSEMBLY

CURRENT LINE: 1 SCREEN: 1 TOTAL: 1

ROW	ACTION	DESCRIPTION
1	DIM	[QUOTING (DIM)Material_Thickness]

BO40

Update Formula

FORMULA

Update

View

QUIT

OVR

Dimension #13 – Material

Configuration-Formula

TYPE: DIMENSION DIM: Material

TRANS: 13 LINK: ASSEMBLY

CURRENT LINE: 1 SCREEN: 1 TOTAL: 1

ROW	ACTION	DESCRIPTION
1	DIM	[QUOTING (DIM)Material]

BO40

Update Formula

FORMULA

Update

View

QUIT

OVR

6. Return to BOM menu and select **“Update”** option and select **“304-2B”** part number, then select **“OK”** to display following screen form and menu options:

Assembly-Edit

LINE #: 1 TRANS #: 7

PART #: 304-2B 304-2B STAINLESS STEEL

QTY: Formula UOM: lbs

ACCURACY: Exact MTRL YIELD: % REMNANT YIELD: %

REF: TYPE: Raw-Material

DIMENSIONS/PARAMETERS	METHOD	VALUES	UOM
-----------------------	--------	--------	-----

STD/OPT: Standard Part

ALT: No

EXPLODE: Yes

LINE: OF:

BILL TYPE: S STANDARD MAX. BOM LINES: DIM. PARAM: No

SHIP WEIGHT: 0.0

CURRENT LIST PRICE: \$0.00 / lbs

CURRENT STD. COST: \$2.1000 / lbs

NOTE LINES: 0 CAD GROUND: No

CFG MODEL COPY: No

DEBUG MODE: No

BO09

Update Component Information

COMPONENT

Update

Instances

Reference

Notes

Cost

Documents

QUIT

OVR

7. Select **“Update”** option to display following menu options:

Assembly-Edit

Enter Component Information, then Press [OK]:

LINE #: 1 TRANS #: 7

PART #: 304-2B 304-2B STAINLESS STEEL

QTY: Formula UOM: lbs

ACCURACY: Exact MTRL YIELD: % REMNANT YIELD: %

REF: TYPE: Raw-Material

DIMENSIONS/PARAMETERS	METHOD	VALUES	UOM

STD/OPT: Standard Part ALT: No EXPLODE: Yes

LINE: OF:

BILL TYPE: S STANDARD MAX. BOM LINES: DIM. PARAM: No

SHIP WEIGHT: 0.0 NOTE LINES: 0 CAD GROUND: No

CURRENT LIST PRICE: \$0.00 / lbs CFG MODEL COPY: No

CURRENT STD. COST: \$2.1000 / lbs DEBUG MODE: No

BO09

Quantity Method: [S]tandard, [E]ntry, [D]efault, [F]ormula

8. Select **“F6-Formula”** option to display the **“Configuration-Formula”** screen form and following menu options:

Configuration-Formula

TYPE: QUANTITY DIM:

TRANS: 7 LINK:

CURRENT LINE: SCREEN: TOTAL: 15

ROW	ACTION	DESCRIPTION
1	IF	IF
2	DIM	[DEMO-01-STOCK-OP (DIM)Material]
3	=	EQUAL TO
4	A	ALPHA 304-2B
5	THEN	THEN
6	DIM	[DEMO-01-STOCK-OP (DIM)Flat_Length]
7	*	MULTIPLIED BY
8	DIM	[DEMO-01-STOCK-OP (DIM)Flat_Width]
9	*	MULTIPLIED BY
10	DIM	[DEMO-01-STOCK-OP (DIM)Material_Thickness]
11	*	MULTIPLIED BY
12	K	CONSTANT 0.279986
13	ELSE	ELSE
14	K	CONSTANT 0.000000
15	FI	END IF

BO40

Update Formula

Quantity Formula (Transaction Number 7 “304-2B”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
7			Q	304-2B		1	IF		
7	DEMO-01-STOCK-OP	4	Q	304-2B		2	DIM	Material	
7			Q	304-2B		3	=		
7			Q	304-2B		4	A	304-2B	
7			Q	304-2B		5	THEN		
7	DEMO-01-STOCK-OP	1	Q	304-2B		6	DIM	Flat_Length	
7			Q	304-2B		7	*		
7	DEMO-01-STOCK-OP	2	Q	304-2B		8	DIM	Flat_Width	
7			Q	304-2B		9	*		
7	DEMO-01-STOCK-OP	1	Q	304-2B		10	DIM	Material_Thickness	
7			Q	304-2B		11	*		
7			Q	304-2B		12	K		0.279986
7			Q	304-2B		13	ELSE		
7			Q	304-2B		14	K		0.000000
7			Q	304-2B		15	FI		

Quantity Formula (Transaction Number 8 “304-4”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
8			Q	304-4		1	IF		
8	DEMO-01-STOCK-OP	4	Q	304-4		2	DIM	Material	
8			Q	304-4		3	=		
8			Q	304-4		4	A	304-4	
8			Q	304-4		5	THEN		
8	DEMO-01-STOCK-OP	1	Q	304-4		6	DIM	Flat_Length	
8			Q	304-4		7	*		
8	DEMO-01-STOCK-OP	2	Q	304-4		8	DIM	Flat_Width	
8			Q	304-4		9	*		
8	DEMO-01-STOCK-OP	1	Q	304-4		10	DIM	Material_Thickness	
8			Q	304-4		11	*		
8			Q	304-4		12	K		0.279986
8			Q	304-4		13	ELSE		
8			Q	304-4		14	K		0.000000
8			Q	304-4		15	FI		

Quantity Formula (Transaction Number 9 “316-2B”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
9			Q	316-2B		1	IF		
9	DEMO-01-STOCK-OP	4	Q	316-2B		2	DIM	Material	
9			Q	316-2B		3	=		
9			Q	316-2B		4	A	316-2B	
9			Q	316-2B		5	THEN		
9	DEMO-01-STOCK-OP	1	Q	316-2B		6	DIM	Flat_Length	
9			Q	316-2B		7	*		
9	DEMO-01-STOCK-OP	2	Q	316-2B		8	DIM	Flat_Width	
9			Q	316-2B		9	*		
9	DEMO-01-STOCK-OP	1	Q	316-2B		10	DIM	Material_Thickness	
9			Q	316-2B		11	*		
9			Q	316-2B		12	K		0.279986
9			Q	316-2B		13	ELSE		
9			Q	316-2B		14	K		0.000000
9			Q	316-2B		15	FI		

Quantity Formula (Transaction Number 10 “5052-H32”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
10			Q	5052-H32		1	IF		
10	DEMO-01-STOCK-OP	4	Q	5052-H32		2	DIM	Material	
10			Q	5052-H32		3	=		
10			Q	5052-H32		4	A	5052-H32	
10			Q	5052-H32		5	THEN		
10	DEMO-01-STOCK-OP	1	Q	5052-H32		6	DIM	Flat_Length	
10			Q	5052-H32		7	*		
10	DEMO-01-STOCK-OP	2	Q	5052-H32		8	DIM	Flat_Width	
10			Q	5052-H32		9	*		
10	DEMO-01-STOCK-OP	1	Q	5052-H32		10	DIM	Material_Thickness	
10			Q	5052-H32		11	*		
10			Q	5052-H32		12	K		0.097904
10			Q	5052-H32		13	ELSE		
10			Q	5052-H32		14	K		0.000000
10			Q	5052-H32		15	FI		

Quantity Formula (Transaction Number 11 “CRS”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
11			Q	CRS		1	IF		
11	DEMO-01-STOCK-OP	4	Q	CRS		2	DIM	Material	
11			Q	CRS		3	=		
11			Q	CRS		4	A	CRS	
11			Q	CRS		5	THEN		
11	DEMO-01-STOCK-OP	1	Q	CRS		6	DIM	Flat_Length	
11			Q	CRS		7	*		
11	DEMO-01-STOCK-OP	2	Q	CRS		8	DIM	Flat_Width	
11			Q	CRS		9	*		
11	DEMO-01-STOCK-OP	1	Q	CRS		10	DIM	Material_Thickness	
11			Q	CRS		11	*		
11			Q	CRS		12	K		0.283960
11			Q	CRS		13	ELSE		
11			Q	CRS		14	K		0.000000
11			Q	CRS		15	FI		

Quantity Formula (Transaction Number 12 “G60”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
12			Q	G60		1	IF		
12	DEMO-01-STOCK-OP	4	Q	G60		2	DIM	Material	
12			Q	G60		3	=		
12			Q	G60		4	A	G60	
12			Q	G60		5	THEN		
12	DEMO-01-STOCK-OP	1	Q	G60		6	DIM	Flat_Length	
12			Q	G60		7	*		
12	DEMO-01-STOCK-OP	2	Q	G60		8	DIM	Flat_Width	
12			Q	G60		9	*		
12	DEMO-01-STOCK-OP	1	Q	G60		10	DIM	Material_Thickness	
12			Q	G60		11	*		
12			Q	G60		12	K		0.283960
12			Q	G60		13	ELSE		
12			Q	G60		14	K		0.000000
12			Q	G60		15	FI		

Section 3: Manufacturing Processes / Routing Structures

This section provides an explanation of the next step of setting up the **Global Edge Configuration Engine** to include the capability to automatically generate routings. This starts with first defining your Manufacturing Processes, then defining the available Manufacturing Processes for each of the parts in the configuration structure.

3.1 – Define Manufacturing Processes

This section includes the steps to define Manufacturing Processes. These steps include the following:

Steps

1. Select **“Engineering > Engineering Setup / Utilities > Engineering Set-Up > Mfg-Processes”** options to display the following screen form and menu options:

The screenshot displays the 'ENGINEERING SET-UP / UTILITIES: Global Edge Windows Demo Server' window. The main form is titled 'Manufacturing-Process'. It contains several input fields and checkboxes:

- PROCESS NAME:** A text input field.
- PROCESS CLASS:** A dropdown menu.
- PROCESS TYPE:** A dropdown menu.
- PART TYPES:** A grid of checkboxes for ASSEMBLY, CASTING, EXTRUSION, FORMED, MACHINED, MOLDED, SHEET METAL, and WELDMENT.
- RATE METHOD:** A dropdown menu.
- STANDARD COST:** A text input field.
- METHOD UOM:** A text input field.
- MARK UP METHOD:** A dropdown menu.
- MARK UP PRECENT:** A text input field.
- MARK UP AMOUNT:** A text input field.
- MTRL YIELD RATE:** A text input field with a percentage symbol.
- SCRAP RATE:** A text input field with a percentage symbol.
- COSTING PROGRAM:** A dropdown menu.

On the right side, there is a vertical menu with the following buttons: Add, Find, Next, Previous, Update, proGrams, cOnfig, grInT, doCuments, Delete, and QUIT. At the bottom left, there is a button labeled 'Add New Process'. At the bottom right, there is a status bar with 'OVR' and a small icon.

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Manufacturing Process

PROCESS	DESCRIPTION	CLASS	STD. COST	UOM
AIDA	AIDA Stamping Operation	FRM	\$75.0000	hours
ASSEMBLY	Assembly Operation	ASM	\$50.0000	hours
BATCH-OVEN	Batch Oven Operation	OVN	\$25.0000	hours
BENCH-WORK	Bench Work Operation	LBR	\$50.0000	hours
BEND	Press Brake Bend Operation	FRM	\$75.0000	hours
CHROMATE-ETCH	Chromating-Etching Operation	FIN	\$85.0000	hours
CORNER	Corner Bending Operation	FRM	\$35.0000	hours
CURING	Curing Operation	OVN	\$25.0000	hours
CUT-TO-LENGTH	Cut-to-Length Operation	SHR	\$55.0000	hours
DEBURR	Deburring Operation	FIN	\$45.0000	hours
DRESS	Dress Operation	WLD	\$45.0000	hours
EMBOSS	Embossing Operation	PNC	\$75.0000	hours
FINAL-INSPECT	Final Inspection	ISP	\$35.0000	hours
FLATTEN	Flatten Operation	FRM	\$75.0000	hours
FOLD	Folder Folding Operation	PNL	\$120.0000	hours
FORM	Forming Operation	FRM	\$75.0000	hours
FORM-2	Form 2 Person	FRM	\$75.0000	hours
GASKETING	Gasketing Operation	GSK	\$35.0000	hours
GENERAL-ASSEMBLY	General Assembly Operation	ASM	\$50.0000	hours
GENERAL-LABOR	General Labor	LBR	\$50.0000	hours
GRAIN	Graining Operation	FIN	\$45.0000	hours
GRIND	Grinding Operation	FIN	\$25.0000	hours
HANGING	Hanging Operation	HNG	\$25.0000	hours
INSPECT	Inspection Operation	ISP	\$35.0000	hours
INSPECT-100	Inspect 100 Percent Operation	ISP	\$35.0000	hours
INSPECT-FINISH-DE	Insp.-Fin.+De-masking Operation	ISP	\$35.0000	hours
INSTALL-PEM-NUTS	Install Pem Nuts	PEM	\$50.0000	hours
INSTALL-PEM-STUDS	Install Pem Studs	PEM	\$50.0000	hours
JOG	JOG Operation	FRM	\$75.0000	hours
LASER-CUT	Laser Cut Operation	LSR	\$140.0000	hours
MASKING	Masking Operation	PNT	\$40.0000	hours
MIG-WELD	MIG Weld Operation	WLD	\$45.0000	hours
PACKAGE	Package	PKG	\$35.0000	hours
PACK-FOR-SHIPMENT	Pack for Shipment	PKG	\$35.0000	hours
PAINTING	Painting Operation	PNT	\$40.0000	hours
PANELBEND	Panel Bender Bending Operation	PNL	\$120.0000	hours
PEM	Pemsert Operation	PEM	\$25.0000	hours
PEM-2	Pemsert 2 Person Operation	PEM	\$25.0000	hours
POWDER-COAT	Powder Coat Operation	PNT	\$40.0000	hours
PROGRAM-NEW-PART	Program New Part Operation	PRG	\$50.0000	hours
PROGRAM-REV-PART	Program Revised Part Operation	PRG	\$50.0000	hours
PROOF-NEW-PART	Proof New Part Operation	PRF	\$50.0000	hours
PROOF-REV-PART	Proof Revised Part Operation	PRF	\$50.0000	hours
PUNCH	Turret Punch Operation	PNC	\$75.0000	hours
RIVET	Rivet Operation	ASM	\$50.0000	hours
SAND-PAINT-PREP	Sand / Paint / Preparation Operation	WPR	\$40.0000	hours
SCREEN-PRINT	Screen Printing Operation	PNT	\$40.0000	hours
SETUP-MASTER-FILE	Setup Master File Operation	PRG	\$50.0000	hours
SHAKE-OUT	Shake Out Operation	FIN	\$75.0000	hours
SHEAR	Shear Operation	SHR	\$55.0000	hours
SHIPPING	Shipping Operation	SHP	\$35.0000	hours
SPOT-WELD	Spot Welding Operation	WSP	\$45.0000	hours
STRAIGHTEN-ROLLER	Straighten Roller Operation	FRM	\$75.0000	hours
STUD-WELDING	Stud Welding Operation	WST	\$45.0000	hours
TIG-WELD	TIG Weld Operation	WLD	\$45.0000	hours
TUMBLE-DEBURR	Tumble Deburr Operation	FIN	\$75.0000	hours
WASHING	Washing Operation	WSH	\$25.0000	hours
WASH-ONLY	Wash Only Operation	WSH	\$25.0000	hours
WELD-MD	Medium Seam-Tack Welding Operation	WLD	\$45.0000	hours
WHITNEY	Whitney Punch & Plasma Operation	PNC	\$75.0000	hours

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3.2 – Define Routing Structures

This section allows you to attach available Manufacturing Processes to each of the parts included in the Master Configuration. After attaching available Manufacturing Processes as outlined in this section, subsequently configuration rules will then be applied to each Manufacturing Process in **Section 4: Configuration Rules / Formulas**.

Steps

1. Select **“Engineering > BOM / Product Configuration > Find”** options and select **“QUOTING”** to retrieve to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Part-Master

PART #: QUOTING QUOTE CONFIGURATION

REV #:

TYPE: Product MST: Yes

PART UOM: EA

LIST: \$0.00

ALIAS OF:

ORIGIN: Manufactured

MFR. PART #:

MFR: LDC Manufacturing

CATEGORY: SHT SHEET METAL SERIAL: None STATUS: Active

STYLE: DEM DEMO SHIP WEIGHT: 0.0 REBUILT: No

MATERIAL:

PART ADDED: 04/10/2023 TRANSFER:

MODIFIED: 04/10/2023 COST QTY: 1.0000

STANDARD PART COST: \$0.0000

QUOTE PART COST: \$0.0000

PROCESS COST: \$0.0000 MFR. SET-UP COST: \$625.75 ROLL-UP COST: \$0.0000

COMPONENT COST: \$0.0000 ONE TIME CHARGE: \$0.00 ROLL-UP DATE:

CAD PART FILE NAME:

Get QUOTE

Get QUOTE

(# 1 of 1)

BO01

Find Part(s)

PART

Add

Find

Next

Previous

Goto

Update

BOM

WhereUsed

reVisions

Mfr-Test

documEnt

Configurator

workQueue

Options

Long

RollUp

category

print

Delete

QUIT

OVR

2. Select **"BOM > Routings"** to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Routing

PART #: QUOTING QUOTE CONFIGURATION

ROUTE #: 1 OF: 1 DESCRIPTION: STANDARD PART ROUTING OPTIMIZATION:

TYPE: Standard ROUTE SOURCE:

LOCATION LEVEL: None WORK QUEUE REBUILD: No SET-UP COST:

LOCATION #:

DEPT #:

W.C. #:

ASSET #:

PROCESS COST:

COMPONENT COST:

TOTAL COST:

ROLL-UP DATE:

SEQ #	ROUTING	ROUTING DESCRIPTION	TYPE	SET UP COST	PROC. COST	MACH.#	MACH.REF	TRANS #
1		Programming Group						103
2	PROGRAM-NEW-PART	Program New Part Operation	Process	\$0.00	\$50.0000			104
3	PROGRAM-REV-PART	Program Revised Part Operation	Process	\$0.00	\$50.0000			105
4	SETUP-MASTER-FILE	Setup Master File Operation	Process	\$0.00	\$50.0000			106
5	PROOF-NEW-PART	Proof New Part Operation	Process	\$0.00	\$50.0000			107
6	PROOF-REV-PART	Proof Revised Part Operation	Process	\$0.00	\$50.0000			108
7		End of Operation Group						109
8		Shearing & Punching Group						110
9	SHEAR	Shearing Operation (Rough Cut)	Process	\$13.75	\$55.0000	1001	SHEAR-1001	111
10	PUNCH	Turret Punch Operation	Process	\$18.75	\$75.0000	1004	TURRET-1...	112
11		End of Operation Group						113
12		Laser Cut Group						114
13	LASER-CUT	Laser Cut Operation	Process	\$14.00	\$140.0000	1003	LASER-1003	115
14		End of Operation Group						116
15		Pre-Form Group						117
16	SHAKE-OUT	Shake Out Operation	Process	\$11.25	\$75.0000	1050	SHAKE-1050	118
17	TUMBLE-DEBURR	Tumble Deburr Operation	Process	\$9.00	\$45.0000	1011	FINISH-10...	119
18	GRAIN	Graining Operation	Process	\$11.25	\$45.0000	1013	GRAIN-1013	120
19		End of Operation Group						121
20		Pemming Group						122
21	PEM	Pemsert Operation	Process	\$12.50	\$50.0000	1006	PEM-1006	123
22	PEM-2	Pemsert 2 Person Operation	Process	\$17.50	\$50.0000	1006	PEM-1006	124
23		End of Operation Group						125
24		Forming Group						126
25	FORM	Forming Operation	Process	\$37.50	\$75.0000	1007	PB-1007	127
26	JOG	JOG Operation	Process	\$37.50	\$75.0000	1055	PR-BRK-1...	128
27	FORM-2	Form 2 Person	Process	\$37.50	\$75.0000	1007	PB-1007	129
28	FLATTEN	Flatten Operation	Process	\$37.50	\$75.0000	1007	PB-1007	130
29	STRAIGHTEN-ROLLER	Straighten Roller Operation	Process	\$26.25	\$75.0000	1056	ROLLER-1...	131
30		End of Operation Group						132

FOUND 62 SEQUENCES

BO10

Add Routing Sequence

ROUTING

Add

Update

View

Delete

Header

Alternate

Reorder

Prod_QTY

Mfr-Test

QUIT

OVR

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QUOTING (Routing Sequence 1 through 35)

PART #	TRANS #	SEQ. #	PROCESS	UOM	SET-UP	SET-UP COST	PROC. COST
QUOTING	103	1	Programming Group				
QUOTING	104	2	PROGRAM-NEW-PART	hours	0.000000	0.00	50.0000
QUOTING	105	3	PROGRAM-REV-PART	hours	0.000000	0.00	50.0000
QUOTING	106	4	SETUP-MASTER-FILE	hours	0.000000	0.00	50.0000
QUOTING	107	5	PROOF-NEW-PART	hours	0.000000	0.00	50.0000
QUOTING	108	6	PROOF-REV-PART	hours	0.000000	0.00	50.0000
QUOTING	109	7	End of Operation Group				
QUOTING	110	8	Shearing & Punching Group				
QUOTING	111	9	SHEAR	hours	0.250000	13.75	55.0000
QUOTING	112	10	PUNCH	hours	0.250000	18.75	75.0000
QUOTING	113	11	End of Operation Group				
QUOTING	114	12	Laser Cut Group				
QUOTING	115	13	LASER-CUT	hours	0.100000	14.00	140.0000
QUOTING	116	14	End of Operation Group				
QUOTING	117	15	Pre-Form Group				
QUOTING	118	16	SHAKE-OUT	hours	0.150000	11.25	75.0000
QUOTING	119	17	TUMBLE-DEBURR	hours	0.200000	9.00	45.0000
QUOTING	120	18	GRAIN	hours	0.250000	11.25	45.0000
QUOTING	121	19	End of Operation Group				
QUOTING	122	20	Pemming Group				
QUOTING	123	21	PEM	hours	0.250000	12.50	50.0000
QUOTING	124	22	PEM-2	hours	0.350000	17.50	50.0000
QUOTING	125	23	End of Operation Group				
QUOTING	126	24	Forming Group				
QUOTING	127	25	FORM	hours	0.500000	37.50	75.0000
QUOTING	128	26	JOG	hours	0.500000	37.50	75.0000
QUOTING	129	27	FORM-2	hours	0.500000	37.50	75.0000
QUOTING	130	28	FLATTEN	hours	0.500000	37.50	75.0000
QUOTING	131	29	STRAIGHTEN-ROLLER	hours	0.350000	26.25	75.0000
QUOTING	132	30	End of Operation Group				
QUOTING	133	31	Machine Shop Group				
QUOTING	134	32	WHITNEY	hours	0.350000	26.25	75.0000
QUOTING	135	33	AIDA	hours	0.750000	56.25	75.0000
QUOTING	136	34	BENCH-WORK	hours	0.250000	12.50	50.0000
QUOTING	137	35	End of Operation Group				

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QUOTING (Routing Sequence 36 through 62)

PART #	TRANS #	SEQ. #	PROCESS	UOM	SET-UP	SET-UP COST	PROC. COST
QUOTING	138	36	Welding Group				
QUOTING	139	37	MIG-WELD	hours	0.350000	15.75	45.0000
QUOTING	140	38	TIG-WELD	hours	0.500000	22.50	45.0000
QUOTING	141	39	STUD-WELDING	hours	0.250000	11.25	45.0000
QUOTING	142	40	SPOT-WELD	hours	0.500000	22.50	45.0000
QUOTING	143	41	DRESS	hours	0.250000	11.25	45.0000
QUOTING	144	42	End of Operation Group				
QUOTING	145	43	Assembly Group				
QUOTING	146	44	RIVET	hours	0.250000	12.50	50.0000
QUOTING	147	45	GENERAL-ASSEMBLY	hours	0.250000	12.50	50.0000
QUOTING	148	46	End of Operation Group				
QUOTING	149	47	Inspection Group				
QUOTING	150	48	INSPECT	hours	0.250000	8.75	35.0000
QUOTING	151	49	INSPECT-100	hours	0.250000	8.75	35.0000
QUOTING	152	50	End of Operation Group				
QUOTING	153	51	Finishing Group				
QUOTING	154	52	MASKING	hours	0.150000	6.00	40.0000
QUOTING	155	53	INSPECT-FINISH-DE	hours	0.250000	8.75	35.0000
QUOTING	156	54	POWDER-COAT	hours	0.150000	6.00	40.0000
QUOTING	157	55	BATCH-OVEN	hours	0.250000	6.25	25.0000
QUOTING	158	56	WASH-ONLY	hours	0.150000	3.75	25.0000
QUOTING	159	57	SCREEN-PRINT	hours	1.500000	60.00	40.0000
QUOTING	160	58	CHROMATE-ETCH	hours	0.250000	21.25	85.0000
QUOTING	161	59	End of Operation Group				
QUOTING	162	60	Shipping Group				
QUOTING	163	61	PACK-FOR-SHIPMENT	hours	0.250000	8.75	35.0000
QUOTING	164	62	End of Operation Group				

3. Select **“Update”** option and highlight **“2 PROGRAM-NEW-PART”** row:

BILL OF MATERIALS: Global Edge Windows Demo Server

Routing

Select Sequence to Update, then Press [OK]:

PART #: QUOTING QUOTE CONFIGURATION

ROUTE #: 1 OF: 1 DESCRIPTION: STANDARD PART ROUTING OPTIMIZATION:

TYPE: Standard ROUTE SOURCE:

LOCATION LEVEL: None WORK QUEUE REBUILD: No OPTIMIZATION QTY:

LOCATION #:

DEPT #:

W.C. #:

ASSET #:

SET-UP COST:

PROCESS COST:

COMPONENT COST:

TOTAL COST:

ROLL-UP DATE:

SEQ #	ROUTING	ROUTING DESCRIPTION	TYPE	SET UP COST	PROC. COST	MACH. #	MACH. REF	TRANS #
1		Programming Group						103
2	PROGRAM-NEW-PART	Program New Part Operation	Process	\$0.00	\$50.0000			104
3	PROGRAM-REV-PART	Program Revised Part Operation	Process	\$0.00	\$50.0000			105
4	SETUP-MASTER-FILE	Setup Master File Operation	Process	\$0.00	\$50.0000			106
5	PROOF-NEW-PART	Proof New Part Operation	Process	\$0.00	\$50.0000			107
6	PROOF-REV-PART	Proof Revised Part Operation	Process	\$0.00	\$50.0000			108
7		End of Operation Group						109
8		Shearing & Punching Group						110
9	SHEAR	Shearing Operation (Rough Cut)	Process	\$13.75	\$55.0000	1001	SHEAR-1001	111
10	PUNCH	Turret Punch Operation	Process	\$18.75	\$75.0000	1004	TURRET-1...	112
11		End of Operation Group						113
12		Laser Cut Group						114
13	LASER-CUT	Laser Cut Operation	Process	\$14.00	\$140.0000	1003	LASER-1003	115
14		End of Operation Group						116
15		Pre-Form Group						117
16	SHAKE-OUT	Shake Out Operation	Process	\$11.25	\$75.0000	1050	SHAKE-1050	118
17	TUMBLE-DEBURR	Tumble Deburr Operation	Process	\$9.00	\$45.0000	1011	FINISH-10...	119
18	GRAIN	Graining Operation	Process	\$11.25	\$45.0000	1013	GRAIN-1013	120
19		End of Operation Group						121
20		Pemming Group						122
21	PEM	Pemsert Operation	Process	\$12.50	\$50.0000	1006	PEM-1006	123
22	PEM-2	Pemsert 2 Person Operation	Process	\$17.50	\$50.0000	1006	PEM-1006	124
23		End of Operation Group						125

FOUND 62 SEQUENCES

BO10

OK

Cancel

OVR

4. Select “OK” to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Routing-Details Run-Quantity Vendor-Qty Inspections Alt-Machine-Tools

ROUTING-DETAIL

Update

Components

Run-quantity

Vendor-qty

Dimensions

Documents

Program

mfr-Test

Notes

History

QUIT

Routing Information

PART #: QUOTING QUOTE CONFIGURATION

SEQ. #: 2 PROCESS TYPE: Process CLASS: PROGRAM

PROCESS: PROGRAM-NEW-PART OPTIMIZATION:

Program New Part Operation

STD. PROCESS COST RATE: \$50.0000

COST METHOD: Time

COST METHOD QTY: 1.000000

COST METHOD UOM: hours

SET-UP TIME MODE: Formula

SET-UP TIME: 0.000000

SET-UP TIME COST: \$0.00

LEVEL: Standard

SUB OF:

VENDOR: No

MARK UP METHOD: None

LOCATION: 1 CORP. HEADQUARTERS / MANUFACTURING

MARK UP PRECENT:

DEPT #: 6 ENGINEERING / R&D

MARK UP AMOUNT:

WC #: 3 MANUFACTURING ENGINEERING

MFR TEST:

MACHINE:

TEST STATUS:

ALT. OK: START GAP: INTERVAL: NEXT STEP:

PROC. TIME METHOD: Calculated

CURVE PROMPT: No

PROC. COST METHOD:

DEFAULT CURVE:

TIME BASE: Labor Hours

PROCESS COST FACTOR: 1.000000

COMPLEXITY PROMPT: No

FACTOR:

TIME/UNIT: HR(S)

COMPLEX TIME/UNIT: HR(S)

UNITS/HOUR:

COMPLEX UNITS/HOUR:

STD. UNIT PROCESS COST: \$50.0000

COMPLEX UNIT COST:

TRANS #: 10.4

JOB COST METHOD: Actual

DEBUG MODE: No

BO04

Update Current Part Routing

OVR

5. Select **“Update > F10-Process Time > F6-Formula”** to display the following screen form and menu options:

BILL OF MATERIALS: Global Edge Windows Demo Server

Configuration-Formula

TYPE: DIM:

TRANS: LINK:

CURRENT LINE: SCREEN: TOTAL:

ROW	ACTION	DESCRIPTION
1	IF	IF
2	DIM	[QUOTING (DIM)Part_Status:]
3	=	EQUAL TO
4	A	ALPHA New
5	THEN	THEN
6	IF	IF
7	DIM	[QUOTING (DIM)Program_Part:]
8	=	EQUAL TO
9	A	ALPHA Simple Part
10	THEN	THEN
11	K	CONSTANT 1.000000
12	ELSE	ELSE
13	IF	IF
14	DIM	[QUOTING (DIM)Program_Part:]
15	=	EQUAL TO
16	A	ALPHA Medium Part
17	THEN	THEN
18	K	CONSTANT 1.500000
19	ELSE	ELSE
20	IF	IF
21	DIM	[QUOTING (DIM)Program_Part:]
22	=	EQUAL TO
23	A	ALPHA Hard Part
24	THEN	THEN
25	K	CONSTANT 2.000000
26	ELSE	ELSE
27	IF	IF
28	DIM	[QUOTING (DIM)Program_Part:]
29	=	EQUAL TO
30	A	ALPHA Very Hard Part
31	THEN	THEN
32	K	CONSTANT 3.000000
33	ELSE	ELSE
34	IF	IF
35	DIM	[QUOTING (DIM)Program_Part:]
36	=	EQUAL TO
37	A	ALPHA Extremely Hard Part
38	THEN	THEN
39	PRMT	PROMPT FOR INPUT

BO40

View Formula

FORMULA

OVR

Last Update: Friday, April 03, 2026

QUOTING (Routing Transaction Number 104 “PROGRAM-NEW-PART”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
104			P	QUOTING	2	1	IF		
104	QUOTING	50	P	QUOTING	2	2	DIM	Part_Status:	
104			P	QUOTING	2	3	=		
104			P	QUOTING	2	4	A	New	
104			P	QUOTING	2	5	THEN		
104			P	QUOTING	2	6	IF		
104	QUOTING	51	P	QUOTING	2	7	DIM	Program_Part:	
104			P	QUOTING	2	8	=		
104			P	QUOTING	2	9	A	Simple Part	
104			P	QUOTING	2	10	THEN		
104			P	QUOTING	2	11	K		1.000000
104			P	QUOTING	2	12	ELSE		
104			P	QUOTING	2	13	IF		
104	QUOTING	51	P	QUOTING	2	14	DIM	Program_Part:	
104			P	QUOTING	2	15	=		
104			P	QUOTING	2	16	A	Medium Part	
104			P	QUOTING	2	17	THEN		
104			P	QUOTING	2	18	K		1.500000
104			P	QUOTING	2	19	ELSE		
104			P	QUOTING	2	20	IF		
104	QUOTING	51	P	QUOTING	2	21	DIM	Program_Part:	
104			P	QUOTING	2	22	=		
104			P	QUOTING	2	23	A	Hard Part	
104			P	QUOTING	2	24	THEN		
104			P	QUOTING	2	25	K		2.000000
104			P	QUOTING	2	26	ELSE		
104			P	QUOTING	2	27	IF		
104	QUOTING	51	P	QUOTING	2	28	DIM	Program_Part:	
104			P	QUOTING	2	29	=		
104			P	QUOTING	2	30	A	Very Hard Part	
104			P	QUOTING	2	31	THEN		
104			P	QUOTING	2	32	K		3.000000
104			P	QUOTING	2	33	ELSE		
104			P	QUOTING	2	34	IF		
104	QUOTING	51	P	QUOTING	2	35	DIM	Program_Part:	
104			P	QUOTING	2	36	=		
104			P	QUOTING	2	37	A	Extremely Hard Part	
104			P	QUOTING	2	38	THEN		
104			P	QUOTING	2	39	PRMT		
104			P	QUOTING	2	40	ELSE		
104			P	QUOTING	2	41	K		0.000000
104			P	QUOTING	2	42	FI		
104			P	QUOTING	2	43	FI		
104			P	QUOTING	2	44	FI		
104			P	QUOTING	2	45	FI		
104			P	QUOTING	2	46	FI		
104			P	QUOTING	2	47	ELSE		
104			P	QUOTING	2	48	K		0.000000
104			P	QUOTING	2	49	FI		

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QUOTING (Routing Transaction Number 105 “PROGRAM-REV-PART”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
105			P	QUOTING	3	1	IF		
105	QUOTING	50	P	QUOTING	3	2	DIM	Part_Status:	
105			P	QUOTING	3	3	=		
105			P	QUOTING	3	4	A	Revised	
105			P	QUOTING	3	5	THEN		
105			P	QUOTING	3	6	IF		
105	QUOTING	51	P	QUOTING	3	7	DIM	Program_Part:	
105			P	QUOTING	3	8	=		
105			P	QUOTING	3	9	A	Simple Change	
105			P	QUOTING	3	10	THEN		
105			P	QUOTING	3	11	K		0.750000
105			P	QUOTING	3	12	ELSE		
105			P	QUOTING	3	13	IF		
105	QUOTING	51	P	QUOTING	3	14	DIM	Program_Part:	
105			P	QUOTING	3	15	=		
105			P	QUOTING	3	16	A	Simple Part	
105			P	QUOTING	3	17	THEN		
105			P	QUOTING	3	18	K		1.000000
105			P	QUOTING	3	19	ELSE		
105			P	QUOTING	3	20	IF		
105	QUOTING	51	P	QUOTING	3	21	DIM	Program_Part:	
105			P	QUOTING	3	22	=		
105			P	QUOTING	3	23	A	Medium Part	
105			P	QUOTING	3	24	THEN		
105			P	QUOTING	3	25	K		1.500000
105			P	QUOTING	3	26	ELSE		
105			P	QUOTING	3	27	IF		
105	QUOTING	51	P	QUOTING	3	28	DIM	Program_Part:	
105			P	QUOTING	3	29	=		
105			P	QUOTING	3	30	A	Hard Part	
105			P	QUOTING	3	31	THEN		
105			P	QUOTING	3	32	K		2.000000
105			P	QUOTING	3	33	ELSE		
105			P	QUOTING	3	34	IF		
105	QUOTING	51	P	QUOTING	3	35	DIM	Program_Part:	
105			P	QUOTING	3	36	=		
105			P	QUOTING	3	37	A	Very Hard Part	
105			P	QUOTING	3	38	THEN		
105			P	QUOTING	3	39	K		3.000000
105			P	QUOTING	3	40	ELSE		
105			P	QUOTING	3	41	IF		
105	QUOTING	51	P	QUOTING	3	42	DIM	Program_Part:	
105			P	QUOTING	3	43	=		
105			P	QUOTING	3	44	A	Extremely Hard Part	
105			P	QUOTING	3	45	THEN		
105			P	QUOTING	3	46	PRMT		
105			P	QUOTING	3	47	ELSE		
105			P	QUOTING	3	48	K		0.000000
105			P	QUOTING	3	49	FI		
105			P	QUOTING	3	50	FI		
105			P	QUOTING	3	51	FI		
105			P	QUOTING	3	52	FI		
105			P	QUOTING	3	53	FI		
105			P	QUOTING	3	54	FI		
105			P	QUOTING	3	55	ELSE		
105			P	QUOTING	3	56	K		0.000000
105			P	QUOTING	3	57	FI		

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QUOTING (Routing Transaction Number 106 “SETUP-MASTER-FILE”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
106			P	QUOTING	4	1	IF		
106	QUOTING	52	P	QUOTING	4	2	DIM	Setup_Master_File?	
106			P	QUOTING	4	3	=		
106			P	QUOTING	4	4	A	Yes	
106			P	QUOTING	4	5	THEN		
106			P	QUOTING	4	6	K		0.500000
106			P	QUOTING	4	7	ELSE		
106			P	QUOTING	4	8	K		0.000000
106			P	QUOTING	4	9	FI		

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QUOTING (Routing Transaction Number 107 “PROOF-NEW-PART”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
107			P	QUOTING	5	1	IF		
107	QUOTING	50	P	QUOTING	5	2	DIM	Part_Status:	
107			P	QUOTING	5	3	=		
107			P	QUOTING	5	4	A	New	
107			P	QUOTING	5	5	THEN		
107			P	QUOTING	5	6	IF		
107	QUOTING	51	P	QUOTING	5	7	DIM	Program_Part:	
107			P	QUOTING	5	8	=		
107			P	QUOTING	5	9	A	Simple Part	
107			P	QUOTING	5	10	THEN		
107			P	QUOTING	5	11	K		0.500000
107			P	QUOTING	5	12	ELSE		
107			P	QUOTING	5	13	IF		
107	QUOTING	51	P	QUOTING	5	14	DIM	Program_Part:	
107			P	QUOTING	5	15	=		
107			P	QUOTING	5	16	A	Medium Part	
107			P	QUOTING	5	17	THEN		
107			P	QUOTING	5	18	K		0.750000
107			P	QUOTING	5	19	ELSE		
107			P	QUOTING	5	20	IF		
107	QUOTING	51	P	QUOTING	5	21	DIM	Program_Part:	
107			P	QUOTING	5	22	=		
107			P	QUOTING	5	23	A	Hard Part	
107			P	QUOTING	5	24	THEN		
107			P	QUOTING	5	25	K		1.000000
107			P	QUOTING	5	26	ELSE		
107			P	QUOTING	5	27	IF		
107	QUOTING	51	P	QUOTING	5	28	DIM	Program_Part:	
107			P	QUOTING	5	29	=		
107			P	QUOTING	5	30	A	Very Hard Part	
107			P	QUOTING	5	31	THEN		
107			P	QUOTING	5	32	K		1.500000
107			P	QUOTING	5	33	ELSE		
107			P	QUOTING	5	34	IF		
107	QUOTING	51	P	QUOTING	5	35	DIM	Program_Part:	
107			P	QUOTING	5	36	=		
107			P	QUOTING	5	37	A	Extremely Hard Part	
107			P	QUOTING	5	38	THEN		
107			P	QUOTING	5	39	K		2.000000
107			P	QUOTING	5	40	ELSE		
107			P	QUOTING	5	41	K		0.000000
107			P	QUOTING	5	42	FI		
107			P	QUOTING	5	43	FI		
107			P	QUOTING	5	44	FI		
107			P	QUOTING	5	45	FI		
107			P	QUOTING	5	46	FI		
107			P	QUOTING	5	47	FI		

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QUOTING (Routing Transaction Number 108 “PROOF-REV-PART”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
108			P	QUOTING	6	1	IF		
108	QUOTING	50	P	QUOTING	6	2	DIM	Part_Status:	
108			P	QUOTING	6	3	=		
108			P	QUOTING	6	4	A	Revised	
108			P	QUOTING	6	5	THEN		
108			P	QUOTING	6	6	IF		
108	QUOTING	51	P	QUOTING	6	7	DIM	Program_Part:	
108			P	QUOTING	6	8	=		
108			P	QUOTING	6	9	A	Simple_Change	
108			P	QUOTING	6	10	THEN		
108			P	QUOTING	6	11	K		0.750000
108			P	QUOTING	6	12	ELSE		
108			P	QUOTING	6	13	IF		
108	QUOTING	51	P	QUOTING	6	14	DIM	Program_Part:	
108			P	QUOTING	6	15	=		
108			P	QUOTING	6	16	A	Simple Part	
108			P	QUOTING	6	17	THEN		
108			P	QUOTING	6	18	K		0.500000
108			P	QUOTING	6	19	ELSE		
108			P	QUOTING	6	20	IF		
108	QUOTING	51	P	QUOTING	6	21	DIM	Program_Part:	
108			P	QUOTING	6	22	=		
108			P	QUOTING	6	23	A	Medium Part	
108			P	QUOTING	6	24	THEN		
108			P	QUOTING	6	25	K		0.750000
108			P	QUOTING	6	26	ELSE		
108			P	QUOTING	6	27	IF		
108	QUOTING	51	P	QUOTING	6	28	DIM	Program_Part:	
108			P	QUOTING	6	29	=		
108			P	QUOTING	6	30	A	Hard Part	
108			P	QUOTING	6	31	THEN		
108			P	QUOTING	6	32	K		1.000000
108			P	QUOTING	6	33	ELSE		
108			P	QUOTING	6	34	IF		
108	QUOTING	51	P	QUOTING	6	35	DIM	Program_Part:	
108			P	QUOTING	6	36	=		
108			P	QUOTING	6	37	A	Very Hard Part	
108			P	QUOTING	6	38	THEN		
108			P	QUOTING	6	39	K		1.500000
108			P	QUOTING	6	40	ELSE		
108			P	QUOTING	6	41	IF		
108	QUOTING	51	P	QUOTING	6	42	DIM	Program_Part:	
108			P	QUOTING	6	43	=		
108			P	QUOTING	6	44	A	Extremely Hard Part	
108			P	QUOTING	6	45	THEN		
108			P	QUOTING	6	46	K		2.000000
108			P	QUOTING	6	47	ELSE		
108			P	QUOTING	6	48	K		0.000000
108			P	QUOTING	6	49	FI		
108			P	QUOTING	6	50	FI		
108			P	QUOTING	6	51	FI		
108			P	QUOTING	6	52	FI		
108			P	QUOTING	6	53	FI		
108			P	QUOTING	6	54	FI		
108			P	QUOTING	6	55	FI		

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QUOTING (Routing Transaction Number 111 “SHEAR”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
111			P	QUOTING	9	1	IF		
111	QUOTING	53	P	QUOTING	9	2	DIM	Shear_Punch:	
111			P	QUOTING	9	3	=		
111			P	QUOTING	9	4	A	Shearing	
111			P	QUOTING	9	5	THEN		
111			P	QUOTING	9	6	K		0.010000
111			P	QUOTING	9	7	ELSE		
111			P	QUOTING	9	8	K		0.000000
111			P	QUOTING	9	9	FI		

QUOTING (Routing Transaction Number 112 “PUNCH”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
112			P	QUOTING	10	1	IF		
112	QUOTING	53	P	QUOTING	10	2	DIM	Shear_Punch:	
112			P	QUOTING	10	3	=		
112			P	QUOTING	10	4	A	Punching	
112			P	QUOTING	10	5	THEN		
112			P	QUOTING	10	6	(		
112	QUOTING	6	P	QUOTING	10	7	DIM	Perimeter	
112			P	QUOTING	10	8	*		
112			P	QUOTING	10	9	K		0.000150
112			P	QUOTING	10	10	)		
112			P	QUOTING	10	11	+		
112			P	QUOTING	10	12	(		
112	QUOTING	17	P	QUOTING	10	13	DIM	Num_Cutouts	
112			P	QUOTING	10	14	*		
112			P	QUOTING	10	15	K		0.002000
112			P	QUOTING	10	16	)		
112			P	QUOTING	10	17	ELSE		
112			P	QUOTING	10	18	K		0.000000
112			P	QUOTING	10	19	FI		

QUOTING (Routing Transaction Number 115 “LASER-CUT”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
115			P	QUOTING	13	1	IF		
115			P	QUOTING	13	2	(		
115			P	QUOTING	13	3	(		
115	QUOTING	63	P	QUOTING	13	4	DIM	Turret_Laser_Water	
115			P	QUOTING	13	5	=		
115			P	QUOTING	13	6	A	Laser	
115			P	QUOTING	13	7	)		
115			P	QUOTING	13	8	OR		
115			P	QUOTING	13	9	(		
115	QUOTING	43	P	QUOTING	13	10	DIM	Cutting_Method	
115			P	QUOTING	13	11	=		
115			P	QUOTING	13	12	A	Open	
115			P	QUOTING	13	13	)		
115			P	QUOTING	13	14	)		
115			P	QUOTING	13	15	THEN		
115			P	QUOTING	13	16	(		
115			P	QUOTING	13	17	(		
115			P	QUOTING	13	18	(		
115	QUOTING	6	P	QUOTING	13	19	DIM	Perimeter	
115			P	QUOTING	13	20	/		
115			P	QUOTING	13	21	PCSP		
115			P	QUOTING	13	22	)		
115			P	QUOTING	13	23	+		
115			P	QUOTING	13	24	(		
115	QUOTING	18	P	QUOTING	13	25	DIM	Cutout_Perimeter	
115			P	QUOTING	13	26	/		
115			P	QUOTING	13	27	CCSP		
115			P	QUOTING	13	28	)		
115			P	QUOTING	13	29	)		
115			P	QUOTING	13	30	/		
115			P	QUOTING	13	31	K		3600.000000
115			P	QUOTING	13	32	)		
115			P	QUOTING	13	33	+		
115			P	QUOTING	13	34	(		
115	QUOTING	17	P	QUOTING	13	35	DIM	Num_Cutouts	
115			P	QUOTING	13	36	*		
115			P	QUOTING	13	37	PTIM		
115			P	QUOTING	13	38	)		
115			P	QUOTING	13	39	ELSE		
115			P	QUOTING	13	40	K		0.000000
115			P	QUOTING	13	41	FI		

QUOTING (Routing Transaction Number 118 “SHAKE-OUT”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
118			P	QUOTING	16	1	IF		
118	QUOTING	54	P	QUOTING	16	2	DIM	Pre-Form:	
118			P	QUOTING	16	3	=		
118			P	QUOTING	16	4	A	Shake-Out	
118			P	QUOTING	16	5	THEN		
118			P	QUOTING	16	6	IF		
118			P	QUOTING	16	7	(		
118	QUOTING	7	P	QUOTING	16	8	DIM	Flat_Length	
118			P	QUOTING	16	9	*		
118	QUOTING	8	P	QUOTING	16	10	DIM	Flat_Width	
118			P	QUOTING	16	11	)		
118			P	QUOTING	16	12	<		
118			P	QUOTING	16	13	K		0.004167
118			P	QUOTING	16	14	THEN		
118			P	QUOTING	16	15	K		0.008333
118			P	QUOTING	16	16	ELSE		
118			P	QUOTING	16	17	K		0.000000
118			P	QUOTING	16	18	FI		
118			P	QUOTING	16	19	FI		

QUOTING (Routing Transaction Number 119 “TUMBLE-DEBURR”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
119			P	QUOTING	17	1	IF		
119	QUOTING	54	P	QUOTING	17	2	DIM	Pre-Form:	
119			P	QUOTING	17	3	=		
119			P	QUOTING	17	4	A	Tumble-Debur	
119			P	QUOTING	17	5	THEN		
119			P	QUOTING	17	7	(		
119	QUOTING	7	P	QUOTING	17	8	DIM	Flat_Length	
119			P	QUOTING	17	9	+		
119	QUOTING	8	P	QUOTING	17	10	DIM	Flat_Width	
119			P	QUOTING	17	11	)		
119			P	QUOTING	17	12	*		
119			P	QUOTING	17	16	K		0.000556
119			P	QUOTING	17	17	ELSE		
119			P	QUOTING	17	18	K		0.000000
119			P	QUOTING	17	19	FI		

QUOTING (Routing Transaction Number 120 “GRAIN”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
120			P	QUOTING	18	1	IF		
120	QUOTING	54	P	QUOTING	18	2	DIM	Pre-Form:	
120			P	QUOTING	18	3	=		
120			P	QUOTING	18	4	A	Graining	
120			P	QUOTING	18	5	THEN		
120			P	QUOTING	18	6	K		0.000250
120			P	QUOTING	18	7	*		
120	QUOTING	7	P	QUOTING	18	8	DIM	Flat_Length	
120			P	QUOTING	18	9	ELSE		
120			P	QUOTING	18	10	K		0.000000
120			P	QUOTING	18	11	FI		

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QUOTING (Routing Transaction Number 123 “PEM”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
123			P	QUOTING	21	1	IF		
123			P	QUOTING	21	2	(		
123	QUOTING	55	P	QUOTING	21	3	DIM	Pem_Options:	
123			P	QUOTING	21	4	=		
123			P	QUOTING	21	5	A	1-Man	
123			P	QUOTING	21	6	)		
123			P	QUOTING	21	7	AND		
123			P	QUOTING	21	8	(		
123	PEM-STUD		P	QUOTING	21	9	PART		
123			P	QUOTING	21	10	>		
123			P	QUOTING	21	11	K		0.000000
123			P	QUOTING	21	12	)		
123			P	QUOTING	21	13	THEN		
123			P	QUOTING	21	14	K		0.010000
123			P	QUOTING	21	15	ELSE		
123			P	QUOTING	21	16	K		0.000000
123			P	QUOTING	21	17	FI		

QUOTING (Routing Transaction Number 124 “PEM-2”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
124			P	QUOTING	22	1	IF		
124			P	QUOTING	22	2	(		
124	QUOTING	55	P	QUOTING	22	3	DIM	Pem_Options:	
124			P	QUOTING	22	4	=		
124			P	QUOTING	22	5	A	2-Man	
124			P	QUOTING	22	6	)		
124			P	QUOTING	22	7	AND		
124			P	QUOTING	22	8	(		
124	PEM-STUD		P	QUOTING	22	9	PART		
124			P	QUOTING	22	10	>		
124			P	QUOTING	22	11	K		0.000000
124			P	QUOTING	22	12	)		
124			P	QUOTING	22	13	THEN		
124			P	QUOTING	22	14	K		0.005000
124			P	QUOTING	22	15	ELSE		
124			P	QUOTING	22	16	K		0.000000
124			P	QUOTING	22	17	FI		

QUOTING (Routing Transaction Number 127 “FORM”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
127			P	QUOTING	25	1	IF		
127			P	QUOTING	25	2	(		
127			P	QUOTING	25	3	(		
127	QUOTING	39	P	QUOTING	25	4	DIM	Fold_Count	
127			P	QUOTING	25	5	>		
127			P	QUOTING	25	6	K		0.000000
127			P	QUOTING	25	7	)		
127			P	QUOTING	25	8	AND		
127			P	QUOTING	25	9	(		
127	QUOTING	56	P	QUOTING	25	10	DIM	Form_Options:	
127			P	QUOTING	25	11	=		
127			P	QUOTING	25	12	A	Form	
127			P	QUOTING	25	13	)		
127			P	QUOTING	25	14	AND		
127			P	QUOTING	25	15	(		
127			P	QUOTING	25	16	(		
127	QUOTING	66	P	QUOTING	25	17	DIM	PressBrk_PanelBend	
127			P	QUOTING	25	18	=		
127			P	QUOTING	25	19	A	Press-Brake	
127			P	QUOTING	25	20	)		
127			P	QUOTING	25	21	OR		
127			P	QUOTING	25	22	(		
127	QUOTING	66	P	QUOTING	25	23	DIM	PressBrk_PanelBend	
127			P	QUOTING	25	24	=		
127			P	QUOTING	25	25	A	Both	
127			P	QUOTING	25	26	)		
127			P	QUOTING	25	27	)		
127			P	QUOTING	25	28	)		
127			P	QUOTING	25	29	THEN		
127	QUOTING	39	P	QUOTING	25	30	DIM	Fold_Count	
127			P	QUOTING	25	31	*		
127			P	QUOTING	25	32	K		0.003333
127			P	QUOTING	25	33	ELSE		
127			P	QUOTING	25	34	K		0.000000
127			P	QUOTING	25	35	FI		

QUOTING (Routing Transaction Number 128 “JOG”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
128			P	QUOTING	26	1	IF		
128	QUOTING	56	P	QUOTING	26	2	DIM	Form_Options:	
128			P	QUOTING	26	3	=		
128			P	QUOTING	26	4	A	Jog	
128			P	QUOTING	26	5	THEN		
128			P	QUOTING	26	6	K		0.004167
128			P	QUOTING	26	7	ELSE		
128			P	QUOTING	26	8	K		0.000000
128			P	QUOTING	26	9	FI		

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QUOTING (Routing Transaction Number 129 “FORM-2”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
129			P	QUOTING	27	1	IF		
129			P	QUOTING	27	2	(		
129			P	QUOTING	27	3	(		
129	QUOTING	39	P	QUOTING	27	4	DIM	Fold_Count	
129			P	QUOTING	27	5	>		
129			P	QUOTING	27	6	K		0.000000
129			P	QUOTING	27	7	)		
129			P	QUOTING	27	8	AND		
129			P	QUOTING	27	9	(		
129	QUOTING	56	P	QUOTING	27	10	DIM	Form_Options:	
129			P	QUOTING	27	11	=		
129			P	QUOTING	27	12	A	Form-2	
129			P	QUOTING	27	13	)		
129			P	QUOTING	27	14	AND		
129			P	QUOTING	27	15	(		
129			P	QUOTING	27	16	(		
129	QUOTING	66	P	QUOTING	27	17	DIM	PressBrk_PanelBend	
129			P	QUOTING	27	18	=		
129			P	QUOTING	27	19	A	Press-Brake	
129			P	QUOTING	27	20	)		
129			P	QUOTING	27	21	OR		
129			P	QUOTING	27	22	(		
129	QUOTING	66	P	QUOTING	27	23	DIM	PressBrk_PanelBend	
129			P	QUOTING	27	24	=		
129			P	QUOTING	27	25	A	Both	
129			P	QUOTING	27	26	)		
129			P	QUOTING	27	27	)		
129			P	QUOTING	27	28	)		
129			P	QUOTING	27	29	THEN		
129			P	QUOTING	27	30	IF		
129	QUOTING	39	P	QUOTING	27	31	DIM	Fold_Count	
129			P	QUOTING	27	32	<		
129			P	QUOTING	27	33	K		3.000000
129			P	QUOTING	27	34	THEN		
129	QUOTING	39	P	QUOTING	27	35	DIM	Fold_Count	
129			P	QUOTING	27	36	*		
129			P	QUOTING	27	37	K		0.016667
129			P	QUOTING	27	38	ELSE		
129			P	QUOTING	27	39	K		0.003333
129			P	QUOTING	27	40	+		
129			P	QUOTING	27	41	(		
129			P	QUOTING	27	42	(		
129	QUOTING	39	P	QUOTING	27	43	DIM	Fold_Count	
129			P	QUOTING	27	44	-		
129			P	QUOTING	27	45	K		2.000000
129			P	QUOTING	27	46	)		
129			P	QUOTING	27	47	*		
129			P	QUOTING	27	48	K		0.083333
129			P	QUOTING	27	49	)		
129			P	QUOTING	27	50	FI		
129			P	QUOTING	27	51	ELSE		
129			P	QUOTING	27	52	K		0.000000
129			P	QUOTING	27	53	FI		

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QUOTING (Routing Transaction Number 130 “FLATTEN”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
130			P	QUOTING	28	1	IF		
130	QUOTING	56	P	QUOTING	28	2	DIM	Form_Options:	
130			P	QUOTING	28	3	=		
130			P	QUOTING	28	4	A	Flatten	
130			P	QUOTING	28	5	THEN		
130			P	QUOTING	28	6	IF		
130	QUOTING	7	P	QUOTING	28	7	DIM	Flat_Length	
130			P	QUOTING	28	8	<=		
130			P	QUOTING	28	9	K		32.000000
130			P	QUOTING	28	10	THEN		
130			P	QUOTING	28	11	K		0.250000
130			P	QUOTING	28	12	ELSE		
130			P	QUOTING	28	13	IF		
130	QUOTING	7	P	QUOTING	28	14	DIM	Flat_Length	
130			P	QUOTING	28	15	<=		
130			P	QUOTING	28	16	K		64.000000
130			P	QUOTING	28	17	THEN		
130			P	QUOTING	28	18	K		0.400000
130			P	QUOTING	28	19	ELSE		
130			P	QUOTING	28	20	K		0.500000
130			P	QUOTING	28	21	FI		
130			P	QUOTING	28	22	FI		
130			P	QUOTING	28	23	ELSE		
130			P	QUOTING	28	24	K		0.000000
130			P	QUOTING	28	25	FI		

QUOTING (Routing Transaction Number 131 “STRAIGHTEN-ROLLER”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
131			P	QUOTING	29	1	IF		
131	QUOTING	56	P	QUOTING	29	2	DIM	Form_Options:	
131			P	QUOTING	29	3	=		
131			P	QUOTING	29	4	A	Straighten	
131			P	QUOTING	29	5	THEN		
131			P	QUOTING	29	6	K		0.016667
131			P	QUOTING	29	7	ELSE		
131			P	QUOTING	29	8	K		0.000000
131			P	QUOTING	29	9	FI		

QUOTING (Routing Transaction Number 134 “WHITNEY”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
134			P	QUOTING	32	1	IF		
134	QUOTING	57	P	QUOTING	32	2	DIM	Machine_Shop:	
134			P	QUOTING	32	3	=		
134			P	QUOTING	32	4	A	Whitney	
134			P	QUOTING	32	5	THEN		
134	QUOTING	17	P	QUOTING	32	6	DIM	Num_Cutouts	
134			P	QUOTING	32	7	*		
134			P	QUOTING	32	8	K		0.002500
134			P	QUOTING	32	9	ELSE		
134			P	QUOTING	32	10	K		0.000000
134			P	QUOTING	32	11	FI		

QUOTING (Routing Transaction Number 135 “AIDA”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
135			P	QUOTING	33	1	IF		
135	QUOTING	57	P	QUOTING	33	2	DIM	Machine_Shop:	
135			P	QUOTING	33	3	=		
135			P	QUOTING	33	4	A	AIDA	
135			P	QUOTING	33	5	THEN		
135			P	QUOTING	33	6	K		0.008333
135			P	QUOTING	33	7	ELSE		
135			P	QUOTING	33	8	K		0.000000
135			P	QUOTING	33	9	FI		

QUOTING (Routing Transaction Number 136 “BENCH-WORK”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
136			P	QUOTING	34	1	IF		
136	QUOTING	57	P	QUOTING	34	2	DIM	Machine_Shop:	
136			P	QUOTING	34	3	=		
136			P	QUOTING	34	4	A	Bench Work	
136			P	QUOTING	34	5	THEN		
136			P	QUOTING	34	6	PRMT		
136			P	QUOTING	34	7	ELSE		
136			P	QUOTING	34	8	K		0.000000
136			P	QUOTING	34	9	FI		

QUOTING (Routing Transaction Number 139 “MIG-WELD”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
139			P	QUOTING	37	1	IF		
139	QUOTING	58	P	QUOTING	37	2	DIM	Welding:	
139			P	QUOTING	37	3	=		
139			P	QUOTING	37	4	A	MIG Weld	
139			P	QUOTING	37	5	THEN		
139			P	QUOTING	37	6	PRMT		
139			P	QUOTING	37	7	ELSE		
139			P	QUOTING	37	8	K		0.000000
139			P	QUOTING	37	9	FI		

QUOTING (Routing Transaction Number 140 “TIG-WELD”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
140			P	QUOTING	38	1	IF		
140	QUOTING	58	P	QUOTING	38	2	DIM	Welding:	
140			P	QUOTING	38	3	=		
140			P	QUOTING	38	4	A	TIG Weld	
140			P	QUOTING	38	5	THEN		
140			P	QUOTING	38	6	PRMT		
140			P	QUOTING	38	7	ELSE		
140			P	QUOTING	38	8	K		0.000000
140			P	QUOTING	38	9	FI		

QUOTING (Routing Transaction Number 141 “STUD-WELDING”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
141			P	QUOTING	39	1	IF		
141			P	QUOTING	39	2	(		
141	QUOTING	58	P	QUOTING	39	3	DIM	Welding:	
141			P	QUOTING	39	4	=		
141			P	QUOTING	39	5	A	Stud Welding	
141			P	QUOTING	39	6	)		
141			P	QUOTING	39	7	AND		
141			P	QUOTING	39	8	(		
141	PEM-STUD		P	QUOTING	39	9	PART		
141			P	QUOTING	39	10	>		
141			P	QUOTING	39	11	K		0.000000
141			P	QUOTING	39	12	)		
141			P	QUOTING	39	13	THEN		
141	PEM-STUD		P	QUOTING	39	14	PART		
141			P	QUOTING	39	15	*		
141			P	QUOTING	39	16	K		0.005833
141			P	QUOTING	39	17	ELSE		
141			P	QUOTING	39	18	K		0.000000
141			P	QUOTING	39	19	FI		

QUOTING (Routing Transaction Number 142 “SPOT-WELD”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
142			P	QUOTING	40	1	IF		
142	QUOTING	58	P	QUOTING	40	2	DIM	Welding:	
142			P	QUOTING	40	3	=		
142			P	QUOTING	40	4	A	Spot-Weld	
142			P	QUOTING	40	5	THEN		
142			P	QUOTING	40	6	PRMT		
142			P	QUOTING	40	7	ELSE		
142			P	QUOTING	40	8	K		0.000000
142			P	QUOTING	40	9	FI		

QUOTING (Routing Transaction Number 143 “DRESS”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
143			P	QUOTING	41	1	IF		
143	QUOTING	58	P	QUOTING	41	2	DIM	Welding:	
143			P	QUOTING	41	3	=		
143			P	QUOTING	41	4	A	Dress	
143			P	QUOTING	41	5	THEN		
143			P	QUOTING	41	6	PRMT		
143			P	QUOTING	41	7	ELSE		
143			P	QUOTING	41	8	K		0.000000
143			P	QUOTING	41	9	FI		

QUOTING (Routing Transaction Number 146 “RIVET”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
146			P	QUOTING	44	1	IF		
146	QUOTING	59	P	QUOTING	44	2	DIM	Assembly:	
146			P	QUOTING	44	3	=		
146			P	QUOTING	44	4	A	Pop Rivet	
146			P	QUOTING	44	5	THEN		
146			P	QUOTING	44	6	PRMT		
146			P	QUOTING	44	7	ELSE		
146			P	QUOTING	44	8	K		0.000000
146			P	QUOTING	44	9	FI		

QUOTING (Routing Transaction Number 147 “GENERAL-ASSEMBLY”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
147			P	QUOTING	45	1	IF		
147	QUOTING	59	P	QUOTING	45	2	DIM	Assembly:	
147			P	QUOTING	45	3	=		
147			P	QUOTING	45	4	A	General Assembly	
147			P	QUOTING	45	5	THEN		
147			P	QUOTING	45	6	PRMT		
147			P	QUOTING	45	7	ELSE		
147			P	QUOTING	45	8	K		0.000000
147			P	QUOTING	45	9	FI		

QUOTING (Routing Transaction Number 150 “INSPECT”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
150			P	QUOTING	48	1	IF		
150	QUOTING	60	P	QUOTING	48	2	DIM	Inspection:	
150			P	QUOTING	48	3	=		
150			P	QUOTING	48	4	A	Inspect	
150			P	QUOTING	48	5	THEN		
150			P	QUOTING	48	6	PRMT		
150			P	QUOTING	48	7	ELSE		
150			P	QUOTING	48	8	K		0.000000
150			P	QUOTING	48	9	FI		

QUOTING (Routing Transaction Number 151 “INSPECT-100”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
151			P	QUOTING	49	1	IF		
151	QUOTING	60	P	QUOTING	49	2	DIM	Inspection:	
151			P	QUOTING	49	3	=		
151			P	QUOTING	49	4	A	Inspect-100	
151			P	QUOTING	49	5	THEN		
151			P	QUOTING	49	6	PRMT		
151			P	QUOTING	49	7	ELSE		
151			P	QUOTING	49	8	K		0.000000
151			P	QUOTING	49	9	FI		

QUOTING (Routing Transaction Number 154 “MASKING”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
154			P	QUOTING	52	1	IF		
154	QUOTING	61	P	QUOTING	52	2	DIM	Finishing:	
154			P	QUOTING	52	3	=		
154			P	QUOTING	52	4	A	Masking	
154			P	QUOTING	52	5	THEN		
154			P	QUOTING	52	6	PRMT		
154			P	QUOTING	52	7	ELSE		
154			P	QUOTING	52	8	K		0.000000
154			P	QUOTING	52	9	FI		

QUOTING (Routing Transaction Number 155 “INSPECT-FINISH-DE”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
155			P	QUOTING	53	1	IF		
155	QUOTING	61	P	QUOTING	53	2	DIM	Finishing:	
155			P	QUOTING	53	3	=		
155			P	QUOTING	53	4	A	Inspect-Finish+De-masking	
155			P	QUOTING	53	5	THEN		
155			P	QUOTING	53	6	PRMT		
155			P	QUOTING	53	7	ELSE		
155			P	QUOTING	53	8	K		0.000000
155			P	QUOTING	53	9	FI		

QUOTING (Routing Transaction Number 156 “POWDER-COAT”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
156			P	QUOTING	54	1	IF		
156	QUOTING	61	P	QUOTING	54	2	DIM	Finishing:	
156			P	QUOTING	54	3	=		
156			P	QUOTING	54	4	A	Powder Coat	
156			P	QUOTING	54	5	THEN		
156			P	QUOTING	54	6	(		
156			P	QUOTING	54	7	(		
156	QUOTING	7	P	QUOTING	54	8	DIM	Flat_Length	
156			P	QUOTING	54	9	*		
156	QUOTING	8	P	QUOTING	54	10	DIM	Flat_Width	
156			P	QUOTING	54	11	)		
156			P	QUOTING	54	12	/		
156			P	QUOTING	54	13	K		144.000000
156			P	QUOTING	54	14	)		
156			P	QUOTING	54	15	*		
156			P	QUOTING	54	16	K		0.005556
156			P	QUOTING	54	17	ELSE		
156			P	QUOTING	54	18	K		0.000000
156			P	QUOTING	54	19	FI		

QUOTING (Routing Transaction Number 157 “BATCH-OVEN”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
157			P	QUOTING	55	1	IF		
157	QUOTING	61	P	QUOTING	55	2	DIM	Finishing:	
157			P	QUOTING	55	3	=		
157			P	QUOTING	55	4	A	Batch Oven	
157			P	QUOTING	55	5	THEN		
157			P	QUOTING	55	6	K		0.050000
157			P	QUOTING	55	7	ELSE		
157			P	QUOTING	55	8	K		0.000000
157			P	QUOTING	55	9	FI		

QUOTING (Routing Transaction Number 158 “WASH-ONLY”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
158			P	QUOTING	56	1	IF		
158	QUOTING	61	P	QUOTING	56	2	DIM	Finishing:	
158			P	QUOTING	56	3	=		
158			P	QUOTING	56	4	A	Wash Only	
158			P	QUOTING	56	5	THEN		
158			P	QUOTING	56	6	K		0.010000
158			P	QUOTING	56	7	ELSE		
158			P	QUOTING	56	8	K		0.000000
158			P	QUOTING	56	9	FI		

QUOTING (Routing Transaction Number 159 “SCREEN-PRINT”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
159			P	QUOTING	57	1	IF		
159	QUOTING	61	P	QUOTING	57	2	DIM	Finishing:	
159			P	QUOTING	57	3	=		
159			P	QUOTING	57	4	A	Screen Printing	
159			P	QUOTING	57	5	THEN		
159			P	QUOTING	57	6	K		0.025000
159			P	QUOTING	57	7	ELSE		
159			P	QUOTING	57	8	K		0.000000
159			P	QUOTING	57	9	FI		

QUOTING (Routing Transaction Number 160 “CHROMATE-ETCH”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
160			P	QUOTING	58	1	IF		
160	QUOTING	61	P	QUOTING	58	2	DIM	Finishing:	
160			P	QUOTING	58	3	=		
160			P	QUOTING	58	4	A	Chromating-Etching	
160			P	QUOTING	58	5	THEN		
160			P	QUOTING	58	6	K		0.016667
160			P	QUOTING	58	7	IF		
160	QUOTING	17	P	QUOTING	58	8	DIM	Num_Cutouts	
160			P	QUOTING	58	9	>		
160			P	QUOTING	58	10	K		0.000000
160			P	QUOTING	58	11	THEN		
160			P	QUOTING	58	12	+		
160			P	QUOTING	58	13	K		0.008333
160			P	QUOTING	58	14	FI		
160			P	QUOTING	58	15	ELSE		
160			P	QUOTING	58	16	K		0.000000
160			P	QUOTING	58	17	FI		

QUOTING (Routing Transaction Number 163 “PACK-FOR-SHIPMENT”)

TRANS #	SOURCE PART #	DIM SOURCE	TYPE	PART NUMBER	DIM #	ORD #	ACTION	MASK	CONSTANT
163			P	QUOTING	61	1	PRMT		