



# Infor LN Warehousing User Guide for Warehousing Inspections

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## About this Guide

This guide provides an introduction to warehousing inspections and describes the setup and use of the inspection procedures.

### Intended Audience

This book is intended for those who want to learn how to use warehousing inspections and to set up the warehouse inspection functionality in the way that best serves their purposes. Both end users and users on administrator level will find the information they require.

### Assumed Knowledge

Familiarity with the business processes involved in inspecting goods in the warehouse, and general knowledge of the LN functionality will help you understand this book. In addition, Warehousing training courses are available to give you a head start.

### References

Use this guide as the primary reference for warehousing inspections. Use the current editions of these documents for information that is not covered in this guide:

- *User Guide for Warehousing Procedures*
- *User Guide for Warehouses*
- *User Guide for the Inbound Goods Flow (U9788 US)*
- *User Guide for the Outbound and Shipments Goods Flows (U9794 US)*
- *User Guide for Warehousing Quarantine Handling (U9876 US)*
- *User Guide for Handling Units (U8938 US)*

### How to read this document

This document is assembled from online Help topics.

Text in italics followed by a page number represents a hyperlink to another section in this document.

Underlined terms indicate a link to a glossary definition. If you view this document online, clicking the underlined term takes you to the glossary definition at the end of this document.

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# Chapter 1: Introduction

## Warehousing inspections

In LN, you can inspect received items, items stored in inventory, and items to be shipped. For example, you can use inspections to:

- Check the quality of goods ordered from a new supplier.
- Monitor a supplier with a history of quality problems.
- Check the quality of outbound goods that were damaged on the way to the staging location.

For received items to be inspected, LN creates inbound inspections. For items to be shipped that require inspection, LN creates outbound inspections. For items stored in inventory, LN creates inventory inspections. This topic discusses inbound and outbound inspections. See *Inventory inspections* for information about inventory inspections.

The inbound inspection procedure is one of the main *warehousing procedures* in LN. You can add the inspection procedure to a warehousing procedure if the setup for the warehouse, supplier, or item requires item inspection.

Unlike inbound inspections, the outbound inspection is not a warehousing procedure in its own right, but an activity that you can add to the outbound procedure. You can add the outbound inspection step to a warehousing procedure if the setup for the warehouse, supplier, or item requires item inspection.

### Creating inspection headers and lines

An inbound and an outbound inspection consists of an inspection header and one or more inspection lines.

During the inbound and outbound process, LN creates inspections for items that require inspection according to the inspection parameter setup. You cannot manually create warehousing inspections.

### How to specify and process inspection results

For both inbound and outbound inspections, first specify the inspection results and then process the inspection, which finalizes the inspection.

Specifying the inspection results for an inbound inspection entails approving, rejecting, destroying, or scrapping the inspected items. For an outbound inspection, this entails approving, rejecting, or scrapping the inspected items.

Destroyed items must always be paid to the supplier, whereas for scrapped items, suppliers are not always involved, and settlement depends on the situation. The availability of scrapping depends on the quarantine parameter setup.

### After processing

After you process an inbound inspection, the approved items are added to the inventory. For location-controlled warehouses, inbound advice from the inspection location to the storage location must be generated and put away. The warehousing-procedure setup determines whether this is done automatically or manually. For non location-controlled warehouses, the approved items are put away automatically.

The rejected items are sent to a quarantine location or quarantine warehouse for further handling, or removed from inventory through an *adjustment order*. This depends on the inspection and quarantine parameter setup.

The destroyed quantity is part of the approved quantity but is removed from inventory. This is because the supplier must be paid for the destroyed goods. Goods are usually destroyed for testing purposes or by some accident, for which the supplier is not liable.

Scrapped items are removed from inventory through an adjustment order.

For outbound inspections, you can approve, reject, or scrap items. The approved quantities will be shipped. The rejected items are sent to a quarantine location or quarantine warehouse for further handling, or removed from inventory through an *adjustment order*, provided with a reject reason code. This depends on parameter setup. You can view the adjustment order in the **Adjustment Orders History (whinh5570m000)** session.

### To inspect handling units

The handling unit setup determines whether handling units are generated, must be created by the user, or are not used for items in the inbound and/or outbound flow. If generated, inspection handling units are generated when the inspection header and inspection lines are created.

If handling units are present for an inbound or outbound inspection header or inspection lines, you can specify the inspection results for the inspection handling units or in the inspection lines.

### Setup

To use inbound or outbound inspections, you must specify the items that require inspection and set up specific warehousing procedures. Inbound inspections are usually carried out in specific inspection locations, whereas outbound items are inspected on a staging location instead of an inspection location. If your warehouses are location-controlled, you must define inspection locations for inbound inspections. Specific setup is required if items rejected during inspection must be handled in a quarantine warehouse or quarantine location.

### Quality Management integration

If Quality inspections are applicable to an item, order, and/or business partner, both Quality inspections and Warehousing inspections are involved in the inbound and/or outbound inspection process.



## Chapter 2: Inspection Headers and Lines

### Creating, updating, and deleting inspection headers and lines

During the inbound and outbound process, LN creates inspections for items that require inspection according to the inspection parameter setup. You cannot manually create warehousing inspections.

This topic discusses inbound and outbound inspections. See *Inventory inspections* for information about inventory inspections.

#### Inbound inspections

For location-controlled warehouses, LN creates an inbound inspection when an inbound advice, or one or more of its advice lines, are put away. If storage lists are used, the inspection is created when the storage list or a *storage mission* is put away.

An inbound inspection corresponds to an inbound order line. If warehouse locations apply and the goods are advised to various locations, LN creates a separate inspection for each inbound order line and each advised location. For example, if the items on order line 1000/10 are advised to locations L1 and L2, this results in inspections INS10111 and INS10112. Next, if order line 1000/20 is advised to locations L2 and L3, this results in inspections INS10113 and INS1014.

If the advice lines of an inbound advice are put away at different moments, the inspection is created when the first advice line is put away. When the next advice lines are put away, these are added to the same inspection if the advised location is the same and if the inspection is still **open**.

If the inspection is set **in process** or has been **processed** in the meantime, a new inspection is created for the advice lines that were put away later on.

For non location-controlled warehouses, LN creates the inspection when at least one receipt line of a receipt is confirmed.

If the receipt lines of a receipt are put away at different moments, the inspection is created when the first receipt line is confirmed. When the next receipt lines are confirmed, these are added to the same inspection if the inspection is still open (and the receipt lines belong to the same inbound order line). If the inspection is set in process or has been processed in the meantime, a new inspection is created for the receipt lines that were confirmed later on.

### Receipt corrections

If a receipt correction is carried out, LN inserts the corrected quantities in the inspection lines of any corresponding inspections. These quantities can be corrected for inspections that are open or in process. If the quantity to be inspected becomes zero after the receipt correction, the inspection line is removed. For processed inspections, LN creates a new inspection for the corrected quantity. Negative receipt corrections are not allowed for processed inspections if the corrected quantity falls below the processed quantity.

### Outbound inspections

LN creates an outbound inspection when outbound advice is released or if the picking list is confirmed, if picking lists apply to the outbound procedure.

An outbound inspection corresponds to an outbound order line. If locations apply, advice lines corresponding to the same outbound order line that are advised to the same staging location are consolidated into one outbound inspection. If one or more advice lines are advised to a different location, a separate inspection is created for each location.

For example, if the items on order line 1000/10 are advised to locations L1 and L2, this results in inspections OUT10100 and OUT10101. Next, if order line 1000/20 is advised to locations L2 and L3, this results in inspections OUT10103 and OUT10104.

If the advice lines of an outbound advice are released at different moments, the inspection is created when the first advice line is released. When the next advice lines are released, these are added to the same inspection if the advised location and the order line are the same, and if the inspection is still open. If the inspection is set in process or has been processed in the meantime, a new inspection is created for the advice lines that were released later on.

### Consolidation of stock points in Warehousing inspections

An inbound and an outbound inspection consists of an inspection header and one or more inspection lines.

During the inbound and outbound process, LN creates inspections for items that require inspection according to the inspection parameter setup. You cannot manually create warehousing inspections.

### Ownership

If a receipt line or outbound advice has different ownership records, a separate inspection line is created for each owner.

### Peg distribution

If the warehouse order line is project pegged, for inbound inspections the approved, rejected, or destroyed quantities are updated for each peg in the **Receipt Line Peg Distribution (whinh3528m000)** session. For outbound inspections, the approved and rejected quantities are updated in the **Outbound Order Line Peg Distribution (whinh2690m000)** session.

## Quality

Selecting the **Consolidate Stock Points in one Warehouse Inspection** check box is strongly recommended if you use Quality to perform warehouse inspections. The reason is, that Quality needs consolidated inspections to properly apply sampling rules, in particular if serialized items are involved.

## Deleting inspections and inspection lines

LN deletes an inspection line if:

- The **Inspection** check box is cleared for the related receipt line and the warehouse is a WMS warehouse.
- If the related receipt line is deleted. If the receipt line corresponds with all inspection lines of an inspection, the inspection is deleted.

If an outbound order line is deleted, the corresponding inspections are deleted.

# Consolidation of stock points in Warehousing inspections

The setting of the Consolidate Stock Points in one Warehouse Inspection check box determines how inspections and inspection lines are created for *low volume* lot or serialized items, LIFO/FIFO items, or items contained in multiple handling units.

If this check box is selected, a separate inspection line is created for each different stock point detail present on an inbound or outbound advice line, a receipt line, a storage list or a picking list.

If this check box is cleared, a separate warehouse inspection is created for each different stock point detail present on an inbound or outbound advice line, a receipt line, a storage list or a picking list.

This topic discusses inbound and outbound inspections. See Inventory inspections for information about inventory inspections.

## High volume lot and serial numbers inbound

When LN creates an inspection line from an advice line or a receipt line with high volume lot or serial numbers, the lot or serial numbers are copied from the **Receipt Line Stock Point Details (whinh3123m000)** session to the inspection lines.

For each serialized item, LN creates an inspection line.

After specifying the destroyed and rejected quantities in the inspection lines, the quantities of the rejected or destroyed lot and serial numbers are updated to the **Receipt Line Stock Point Details (whinh3123m000)** session. After processing, LN uses this information to create quarantine IDs or adjustment orders to deal with the rejected items.

## Low volume serials inbound

For *low volume* serialized items received in a warehousing order with origin **JSC Production**, inbound inspections are created in the same way as high volume serials if the **Consolidate Stock Points in one Warehouse Inspection** check box is selected: when the serialized items are reported complete in production,

LN creates a warehousing order with a single inbound order line and registers the serial numbers in the **Inbound Order Line Lots and Serials (whinh2116m000)** session. From the inbound order line LN creates a single inspection and an inspection line for each serialized item.

### High volume lot and serial numbers outbound

When LN creates an inspection line from an outbound advice line with *high volume* lot or serial numbers, the lot or serial numbers are copied from **Outbound Advice Lots and Serials (whinh4126m000)** session to the inspection lines.

For each serialized item, LN creates an inspection line.

You can register lot and serial numbers on the inspection line. Alternatively, you can postpone this until after processing the inspections or inspection lines and the release of the outbound advice. At this point lot and serial registration is done in the **Shipment Line Stock Point Details (whinh4133m000)** session.

## Inbound warehouse inspection consolidation for stock points - example

If the **Consolidate Stock Points in one Warehouse Inspection** check box is selected, LN consolidates the inbound advice lines that belong to the same inbound order line and inspection location into a single inspection. If warehouse locations do not apply, LN consolidates the receipt lines that belong to the same inbound order line into a single inspection. For each different stock point detail associated with an inbound order line, a separate inspection line is created.

For a purchase manual order, 100 pcs of lot (in inventory) item A are received. LN creates receipt REC000001 with the following receipt lines:

Receipt Line	Received quantity	Lot	Inventory date
REC000001 - 10	50 pcs	Lot1	10-02-2013
REC000001 - 20	10 pcs	Lot1	12-02-2013
REC000001 - 30	40 pcs	Lot2	13-02-2013

25 pcs of Lot1 are advised to inspection location INS2, while the remainder of Lot1 and Lot2 is advised to inspection location INS1. As a result, LN creates the following inspections:

Warehouse inspection	Location	To be inspected	Inspection line	To be inspected	Lot	Inventory date
INS000001 - 10	INS1	75 pcs	1	25 pcs	Lot1	10-02-2013
			2	10 pcs	Lot1	12-02-2013
			3	40 pcs	Lot2	13-02-2013
INS000002 - 10	INS2	25 pcs	1	25 pcs	Lot1	10-02-2013

Inspection INS000001 - 10 is created with three inspection lines, because the receipt includes two lot codes and three different inventory dates. Inspection INS000002 - 10 is created because part of Lot1 was advised to a different inspection location.

If locations do not apply, or if the entire receipt is advised to inspection location INS1, the following inspection is created:

Warehouse inspection	Location	To be inspected	Inspection line	To be inspected	Lot	Inventory date
INS000001 - 10	INS1	100 pcs	1	50 pcs	Lot1	10-02-2013
			2	10 pcs	Lot1	12-02-2013
			3	40 pcs	Lot2	13-02-2013

## Outbound warehouse inspection consolidation for stock points - example

If the **Consolidate Stock Points in one Warehouse Inspection** check box is selected, LN consolidates the outbound advice lines that belong to the same outbound order line into a single inspection. If warehouse locations apply, the staging locations must also match. For each different stock point detail associated with an outbound order line, a separate inspection line is created.

For a sales (manual) order, 100 pcs of lot controlled (in inventory) item B are issued. LN creates the following outbound advice:

Outbound advice	From location	To location	Advised quantity	Lot	Inventory date
1	B1	S1	20 pcs	Lot3	10-02-2013
2	B1	S1	40 pcs	Lot4	10-02-2013
3	B2	S1	30 pcs	Lot4	10-02-2013
4	B2	S2	10 pcs	Lot4	10-02-2013

Because two different lots are picked and part of Lot4 is advised to two different staging locations, the following inspections are created:

Warehouse inspection	Location	To be inspected	Inspection line	To be inspected	Lot	Inventory date
OBI000001 - 10	S1	90 pcs	1	20 pcs	Lot3	10-02-2013
			2	40 pcs	Lot4	10-02-2013
			3	30 pcs	Lot4	10-02-2013
OBI000002 - 10	S2	10 pcs	1	10 pcs	Lot4	10-02-2013

Inspection OBI000001 - 10 is created with three inspection lines, because each outbound advice results in an inspection line unless a new inspection header needs to be created. Inspection OBI000002 - 10 is created because part of Lot4 was advised to a different staging location.

## Warehouse inspection consolidation of different ownership - example

If a receipt line or outbound advice has different ownership records, a separate inspection line is created for each ownership record.

Inbound inspection						
Warehouse in- spection	To be in- spected	Inspection line	Ownership sequence	To be in- spected	Ownership	Own- er
INS000003 - 10	30	1	1	20	Company owned	
		2	2	10	Consigned	ACB
Outbound inspection						
Warehouse in- spection	To be in- spected	Inspection line	Ownership sequence	To be in- spected	Ownership	Own- er
OUT000003 - 10	100	1	1	80	Company owned	
		2	2	20	Consigned	ACB

## Chapter 3: Inspection Handling

### How to specify inspection results and process warehousing inspections

For both inbound and outbound inspections, first specify the inspection results and then process the inspection, which finalizes the inspection.

Specifying the inspection results for an inbound inspection entails approving, rejecting, destroying, or scrapping the inspected items. For an outbound inspection, this entails approving, rejecting, or scrapping the inspected items.

This topic discusses inbound and outbound inspections. See Inventory inspections for information about inventory inspections.

To process one or more inbound or outbound warehouse inspections without specifying approved or rejected quantities:

- 1 Select the inspection or inspections in the **Warehouse Inspections Overview (whinh3122m000)** session.
- 2 From *appropriate menu*, select:
  - Approve and Process to approve and process the inspections.
  - Reject and Process to reject and process the inspections.

You cannot destroy and process one or more inbound inspections without specifying the item quantities. To specify that all of the items of an inbound inspection are destroyed, for each inspection line of the inspection you must specify the total item quantities in the **Destroyed Quantity** field in the **Inspection Lines (whinh2131m000)** session. See step 3 below.

To handle an inbound or outbound warehouse inspection:

- 1 Look up the inspection in the **Warehouse Inspections Overview (whinh3122m000)** session.
- 2 In the **Warehouse Inspections Overview (whinh3122m000)** session, double-click the inspection.
- 3 In the **Warehouse Inspection (whinh3622m000)** session that opens, in the **Inspection Result** tab, specify the approved, rejected, or (inbound only) destroyed quantities.
- 4 Optionally, double-click the inspection line to open the **Inspection Lines (whinh2131m000)** session to specify additional data such as inspection text in the **Attachments** tab.
- 5 Repeat previous two steps for any other inspection lines.
- 6 Save the inspection lines.
- 7 Click **Process** in the toolbar of the **Warehouse Inspection (whinh3622m000)** session to process the inspection.

### Handling units

If the inspected quantities are contained in handling units, you can only process the warehouse inspection if the approved, rejected, or destroyed quantities of the handling unit or handling unit structure and the inspection line quantities match.

### Partial inspections

If you process an inspection that has items not yet approved, rejected, or (inbound only) destroyed, LN creates a new inspection sequence for these items.

### In Process

An inspection automatically obtains the **In Process** status after approving, rejecting, or (only inbound inspections) destroying one or more of the items of an inspection. LN cannot add inspection lines to inspections that are **In Process**. If an inspection is open, LN can add new inspection lines to the inspection. This happens, for example, if the receipt lines of a receipt are confirmed at different moments. LN creates an inspection when the first receipt line is confirmed, and adds new inspection lines when the subsequent receipt lines are confirmed, provided that the inspection is not set in process or has been processed in the meantime.

You can manually set an open inspection or inspection line to **In Process** to prevent additional inspection lines to be added to the inspection or inspection line. This can be useful if you want to set the inspection apart for more detailed handling.

If Quality is implemented, you can trigger the creation of the corresponding order inspection if you set the inspection to **In Process**.

## Warehousing inspections after processing

For inbound inspections, LN creates inbound advice to move the approved and processed quantities from the inspection location to the storage location if the warehouse is location-controlled. The warehousing procedure setup determines whether the generate and put away inbound-advice steps are performed automatically. For non-location controlled warehouses, the approved quantities are automatically added to the warehouse inventory when processed. Rejected item quantities are removed from inventory through an adjustment order or sent to the quarantine warehouse or quarantine location without inbound advice. Destroyed quantities are removed from inventory through an automatically created adjustment order.

For outbound inspections, LN creates shipment lines for the approved and processed items. Rejected and processed item quantities are removed from inventory through an adjustment order or sent to the quarantine warehouse or quarantine location without using the outbound and shipment procedures. The rejected quantities are listed on the corresponding outbound order lines.

This topic discusses inbound and outbound inspections. See Inventory inspections for information about inventory inspections.



### Ownership

After processing, for inbound inspections the ownership details of the approved, rejected, or (inbound only) destroyed quantities are updated to the **Receipt Line Ownership (whinh3521m000)** session. From there, the approved quantities are used to update the inventory ownership information. The ownership information of the rejected and destroyed quantities are used as input for inventory adjustment orders. If the quarantine functionality is implemented, ownership of rejected inventory is stored in quarantine.

For outbound inspections, the ownership details of the approved quantities are passed on to the outbound advice, where they are used to create shipment line ownership details and to update the inventory levels per owner.

### Peg distribution

If the inspected order line is project pegged, the adjusted inventory levels after processing the inspection are updated for the corresponding project pegs.

## Chapter 4: Inventory Inspections

### Inventory inspections

Inventory inspections are used to check if items stored in inventory meet the required quality standards. Items, such as oil or chemicals, can deteriorate over time and therefore require periodical inspection. Also, instant inspections can be needed in unexpected circumstances, such as power outages in the warehouse.

In LN, you can create both ad hoc and periodic inventory inspections.

Ad hoc inventory inspections are manually created in the **Warehouse Inventory Inspection (whinh3622m200)** session. Periodic inventory inspections are created in the **Generate Inventory Inspections (whinh2211m000)** session.

#### Inventory inspection headers and lines

An inventory inspection consists of a header and one or more lines.

The inventory inspection header shows general information such as the warehouse, the location, the item, and the aggregated inspection results.

The inventory inspection line shows the information at the most detailed stock point level. For example, if the item is lot-controlled and serialized, the inspection line shows the serial number and the inspection results for the individual serial number. If the item is lot-controlled, the inspection line shows the inspection results for the items contained in the lot.

#### Inventory inspection handling units

You can create inventory inspections for handling units.

When an inventory inspection is created for a handling unit, the inspection header is displayed in the **Warehouse Inventory Inspections Overview (whinh3122m200)** session and the **Warehouse Inventory Inspection (whinh3622m200)** session. The inspection lines are displayed in the Inspection Lines tab of this session, and the handling units are displayed in the Handling Units tab.

#### Blocking

Items in inventory that are inspected are automatically blocked for inbound and outbound processes, cycle counting, and inventory adjustments.

### Inspection results

For items in inventory, you can specify these inspection results:

- Approved
- Destroyed
- Scrapped
- Rejected

For approved items, the block is automatically lifted.

Scrapped and destroyed items are removed from inventory through an automatically created adjustment order. If the destroyed items are not company owned, this is at the owner's expense.

The adjustment orders are automatically created and processed, and financial transactions are created.

Rejected items are subject to quarantine handling for further examination.

If the quarantine functionality is not implemented, rejected items are removed from inventory through an automatically created adjustment order.

### Quarantine handling for inventory inspections

Quarantined items are automatically blocked for inbound and outbound processes.

In quarantine, items are given dispositions for further action such as use as is, rework, return to vendor, or scrapping.

Quarantine handling for items rejected in inventory inspections is done in the warehouse or the location in which the items are stored. Optionally, use the **Move Quarantine Inventory** option in the **Quarantine Inventory Disposition (whwmd2172m000)** session to move the items to a different location.

After quarantine processing, the selected *disposition* determines, if, where and how the inventory is moved. For example, items can be returned to the supplier through a purchase return order, sent to a rework location through a production order, or simply be unblocked if the disposition is use as is.

### Inventory inspection ownership

When consigned or customer owned inventory is to be inspected, you must specify the owner of the inventory on the inspection line. When you save the inspection line, LN checks whether the inventory is On Hand according to the ownership settings in these sessions:

- **Warehouse - Item Inventory Ownership (whwmd2615m000)**
- **Inventory by Warehouse and Lot (whltc1605m000)**
- **Item - Serials and Warehouses (whltc5100m000)**

### Integration with Quality for inventory inspections

You can link Warehousing inventory inspections with Quality inventory inspections.

If the functionality for Warehousing inventory inspections is implemented for an item, the storage inspection functionality from Quality is unavailable for the item.

## Inventory inspection setup

The inventory inspection functionality is implemented by item, item by site, and item by warehouse.

The settings by item serve as default settings for individual sites, and the settings by site serve as default settings for individual warehouses. This means that you can define central settings for items and define different settings for individual sites or warehouses.

To set up the inventory inspection functionality for an item, complete these steps:

- 1 Select the **Inventory Inspection** check box.
- 2 Define the frequency for periodic inspections in the **Frequency for Inventory Inspection** field.
- 3 Specify the series for inventory inspection records.

The **Inventory Inspection** check box and the **Frequency for Inventory Inspection** field are available in these sessions:

- **Item - Warehousing Defaults (whwmd4501m00)**
- **Item - Warehousing (whwmd4500m000)**
- **Item Warehousing Defaults by Site (whwmd4109m000)**
- **Item - Warehousing by Site (whwmd4104m000)**
- **Item Data by Warehouse (whwmd2510m000)**

Series for inventory inspections are specified in these sessions:

- **Inventory Handling Parameters (whinh0100m000)**
- **Warehousing Settings by Site (whwmd2101m000)**
- **Warehousing User Profiles (whwmd1140s000)**

The series defined for individual sites overrule the general parameter series. The series defined for individual users overrule the general series and those defined for individual sites.

## Defining periodic inventory inspections

Periodic inventory inspections are created in the **Generate Inventory Inspections (whinh2211m000)** session. The items to be inspected are selected by specifying search criteria in the range fields.

Inventory inspections are generated for items that match the criteria and whose inspection due date has passed.

To calculate the due date, the value in the **Frequency for Inventory Inspection** field in the **Item Data by Warehouse (whwmd2510m000)** session is added to the value of the **Last Inventory Inspection Date** field in the **Stock Point Inventory (whinr1540m000)** session or the **Item - Serials and Warehouses (whltc5100m000)** session.

For items that match the selection range criteria but whose calculated due date is later than the current date, no inventory inspections are created.

## History data

To store history data about inbound inspections, outbound inspections, or inventory inspections, select the **Inspection History** check box in the **Inventory Handling Parameters (whinh0100m000)** session.

## Handling inventory inspections

- 1 In the **Generate Inventory Inspections (whinh2211m000)** session, generate inventory inspections. Alternatively, click New in the *appropriate menu* of the **Warehouse Inventory Inspections Overview (whinh3122m200)** session to manually create an ad hoc inspection and New in the *appropriate menu* of the **Warehouse Inventory Inspection (whinh3622m200)** session to create an inspection line.
- 2 In the **Warehouse Inventory Inspections Overview (whinh3122m200)** session, double-click an inspection.
- 3 In the **Warehouse Inventory Inspection (whinh3622m200)** session, double-click an inspection line.
- 4 In the **Inventory Inspection Lines (whinh2131m200)** session, specify the stock point details of the items to be inspected.
- 5 Specify the quantity of the items to be inspected.
- 6 Specify the inspection results and the quantities as needed.
- 7 On the *appropriate menu* of the **Warehouse Inventory Inspection (whinh3622m200)** session, select **Process**.

### Alternative procedures

On the *appropriate menu* of the **Warehouse Inventory Inspections Overview (whinh3122m200)** session, you can approve, reject, or process multiple inspections at once.

On the *appropriate menu* of the **Warehouse Inventory Inspection (whinh3622m200)** session, you can approve, reject, or process the entire inspection.

On the *appropriate menu* menu of the **Inventory Inspection Lines (whinh2131m200)** session, you can approve or reject the entire inspection line.

Before processing, you can save the inspection if processing the inspection at a later stage is preferred.

You are not required to specify the inspection results of the entire quantity to be inspected at once. You can save the inspection line, close the session, and complete the inspection at a later stage. To complete the inspection line, you can use the options on the *appropriate menu* to approve or reject the remaining quantities.

### Partial inspections

You can process an inspection before specifying inspection results for the entire quantity to be inspected. A new inspection is generated for the quantity still to be inspected. This inspection has the same ID, but the sequence number is increased by 1.

## Inventory inspection project pegs

When an inventory inspection line is created for a project pegged item, the inventory inspection pegs are created. The pegs are composed in this order:

- 1 Unpegged inventory
- 2 Pegs with *Excess* inventory
- 3 Pegs with ATT (*available to transfer*) inventory

#### 4 Other pegs

This means that the unpegged inventory is used first. If more inventory is needed for the peg, the required additional quantity is taken from the pegs with excess inventory. If this still does not cover the required quantity, the remaining quantity is taken from the pegs with available to transfer inventory, and so on. The peg details are displayed in the **Inventory Inspection Line Peg Distribution (whinh2138m000)** session.

During inventory inspection and quarantine handling the inventory is blocked for other processes. The blocked inventory is displayed in the Project Pegged Inventory (whwmd2560m000) session.

The **Inventory Inspection Line Peg Distribution (whinh2138m000)** session is updated with the destroyed, scrapped or rejected quantities during inventory inspection.

After the inventory inspections are processed, the inventory inspection pegs are deleted and the inventory is unblocked.

For the rejected and destroyed quantities, the inventory inspection pegs are created again. The pegs of the destroyed and rejected quantities are used to automatically create adjustment orders to remove the inventory. If quarantine handling is implemented, the pegs are used to show the updates during the quarantine process. The pegs are deleted when the inventory inspection lines are deleted.

## Chapter 5: Handling Units

### To inspect handling units

The handling unit setup determines whether handling units are generated, must be created by the user, or are not used for items in the inbound and/or outbound flow. If generated, inbound or outbound inspection handling units are generated when the inspection header and inspection lines are created.

If handling units are present in inventory, you can perform inventory inspections for handling units. See [Inventory inspections for handling units](#).

If handling units are present for an inbound, outbound, or inventory inspection header or inspection lines, you can specify the inspection results for the inspection handling units or in the inspection lines.

The **Handling Unit(s) Present** field in the inspection header in the **Warehouse Inspections Overview (whinh3122m000)** session and the **Warehouse Inspections Overview (whinh3122m000)** session shows whether handling units are present.

If you specify the inspection results for the handling units, the corresponding inspection line quantities are updated.

Inspection results specified in the inspection lines are updated on the corresponding handling units after you process the inspection, but only if all inspection lines of the inspection have the same inspection results, that is, the entire inspection must be approved, rejected, or (inbound only) destroyed.

Partial inspections are manually processed in the **Warehouse Inspections Overview (whinh3122m000)** session, the **Warehouse Inspection (whinh3622m000)** session, the **Warehouse Inspections Overview (whinh3122m000)** session, or the **Warehouse Inventory Inspection (whinh3622m200)** session.

After you have specified the inspection results for all of the handling units of an inspection, the inspection is processed:

- By LN if the inspection results were specified starting from the **Handling Units (whwmd5130m000)** or the **Handling Units (whwmd5630m000)** session.
- Manually by the user

**Note:**

If you process an inspection for which part of the item quantity is not approved, rejected, or (inbound only) destroyed, LN creates a new inspection for the remaining quantity.

However, processing an inspection is not allowed if a corresponding bottom-level handling unit has an unspecified quantity and an approved quantity. In such cases a message is displayed and you must specify the entire quantity and process the corresponding inspection handling units.

If the bottom-level handling unit has an unspecified quantity and a rejected or destroyed, but no approved quantity, processing the inspection is allowed. In such cases the destroyed and rejected quantities are removed

from the handling unit and processed anonymously, that is, outside the handling unit. The unspecified quantity stays in the handling unit, for which LN creates a new inspection sequence.

## Inventory inspections for handling units

You can perform inventory inspections for inventory with *handling units* and without handling units.

If an inventory inspection contains handling units, you can specify the inspection results for the inspection handling units or in the inspection lines.

To perform an inventory inspection for a handling unit, a handling unit must meet these conditions:

- The handling unit must be single item, that is, the **Multi Item** check box must be cleared in the **Handling Unit Stock Point Details (whwmd5136m000)** session.
- The status is **In Stock**.
- The handling unit is linked to an inventory inspection.

**Note:** When you link a handling unit with the In Stock status to an inventory inspection, the status of the handling unit changes to **To be Inspected**.

### Creating inventory inspections with handling units

Inventory inspections with handling units are created in these ways:

- In the **Handling Units (whwmd5130m000)** session or the **Handling Units (whwmd5630m000)** session, complete these steps:
  - 1 Select a handling unit with status **In Stock**.
  - 2 From the *appropriate menu*, select **Inventory Inspection** and from the submenu, select **Create**.
- In the **Generate Inventory Inspections (whinh2211m000)** session, complete these steps:
  - 1 Select the **Handling Unit Inventory** check box.
  - 2 Select the preferred option in the **Inspect Top or Bottom Level Handling Units** field.
  - 3 Specify the selection ranges as required.
  - 4 Click **Generate**.
- In the **Warehouse Inventory Inspections Overview (whinh3122m200)** session or the **Warehouse Inspection Handling Units (whinh2534m000)** session, complete these steps:
  - 1 Select an inventory inspection.
  - 2 From the *appropriate menu*, select **Link Handling Unit(s)**.
  - 3 From the **Handling Units (whwmd5130m000)** session, select the handling units as required. The handling units displayed in this session have the **In Stock** status and match the item, warehouse, and location of the selected inventory inspection.

### Generating inventory inspections with handling units

For a handling unit to be selected in the **Generate Inventory Inspections (whinh2211m000)** session, these conditions apply:

- The item, warehouse, and location must match the selection ranges.



- The inventory date, serial number, or the lot number must match the selection ranges.
- The handling unit status must be **In Stock**.

If the **Inspect Handling Unit Top Levels** option is selected, all top level handling units including the handling units contained in them that match the criteria are selected.

If the **Inspect Handling Unit Bottom Levels** option is selected, all bottom level handling units that match the criteria are selected.

### The process of creating inventory inspections with handling units

If you create an inventory inspection for a handling unit, LN performs this process:

- 1 Create inspection header for the warehouse, location, and item of the handling unit.
- 2 Create inspection lines based on the stock point details contained in the handling unit.
- 3 Set the status of the handling unit to be inspected to **To Be Inspected**.
- 4 For the inventory inspections and related handling units thus created, enable maintenance in these sessions:
  - **Warehouse Inventory Inspections Overview (whinh3122m200)**
  - **Warehouse Inventory Inspection (whinh3622m200)**
  - **Warehouse Inspection Handling Units (whinh2534m000)**
  - **Inspect Handling Unit (whinh2234m000)**

## How to specify inspection results for handling units

- 1 Look up an inbound or outbound inspection in the **Warehouse Inspections Overview (whinh3122m000)** session, or look up an inventory inspection in the **Warehouse Inventory Inspections Overview (whinh3122m200)** session.
- 2 Select the inspection.
- 3 On the toolbar, click the **Handling Unit Tree**.
- 4 In the **Handling Unit Tree**, you can:
  - Approve or reject an entire handling unit including its children, if present.
  - For bottom handling units only, approve, reject, or destroy the items contained.

### Approve or reject handling unit including children

- 1 In the **Handling Unit Tree**, select the handling unit.
- 2 On the toolbar, click **Approve Remaining** or **Reject Remaining**. If you click **Reject Remaining**, select a reject reason in the dialog box that is displayed.
- 3 Save and close the **Handling Unit Tree**.

### Approve, reject, or destroy bottom-level handling units

- 1 In the **Handling Unit Tree**, select the handling unit.

- 2 From the *appropriate menu*, select **Inspect Handling Unit** to open the **Inspect Handling Unit (whinh2234m000)** session.
- 3 Specify the quantities to approve, reject, or destroy. If you reject or destroy items, enter a reject or destroy reason.
- 4 Save and close the **Inspect Handling Unit (whinh2234m000)** session.
- 5 Save and close the **Handling Unit Tree**.

### Approve, reject, or destroy bottom-level handling units for specific stock point details

- 1 Do either of the following:
  - In the **Inspect Handling Unit (whinh2234m000)** session, click **Stock Point Details**.
  - In the **Handling Unit Tree**, select **Stock Point Details** from the *appropriate menu*.
- 2 In the **Handling Unit Stock Point Details (whwmd5136m000)** session that opens, specify the quantities to approve, reject, or destroy. If you reject or destroy items, enter a reject or destroy reason.

**Note:** If the items in the handling unit are high volume serialized, and the handling units correspond to multiple inspection lines, you must register the serial numbers before specifying the inspection results. This applies to inbound and outbound inspections. See Serial registration for inspection handling units.

## Alternative ways to specify inspection results for handling units

To specify inspection results for handling units, you can also:

- 1 Look up an inbound or outbound inspection in the **Warehouse Inspections Overview (whinh3122m000)** session, or look up an inventory inspection in the **Warehouse Inventory Inspections Overview (whinh3122m200)** session.
- 2 Do one of the following:
  - On the toolbar, click **Warehouse Inspection Handling Units** and in the **Warehouse Inspection Handling Units (whinh2534m000)** session, select the relevant handling unit and on the toolbar, click one of the following:
    - **Inspect Handling Unit**
    - **Handling Unit Tree**
    - **Approve Remaining**
    - **Reject Remaining**
  - Look up an inbound or outbound inspection in the **Warehouse Inspections Overview (whinh3122m000)** session, select the inspection and start the **Warehouse Inspection (whinh3622m000)** session
  - Look up an inventory inspection in the **Warehouse Inventory Inspections Overview (whinh3122m200)** session, select the inspection and start the **Warehouse Inventory Inspection (whinh3622m200)** session.
  - In the **Handling Units** tab of either session, select a handling unit.
  - On the toolbar, click **Handling Unit Tree**.
- 3 Continue as described in How to specify inspection results for handling units.

## Scrapping and rejecting handling units during warehouse inspection

If part of a handling unit is rejected in inspection, the rejected quantity is taken out of the handling unit and handled anonymously. The rejected quantity is removed through an inventory adjustment order.

If quarantine handling is activated, for the rejected part in quarantine no handling unit is present.

Handling units that are entirely scrapped in inspection are set to **Closed**. The items contained in these handling units are removed through an inventory adjustment order.

If part of a handling unit is scrapped during inspection and the remaining part is rejected, the scrapped part is removed from the handling unit and the rejected part is quarantined anonymously. The handling unit is set to **Closed**.

**Note:** Partial scrapping is only allowed for bottom-level handling units.

## Serial registration for inspection handling units

For each *high volume* serialized item that requires inspection, and each *low volume* serialized item if the Consolidate Stock Points in one Warehouse Inspection check box is selected, LN creates a separate inspection line. If handling units are present for such inspection lines and you specify inspection results for these handling units, LN updates the inspection results on the inspection lines.

However, if no serial numbers are present for the handling units, LN cannot determine the inspection lines on which to update the inspection results in situations as described in the following examples. In such cases, a message is displayed prompting you to register the serials before entering the inspection results.

### Example

Inspection INS00001 has the following inspection lines:

Inspection Line	Serial	Approved	Destroyed	Rejected
1	S1	0	0	0
2	S2	0	0	0
3	S3	0	0	0
4	S4	0	0	0
5	S5	0	0	0
6	S6	0	0	0

Each inspection line has 1 *high volume* serialized item. For INS00001 handling unit HU001 is present, which has two child handling units: HU002 and HU003, each of which contain 3 serialized items. If you decide to

reject HU002 entirely, LN cannot determine to which inspection lines the rejected items must be updated. Therefore, you must first register the serial numbers for HU002.

If you generate serials S1, S2, and S3 for HU002 and then reject these items for HU002, LN updates the inspection lines as follows:

Inspection Line	Serial	Approved	Destroyed	Rejected
1	S1	0	0	1
2	S2	0	0	1
3	S3	0	0	1
4	S4	0	0	0
5	S5	0	0	0
6	S6	0	0	0

If you then decide to approve HU003 entirely, registering the serial numbers for HU003 is not required, because LN can determine that all of the remaining inspection lines must be approved. When you process the inspection, inspection lines 4, 5, and 6 will be updated:

Inspection Line	Serial	Approved	Destroyed	Rejected
1	S1	0	0	1
2	S2	0	0	1
3	S3	0	0	1
4	S4	1	0	0
5	S5	1	0	0
6	S6	1	0	0

### Example

Inspection INS00002 has the following inspection lines:

Inspection Line	Lot	Serial	Approved	Destroyed	Rejected
1	L1	S1	0	0	0
2	L1	S2	0	0	0
3	L1	S3	0	0	0
4	L2	S4	0	0	0
5	L2	S5	0	0	0
6	L2	S6	0	0	0

Each inspection line has 1 item which is *high volume* serialized and *low volume* lot controlled. For INS00002 handling unit HU004 is present, which has two child handling units: HU005 and HU006.

HU005 contains lot L1 with 3 serialized items, HU006 contains lot L2, also with 3 serialized items.

If you approve HU005 entirely and reject one item of HU006, LN cannot determine to which inspection lines the approved and rejected items must be updated. Therefore, you must first register the serial numbers for HU005 and HU006. If you then approve HU005 and reject S in HU006, you cannot process INS00002, because in HU006 there are still two items without inspection results. Processing an inspection is not allowed if one of its bottom level handling units has a quantity not approved, rejected, or destroyed.

## To process handling unit inspection results

Partial inspections are manually processed in the **Warehouse Inspections Overview (whinh3122m000)** session or the **Warehouse Inspection (whinh3622m000)** session for inbound or outbound inspections.

After processing, rejected or destroyed handling units are unlinked from the handling unit structure. Rejected handling units obtain the **Quarantine** status if the quarantine functionality is activated, otherwise these handling units obtain the **closed** status. Destroyed handling units obtain the **closed** status.

When you process a partial inspection, the handling units for which no inspection results were specified are unlinked from the handling unit structure and a new inspection is created for these handling units.

However, processing an inspection is not allowed if a corresponding bottom-level handling unit has an unspecified quantity and an approved quantity. In such cases a message is displayed and you must specify the entire quantity and process the corresponding inspection handling units.

If the bottom-level handling unit has an unspecified quantity and a rejected or destroyed, but no approved quantity, processing the inspection is allowed. In such cases the destroyed and rejected quantities are removed from the handling unit and processed anonymously, that is, outside the handling unit. The unspecified quantity stays in the handling unit, for which LN creates a new inspection sequence.

If a handling unit is partly approved and partly rejected or destroyed, after processing the destroyed or rejected quantity is removed from the handling unit and processed anonymously.

For further information on processed inspections, refer to Warehousing inspections after processing.

## Inspection handling-unit structures in the Handling Unit Tree

The inspection lines of an inspection do not correspond directly with the handling units present for an inspection. The handling unit structure of an inspection is determined by:

- The quantity of the items to be inspected
- The package definition used

- If no package definition is used, a manually created handling unit structure.
- The stock points present for the quantities to be inspected

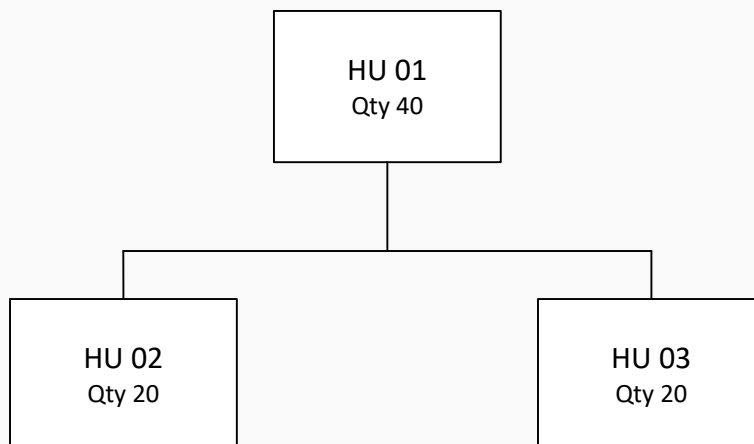
The handling units of an inspection are displayed in the **Warehouse Inspection Handling Units (whinh2534m000)** session. If a handling unit structure is present, the top-level handling unit of the handling unit structure is displayed in the **Warehouse Inspection Handling Units (whinh2534m000)** session. Depending on the total quantity of items to be inspected and the package definition used, more than one instance of a handling unit structure can be present for an inspection. In such cases, an extra top-level handling unit is superimposed on the instances of the handling unit structure present, as shown in the following example.

#### Example

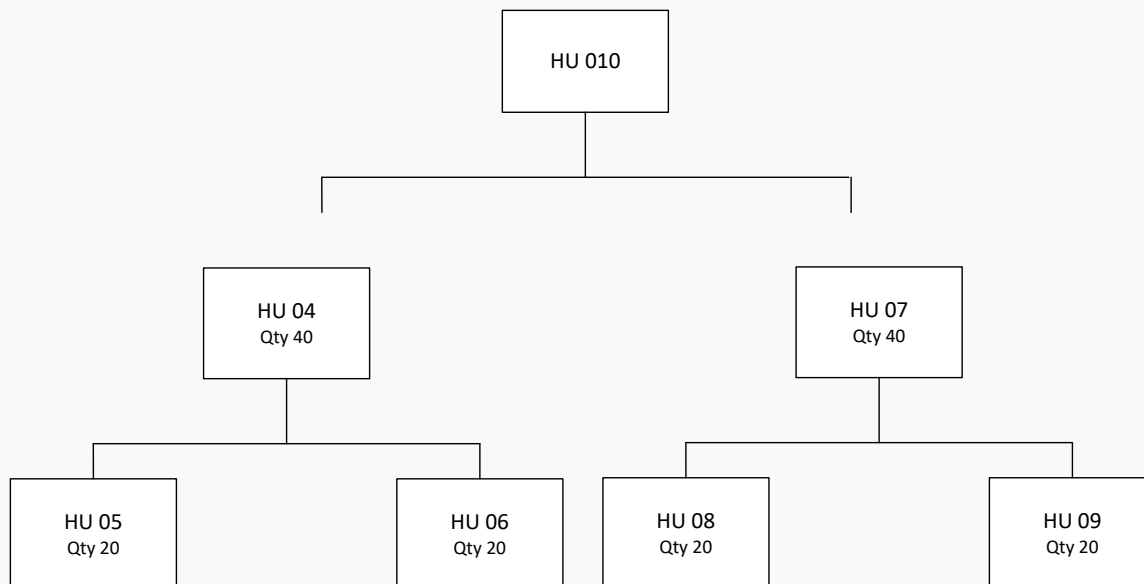
Inspection INS0001 uses package definition PD01 to create handling units. PD01 is set up as follows:

Node	Packaging Item	Packaging item quantity	Item quantity
1	Pallet	1	-
2	Box	2	40 pcs, 20 pcs per box

Inspection INS0001 has a total quantity of 40 items to be inspected. The resulting handling unit structure is:



Handling unit HU 01 is displayed in the **Warehouse Inspection Handling Units (whinh2534m000)** session. Inspection INS0002 also uses package definition PD01. Inspection INS0002 has a total quantity of 80 items to be inspected. The resulting handling unit structure is:



Because the total number of items to be inspected exceeds the maximum quantity that can be contained in package definition PD01, LN creates another instance of the handling unit structure. That is, an additional pallet with two boxes. For such additional instances, no packaging information is present, and no labels are printed. Handling units HU 04 and HU 07 are displayed in the **Warehouse Inspection Handling Units (whinh2534m000)** session.

In addition, LN superimposes top handling unit HU 010 on HU 04 and HU 07. This is to keep all handling units of INSP0002 together in a single handling-unit structure, which would otherwise have consisted of two separate structures under HU 04 and HU 07. HU 010 is not shown in the **Warehouse Inspection Handling Units (whinh2534m000)** session, but is visible in the **Handling Unit Tree**.

Therefore, if you select handling unit HU 04 in the **Warehouse Inspection Handling Units (whinh2534m000)** session and open the **Handling Unit Tree**, the entire structure from HU 010 onwards is displayed. If you select HU 01 for INS0001 in the **Warehouse Inspection Handling Units (whinh2534m000)** session, HU 01 is the top handling unit of the entire structure.

## Chapter 6: Setup

### Warehouse inspections - setup

Inspections can be defined in Warehousing, Purchase Control, and in Quality. This topic discusses inbound and outbound inspections. See Inventory inspections for information about inventory inspections.

#### Inbound inspections

- If your warehouse is location-controlled, a location of the **Inspection** type must be specified for your warehouse. In the **Warehouses (whwmd2500m000)** session, you can specify whether a warehouse is location-controlled. In the **Warehouse - Location (whwmd3100s000)** session, you can specify the locations of the warehouse.
- An inspection procedure must be specified for the warehousing order lines of the received goods. The first activity of the inspection procedure must be the **Warehouse Inspections Overview (whinh3122m000)** session.
- For purchased items, the **Inspection** check box in the **Purchase Order Lines (tdpur4101m000)** session must be selected. To select this check box by default, or to make this check box available, select at least one of the following check boxes:
  - The **Inspection** check box in the **Item - Purchase** session
  - The **Inspection** check box in the **Items - Purchase Business Partner (tdipu0110m000)** session
  - The **Inspection** check box in the **Ship-from Business Partner (tccom4121s000)** session

#### Purchase Control settings overrule Warehousing and Quality settings

The settings of the **Inspection** check box in the **Item - Purchase** and the **Items - Purchase Business Partner (tdipu0110m000)** session overrule the inspection settings of the applicable warehousing order types and the testing combinations specified for items in Quality. See Quality Management - Warehousing inspection integration.

If these check boxes are selected while no inspection procedure is specified for the warehousing order type, an inbound inspection is created nevertheless. Conversely, if these check boxes are cleared, and an inspection procedure is specified for the warehousing order type, no warehouse inspection is generated.

Similarly, if these check boxes are cleared and testing combinations are present for the items, no inspections are generated.

#### Outbound inspections

- Define an outbound procedure for the relevant outbound orders.



- The last activity of the outbound procedure must be the **Warehouse Inspections Overview (whinh3122m000)** session.

### Inbound and outbound - stock point details

To determine how inspections and inspection lines are created for *low volume* lot or serialized items, LIFO/FIFO items, or items contained in multiple handling units, select or clear the **Consolidate Stock Points in one Warehouse Inspection** check box in the **Inventory Handling Parameters (whinh0100m000)** session.

### History data

To store history data about inbound inspections, outbound inspections, or inventory inspections, select the **Inspection History** check box in the **Inventory Handling Parameters (whinh0100m000)** session.

## Warehouse inspections and order origin

In Warehousing, inspections are possible for all order origins, including manual orders, and for items stored in inventory. This topic discusses inbound and outbound inspections. See Inventory inspections for information about inventory inspections.

In Quality, however, no inspection orders can be created for the following (manual) order origins:

- **Sales (Manual)**
- **Service (Manual)**
- **Maintenance Sales (Manual)**
- **Maintenance Work (Manual)**
- **JSC Production (Manual)**
- **ASC Production (Manual)**
- **Transfer (Manual)**
- **Project (Manual)**
- **Purchase (Manual)**

If the warehouse inspection activity is part of the order type, this activity must be added as an order step for the applicable order origin, when users create activities in any of the following sessions:

- **Activities by Warehousing Order (whinh2104m000)**
- **Activities by Inbound Order Line (whinh2114m000)**
- **Activities by Outbound Order Line (whinh2124m000)**

If, for example, a manual inbound order line or transfer order line is received (and put away), a warehouse inspection line must be created.

Inbound warehouse inspections can be approved, rejected or destroyed, whereas outbound warehouse inspections can only be approved or rejected.

The following should be taken into account:

- Rejections for **Purchase (Manual)** orders are handled in the same way as for **Purchase** orders and **Purchase Schedule**. For these order origins the original receipt transaction is reversed. For all other order origins rejections are handled by creating an *adjustment order* for the rejected quantity.
- The usage of **Quarantine Inventory Overview (whwmd2171m000)** session is based on the parameter settings.
- LN handles the rejected inventory against the specification as determined in the original purchase order and purchase order line.

As a result, handling rejected inventory is not possible for **Purchase (Manual)** orders, because:

- There is no purchase (return) order for returning the rejected inventory.
- Destroying can be performed directly from the warehouse inspection.

The following table summarizes handling of destroyed or rejected inventory and is applicable if the Quarantine Inventory check box is not selected in the **Inventory Handling Parameters (whinh0100m000)** session and the inventory is inspected in a regular process which is Approve or Scrap, based on order origin.

Order Origin	Inbound Inspections		Outbound Inspections
	Destroy	Reject	Reject
<b>Purchase</b>	Adjustment order	Reverse original order	Adjustment order
<b>Purchase Schedule</b>			
<b>Purchase (Manual)</b>			
Other origins	Adjustment order	Adjustment order	Adjustment order

## Chapter 7: Quality Management

### Quality Management - Warehousing inspection integration

If Quality inspections are applicable to an item, order, or business partner, both Quality inspections and Warehousing inspections are involved in the inbound and/or outbound inspection process.

In the **Quality Management (QM)** field of the **Implemented Software Components (tccom0100s000)** session, you can specify whether Quality is implemented. In the **Quality Management Parameters (qmptc0100m000)** session, you can specify the order origins for which you want to use Quality.

If Quality inspections are implemented and the **Consolidate Stock Points in one Warehouse Inspection** check box is selected in the **Inventory Handling Parameters (whinh0100m000)** session, the Quality inspection is created after the warehousing inspection is created and the entire order line for which the inspection was created has been:

- Inbound  
Put away in the inspection location, or, if no locations are used, the receipt of the entire order line is confirmed.
- Outbound  
Picked.

If the **Consolidate Stock Points in one Warehouse Inspection** check box is cleared (and Quality inspections are implemented), the Quality inspection is created after the warehouse inspection is created. The warehouse inspection is created the moment part of the order line quantity is put away, confirmed or picked.

The Quality inspection is also created if the user clicks **Set In Process** in the **Warehouse Inspections Overview (whinh3122m000)** or **Warehouse Inspection (whinh3622m000)** session.

If the QM Overrides Warehouse Inbound Order Type check box is selected in the **Warehouses (whwmd2500m000)** or the **Item Data by Warehouse (whwmd2510m000)** session, and testing combinations are available, inspections are created in Quality and Warehousing, even if no warehousing inspection procedure is present. Testing combinations are specified in the **Testing Combinations (qmptc0119m000)** session. See Quality settings determine inbound inspections.

The settings in the **Testing Combinations (qmptc0119m000)** session determine whether the Quality inspections are leading in the inspection procedure. If yes, Quality inspection results are updated on the warehouse inspection and the warehouse inspection is processed when the Quality inspection is processed.

If no, the Quality inspection results are inserted as default values in the **Warehouse Inspections Overview (whinh3122m000)** or **Warehouse Inspection (whinh3622m000)** session. The user can adjust these results and process the warehouse inspection, which will also process the Quality inspection.

### Effectivity units and Engineering revisions

If Quality is used, LN creates a separate inspection for each combination of effectivity unit and engineering revision, regardless of the setting of the **Consolidate Stock Points in one Warehouse Inspection** check box. This is because Quality determines the test combinations for each combination of effectivity unit and engineering revision, and therefore requires an order inspection for each combination.

### Multiple ownership handling

Quality does not store ownership data. Therefore, Quality inspection results could be updated to the wrong Warehousing inspection line if a warehousing inspection has multiple ownership records. To prevent this, a warning is displayed when Quality updates the inspection results on the Warehousing inspection. The user is then allowed to adjust the Warehousing inspection lines. This also applies if Quality is leading.

## Quality settings determine inbound inspections

Inbound inspections can be defined for Purchase Control, Quality, and Warehousing.

The QM Overrides Warehouse Inbound Order Type checkbox in the **Warehouses (whwmd2500m000)** or the **Item Data by Warehouse (whwmd2510m000)** session determines whether the Quality settings overrule the Warehousing settings, or vice versa, when creating inbound inspections.

The inspection settings for purchased items in Purchase Control overrule the Quality or the Warehousing settings. See Warehouse inspections - setup.

### QM Overrides Warehouse Inbound Order Type

The **QM Overrides Warehouse Inbound Order Type** check box and the inspection settings in Quality and Warehousing are used to determine how inbound inspections are created.

#### If the QM Overrides Warehouse Inbound Order Type check box is selected

Testing combination	Inspection procedure	Inbound inspection
X	X	Generated in Quality and in Warehousing
X		
	X	Generated in Warehousing
		No inbound inspection

#### If the QM Overrides Warehouse Inbound Order Type check box is cleared

Testing combination	Inspection procedure	Inbound inspection
X	X	Generated in Quality and in Warehousing
X		No inbound inspection

Testing combination	Inspection procedure	Inbound inspection
	X	Generated in Warehousing
		No inbound inspection

### Legend

Testing combinations	Testing combinations are specified in the Testing Combinations (qmptc0119m000) session.
Inspection procedures	A <i>warehousing procedure</i> . See To define warehousing procedures

## Order inspections

Order Inspections comprises of inspection orders that are used to structure the inspection of products that are purchased, produced, transferred, or sold. For products in inventory, a storage inspection order instead of a standard inspection order is used.

The standard inspection process:

- 1 Inspection orders are created automatically by means of predefined testing combinations, but you can also manually add, delete, or maintain inspection orders based on the origin of the order (refer to the **Order Inspections (qmptc1120m000)** session).
- 2 For each inspection order, you can create different samples with different sample sizes and different dates and time in the **Inspection Order Samples (qmptc1110m000)** session. LN checks if the total of all samples matches the sample size.
- 3 Enter the test data in the **Inspection Order Test Data (qmptc1115m000)** session (by characteristic). The session in which you enter the test data depends on the settings in the **Quality Management Parameters (qmptc0100m000)** session. When the test data is entered, the LN generates the overall results defined for that specific characteristic.
- 4 Complete Inspection collectively by order, origin, or storage using the **Complete/Process Order Inspections (qmptc1202m000)** session. If an inspection order is completed, LN checks if the test data is specified. If not, the inspection order cannot be completed.
- 5 Inspection orders can be processed by inspection order, by origin, and by storage inspection. LN determines the pass and the fail pieces in the sample size. Based on this evaluation, LN calculates the actual accepted and rejected quantities. These accepted and rejected quantities are compared with the acceptable quality level (AQL) specified in the **Test Groups (qmptc0136m000)** details session. If the percentage of accepted quantity is less than the AQL, the entire order or lot is rejected. In case of continuous sampling, the part of the order displayed in the **Frequency** field is rejected.

If an algorithm is defined for a characteristic, this algorithm is calculated during inspection. Each algorithm is calculated only when the variables (characteristics) required for that algorithm are specified.

## Storage inspections

Storage inspections are quality inspections for items in inventory. If a storage inspection is generated for the selected items, these items are blocked for use and are regarded as inventory on hold.

**Note:** If the **Inventory Inspection** check box is selected for an item and warehouse combination in the **Item Data by Warehouse (whwmd2510m000)** session, the Quality storage inspection functionality is unavailable. Instead, you can perform inventory inspections. See Inventory inspections for information about inventory inspections.

### Procedure for storage inspections

- 1 Generate storage inspections in the **Generate Storage Inspections (qmptc2220m000)** session. You can generate storage inspection orders based on item, warehouse, location, lot, business partner, and date. LN uses the testing combination and standard test procedure for the default inspection data.
- 2 Use the **Storage Inspections (qmptc2120m000)** session to view the storage inspections that you generate in the **Generate Storage Inspections (qmptc2220m000)** session.
- 3 Use the **Storage Inspection Inventory (qmptc2130m000)** session to allocate the lot(s), the warehouse(s), and the items that must be inspected for this inspection order.
- 4 Use the **Storage Inspections (qmptc2120m000)** session to display the storage inspection orders that are created by default. In this session you can also modify storage inspection orders or create new storage inspection orders.
- 5 Use the **Inspection Order Lines (qmptc1101m000)** session to display, modify, or create inspection order lines. The inspection order lines indicate how an item is tested.
- 6 Use **Inspection Order Samples (qmptc2110m000)** session to create different samples with different sample sizes and different dates and times for each inspection order. LN checks if the total of all the samples matches the sample size.
- 7 Enter the test data in the **Inspection Order Test Data (qmptc1115m000)** session by characteristic. When the test data is specified, LN generates the overall results defined for that specific characteristic.
- 8 Process the inspection orders using the **Complete/Process Order Inspections (qmptc1202m000)** session. ERP determines the 'good' and the 'bad' pieces in the sample size. Based on this, ERP calculates the actual accepted and rejected quantities. These accepted and rejected quantities are compared with the acceptable quality level (AQL), entered in the **Test Groups (qmptc0136m000)** session. If the percentage of accepted quantity is less than the AQL, the entire order or lot is rejected.
- 9 Use the **Close Storage Inspections (qmptc2221m000)** session to close the orders with the status processed. ERP checks for all processed storage inspections and unblocks all inventory.

## Order specific test procedures

Inspection orders are used to structure the inspection of products. The orders are generated based on testing combinations. The inspection process for items with testing combination is the same.

LN also allows you to define order-specific test procedure. Order-specific test procedure data is the copied testing combination (that is, standard inspection data) that you can modify and change for a specific order in a specific scenario.

The order-specific inspection order is now generated. The rest of the inspection procedure is the same as that described from step 2 (drawing samples) in the Order inspections online manual topic.

### Process to generate order specific test procedures

- 1 Specify order origins and the related orders details in the **Order Specific Test Procedures (qmptc0149m000)** session.  
**Note:** To implement order-specific inspections if you select one or more Order-Specific Inspection Data check boxes in the Quality Management Parameters (qmptc0100m000) session. These parameters indicate, per origin, whether or not order-specific inspection data can be defined for a specific origin order.
- 2 Start the **Order Specific Inspections (qmptc0150m000)** session from the **Order Specific Test Procedures (qmptc0149m000)** session. You can change, add, or delete order-specific inspection orders in the **Order Specific Inspections (qmptc0150m000)** details session.
- 3 Start the **Order Specific Inspection Lines (qmptc0151m000)** session from the **Order Specific Inspections (qmptc0150m000)** session. You can now define the order-specific inspections lines. Each line represents a characteristic that was defined in the **Test Group Characteristics (qmptc0137m000)** session.

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