IFS Aviation Maintenance

Supply Chain

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Part Control

Part Control involves assigning part numbers and updating part layers to ensure accurate tracking and organization.

New parts are created in the solution configuration module called Allowable Configuration. Serialized items will typically be created by configuration engineers and consumable or expendable parts will typically be created by store managers.

1.1Create a Consumable Part

A Configuration Engineer or System Engineer can create a new part in CAMO module so it is available for use in maintenance, purchasing, and warehousing.

The aim is to keep information correct and up to date without needing repeated manual intervention.

1.1.1Selecting or Creating a Part Group

On the *Part Group Search* page, use the search bar to locate an existing Part Group. If no group exists, click *New Part Group*.

Use the *Modify Change Source* option and click *OK*. This action will enable you to create a new part or add an existing part to the Part Group.

On the *Alternative* tab, click *New Part*. Next, enter the following information on the *Part Details* Page:

- OEM Part No
- Part Name
- Manufacturer

Select OK once completed.

For more information, refer to the Tooling Management section of this document.

1.1.2Selecting or Creating a Tool Part Group in Allowable Configuration

Use the search bar to locate an existing Part Group (TSE assembly). If no part group exists, click *New Part Group*.

Use the *Modify Change Source* option and select *OK*. This action will enable you to create a new part or add an existing part to the Part Group.

On the Alternate tab, click *New Part*. Next, On the *Part Details* page, enter the following information:

- OEM Part No
- Part Name
- Manufacturer

Confirm the details by selecting *OK*.

For more information, refer to the Tooling Management section of this document.

1.2SOS Functionality

The essence of SOS is to determine whether the issue with the malfunctioning part removed during maintenance was resolved.

1. If it was resolved by removing the inventory and installing a new one, then the removed component was faulty and needs to be shipped to the vendor for repair.
2. If the issue was not resolved, it means the root cause was not the removed component and is likely something else. After the removed component is inspected, it can be returned to the shelf. To perform this action, the technician needs to know whether the part is SOS applicable.In this approach, SOS status is managed through the Part Class field in the Engineering Part section.

The Part Class field in the Engineering Part setup defines SOS applicability as follows:

- **SOS - YES**: SOS applicable part
- **SOS - NO**: SOS non-applicable part

When a new part is created, the Part Class field in the Engineering Part setup defines SOS applicability.

1.3New Part Number Board

Once a new part is created through Engineering or Stores, Material Controllers are notified via their landing lobby, where a dedicated lobby element displays the count of newly created parts. Selecting this element opens the New Part Number Board.

The *New Part Number Board* displays the list of recently created parts along with details such as the created date and overall status.

Once new part numbers are created, it is recommended for supply chain users to complete these records with critical information:

- A *Purchasing Agent* will typically provide the following information on the purchase part record: list of vendors/suppliers (purchase, repair, borrow, exchange), the agreed price, and shipping lead time. Once updates are done, the part number record on the board should be marked as 'Purchase Info Update'.
- A *Storeroom Clerk* will typically provide the following information on the inventory part record: warehouse BIN in which the part must be stored, Inspection controls and stock-related information. Once updates are done, the part number record on the board should be marked as 'Store Info Update'.
- A *Configuration Enginee*r reviews all Engineering data on the Aviation Part page.

The created part will be displayed on the Part Control Board and can also be checked through the respective part layers.

Parts can be in either of the statuses listed below. However, when a new part is created, its initial status will be Pending.

- **Completed**: All required information has been updated.
- **Partially Updated**: Only some of the information has been updated.
- **Pending**: The part has been created, but updates are yet to be made.
- **Not Created**

2
Repair Routing

When a part is removed from an aircraft during maintenance, it must be transferred from the maintenance site back into defined warehouse locations. These locations are typically split into:

- Serviceable Staging.
- Unserviceable Staging.

From there, the part can be routed for further action: internal repair, external repair, return to serviceable stock, or quarantine.

The *Component Returns* page is the central workspace where Repair Routers, Runners, and Storeroom Clerks manage the flow of parts that are removed during a maintenance visit. It provides visibility into both actual returns (parts that have already been removed) and expected returns (parts that are anticipated to be removed based on issued inventory). In practice, it acts as a staging area for both serviceable and unserviceable components and serves as the starting point for repair routing activities.

2.1Creating Expected Returns

ICAM automatically generates expected returns for repairable parts. For example, when repairable inventory is issued to fulfill a material requisition, the solution anticipates that a part of the same part number or valid alternate will be removed from the aircraft and returned to the warehouse. To track this, ICAM creates an expected return record on the *Component Returns* page.

- If the installation has occurred but the removal has not yet been recorded, the record shows only information about the issued inventory:
  - Work Package No
  - Task Barcode
  - Site
  - Part Number

- Aircraft
- Planned Quantity
- UoM (Unit of Measure)
- SOS information

- Once the removal is recorded, the record is updated to display details of the removed part:
  - Work Package No
  - Line No
  - Task No
  - Task Barcode
  - Site
  - Part No
  - Serial No
  - Lot/Batch No
  - Aircraft
  - Removal Reason
  - Removal Date

- Once the part is returned to the inventory, the record displays the following detaisl:
  - Condition Code
  - Operational Condition
  - Part Availability Control,
  - Quantity Returned,
  - Location No
  - Location Description
  - Inventory Value

This creates a clear link between the issued inventory and the expected return, ensuring traceability and accountability.

2.2Routing Based on Removal Reason

The next step depends on why the part was removed. The removal reason determines whether the part is considered serviceable or unserviceable and how it should be routed. For example:

- If the part was removed for access, stagger, or swap, it is usually still serviceable and can be placed back into a serviceable bin or even reinstalled later.

- If the part was removed due to an unscheduled removal, scheduled removal or found to be faulty, it is considered unserviceable. These parts are staged in an unserviceable location (often tagged as Repair Required or REPREQ) until the Repair Router or Clerk decides the next step.

Based on the removal reason, the system automatically updates the operational condition for TRK, SER, and ASSY parts. Stores personnel can then move components in different locations with Move to Serviceable Location or Move to Unserviceable Location buttons to place the components in the correct warehouse location.

Each warehouse location is governed by predefined Part Availability Controls, which enforce rules on what inventory transactions are allowed. These controls ensure that only appropriate actions—such as issuing, reserving, or routing parts—can be performed depending on whether the item is serviceable, unserviceable, or restricted.

Removal Reason Code	Description	Part Availability Control	Serial Operational Condition
VENDRET	Return to Vendor	RFI	Operational (Serviceable)
UNSCHED	Unscheduled Removal	REPREQ	Non Operational Unserviceable
ACCESS	Removed for Access	RFI	Operational (Serviceable)
ROB	Rob Serviceable Component	RFI	Operational (Serviceable)
STAGGER	Removed Serviceable for Stagger	RFI	Operational (Serviceable)
SWAP	Component Swap	RFI	Operational (Serviceable)
COMPCONV	Remove Serviceable	RFI	Operational (Serviceable)
SCHDLED	Scheduled Removal	RFI	Operational (Serviceable)
SOS	Ship or Shelf	REPREQ (to be moved to QUAR)	Non Operational Unserviceable

2.3Repair Routing Options

For unserviceable components, Repair Routers review the staging area and determine the appropriate routing action:

- **Internal Repair**: A Component Repair Order (CRO) is created, and the repair is performed in-house using a shop order or disposition shop order.
- **External Repair**: An external service order is created through CRO, and the component is sent to an approved vendor.
- **Exchange**: The unserviceable component may be exchanged with a supplier for a serviceable replacement.
- **Quarantine**: If a part requires further review or non-repair actions before it can be released to service, it is moved into a quarantine location.

This workflow ensures that no component remains in staging indefinitely and that all unserviceable parts are routed to the right process.

2.4Using the Component Returns Page

For repair routers, runners, and storeroom clerks, the Component Returns page is more than just a list. It is a management tool. They can:

- Filter and search for returns by part number, work package barcode, task barcode, quantity to return, removal date, or removal reason etc.
- Return parts into serviceable or unserviceable locations as appropriate.
- Navigate directly to related inventory pages or create Component Repair Orders (CROs) from the same screen.
- View detailed part availability and operational condition information once returned.

By providing a clear link between maintenance actions (removals and installations) and supply chain processes (repairs, exchanges, and procurement), the Component Returns page keeps both maintenance and logistics teams aligned.

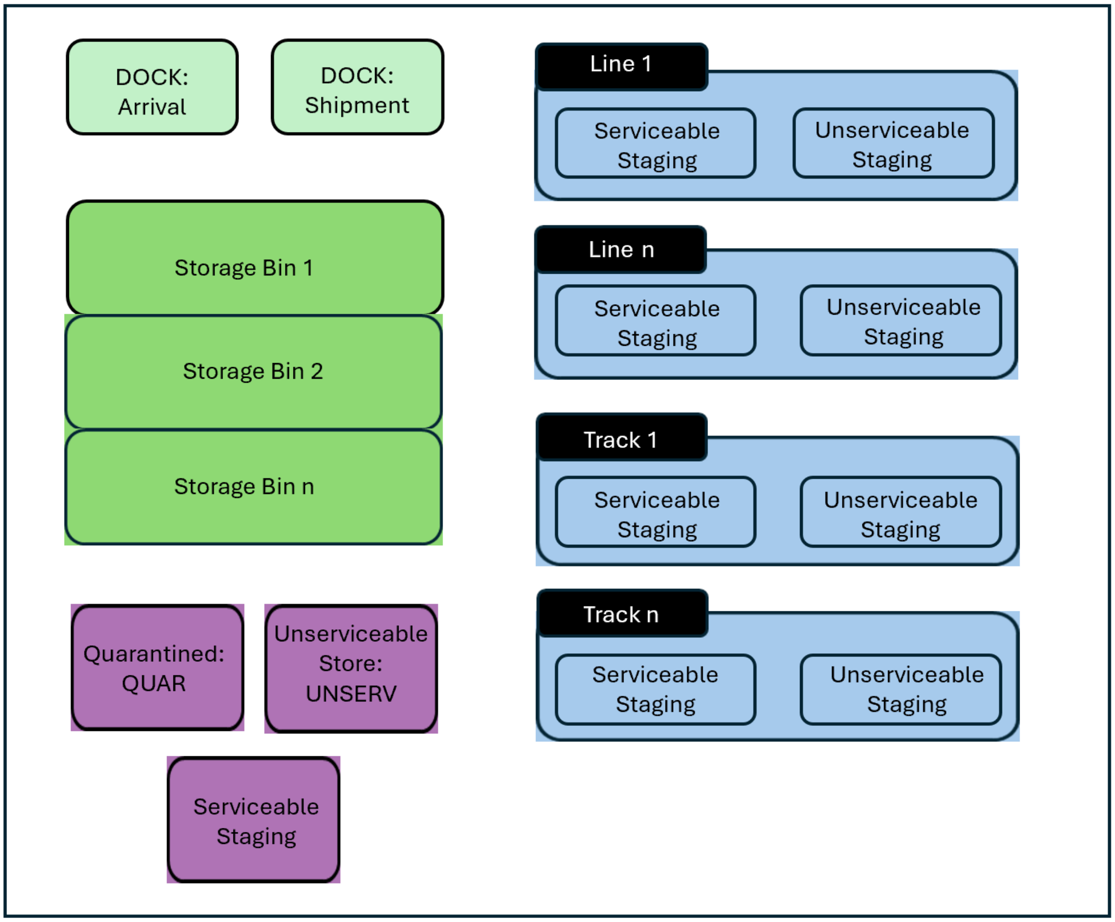
For more information on component repair routing, refer to the following:

Component Repair Order

3
Warehouse Management

The warehouse structure drives the efficiency of processes. IFS solution enables an organization to create a structure which matches closely with the physical organization of the warehouse space.

The diagram below presents a typical warehouse organization:



Mandatory

Requirements:

1. Maintain at least one general storage area (Store) where parts are ready for issue.
2. Maintain at least one bay/area to store quarantined components.
3. Maintain at least one location where unserviceable components are kept.
4. It is mandatory to have two dock locations in the system to track incoming and outgoing parts and movement workflows correctly. It is recommended to have one Arrival Dock and one Shipment Dock.
5. To effectively manage removed or unused parts during maintenance operations, it is mandatory to have two distinct locations for each maintenance area. This setup ensures clear tracking and staging of components throughout the process:
    a. Serviceable Staging Area: When a serviceable part is removed from an aircraft for various reasons (Rob for another aircraft, Swap, or simply removed to provide access to another area), it will be put in the serviceable staging area until it is issued back to the same or another aircraft. Unused part or material will be returned into stock later.
    b. Unserviceable Staging: Used to track items that have been removed from assemblies as unserviceable and are awaiting routing or further processing

3.1Receiving Process

The receiving process ensures accuracy, quality, and traceability from supplier to stock; once the arrival of a part is registered.

For more information, refer to the following:

Manual Match Incoming Receiving Advice: Type Arrived Goods

Manual Match Incoming Receiving Advice: Type Approved Goods

Step 1: Navigate to the *Register Arrivals* page.

Step 2: Select the arrival and click *Receive*.

Step 3: Ensure the following fields are populated – Received By, Actual Delivery Date, Actual Arrival Date.

Step 4: Ensure the relevant toggles are turned on in the Print section (Example, Print Barcodes).

Step 5: Ensure the correct part is selected and click *OK*.

3.2QC Control Process

QC Control ensures that products meet defined standards throughout their lifecycle—from procurement to delivery. It acts as a safeguard for operational integrity, customer satisfaction, and regulatory compliance. It involves receiving goods and conducting quality checks, supplier quality management, lot and serial tracking etc.

For more information refer to the following:

About - Control Plan

Process Model - Control Plan

Process Model - Quality Assurance

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3.3Putaway Process

Inventory Putaway

3.4Cycle Counting Process

The cycle counting process is a method of regularly verifying inventory accuracy by counting selected items on a recurring schedule. This helps maintain inventory accuracy and uncover discrepancies without disrupting operations.

Step 1: Navigate to the Inventory Part page. Step 2: Navigate to the Main tab and select the required Cycle Interval. Step 3: Enable the Cycle Counting toggle.

3.5Shipping Process

Inspect and Move to Shipping

Ship Goods and Assets

Material Preparation

3.6Issue and Transfer to Maintenance Locations

Parts can be moved between inventory locations in five different ways. The method to use depends on the situation and the kind of move that should be performed.

Please refer to *Moving Parts between Locations*

For more information, refer to the following:

Issue Material from Inventory, Casual

Shop Order Material Issue

Inventory Locations and Warehouse Structure

Move Parts from Arrival to QA

Move From Stock to QA

Handle Barcodes

Maintain Inventory

4

Demand Management

Demand Management refers to part requests being sent from CAMO Module and turned into maintenance material requisitions to be fulfilled.

While some maintenance tasks will generate one or multiple material requirements, some tasks will have none.

- For serialized items (inventory class=TRK or SER or KIT), one Maintenance Material Requisition Line is created with quantity =1.
- For non-serialized items (inventory class=BATCH), Maintenance Material Requisition for batch parts will carry the complete quantity. It could be divided into multiple lines throughout the Maintenance Material Requisition Line page depending on the availability through multiple batches.

4.1How do Demands Arise?

For a Maintenance Planner, a demand typically begins when a Work Package is created, and tasks are assigned to the work package. If tasks within the package require parts, the system generates material requisitions. These requisitions include details such as the location where the part is needed and the "Needed By" date. At times, technicians working on the aircraft may also request parts directly for their assigned Work Package, which feeds into the same demand process.

Once a material requisition is created, the Material Controller takes over. Their responsibility is to ensure the demand is fulfilled in the most efficient way possible:

- If the part is in local stock, they reserve it immediately.
- If it's not available locally but can be sourced from another station or airport, they arrange a remote reservation

- If neither option is possible, they initiate procurement from an approved vendor.

These processes happen through the Maintenance Material Requisitions page, which gives the controller a consolidated view of all requisitions—both open and fulfilled. From here, they can search, sort, and filter requests by urgency, location, aircraft serial number, or required date to prioritize what needs attention first.

4.2How are Material Requisitions Structured?

A requisition consists of a header and one or more lines.

- The header contains details that apply to the whole requisition (example, Work Package reference, task reference).
- Each line represents an individual part request.

A maintenance material requisition line has the following attributes:

- Order Number (Maintenance Material Requisition Header number)
- Maintenance Material Requisition Status.
- Quantity Required
- Unit of Measure
- Required Date
- Requisition Site
- Work Package Barcode
- Work Location (TRK or LINE)
- Task Barcode
- Task Number
- Work Package Number
- Work Package Status
- Work Location
- Aircraft Serial Number

4.3How are Demands Fulfilled?

- Local reservation: Involves reserving local stock at the airport/station in which the maintenance work is performed. This is the preferred option.
  - Alternate Part: When the available quantity of a required standard part is 0, an alternate part can be selected. Since alternate parts are aircraft specific, a part will have specified alternatives. This list is updated according to the aircraft that a work package is defined under.

- Remote reservation: Involves looking up available stock at a different airport/station when no local stock is available or local stock is fully reserved for other prioritized work.
- Supply Code: Defines how the required part will be sourced. Understanding the supply methods are important for Material Controllers, since not all part demands can be met from local inventory.

4.4Purchase Type

A purchase type specifies whether the procurement of the part will take place through an inventory order, purchase order, exchange, or external repair.

1. Inventory Order (default) – When a requisition line is created, the supply code is set to Inventory Order by default. This means the system expects the part to be provided from stock that is already available locally within the organization.
2. Purchase Order: If no stock is available, the supply code can be changed to indicate that the part must be purchased from an external supplier. The Purchase Type field then specifies how the procurement will be handled:
    a. Regular Purchase - A standard purchase order for all parts.
    b. Borrow – In some cases, a part may be borrowed from another operator, airline, or partner organization. The supply code can be set to Borrow to reflect that the part is temporarily sourced and must later be returned.
    c. The supply code can be set to Exchange, meaning a supplier or partner provides a replacement part in exchange for the unserviceable one being returned.
    d. Instead of buying a new component, the existing unserviceable one is shipped out to an approved repair vendor. Once repaired, it is returned to stock and made available again for use.

    This purchase types listed above, trigger the creation of a purchase requisition, which can later be converted into a purchase order.
3. Shipment Oder: When the required part is held in the network but located at a different site, the supply code can be set to Shipment Order. This creates a logistics request to transfer the part from the remote site to the requesting site. Material Controllers rely on this option when they know another site has available inventory that can be quickly shipped over.
4. Distribution order: If the part must be sourced from a different company within the same corporate group, the system uses a Distribution Order. Like a shipment order, it enables inter-company transfers while handling the necessary financial and logistical transactions between entities. This method is especially useful for large organizations with multiple subsidiaries or regional business units.

4.5Interchangeable Part Handling

Interchangeability is a feature that enables a standard part on a maintenance material requisition line to be substituted with a valid interchangeable part. An interchangeable part is one that meets the necessary specifications and can replace the standard part without impacting performance or compliance.

In this functionality, the starting supply code on a material line needs to be changed to a purchase order. Although it applies to the regular and borrow purchasing methods, it is not supported by: repair order and exchange order.

Taking into consideration the rules defined in CAMO, the allowed interchangeable parts are filtered.

4.6Initiating a Purchase Requisition

4.6.1Purchase Method: Regular Purchase

When the supply code in a material line is changed to a purchase order, a purchase requisition is generated automatically.

Through the Add/Change Interchangeable Assistant, all interchangeable parts related to the selected material line part can be viewed. These parts are classified as inventory–purchase parts and do not require an assigned supplier.

When an interchangeable part is selected to replace the prime (standard) part:

- A new material line is created for the selected interchangeable part.
- If multiple interchangeable parts are chosen, a separate material line is created for each part.
- These new lines are automatically added to the material requisition of the original line, with the supply code set to the purchase order.
- If a primary supplier exists for the selected interchangeable part, that supplier is updated as the Sender ID.

Interchanged lines cannot be edited or deleted. All modifications must be made through the Add/Change Interchangeable Assistant. The original line can still be modified, but only in accordance with its purchase order status. If only authorized purchase requisition exists, modifications must comply with the Purchase Requisition Authorization Rule; otherwise, an error will occur. Since interchangeable lines are connected to other objects, such as purchase requisitions and purchase orders, they cannot be directly modified. To change quantities, the related requisition or order must first be removed.

These conditions also apply when material lines contain mixed supply codes. Interchange lines cannot be edited if the original line's supply code is set to Purchase Order. In addition, Interchange Lines with the supply code Purchase Order cannot be edited, regardless of the original line's supply code.

4.6.2Purchase Method: Borrow Order

All the above-mentioned functionalities for the regular purchase order also apply to the Borrow Order Purchase Method when using the Interchangeable functionality on the Maintenance Material Requisition. The only difference is that the ownership type is Supply Loaned.

Since the Borrow Order Purchase Method is enabled only for serial-enabled parts with a quantity of 1, it is possible to perform a fully interchangeable operation only by using the Add/Change Interchangeable command.

Furthermore, the purchase method can be changed from the Material Line, provided that the Purchase Requisition status is not Closed.

4.7Initiating a Purchase Order

4.7.1Purchase Method: Regular Purchase

Once a purchase requisition is converted into a purchase order, the Interchangeable functionality operates in a specific way under the Regular Purchase method.

The Add/Change Interchangeable command can be applied at the Purchase Order line level when the line status is anything except Arrived, Received, Closed, Stopped, or Cancelled, and when no purchase order change order is already created or enforced.

If a Purchase Order originates from a material demand line, the Interchangeability function cannot be applied on the material line. In this case, part changes must occur to the Purchase Order. When the command is applied at the Purchase Order level, all related changes (such as line splitting) also update the original Material Requisition and the Purchase Requisition.

When a full interchange happens, the system sets the original line to Cancelled with quantity = 0. When a partial interchange happens, the system creates a new line, reduces the quantity on the original line, and sets its status to Released.

If partial arrival or receiving occurs on the original purchase order line, interchange remains possible for the remaining demand quantity. Only valid interchangeable parts for the selected item appear, and the list is restricted to parts from the same supplier as defined on the Purchase Order header.

If an item cannot be purchased via interchangeable parts, the Purchase Order line can be cancelled and the supplier updated in the Purchase Requisition. Alternatively, if the part exists in the inventory, all supply objects can be cancelled. This generates a supply code Invent Order line in the Material Requisition.

Note If the parent line's supply code is Purchase Order, sourcing is not possible - even if the interchanged line has supply code Invent Order.

Note If the parent supply code is Purchase Order and the interchanged part lines have Invent Order, those interchanged lines cannot be deleted from the Maintenance Material Requisition.

When the Interchangeable command is used on a Purchase Order, priority always follows the demand quantity, and line splitting aligns with it. Any quantity change made before splitting is ignored, as the demand quantity in the Maintenance Material Requisition takes precedence.

When lines are split from a Purchase Order through interchangeability, pegged quantities are also split accordingly in the Maintenance Material Requisition. Based on whether items are received into inventory or arrival, the pegged quantity updates. If partial receiving occurs and the Interchangeable command is applied afterward, pegged quantities are adjusted as follows:

- The Purchase Order quantity is updated.
- The Interchangeable command is applied.
- The pegged quantity splits accordingly in the Maintenance Material Requisition.

If the Purchase Order requires authorization, any split attempted afterward must still comply with existing Purchase Order Authorization rules, including amount thresholds.

4.7.2Purchase Method : Borrow Order

All the above-mentioned functionalities for the regular purchase order also apply to the Borrow Order Purchase Method when using the Interchangeable functionality on the Purchase Order. The only difference is that the ownership type is Supply Loaned.

Since the Borrow Order Purchase Method is enabled only for serial-enabled parts with a quantity of 1, it is possible to perform a fully interchangeable operation only by using the Add/Change Interchangeable command. This means that the demand from the material line will be used for the interchange.

4.8Purchase Order Change

4.8.1 Purchase Method: Regular Purchase

When a Purchase Order Change Order (POCO) is created for a Purchase Order (PO), the Interchangeable functionality follows specific rules when using the Regular Purchase Method.

Once a POCO is initiated, interchangeability is no longer available at the Purchase Order level. All modifications must be performed through the POCO interface. Within the POCO page, part order lines can only be interchanged when the header status is Planned. In all other statuses - Released, Authorized, PO Updated, or Cancelled - the Add/Change Interchangeable command is unavailable.

To ensure that changes made through the Add/Change Interchangeable command (such as line splitting) are reflected in the Purchase Order, Purchase Requisition, and Maintenance Material Lines, the POCO must be transitioned to the PO Updated status. When a quantity is fully interchanged at the POCO line level, the corresponding PO line reflects this upon conversion to PO Updated. In these cases, the original line is marked as Cancelled with a quantity = 0.

When interchangeability is applied through a POCO, line splitting is enabled. Only eligible parts from the same supplier as the Purchase Order header appear in the list; parts from other suppliers are not displayed.

As with other procurement modules, the POCO process prioritizes demand originating from the material line and performs line splitting accordingly. If a quantity modification is made at the POCO line level before interchangeability is applied, that modification is ignored. Once the Interchangeable command is used within a POCO, all relevant Purchase Order authorization rules continue to apply after the change is released.

4.8.2 Purchase Method: Borrow Order

All the above-mentioned functionalities for the regular purchase order also apply to the Borrow Order Purchase Method when using the Interchangeable functionality on Purchase Order Change Order. The only difference is that the ownership type is Supply Loaned.

Since the Borrow Order Purchase Method is enabled only for serial-enabled parts with a quantity of 1, it is possible to perform a fully interchangeable operation only by using the Add/Change Interchangeable command. This means that the demand from material line will be used for the interchange.

4.9Receiving Goods

4.9.1 Purchase Method: Regular Purchase

When the goods become available for receipt in the warehouse area, interchangeable parts can still be used, as long as the supplier has already delivered the applicable interchangeable parts for the given item. When the Purchase Order line status is anything other than Planned, Closed, or line quantity is 0, the user can use the Add/ Change Interchangeable command from Register Arrivals.

If a Purchase Order is created from a line demand generated from a task, the material controller cannot use the Add/Change Interchangeable command from the Material line. If a part change is needed during the arrival process, it must be performed by Register Arrivals.

When the user applies the Interchangeable command during the arrival process, the related changes (such as splitting) automatically update the original Material Requisition, Purchase Requisition, and Purchase Order. If any purchase order change order related functionality is used, it is also updated accordingly.

When the Interchangeable command is used in Register Arrivals, priority is always given to the demand quantity, and any splitting follows that quantity. If a quantity change is made before splitting, it is ignored—the demand quantity from the Maintenance Material Requisition is used instead. Depending on the receive case — whether it is received into inventory or receive into arrival — the pegged quantity should be updated accordingly, and if any partial arrival or partial receiving happens, it should be following the same concept.

When a full interchange occurs, the original line is set to Cancelled with the quantity of 0; the pegged quantity is updated accordingly, and it no longer appears on the Register Arrivals page. When a partial interchange occurs, a new line is created and displayed on Register Arrivals, since it is a newly added purchase order line with released status. This new line of information is also replicated to the Maintenance Material Requisition. The original line is updated with the reduced quantity and its status set to Released.

The user only sees a list of valid interchangeable parts for the selected part, and only the same supplier defined on the Purchase Order header, including when the command is used from Register Arrivals. Parts from other suppliers do not appear on this list.

When lines are split from Register Arrivals through the Interchangeable functionality, the pegged quantity is also split accordingly in the Material Requisition.

This is demonstrated in the example where a user first updates the quantity to receive in the Register Arrivals and then applies to the Interchangeable command. The pegged quantity is split accordingly in the Maintenance Material Requisition.

4.9.2Purchase Method: Borrow Order

All the above-mentioned functionalities for the regular purchase order also apply to the Borrow Order Purchase Method when using the Interchangeable functionality on Register Arrivals. The only difference is that the ownership type is Supply Loaned.

Since the Borrow Order Purchase Method is enabled only for serial-enabled parts with a quantity of 1, it is possible to perform a fully interchangeable operation only by using the Add/Change Interchangeable command.

5

Changing the Maintenance Material Requisition Line Sourcing

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Reservation Management

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B2B Portal Documentation

12

Tooling Management

This section explains how a user, such as a Configuration Engineer or System Engineer, Tool Manager, or Material Controller, can create a new part in the ICAM Module, making it available for use in maintenance, purchasing, and warehousing.

The goal is to maintain accurate and up-to-date information while minimizing the need for repeated manual intervention.

Once a part is created and approved, it becomes inducted within the fleet, ensuring it is a valid and recognized component in operational use. Following this step, the part information is published across the entire ecosystem, allowing all connected areas to access accurate and consistent data.

12.1Creating a Consumable Part

A Configuration Engineer or System Engineer can create a new part in CAMO module so it is available for use in maintenance, purchasing, and warehousing.

The aim is to keep information correct and up to date without needing repeated manual intervention.

12.1.1Selecting or Creating a Part Group

On the *Part Group Search* page, use the search bar to locate an existing Part Group. If no group exists, click *New Part Group*.

Use the *Modify Change Source* option and click *OK*. This action will enable you to create a new part or add an existing part to the Part Group.

On the *Alternative* tab, click *New Part*. Next, enter the following information on the *Part Details* Page:

- OEM Part No
- Part Name
- Manufacturer

Select *OK* once completed.

12.1.2 Publishing the Part

The *Modify Change Source detail* option should be used to get the part approved and published.

The part information is automatically published across the entire ecosystem and creates the following part layers:

- Master Part: Holds the core part details.
- Inventory Part: Enables stock tracking and storage.
- Engineering Part: Retains design or revision data.
- Purchase Part: Used for supplier orders.
- Sales Part: Used when parts are sold to customers.
- Manufacturer records: Connects the part to its manufacturer record.

12.1.3 Review and Complete Newly Created Part Numbers

The created part will be displayed on the New Part Number Board and can also be checked through the respective part layers.

Parts can be in either of the statuses listed below. However, when a new part is created, its initial status will be Pending.

- **Completed**: All required information has been updated.
- **Partially Updated**: Only some of the information has been updated
- **Pending**: The part has been created, but updates are yet to be made.
- **Not Created**.

12.2 Creating a Tool

Tools are essential for performing maintenance, inspection, and repair activities in aviation operations.

In the ICAM Module, Tool managers can create new tools in the same simple way as parts. The process follows the same layers:

- Master Part: Holds the core part details.

- Inventory Part: Enables stock tracking and storage.
- Purchase Part: Used for supplier orders.
- Sales Part: Used when parts are sold to customers.
- Manufacturer Records: Connects the part to its manufacturer record.
- Resources Group: Defines the classification and grouping of tools or equipment based on their usage, capability, or maintenance requirements.
- Tool and Equipment: Represents physical tools and equipment linked to their serial objects.
- Preventive Maintenance Actions: Defines recurring maintenance or calibration tasks to ensure tool accuracy, compliance, and readiness for operational use.

Once a tool is created, it can be tracked, stored, and managed across maintenance and store functions ensuring each tool is available, calibrated, and safe for use

12.2.1Selecting or Creating a Tool Part Group in Allowable Configuration

On the Part Group Page, use the search bar to locate an existing Part Group (TSE). If no group exists, click New Part Group. Use the Modify Change Source option and select OK. This action will enable you to create a new part or add an existing part to the Part Group.

12.2.2Creating a New Tool Part

On the Alternate tab, click New Part. Next, On the Part Details page, enter the following information:

- OEM Part No
- Part Name
- Manufacturer

Confirm the details by selecting OK.

12.2.3Publishing the Tool Part

he Modify Change Source detail option is used to get a tool part approved and published.

The part information is then automatically published across the entire ecosystem and creates the following part layers:

- Master Part - Holds the core part details.
- Inventory Part - Enables stock tracking and storage.
- Engineering Part - Retains design or revision data.
- Purchase Part - Used for supplier orders.
- Sales Part - Used when parts are sold to customers.

- Manufacturer records - Connects the part to its manufacturer record.

12.2.4Confirm the Created Records

Parts can be in any of the statuses listed below. A newly created Tool part will start in the Pending status if created successfully.

- Completed: All required information has been updated.
- Partially Updated: Only some of the information has been updated
- Pending: The part has been created, but updates are yet to be made.
- Not Created.

12.2.5Complete the rest of the information - Part Control Board

After records are created, the Tool Manager or Tool Clerk completes their assigned updates:

- Add supplier name, price, and lead time details.
- Enter warehouse location and stock conditions.
- Create Tool and Equipment and Preventive Maintenance Actions
- Review all data on the tool page.
- Mark as Purchase Info, Store Info, and Tool Info Updated.

12.2.6Creating an Actual Tool

On the Tool Inventory page, select Create New and enter the following:

- Tool ID: Enter a unique code (e.g., TWV250_SN001). Tool Part Number + Serial Number
- Tool Name: Same as the master tool name (e.g., Torque Wrench 250 Nm).
- Part Number: Enter the tool's part number.
- Serial Number: Enter the tool's serial number.
- Tool Group: Link to the appropriate Tool Resource Group Sub level.
- Operational Condition: Set as Operational once the tool is ready for use.

12.3Set Preventative Maintenance Actions for Calibration

On the *Preventative Maintenance* Page within Maintenance, select *PM Action* and click on New PM action. Next, fill in the following information:

- Action: Select Calibration.
- Object Type: Choose Tool/Equipment.

- Object ID: Enter the specific Tool ID (e.g., TWV250_SN001).
- Start Date: Enter the calibration start date.
- Interval Unit: Select Days.
- Interval Value: Enter the number of days between calibrations (e.g., 90).
- Responsible Org: Select the maintenance organization responsible for calibration.

12.3.1Register Calibration Completion

On the Tool Inventory page, search for the tool (e.g., TWV250_SN001). Select the tool and click *Register Calibration*.

Fill in the following information:

- Tool/Equipment ID: Automatically populated.
- Description: Displays the tool name.
- Calibration Date: Select the date and time when calibration was completed.
- Note: Add any relevant comments or observations.
- Attach Media Items: Attach calibration photos, screenshots, or certificates.
- Attach Documents: Attach calibration reports or vendor certificates.
  - The tool's Calibration Status in Tool Inventory is then updated.

12.4Manage Operational Condition Changes

This section refers to the management of the operational status of a serialized tool.

The Operational Condition determines whether a tool can be issued, checked out, or used in maintenance activities.Tools marked Non-Operational are restricted from use until re-enabled.

On the Part Serial page,review the details on the right-hand panel, including:

- Part Number
- Serial Number
- Current Position (e.g., In Inventory, Issued, In Facility)
- Operational Condition (shows current state).

12.5Define Item Classes

Item Classes are only defined in scenarios when Preventative Maintenance (PM) is required in bulk. An Item Class categorizes tools or equipment for maintenance and calibration purposes.

On the Item Classes page, click + New on the toolbar and enter the following details in the new line:

- Item Class: Enter a short unique code (example, CAL- TWV250 - Wrench).
- Item Class Name: Enter a description (example, Calibration Tool).
- Parent Item Class: Leave blank or select a parent if applicable.
- Note: This field is optional (example, used for torque and pressure measuring tools).

12.6Define Process Classes

Process Classes define maintenance or calibration processes that can be linked to Item Classes.

On the Process Classes page, click + New on the toolbar and enter the following details in the new line:

- Process Class: Enter a short code (example, CALIB- Wrench).
- Process Class Name: Enter a description (example, Calibration Process).
- Parent Process Class: Leave blank or choose one if it's part of a hierarchy.
- Notes: This field is optional (example, add comments such as "Covers all in-house calibration tools").

Complete the process by setting the *Validity* to *Active* and clicking Save.

12.7Creating a Work Task for Repair

When a tool fails calibration, becomes damaged, or is declared unserviceable, it must be repaired so that it can return to operational use.

On the Work Task Overview page, + Create a New Work Task and link the Tool to the Work Task.

12.7.1Define the Work Task Template

The Work Task Template defines the standard instructions, triggers, and resources used to perform repeatable maintenance activities such as tool calibration or repair.

When connected to a PM Program, these templates automatically populate work orders with consistent data, steps, and planning parameters.

On the Work Task Template page,Click + New Work Task Template to create a new record and fill in the General tab with the following:

- Task Template ID - Unique ID for this task (example, Calibration – Hammer Torque Tool).
- Definition - General purpose or activity type.
- Action - Action type linked to calibration process (Calibration)

- Status - Status must be Active to use in PM Programs.
- Work Type - Defines the nature of work.
- Planned By - Person or role responsible for the plan.
- Valid From / Valid To - Period of template validity.
- Performed Date Based - Yes.

Ensure the Maintenance Triggers are set to the following:

- Calendar = Yes (for time-based calibration).
- Work List = Yes (task includes detailed work steps).
- Resources = Yes (assign people/tools as needed).
- Valid for Sites = Yes (linked to actual site).

The fields in the Prepare tab should be completed with the following:

- Job Description: Enter a clear summary of the job (e.g., Perform calibration of torque wrench per OEM procedure).
- Category List: connect this Work Task Template to the Item Class that represents the tools being calibrated.
- Category: Item Class
- Identity: Tool
- Description: Tool Description
- Revision control and audit data are automatically captured.

Define the Work List with the following:

- Work step
- Resource
- Material
- Planning

Configure Maintenance Triggers:

- Add a new trigger record:
    - Trigger Type: Calendar
    - Interval Unit: Days
    - Calendar Interval: 90

Assign Valid Sites:

- Site
- Maintenance Organization
- Planner
- Calendar

Save and activate:

- Review all tabs to confirm information is complete.
- Set Status = Active.
- Click Save.

The template can now be used in PM Programs, PM Actions, or Work Orders.

12.8Define Preventative Maintenance Program

A Preventive Maintenance (PM) Program defines when and how recurring maintenance (such as calibration or inspection) is automatically planned for multiple tools or equipment.

A PM Program combines the following:

- Item Classes and Process Classes to group similar tools.
- Work Task Templates to define the standard calibration job.
- Triggers and Intervals to control scheduling.
- Sites and Maintenance Organizations to determine responsibility.

On the PM Programs page, Click + New PM Program to create a new record and fill in the General Information:

- PM Program ID - Unique program identifier.
- Description - Defines maintenance purpose.
- Revision - Default revision number.
- Revision Control - Enables version tracking.
- Status - Set to Active when ready to generate PM Actions.

Next, link the Work Task Template and assign valid sites.

Add applicable objects:

- Process Class.
- Item Class.

Activate and save the Program.

Generate PM Actions:

- On the toolbar, click Generate PM Actions.
- The system then automatically generates PM Actions for every Tool/Equipment object linked through the defined Item Class and Process Class.

12.9Moving Parts Between Locations

Parts can be moved between inventory locations in five different ways. The method to use depends on the situation and the kind of move that should be performed.

For more information, refer to the following: *Moving Parts Between Locations*

12.10Tool Check-In

The Tool Status Checked In page is used to record tools being returned to the Tool Store after use.It provides a simple, centralized way to confirm tool returns, update availability, and flag tools that may require calibration or maintenance before being issued again.

Once on the page, the person returning the tool must be selected. Next, select the tool(s) to be checked in, Add Return Notes (Optional) and select Check in.

12.11Tool Check-Out

The Tool Requirements page provides a real-time view of all tools required for active maintenance work.

It consolidates tool demand generated by work orders, work packages, or maintenance tasks, allowing the Tool Store to issue (check out) the required tools directly to technicians.

The user is required to open the Tool Requirements page, filter the tool demand, review tool availability and directly check-out from tool demand,.

12.12Tool Check-Out History

The Tools Check Out History page provides a complete transaction history of all issued and returned tools in IFS Cloud.

Once on the page, the records must be searched or filtered so that the transaction details can be reviewed.

ABOUT IFS

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