

**Oracle® Agile Product Lifecycle Management for
Process**

Global Specification Management User Guide

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Preface

The *Agile Product Lifecycle Management for Process Global Specification Management User Guide* explains how the Global Specification Management (GSM) application provides your company with a collaborative business process for managing data creation, localization, taxonomy, and workflow for all levels included in the product genealogy — across the enterprise and with value chain partners.

This preface contains these topics:

- [Audience](#)
- [Variability of Installations](#)
- [Documentation Accessibility](#)
- [Software Availability](#)
- [Related Documents](#)
- [Conventions](#)

Audience

This guide is intended for end users who are responsible for creating and managing information in Oracle Agile Product Lifecycle Management (PLM) for Process. Information about administering the system resides in the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Variability of Installations

Descriptions and illustrations of the Agile PLM for Process user interface included in this manual may not match your installation. The user interface of Agile PLM for Process applications and the features included can vary greatly depending on such variables as:

- Which applications your organization has purchased and installed
- Configuration settings that may turn features off or on
- Customization specific to your organization
- Security settings as they apply to the system and your user account

Documentation Accessibility

For information about Oracle's commitment to accessibility, visit the Oracle Accessibility Program website at <http://www.oracle.com/pls/topic/lookup?ctx=acc&id=docacc>.

Access to Oracle Support

Oracle customers have access to electronic support through My Oracle Support. For information, visit <http://www.oracle.com/pls/topic/lookup?ctx=acc&id=info> or visit <http://www.oracle.com/pls/topic/lookup?ctx=acc&id=trs> if you are hearing impaired.

Software Availability

Oracle Software Delivery Cloud (OSDC) provides the latest copy of the core software. Note the core software does not include all patches and hot fixes. Access OSDC at: <http://edelivery.oracle.com>.

Related Documents

For more information, see the following documents in the Agile PLM for Process documentation set:

- *Agile Product Lifecycle Management for Process Administrator User Guide*
- *Agile Product Lifecycle Management for Process Computer Aided Compliance Screening User Guide*
- *Agile Product Lifecycle Management for Process eQuestionnaire User Guide*
- *Agile Product Lifecycle Management for Process New Product Development User Guide*
- *Agile Product Lifecycle Management for Process Document Reference Library User Guide*
- *Agile Product Lifecycle Management for Process Product Quality Scorecard User Guide*
- *Agile Product Lifecycle Management for Process Reporting User Guide*
- *Agile Product Lifecycle Management for Process Supply Chain Relationship Management User Guide*
- *Agile Product Lifecycle Management for Process Supplier Portal User Guide*
- *Agile Product Lifecycle Management for ProcessProduct Quality Management User Guide*
- *Agile Product Lifecycle Management for Process Configuration Guide*
- *Agile Product Lifecycle Management for Process Security Configuration Guide*
- *Agile Product Lifecycle Management for Process Release Notes*. Up-to-date Release Notes and other documentation are posted on Oracle Technology Network (OTN) at this location:

<http://www.oracle.com/technetwork/documentation/agile-085940.html#plmprocess>

Conventions

The following text conventions are used in this document:

Convention	Meaning
boldface	Boldface type indicates graphical user interface elements associated with an action, or terms defined in text or the glossary.
<i>italic</i>	Italic type indicates book titles, emphasis, or placeholder variables for which you supply particular values.
<code>monospace</code>	Monospace type indicates commands within a paragraph, URLs, code in examples, text that appears on the screen, or text that you enter.

Introduction to Global Specification Management

Global Specification Management (GSM) provides your company with a collaborative business process for managing data creation, localization, taxonomy, and workflow for all levels included in the product genealogy — across the enterprise and with value chain partners.

Solution Overview

GSM is the solution:

- In which your company's products are created and modified
- From which the product data are syndicated to other enterprise systems

GSM enables your company to create “one version of the truth” of your entire product record, from finished products and manufacturing processes to your materials and packaging materials. The entire product genealogy is connected, enabling your company to build an integrated view of the interrelationships among all specifications.

GSM is a critical part of the larger Agile PLM for Process suite. For general information about the Agile PLM for Process suite, please see the *Agile Product Lifecycle Management for Process Getting Started Guide*.

Specification Overview

Raw Materials

Material specifications — Define the requirements for raw materials used in the manufacturing process. Materials impact formulation and nutrition.

Packaging material specifications — Define requirements of packaging materials used to package outbound products. Packaging primarily includes non-printable materials that contact food items or act as an intermediate.

Printed packaging specifications — Define all printed variants of a packaging material used for outbound products. Labels used for outbound purposes are managed as Printed Packaging Material.

Manufacturing Process and Finished Goods

Formulation specifications — Define the processes used to produce an item. This includes intermediates, processing operations, and post-processing operations such as filling, sterilization, and packaging. Commonly associated with Work in Progress (WIP).

Trade specifications — Define attributes for consumer and trade units for use by quality, marketing, sales, regulatory affairs/legislation and syndication to customers. Commonly associated with Finished Goods.

Nutrient profiles — Identifies the nutrient content for finished goods and/or manufacturing process.

Supplier Packaging

Labeling specifications — Define labeling and coding requirements for material packing specifications used for inbound raw materials.

Delivered material packing specifications — Define requirements for material packing specifications used for inbound raw materials.

Packing configuration specifications — Define how inbound raw materials (ingredients and packaging materials) are delivered to a factory.

Additional Specifications

Master specifications — A general specification that can be associated with most specification types. Provides central management for attachments such as general procedures, handling instructions, and other standard documentation.

Equipment specifications — Designed to further describe the packaging process by identifying vending equipment as it relates to packaging materials.

Menu item specifications — Menu item specifications are used by some Foodservice customers. We suggest you consult a services professional about whether this specification type suits your business needs.

Product specifications — Product specifications are used by some Foodservice customers. We suggest you consult a services professional about whether this specification type suits your business needs.

Touch Points with Other Applications

Computer Aided Compliance Screening

Computer Aided Compliance Screening (CACS) enables you to screen products through rules and regulations to ensure their compliance with customer, market, nutritional, and regulatory constraints. For more information, refer to the *Agile Product Lifecycle Management for Process Computer Aided Compliance Screening User Guide*.

eQuestionnaire

eQuestionnaire (eQ) is a tool that you can use to obtain specification data from suppliers and manage their disposition in GSM. For more information, refer to the *Agile Product Lifecycle Management for Process eQuestionnaire User Guide*.

New Product Development

Use the activities feature in New Product Development (NPD) to tie specifications created in GSM to projects. For more information, refer to the *Agile Product Lifecycle Management for Process New Product Development User Guide*.

Document Reference Library

You can associate Document Reference Library (DRL) documents to many Agile business objects within Agile PLM for Process applications, such as GSM specifications, New Product Development projects, and eQuestionnaire questionnaires. For more information, refer to the *Agile Product Lifecycle Management for Process Document Reference Library User Guide*.

Product Quality Management

Specification in GSM can be associated with objects in Product Quality Management (PQM). For more information, refer to the *Agile Product Lifecycle Management for Process Product Quality Management User Guide*.

Product Quality Scorecard

You can syndicate GSM core data to other Agile PLM for Process applications as well as to other systems in your company. Product Quality Scorecard (PQS) uses testing protocols, which must be configured in GSM. For more information, see the *Agile Product Lifecycle Management for Process Product Quality Scorecard User Guide*.

Reporting

The Reporting application provides reporting capability for data in GSM. For more information, see the *Agile Product Lifecycle Management for Process Reporting User Guide*.

Supply Chain Relationship Management

GSM specifications are syndicated to Supply Chain Relationship Management (SCRM), where sourcing approvals are created. Refer to the *Agile Product Lifecycle Management for Process Supply Chain Relationship Management User Guide* for more information.

Supplier Portal

Suppliers can view specifications created in GSM using Supplier Portal. For more information, see the *Agile Product Lifecycle Management for Process Supplier Portal User Guide*.




Working with Specifications

This chapter presents guidance on using workflows and other common features of GSM. Topics in this chapter include:

- [Page-Level Functions](#)
- [Creating Specifications](#)
- [Managing Specifications](#)
- [Comparing Specifications](#)
- [Printing Specifications](#)


Page-Level Functions

In the upper left corner of the page is a menu containing options and set of action icons that trigger actions that can affect the entire page. Not all functions are available on every page, or for every specification type. Many of these functions are described later in this chapter or in chapters devoted to specific specifications.

- **Edit** ()—Place the entire page in edit mode so that you can modify it.
- **New** ()—Users with certain roles can create new specifications, as described in ["Creating a New Specification"](#) on page 2-3.
- **Open**—Opens a search page for the selected specification type.
- **New Template**—Users with certain roles can create new specification templates, as described in [Chapter 21, "Creating and Managing Templates"](#).
- **Open Template**—Opens a template search page for the selected specification type.
- **Workflow** ()—Move the current specification, or document, from one workflow step to another. For more information on workflows, please see ["Transitioning a Workflow"](#) on page 2-7.
- **Resolve Workflow**—Re-resolve the specification to a new workflow (present only when you are logged in with a user account that has the user role of [CAN_RERESOLVE_WORKFLOWS].) When a specification is re-resolved, it will be resolved to the first stage of the new workflow.
- **Issue**—Create a new revision of the specification. For discussion of this commonly used function, please see ["Creating a Copy of an Existing Specification"](#) on page 2-4.
- **Copy**—Create a new copy of the current specification. For discussion of this commonly used function, please see ["Creating a Copy of an Existing Specification"](#) on page 2-4.


- **Target Revision**—Allows users to create a new issue of a given specification by:
 - Starting with an established specification.
 - Using "Target Revision" to point to another specification (the target) and generating a new issue based on the target specification's lineage (Specification Number and Issue Number).

This feature is valuable when designers/developers create many different variations of a potential product yet want to conform to a specific issue number.

- **Print** ()—Opens a dialog box through which you can print the current specification. When the print action is selected while the specification is in edit mode, GSM saves the specification before opening the print dialog. For more information on printing, please see ["Printing Specifications"](#) on page 2-14.
- **Action Items**—Displays action items, as described in ["Action Items"](#) on page 2-6.
- **Spec Compare**—Compares specifications, as described in ["Comparing Specifications"](#) on page 2-13.
- **Validate**—Validates the testing protocol to ensure key data has been entered corrected. Validation uses customer rules that must be built as part of an implementation.

Tools Submenu

Access the Tools submenu by selecting **Tools > [option]**. Options are defined as follows:

- **CACS**—Screen the current specification using Computer Aided Compliance Screening (CACS), an application that you can use to inspect materials for fitness against any number of user-defined screens. (Appears only if your installation includes CACS.) For more information on CACS, please refer to the *Agile Product Lifecycle Management for Process Computer Aided Compliance Screening User Guide*.
- **Act**—Create a primary activity, or mini-workflow, for this specification. For more information about this function, please see [Chapter 20, "Activities"](#).
- **Formula Compare**—Available for formulation specifications, as described in ["Tools Submenu"](#) on page 5-6.
- **Item History**—Display all issues of the specification that exist, along with the reason for creating each issue and other identifying information. For more information on this feature please see ["Item History"](#) on page 2-5.
- **Calculate** ()—Performs all custom data calculations. Calculation also happens when you save your specification.

Note: By default, calculation is turned off when the specification is in read mode. See the *Agile Product Lifecycle Management for Process Configuration Guide* for more information.

- **Optimization**—Available for formulation specifications, as described in ["Tools Submenu"](#) on page 5-6.
- **Snapshot**—Available for formulation specifications, as described in ["Tools Submenu"](#) on page 5-6.
- **Refresh**—Available for formulation specifications, as described in ["Tools Submenu"](#) on page 5-6.

- **LIO**—Create a new LIO profile associated to the specification you are on. Depending on the specification type, the active nutrient profile and material specification are automatically associated with the LIO profile.

Creating Specifications

Creating a New Specification

All specification types have the same creation process in GSM. You can either create a new blank specification or a specification based on an approved template.

Creating a Blank Specification

To create a blank specification, you must use the blank option. Users must have the appropriate role to create blank specifications, SPEC_CREATOR_<OBJECT TYPE>. For example, users assigned to the SPEC_CREATOR_1009 role can create blank packaging material specifications. See the roles appendix in the *Agile Product Lifecycle Management for Process Administrator User Guide* for a full list of roles.

1. On the left navigation panel, click **New > OBJECT TYPE > Blank**. GSM displays a specification page with empty fields. If you do not have access to create specifications from templates, you will not see the third navigation panel with the blank option. In that case, click on the object type to create a blank specification.
2. Follow the guidelines for your desired specification type as laid out in the chapter in this manual that specifically addresses that type of specification.

Creating a Specification from a Template

A user must have the appropriate role, CREATE_FROM_TEMPLATE_<OBJECT TYPE>, to create a specification from a template. For example, users assigned the CREATE_FROM_TEMPLATE_1009 role can create packaging material specifications from templates. See the roles appendix in the *Agile Product Lifecycle Management for Process Administrator User Guide* for a full list of roles.

Users with this role see the **New > OBJECT TYPE > From Template** options in the navigation menu. This menu lists your most recently used templates as well as an option to search for templates. Click a most recently used template and the system will create a specification based on the template you selected. If you do not see the template you want to use, you can search for templates by selecting the **From Template** header or the **More...** option.

Figure 2–1 New menu and submenu



To create a specification using the Template search option:

1. On the left navigation panel, click **New > OBJECT TYPE > From Template**. GSM displays the template search page for that object type.

Figure 2–2 Search page

Use this page to search for the template you would like to use. The template you select automatically creates the new specification based on that template and puts it in edit mode. You can preview the template using the view details icon (🔍) to the left of the template name.

- The From Template header in the third panel displays the most recently used templates. Click on any of the most recently used templates to instantly create a specification using that template.
 - You can also click the **More...** option to open a template search screen.
2. After selecting a template, complete the specification by following the guidelines for the specification type as laid out in the chapter in this manual that specifically addresses that type of specification.

For more information on creating templates, please see [Chapter 21, "Creating and Managing Templates"](#).

Creating a Copy of an Existing Specification

To create a copy of a specification, use the Copy action, which is visible only to those with the user role of [SPEC_COPIER] and the specification creator role for the specification type you are trying to copy. To create an issue of a specification, you must have the role [SPEC_ISSUER] and the specification creator role for the specification type you are trying to issue. For more information on user roles, please see the *Agile Product Lifecycle Management for Process Administrator User Guide*.

To create a copy of an existing specification:

1. Navigate to the specification to copy.
2. In the action menu, click **Copy**. This action duplicates most data on the specification, assigning a new specification number. This method saves time when creating similar specifications.
3. Fill in any required data and click **Save**. GSM displays the Select Workflow Template dialog box or auto resolves the specification to a workflow.
4. In some cases, you will be prompted to select a workflow for the new specification. Select a workflow, and then click **Done**.
5. Click **Save** or **Save & Close**.

To create an issue of an existing specification:

1. Navigate to the specification to issue.
2. In the action menu, click **Issue**. GSM creates another issue of the specification. This action duplicates most of the data on the specification, increasing the latest Issue # by 1 for the current specification number prefix.

Note: GSM appends issue numbers to the end of the specification number when specifications are referenced. For example, in the specification # 5077456-001, the last 3 digits (001) represent the issue number. GSM tracks specification issues by using the item history feature. For more information, please see ["Item History"](#) on page 2-5.

3. Fill in any required date and click **Save**. GSM displays the Select Workflow Template dialog box or auto resolves the specification to a workflow.
4. In some cases, you will be prompted to select a workflow for the new specification. Select a workflow, and then click **Done**.

Note: When a copy or issue of a specification is created, the resolved workflow and active workflow step will not follow the specification. The specification will re-resolve to a workflow when saved within GSM. For more on workflows, please see ["Resolving Workflows"](#) on page 2-7.

5. Click **Save** or **Save & Close**.

Item History

Specification issues are tracked using the item history feature. To access the item history of a specification, navigate to the specification and do one of the following:

- Click **Tools > Item History** in the action menu. GSM opens the Spec History dialog box, as shown in [Figure 2-3](#).

Figure 2-3 Spec History dialog box

Spec History Close						
Name	Spec Number	Create Date	Originator	Last Modified	Status	Reason for Change
Mango/Orange Drink #2	5084999-002	7/26/2007	Springle, Raymond	9/25/2007	Draft	
Mango/Orange Drink #2	5084999-001	7/25/2007	Springle, Raymond	9/21/2007	Draft	

The Spec History table displays all issues of the specification that exist. Click any linked specification name to view that specification. Along with other identifying information, this table also displays the reason that the specification was changed. The value in the Reason for Change column appears in most specifications in a field in the Summary Information section of the Summary tab. This section is ordered from newest to oldest, highlighting the current specification.

- From formulation specifications, click the specification history icon (🔍) in the Inputs table, as shown in [Figure 2-4](#). GSM displays the input's history.

Figure 2–4 BOM table in edit mode, showing specification history icon

USD/100g	EXT Cost			
0.00000	0.00000			
0.00000	0.00000			
0.00000	0.00000			

- From menu item specifications, click the specification history icon (📄) in the Menu Item Build table. GSM displays the input's history.

Managing Specifications

All GSM specifications are workflow enabled. A workflow is a business process, in whole or in part, during which documents, information, or tasks are passed from one participant to another for action, according to a set of procedural rules. In Agile PLM for Process, workflows are managed using the Workflow Administration (WFA) application. For more information on WFA, please see the "Workflow Management for GSM" chapter in the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Action Items

As a document moves through the workflow process, the system generates a to-do list, or "action items," for designated team members. When a specification, or business object, moves from one workflow status to another, GSM adds an entry to the Action Items list for the current owner of that object.

There are three types of action items:

- Specification
- Signature document
- Activity

Accessing Your Action Items

You can access the Action Items page in three different ways:

- Click **Applications > GSM > Action Items** on the Application menu in the top menu bar
- Click **GSM > Action Items** on the left navigation panel from the Portal
- From within GSM, click **Action Items** from the action menu

Understanding the Action Items Page

The Action Items page contains a table with the following sortable columns:

RAG Status (not labeled)—This column displays the Red Amber Green (RAG) status of the specification. The RAG status is an indicator of compliance with the established service level agreement (SLA) timelines for that document type. SLAs for a specification are defined in that specification's workflow. When action items are sorted by this column in descending order they will be sorted in Red | Amber | Green sort order listing older red dates first. When items are sorted in ascending order they will be sorted in Green | Amber | Red listing newer green dates first.

Spec #—The number of the specification

Equivalent—The cross reference number

Title—The name of the specification

Type— The type of action item

NPD Project—The name of the New Product Development (NPD) project tied to the formulation specification. Depending on your configuration, this column may not appear.

Status— The workflow step that the object is in (for example, draft, developmental, draft (review), requested for certification, and others)

Amber— The date the action item is entering an amber state.

Red—The date the action item will be entering the red state.

Resolving Workflows

When you first save a specification within GSM, the application associates a workflow with the specification. In some cases, when the specification resolves to multiple workflow templates, you will need to select the workflow template from the available options.

In such a situation, select a template for this specification from the Select Workflow Template dialog box, and then click **Done**.

Warning: Once you have selected a workflow template, you will not be asked to define the workflow again. If your specification needs to be re-resolved, you will need to use the Resolve Workflow button, which is visible only to those with the user role of [CAN_RERESOLVE_WORKFLOWS]. For more information on user roles, please see the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Transitioning a Workflow

Within a specification or signature document, use the workflow feature to move a document from one workflow step to another.

To move a document in a workflow:

1. Click **Workflow** in the action menu. The Document Workflow dialog box opens, as shown in [Figure 2-5](#). Remember that the buttons and fields that display vary based on the workflow and current workflow step.

Figure 2–5 Document Workflow dialog box

Document Workflow [Cancel]

Next Action

← Draft Developmental →

Your Comments

Current Status

Current Owner: [Name]
 Current Workflow: Ingredient Spec Workflow
 Current Status: Draft (Review)
 Desired Action: Please review and approve this specification.

Start Date: 4/3/2011
 Amber Date: -----
 Red Date: -----

Annotations:
 - Arrow to 'Your Comments' field: You must enter comments in this field
 - Arrow to 'Developmental' dropdown: Select a step from this drop-down list

2. Enter comments in the **Your Comments** field (required).
3. Select a step from a drop-down list in the Next Action section.
4. Click the advance workflow icon (→) to forward the specification or signature document to the next step in the approval process, or click the move back icon (←) to return it to a prior step. The system updates the workflow status based on your selection.

Selecting Workflow Participants

If the advance workflow icon includes people (→), in the next dialog box you may have to select workflow participants, such as one or more owners, persons being asked for a signature, or persons being notified. As [Figure 2–7](#) shows, the dialog box may contain preselected data or may prompt you to select one or more participants. Refer to [Figure 2–6](#) through [Figure 2–8](#) for an example of selecting workflow participants.

Figure 2–6 Single select example: Choose a single owner

Select Owner(s) [Next >>] [Cancel]

☐ approver, spec (specapprover) (Acme Europe)

☐ Smith, Sally (ssmith)

☐ Green, Walter (wgreen)

☐ Foodman, Joe (jfood) (Acme Europe)

Figure 2–7 Pre-Selected Example: Notification recipient(s) have been preselected in the workflow template

Select Notification Recipient(s) [Done] [Cancel]

Member(s) have been selected

Figure 2–8 Multiple select example: Select one or more signatories from each tab

Select Signator(s) [Done] [Cancel]

Marketing **Quality Assurance**

☐ approver, spec (specapprover) (Acme Europe)

☐ Johnson, Sally (scjohnson)

☐ Jones, Jo (jjones)

☐ Smith, Jane (jsmith)

Each tab represents a functional area in which you may need to make a selection

Re-Authentication

Depending on workflow configurations, you are sometimes asked to re-authenticate while workflowing a specification. You will be asked to enter a passphrase to prove your identity. Your passphrase is managed through profile and preferences. For more information, refer to the *Agile Product Lifecycle Management for Process Getting Started Guide*. For more information around how to configure the re-authentication process, refer to the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Working with Signature Documents

Use a signature document to solicit approval for a specification before the specification can move to the next step in the workflow. All requested signature documents must be moved to an approved state before the specification can move to the next workflow step. When you select a signature document — whether by action item or an email link — GSM displays the signature document page, as shown in [Figure 2–9](#):

Figure 2–9 Signature document page

Signature Document Review

Summary Approval/Audit Trail

You have been asked to approve the specification for **Mango Puree** on behalf of **European Quality Leads**.
Please use the **Workflow** action to submit your approval (or return with comments) once you have reviewed the supporting documents.

Specification

Spec Name: Mango Puree (5104090-001)
Spec Status: Approved
[click HERE to review the specification](#)

The Summary tab shows the specification that you have been asked to review. You can follow the link to view the specification.

As Figure 2–10 shows, the Approval/Audit Trail tab shows the current status and owner of the signature document, the desired action, assigned dates, and the history of the signature document.

Figure 2–10 Signature Approval tab

Signature Document

Summary Approval/Audit Trail

Current Status

Current Owner: [User Name]
Current Workflow: Specification Signature Document Workflow
Current Status: Review
Desired Action: Review and move forward in the workflow.

Start Date: 8/11/2010
Amber Date: 8/14/2010
Red Date: 8/18/2010

Event History

Status	User	Time	Comments
Review	[User Icon]	8/11/2010 1:07:15 AM	

Click **Workflow** in the action menu to take action on the signature document by changing its status to “approved” or “not approved.”

Temporary Signature Authority Temporary signature authority enables a person who has been asked to provide a signature to assign that task to another user. A user with temporary authority can view and advance or move back all signature documents that are currently owned by the original signature authority. Tasks assigned to a user with temporary authority also appear in the Action Items list of that person.

Accessing Temporary Signature Authority Access temporary signature authority from the left navigation panel. GSM displays the Temporary Signature Authority Search page, which you can use to search for existing signature authorities. For detailed guidance on searching, please see the *Agile Lifecycle Management for Process Getting Started Guide*.

Creating a Temporary Signature Authority To create a new signature authority, click **New > Temporary Signature Authority**. Figure 2–11 shows the fields on this page.

Figure 2–11 Temporary Signature Authority fields



Temporary Signature Authority


Current Owner: Sarah Jones 


Temporary Owner: 


Start Date: 4/12/2011 

End Date: 4/12/2011 

Status: ☒ Enabled ☐ Disabled

Current Owner—You can designate temporary signature authority by clicking the search icon (). GSM displays the user selection dialog box, which you can use to search for the desired user. Selecting the user name closes the dialog box and populates the Current Owner field. Changing the current owner is only available if you have the role TSA_ADMIN.

Temporary Owner—You can designate temporary signature authority by clicking the search icon (). GSM displays the user selection dialog box, which you can use to search for the desired user. Selecting the user name closes the dialog box and populates the Temporary Owner field.

Start Date and **End Date**—These fields represent when the temporary signature authority begins and ends. To change the dates listed, type the dates directly into the fields, or use the calendar icon () to select dates.

Status—Using this field, you can enable and disable the signature authority.

Editing an Existing Temporary Signature Authority You can edit existing signature authorities that you have created. Search and select the signature authority to edit and click **Edit** from the action menu. When done editing, click **Save & Close**.

Approval/Audit Tab

All workflow-enabled specifications contain an Approval/Audit Trail tab. This tab contains the data related to the workflow status and history of a specification. This page consists of the following system-defined sections:

- [Current Status Section](#)
- [Event History Section](#)
- [Lineage/History Section](#)
- [Signature Document Section](#)

Figure 2–12 Approval/Audit tab

Mango/Orange Drink #2 (5084999-002) Trade Specification Draft

Summary | Packaging | Compliance | Ext Data | Related Specs | CSS | Supporting Documents | References | **Approval/Audit Trail**

Current Status

Current Owner: [\[User Name\]](#)

Current Workflow: Trade Spec - Short Template

Current Status: Draft

Desired Action: Draft

Start Date: 7/26/2007

Amber Date: -----

Red Date: -----

Event History

Status	User	Time	Comments
Draft	[User Name]	7/26/2007 9:46:36 AM	Re-resolved to 'Trade Spec - Short Template' (7).

Lineage/History

	Date	User	Action	Specification
1	3/29/2011 12:09:06 PM	[User Name]	Create New Copy	Mango/Orange Drink #2 (5105818-001)

[View All History](#)

Signature Document

[View Historical Signature Documents](#)

Current Status Section

The Current Status section contains the workflow data related to a specification.

Event History Section

The Event History section contains the list of preceding workflow actions associated with the specification.

Lineage/History Section

The Lineage/History section shows a history of where a specification was created and updated from.

Signature Document Section

The Signature Document section contains the list of signature documents associated with that step of the workflow. All signature documents associated with a specification must be in the approved state before the specification can be moved forward in the workflow.

Clicking **View Historical Signature Documents** opens a view of signature documents completed prior to the current stage.

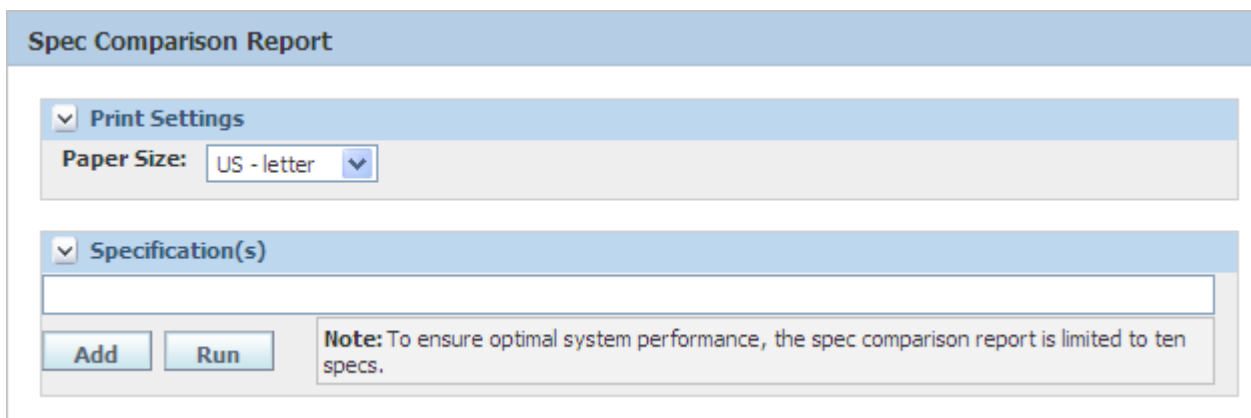
Comparing Specifications

You can compare up to 10 specifications of the same type by using the specification comparison tool. This tool respects BU security, WFA security, and OLS.

To access this tool:

1. Click **Spec Compare** from the action menu within GSM. GSM displays the Spec Comparison Report dialog box, as shown in [Figure 2-13](#).


Figure 2-13 Spec Comparison Report dialog box



The image shows a software dialog box titled "Spec Comparison Report". It has a light blue header bar with the title. Below the header, there are two main sections. The first section is titled "Print Settings" with a dropdown arrow on the left. It contains a label "Paper Size:" followed by a dropdown menu currently showing "US - letter". The second section is titled "Specification(s)" with a dropdown arrow on the left. It contains a large, empty text input field. Below this input field are two buttons: "Add" and "Run". To the right of these buttons is a note box with the text: "Note: To ensure optimal system performance, the spec comparison report is limited to ten specs."

2. Click **Add** to select the specifications to compare. GSM opens the specification search dialog box.
3. Find up to 10 specifications to compare and click **Done**. The specifications search dialog box closes, and your selected specifications appear in the Specification(s) box.
4. Click **Run** to generate the report. GSM generates a Spec Comparison Report in Adobe Acrobat .PDF format.

Printing Specifications

Where available, you can print specifications by selecting **Print** from the action menu, or by clicking the print action icon (), thereby opening the print dialog box. Options in the printing dialog box vary according to specification type, as discussed below.

Printing Trade Specifications

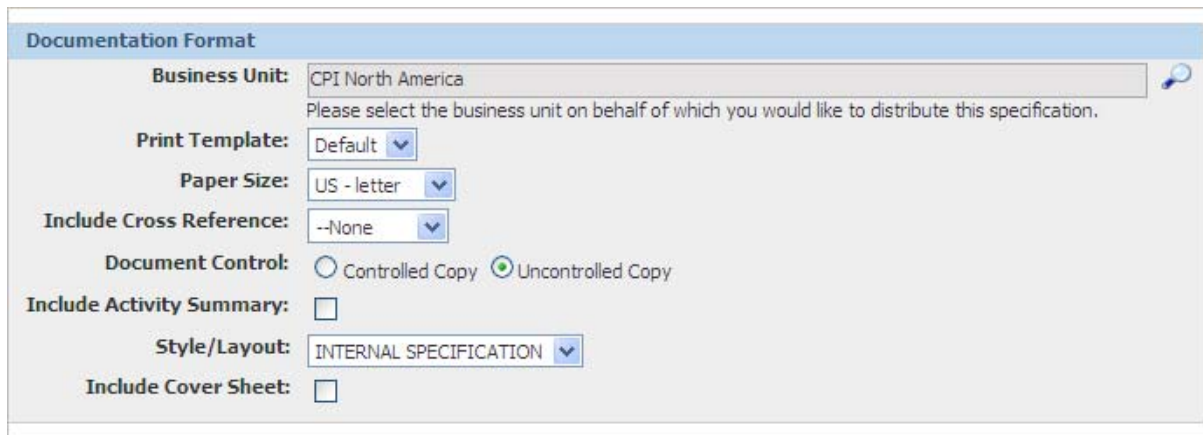
Trade specifications follow a unique printing method. The printing dialog box can contain many sections, depending on what items are related to that specification.

The sections include Documentation Format and Packaging Hierarchy. The print dialog box for trade specifications may contain sections for additional, related items.


Documentation Format Section

The Documentation Format section, shown in [Figure 2–14](#), contains fields that directly affect the format of the printed output.

Figure 2–14 Documentation Format section



Documentation Format

Business Unit: CPI North America 
Please select the business unit on behalf of which you would like to distribute this specification.

Print Template: Default ▾

Paper Size: US - letter ▾

Include Cross Reference: --None ▾

Document Control: ☐ Controlled Copy ☒ Uncontrolled Copy

Include Activity Summary: ☐

Style/Layout: INTERNAL SPECIFICATION ▾

Include Cover Sheet: ☐

Key fields include:

Business Unit—Controls which master specifications are available for printing. Changing this value changes the master specification listing.

Print Template—Lists all print templates available for the current specification. Print templates control which data is included in the printed output.

Paper Size—Controls the page size.

Include Cross Reference—Includes the selected cross-reference inside the header of each printed page.

Document Control—Dictates which watermark to display ("controlled copy" or "uncontrolled copy"). Options that are displayed are based on role; for example controlled copy is only displayed if the user has the role SPEC_PRINT_CONTROLLER.

Include Activity Summary—Attaches a summarized printout of each activity that is attached to the specification, as shown in [Figure 2–15](#).

Style/Layout—Dictates the style and output of the specification.

Include Cover Sheet—Adds a cover sheet to the outgoing PDF, as shown in [Figure 2-16](#).

Figure 2-15 Trade specification activity summary sample


Orange Juice - 12 oz bottle (5091133-001)		#	
	Activity Summary (5091143-001)	Status:	Draft
		Effective:	10-Aug-2009
		Prepared By:	Smith, David
Label Review (act 5091143-001)			
Effective: 10-Aug-2009 Inactive: Activity Type: Label Review Originator: Smith, David Status: Draft Special Notes: Label Review for Sunshine Orange Juice. Please verify the nutritional fact panel. Last Edit: 10-Aug-2009			
Related Items			
Type	Description	Status	Comments
Trade Specification	Orange Juice - 12 oz bottle (5091133-001)	Draft	
Extended Attributes			
Extended Attributes	Notes		
Countries Sold To	USA		

Figure 2–16 Trade specification cover sheet sample

BBQ Beef and Vegetable Dinner - 11 oz (5077539-001) #	
ACME	Cover Sheet
	Status: Packaging Engineering Review
	Effective: 03-Oct-2010
Prepared By: Jones, Sally	

Summary Information

Spec Name: BBQ Beef and Vegetable Dinner - 11 oz
Short Name: BBQ Beef and Vegetable Dinner - 11 oz
Spec Status: Packaging Engineering Review - Please attach correct packaging BOM and unit load.
Category: Meat, Poultry and Game
Sub Category: Meat, Poultry and Game - Prepared and Processed
Group: Meat, Poultry and Game - Prepared and Processed (Frozen)
Originator: [Redacted]
Supercedes: New Item
Reason for Change:

Spec #: 5077539
Issue #: 001
Effective: 03-Oct-2004
Available Date: 02-Mar-2005
End Available: 11-Jan-2006
Date:
Last Edit: 02-Jul-2010

Documentation Version/Status

Dependent Specification(s)	Effective Date	Status
BBQ Beef and Vegetable Dinner - 11 oz (trd 5077539-001)	03-Oct-2004	Packaging Engineering Review
X887 (ing 5077416-001)	31-Jul-2001	Approved

As shown in Figure 2–16 above, the cover sheet includes the following information:

- Specification name and number
- Status of the specification and all dependent specifications
- Effective date of the specification and all dependent specifications
- Available date and end available date of the specification and all dependent specifications
- Name of the preparer
- Name of the specification, if any, that this specification supersedes

Packaging Hierarchy

The Packaging Hierarchy section contains a list of all related trade specifications and their objects that are available for printing.

Title Specification

This drop-down list controls what specification will be displayed at the top of the hierarchy. Changing this value adjusts the related trade specification listing.

Related Trade Specifications

The trade specifications available for printing are organized by item type (TU=Traded Unit or CU=Consumer Unit). The active specification is shown in the row that is highlighted.

The printed output includes everything that you have selected in the Related Trade Items table. Those objects vary by specification but could include:

- Specification—Indicated by the specification name and item type.
- Supporting Documents—Indicated by the type or name of the document. Types of supporting documents are:
 - Attachments/Procedures are listed as: Attachment Title - Filename
 - Rich Text Documents are listed as Rich Text Document - Rich Text Name
 - URLs are not included in the print dialog

See [Figure 2–17](#) for examples.

To include any of these items in your printed output, check the box next to the corresponding item in the **Append Specification** column.

You can print attachments individually outside of the printed output. These attachments are listed underneath the associated trade specification and are indicated by the attachment file name.

Figure 2–17 Packaging Hierarchy section

Packaging Hierarchy:

Title Specification: Orange Juice 16 oz Can (5080525-001) ▼

Related Trade Items		Include Summary	Append Specification
CU	 Orange Flavored Sugar Water RR Consumer Unit - (3)	<input type="checkbox"/>	<input type="checkbox"/>
	 Imported From ProcessSpec (Orange Flavored Sugar Water)	--	--
CU	 Orange Juice 16 oz Can Consumer Unit - (1)	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

To print attachments, click the linked attachment file name. In addition to printing attachments separately, you can also include JPG and GIF images formats in your PDF package. To include a JPG or GIF, check the box in the **Append Specification** column next to the images to include.

Additional Related Items

Additional related items are listed below the Packaging Hierarchy section. These items are listed in their own sections. Each section is titled by the item type, as shown in [Figure 2–18](#).

Possible related specifications include: printed packaging materials, packaging materials, nutrient profiles, testing protocols, and master specifications. On co-pack trade specifications, material breakdowns added to the supporting documents tab will be listed as well, as shown in [Figure 2–19](#).

If the related specification includes attachments, the attachments will be listed below the specification. To print attachments, click on the linked attachment file name. By default, the custom data on the selected specifications is included in the printout after the activity summary, unless your administrator has indicated to suppress printing.

%Breakdown summary information includes restrictions, formula classifications, and tags for each % breakdown.

Sourcing approvals can also be included in the printout.

Figure 2–18 Additional related items
























 Packaging Material Specs		
PKG_20110704_10 lb / 1 unit (5106690-001)	--	<input type="checkbox"/>
 Printed Packaging Specifications		
PPKG_20110704_1 lb/ 1 unit (5106679-001)	--	<input type="checkbox"/>
PPKG_20110704_1 lb/ 1 unit_2 (5106680-001)	--	<input type="checkbox"/>
 Master Specifications		
Master2 (5094180-001)	--	<input type="checkbox"/>
master (5083956-001)	--	<input type="checkbox"/>
 doc - Mom'sCoffeeCake.doc	--	--
 jpg - valley.jpg	--	<input type="checkbox"/>
 txt - special characters.txt	--	--
 rtf - Document.rtf	--	--
 bmp - Copy of valley.bmp	--	<input type="checkbox"/>
 Rich Text Document	--	<input type="checkbox"/>

Figure 2–19 Additional related items, co-pack trade specification

 Packaging Material Specs		
Pkg (5089529-003)	--	<input type="checkbox"/>
 doc - Package Assembly.doc	--	--
 picture - PackageAssembled.jpg	--	<input type="checkbox"/>
 Ref - (http://docs.mycompany.com/PkgAssemblies)	--	--
 Testing Protocol		
Trade TP 20090624 (6/24/2009)	--	<input type="checkbox"/>
TP Library 20090615 (6/15/2009)	--	<input type="checkbox"/>
 Explicit Master Specifications		
Master (5092607-001)	--	<input type="checkbox"/>
 Printed Packaging Specifications		
PPKG (5091145-005)	--	<input type="checkbox"/>
 Master Specifications		
mj master (5083956-001)	--	<input type="checkbox"/>
 Material Breakdown		
formula one - Northern Europe	--	<input type="checkbox"/>
 Nutrient Profile		
New Issue Nutp (5089787-002) (Active Profile)	--	<input type="checkbox"/>
 doc - ChildNutritionReport.doc	--	--
 picture - FactPanelPlacement.jpg	--	<input type="checkbox"/>
 Rich Text Document - Please read	--	<input type="checkbox"/>
 Ref - (http://docs.mycompany.com/NutritionStandards)	--	--
Nutrient Profile (5085265-001)	--	<input type="checkbox"/>

Printing Other Specifications

Generally, all specifications other than trade specifications use the same print function. The printing dialog box for these specifications contains two sections:

- [Documentation Format](#)
- [Specification Listing](#)

Documentation Format

The specification format section contains fields that directly affect the format of the printed output.

Key fields include:

Business Unit—Controls which master specifications are available for printing. Changing this value changes the master specification listing in the Specification Listing section.

Print Template—Lists all print templates available for the current specification. Print templates control which data is included in the printed output.

Paper Size—Controls the page size.

Document Control—Dictates which watermark to display ("controlled copy" or "uncontrolled copy"). Options that are displayed are based on role; for example controlled copy is only displayed if the user has the role SPEC_PRINT_CONTROLLER.

Include Activity Summary—Attach a summarized printout of each activity that is attached to the specification. This option is explained in more detail on page 2-14.

Specification Listing

The specification listing section contains a list of all specifications and their objects available for printing. Specifications available for printing vary based on specification type. The final printed output is an Adobe Acrobat (PDF) file. The print output can include multiple specifications and objects.

The specification listing section includes the following information:

Specification Type

The specifications available for printing are organized by specification type. The active specification is indicated by the text "Current Specification."

Sections

The printed output includes everything you have selected in the Sections column. Those objects vary by specification type but could include:

Specification—Indicated by the specification number and name

Supporting Documents—Indicated by the type or name of the document (does not include supporting documents/attachments that are marked as proprietary)

Custom Sections—Indicated by the name of the custom section (does not include custom sections that are marked with the suppress printing tag)

Testing Protocols—Indicated by the name of the testing protocol

% Breakdown—Indicated by the % breakdown name (does not include % breakdowns that are marked with the suppress printing tag)

Sourcing Approval—Indicated by Sourcing Number - sourcing facility/receiving facilities. Includes any sourcing approvals attached to the specification.

Nutrient Composition—Includes the nutrient composition supporting document information

For formulation specifications:

Include the Expanded Bill of Materials—Includes a listing of all materials used in lower level formulations

Include Formulation Steps—Includes a summary view of each formulation step

Include Material Summary—Includes a printout containing a summary view of every material used in the formulation specification

Attachments You can print attachments individually outside of the printed output. These attachments are listed in the Attachments column and are indicated by the attachment file name. The printed output can include images in JPG or GIF format. To include JPG or GIF images in the output, check the **Supporting Documentation** check box in the same row as the image files that you would like to include.

Figure 2–20 Material specification print example






Specification Type	Sections	Attachments
 Current Specification	<input checked="" type="checkbox"/> Step 2 Output 5090210-001 (5090210-001)	
	<input type="checkbox"/>	
 Master Specifications	<input type="checkbox"/> master (5083956-001)	DOC: Mom'sCoffeeCake.doc TXT: special characters.txt RTF: Document.rtf
	<input type="checkbox"/> Supporting Documentation	JPG: valley.jpg
	<input type="checkbox"/> Supporting Documentation	BMP: Copy of valley.gif
	<input type="checkbox"/> Rich Text - Rich Text Test	
	<input type="checkbox"/> Custom Section - Flavors	

Figure 2–21 Formulation specification print example

Specification Type	Sections	Attachments
 Current Specification	<input checked="" type="checkbox"/> Sugar Water (5094454-001)	
	<input type="checkbox"/> Include the Expanded Bill of Materials	
	<input type="checkbox"/> Include Formulation Steps	
	<input type="checkbox"/> Include Material Summary	
 Outputs	<input type="checkbox"/> Sugar Water (5094455-001)	
	<input type="checkbox"/> Nutrient Composition	
 Master Specifications	<input type="checkbox"/> Master Spec (5092029-001)	
	<input type="checkbox"/> Supporting Documentation	valley.jpg
	<input type="checkbox"/> Custom Section - custom	

Optional Objects to Print Through the Print Dialog Box For each specification type, there are objects that can be printed using the Print dialog box. For more information, refer to the *Agile Product Lifecycle Management for Process Security Configuration Guide*.

Commonly Used Sections

This chapter describes sections that are used in many or most specification types. Topics in this chapter include:

- [Overview](#)
- [Summary Tab](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [CSS Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)

Overview

Information in GSM is organized into tabs that are in turn organized into sections. Several sections are common to all or most types of specifications.


This chapter describes the most commonly used tabs and the sections within them.

Summary Tab

The Summary tab in GSM contains the following sections common to several specification types:

- ["Summary Information Section"](#) on page 3-3
- ["Available UOM Section"](#) on page 3-4
- ["Cross References Section"](#) on page 3-5
- ["Approved for Use in Section"](#) on page 3-6



Figure 3–1 Summary Tab


Water - Carbonated (98769878)
 Material Specification


Draft


Summary | Formulation | Nutrition | Compliance | Ext Data | Related Specs | CSS | Supporting Documents | References | Approval/Audit Trail

Summary Information



Spec Name: Water - Carbonated 
Short Name: Water 
Spec Status: Draft - This specification is currently in draft status

Spec #: 5077462-001
Category: Other
Sub Category: Liquids
Group: Water

Supersedes: 34756
Reason for Change: 

Originator: 
Effective: Tuesday, September 28, 2004
Inactive:
Last Edit: Thursday, May 21, 2009

Material Attributes

Material Type: Raw Material
Description: Water 
Classification: Mild Acid
Country Of Origin:
Shipping Requirements:
Shipping Instructions: 

Design Attributes

Density: 1 g = 1 mL
Total Solids: %
Formulation Tags:

Shelf Life

	Storage Requirements	Tags	Supplier's Shelf Life	Internal Shelf Life	Min Days Remaining	Storage Instructions	Relative Humidity
1	Preferred Shelf Life						

Available UOM

UOM Category: Mass
Base UOM: kg
Additional UOMs:

UOM Conversions

	UOM	Status
1	1.00000 BG25 = 20.00000 kg	Active

Cross References

	System Name	System ID	Equivalent	Description	UOM	Externally Managed	Status
1	SAP System	USSAP	98769878			<input checked="" type="checkbox"/>	Active

Approved for Use In

Concept(s):
Business Unit(s): CPI North America

Summary Information Section

The section contains the primary identifying information for the specification. The table below shows the key fields for the Summary Information section:

Table 3–1 Summary Information key fields

Field Name	Importance	Details
Spec Name	Required	Use it to identify your specification. This data is used throughout the Agile PLM for Process suite when linking/referencing specifications. HTML tags are not allowed in this field.
Short Name	Required	Short name is a shorter reference to the specification name. Depending on your configuration, Short name may or may not be required or even displayed.
Access Level		Represents the access level for secured objects on that specification. Depending on your configuration this field may not be visible. For more information about object level security, see the <i>Agile Product Lifecycle Management for Process Security Configuration Guide</i> .
Spec Status		Shows the current workflow status.
Spec #	System Generated	Number used to identify specifications. This number is appended with three digits. This represents the revision number.
Originator	System Generated	Auto-populated field that denotes the person who created the specification. Originator Name, Originator Country
Category/Sub Category/Group	Required, Drives behavior	Defaults to the first node in the specification category.
Supercedes	Manual Entry or System Generated	Identifies the superceded specification.
Reason for Change		Shows the reason given for changing the specification.
Last Edit		Shows the date of the last save.

Note: Date fields vary based on specification type.

Available UOM Section

The Available UOM section contains the valid UOM's for the specification. The user has the ability to define the base UOM, additional UOMs and define conversions to the base UOM. UOMs are defined using the Data Administration application. Only active UOMs can be used in this section.

UOM Conversions

The UOM Conversions grid is used to define conversions from other UOMs back to the base.

For example, if the base UOM is LB, the Additional UOMs section will allow the user to define additional UOMs to be used for the specification.

Once the UOMs from the base category have been defined, the user can enter other UOMs and relate them back to the base. The UOMs in the left column are filtered so the user does not see any UOM from the same category as the base UOM, except for UOMs from the category of "OTHER". UOMs from the "OTHER" category should always be available in the left column. Additionally, once a UOM from a category has been added, no other UOMs from that category should be available. This will prevent users from specifying that 1IN = 1LB and 1FT=1LB.

The Available UOM control will not allow a user to define the density of a material. The density data is already described on the specification so the list will be filtered to prevent that from occurring.

The Available UOM control will also disallow conversions for UOMs in the following categories:

- Concentration (ratio, %, Brix)
- Temperature (F, C)
- Time (ms, s, min, hr, days, wks, mos, yrs)

The available UOM selector respects the status assigned to each UOM described in Data Administration (ADMN). Only Active UOMs are available for selection.

The user can add a status to the UOM conversions and can therefore inactivate specific conversions. When a conversion is marked as inactive, the BOM consumption should not show the UOM.

Once the available UOMs have been added to the specification and the specification has been saved, the available UOM data cannot be edited by the user. Up until the point the specification is saved, the user can edit or delete available UOM data. Users can add new UOM conversions any time they have edit access to the specification.

Note: If you have the role of [AVAILABLE_UOM_ADMIN] you will be allowed to edit the UOM conversion entry as long as it has not been consumed in any specifications.

Cross References Section

The Cross References section contains the list of cross-reference numbers for the specification, as stored in external systems. You can use the equivalent value as a search criteria and it can display in specification search results. Key fields include:

System Name—The name of the external system.

System ID—A code that identifies the external database. Agile PLM for Process obtains this code from the external system.

Equivalent—The equivalent number designed to identify the material as it is referenced by other cross-reference systems.

Description—Expandable and translatable text field that allows for 256 characters. This will be the specification name used when a pack size is specified in a consumption point

UOM—Multi select selection tool listing all available UOMs for selection. The available UOMs are defined in the Available UOM section. You can only select UOMs that are active. Use the add data icon (+) to select UOMs. Once selected, UOMs will be listed in a comma-separated list. For example: g, kg, 5lb bag.

If a selected UOM is later made inactive, the Cross References grid will not automatically remove that inactive UOM. It is the user's responsibility to remove inactive selected UOMs.

If a selected UOM is later deleted, GSM updates the Cross Reference grid by removing the UOM selected. For example, if kg is deleted from the Additional UOMs field, the cross reference rows that reference kgs will be updated, removing kgs. As an example of editing, if a UOM conversion was changed from Bag to Box, the cross reference rows that reference Bag will be updated, removing Bag.

Note: Only material, packaging material, printed packaging, and equipment specifications include the Description and UOM fields.










Externally Managed—An indication of whether this data is managed externally or within Agile PLM for Process. If the data is managed externally, you cannot modify the equivalent number from within Agile PLM for Process.

If the cross-referenced database is managed from within Agile PLM for Process, you can modify the equivalent value in the Equivalent field in this table.

Note: Only an Agile administrator can turn the Externally Managed flag on or off. For more information on this feature, please see the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Status—Dropdown choice of status. This list is managed in ADMN. This is a required field.

Figure 3–2 Cross References section

Cross References								
	System Name	System ID	Equivalent	Description	UOM	Externally Managed	Status	
1	 FS System	TSFS	TSFS-123			<input type="checkbox"/>	Active	
2	 BPCS System	USBPCS	BPCS-123			<input type="checkbox"/>	Active	
3	 Oracle2 System	ZORCAL	ORA2-123			<input type="checkbox"/>	Active	
4	 Oracle System	USORACLE	ORA-123			<input type="checkbox"/>	*20120913	

Add New

Approved for Use in Section

The Approved for Use In section contains a list of business units that the specification is approved for use in. Business Units is a required field. Business Unit is used in relation to search visibility. The Business Unit field can also be used as the deciding factor in workflow resolution.

This section is configurable. One configuration is Concepts and Business Unit; the other is Business Units and Countries, as shown in the figures below.

Figure 3-3 *Approved for Use In section with Concepts and Business Units fields*

Approved for Use In

Concept(s): 

Business Unit(s): 

Figure 3–4 *Approved for Use In section with Business Units and countries fields*

Approved for Use In			
	Business Unit(s)	Countries	
1	+ CPI North America	+	✖

Add New

Compliance Tab

The Compliance tab contains the compliance, additive, allergen, and intolerance data related to a specification. Depending on your system configuration, some of these sections may not be visible.

Figure 3–5 Compliance tab

Water - Carbonated (5077462-001) Draft

Material Specification

Summary Formulation Nutrition **Compliance** Ext Data Related Specs CSS Supporting Documents References Appro

Compliance Information

Complies With:

Non-GM Kosher These fields were added using the type-ahead feature or by using the search icon.

Allergens

Known to Contain

	Allergens		Max / 100g	Source / Comments	
1	Ascorbic Acid	<=	5.00000 mg		
2	azo dyes	<=	10.00000 mg		
3	Single cell protein	<=	2.00000 g		

Add New

May Contain

	Allergens		Max / 100g	Source / Comments	
1	Peanut Contamination	<=	1.00000 mg		

Add New

Does not contain

Tree Nuts

Intolerances

Known to Contain

Complies With Section

Adding Complies With Items


To add items:

1. Click the search icon () located to the right of the **Complies With** field to open the Compliance dialog box. Select the compliance items to add on the left, holding down the **Ctrl** key to select multiple compliance items.
2. Click the add selected data icon () to move your selections to the right.
3. When you have made all of your selections, click **Done**. The page reloads and the Complies With field displays your choices.



Or, you can use the type-ahead feature to add a compliance item. As you type in the field, GSM displays a selection panel listing possible matches. Click the item you want to add.

Once items have been selected using type ahead or search, they appear below the field while in edit mode, as [Figure 3–5](#) shows. For more information, refer to the *Agile Product Lifecycle Management for Process Getting Started Guide*.


Removing Complies With Items

Compliance items can be removed in two ways. You can click the search icon and remove items using the compliance dialog box. Or you can delete individual items by clicking the remove item icon () next to the item name you would like to delete.

To remove one or more compliance items using the search tool:

1. Click the search icon () to open the Compliance dialog box.
2. Select the compliance items to remove on the right, holding down the **Ctrl** key to select multiple compliance items.
3. Click the remove selected data icon () to remove the selected items from the selection box.
4. Click **Done** to commit your changes. The page reloads and the Complies With field reflects your changes.

Compliance Import

Trade and menu item specifications contain an import icon () to the right of the Complies With field. This icon opens the compliance import dialog box.

Trade Specification Compliance Import

This tool will import the compliance attributes (complies with, allergens, additives, intolerances) found on the associated material specification.

A material specification is associated to a trade on the Related Specs tab > Material Specifications section.

Compliance attributes are calculated using the formulation specification. Once compliance attributes are on the output material and the output material is associated to a trade specification, this tool allows you to import the compliance values. This tool is meant to be a usability helper so compliance attributes that were already calculated do not have to be manually re-entered.

Note: The import process replaces all pre-existing compliance attributes on the trade specification. For example, if allergens A and B were already added to the trade specification the import process would remove allergens A and B when importing.

Warning: Make sure the breakdown on the output material specification is using Free Text or Component Catalog terms as breakdown components. If the output material breakdown is being used improperly and material specifications are used as components this tool will import values from the material specifications used as components. Since this tool does not perform calculations those compliance attributes will not be accurately represented. The formulation specification should be used to calculate compliance attributes.

See [Chapter 5, "Formulation Specifications"](#) for more information around compliance roll up.

Menu Specification Compliance Import

This tool will import the compliance attributes found on the associated specifications inside the menu item build section. With this tool the user would be able to see all compliance attributes down the menu item hierarchy. For example, Menu A contains Product AB and Product CD in its build. Product AB has a breakdown on it that includes Material Spec A and Material Spec B. Product CD has a breakdown on it that includes Material Spec C and Material Spec D. Compliance attributes on Product AB, Mat A, Mat B, Mat C and Mat D will be included in the import popup.

Note: Depending on your configuration, this feature may only go down one level of the menu item hierarchy.

This tool does not perform calculations. It is meant to be merely a usability helper so compliance attributes on all the menu build items can be seen in one location. The user can then decide which attributes to import onto the menu item specification.

Note: If the import tool finds the same compliance item on multiple specifications in the menu hierarchy it will not import the max 100g value. Since the tool is not calculating compliance attributes, the user is required to look at the values and manually type in a max 100g that is accurate.

Additives, Allergens, and Intolerances Sections


Note: The Additives, Allergens, and Intolerances sections all follow the same procedures. This section demonstrates the use of additives, but the same behavior can be used for allergens or intolerances.

The Additives section contains the additive data linked to a specification, and can be broken out by "known to contain," "does not contain," and "may contain."

Adding Additives

To add items:

1. Click **Add New** button to open the Additives dialog box.
2. Select the additives to add on the left.


3. Click the add selected data icon () to move your selections to the right.
4. When you have made all of your selections, click **Done**.
5. The page reloads, and the Additives table displays the additives that you selected.

To add/edit the Max/100g and Source/Comments values:

1. Click the **Max** field, and type the value.
2. Select a measurement from the 100g drop-down list.
3. Click the **Source/Comments** field, and type your comment.


Note: Max/100g values and Source/Comment values are only available for Known to Contain and May Contain fields.

Removing Additives

To remove a single additive, click the delete icon () when the specification is open for edit.

Note: As described above, removing values is only available for Known to Contain and May Contain fields.

To remove one or more additives:

1. Click the **Additives** link to open the Additives dialog box.
2. Select the additives to remove on the right.
3. Click the remove selected data icon () to remove them from the selection box.
4. Click **Done** to commit your changes.

Ext Data Tab

Select specifications contain custom data. Use custom data to enter customized information, in the form of extended attributes or custom sections.

The extended attributes and custom sections templates are created and maintained by your administrator.

Custom data can consist of:

- Extended Attributes
- Custom Sections

These are represented by sections on the Ext Data tab, as described below. For more information on creating custom data or extended attributes, see the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Warning: If you remove a custom section or extended attribute, the system deletes the data that you entered. Delete data with caution, because deleted data cannot be restored.

Extended Attributes Section

Extended attributes define important features and characteristics of the specification. You can build these attributes to meet specific needs, as shown in the figure below.

Two roles are associated with extended attributes:

- [ADD_EXT_ATT]—Users with this role can see and use the Add New button to add extended attributes.
- [REMOVE_EXT_ATT]—Users with this role can see and use the Delete column of the Extended Attributes grid to remove extended attributes.

Figure 3–6 Extended Attributes section

Extended Attributes			
	Extended Attributes		Notes
	Calories		
	Orange Flavor	2 g	Trace flavoring

Custom Sections

Custom sections are configurable sets of extended attributes. The custom data that you enter is displayed in a table, as shown in the figure below.

Two roles are associated with custom sections:

- [ADD_CUSTOM_SECTION]—Users with this role can see and use the Add Sections button to add custom sections.
- [REMOVE_CUSTOM_SECTION]—Users with this role can see and use the Remove Sections button to remove custom sections.

Figure 3–7 Custom section

Flavors		
Flavors	Flavor	Target
	Banana	2 g
	Cherry	2 g
	Mango	3 g
	Watermelon	2 g
Total	---	kg

Edit Section

Manage Custom Sections	
Add Sections	Remove Sections

Calculated Attributes

Some extended attributes inside the Extended Attributes table and in custom sections can be calculated. A calculated extended attribute is an attribute that references other specification attributes and performs calculations. When you add a calculated attribute to your specification, GSM calculates it when you click any of the following action buttons:

- **Calculate**
- **Save**
- **Save & Close**

GSM can calculate attributes only when the specification is in edit mode. If GSM encounters an error while calculating the attribute, it displays a calculation error icon (⚠️). In some cases, you can click the error icon to see error details.

Note: You can add each distinct attribute to a specification once only. Only distinct attributes inside the Extended Attributes table are pulled into formulation specifications for use in prototyping. Additionally, extended attributes tagged as design attributes will automatically be added to the output.

Adding a Custom Section

To add a custom section:

1. With the page in edit mode, click **Add Sections** inside the Manage Custom Section section. GSM displays a dialog box listing available custom sections. Select the custom sections to add on the left, holding down the **Ctrl** key to select multiple items.
2. Click the add selected data icon (➡️) to move your selections to the right.
3. When you have made all of your selections, click **Done**. The page reloads and the custom section is added to the specification.

Editing a Custom Section

To edit a custom section table, row, or column:

1. To add values to the custom section, click **Edit Section**. A dialog box displays the custom section in edit mode, as Figure 3–8 shows. The edit icon (✏️) displays for every editable row and column. It also displays in the upper left corner of the table, indicating you can edit the entire section. Depending on the size of your custom section, editing the entire section may not be available.

Figure 3–8 Custom section in edit mode

Flavors	Flavor	Target
	Cherry	2 g
	Grape	3 g
	Watermelon	5 g
	Lime	3 g
Total	---	100 kg

- Click the edit icon () and make appropriate changes to the table, row, or column. For repeatable rows, the add row icon () displays to the right of the edit icon. Use this icon to quickly add the repeatable row to the table. You can then set the row order using the reorder row icons ().
- Click the apply changes icon ().
- Click **Done**.
- Click **Save**.

To add a row:

- With the custom section in edit mode, click **Add Row**. GSM displays a dialog box listing rows that can be added.
- Select a row, and then click the add selected data icon ().
- Repeat step 2 to add additional rows.
- Click **Done**. GSM closes the dialog box. The added rows display in the table.
- Click **Save**.


To delete a row:

- With the custom section in edit mode, click the edit icon () on the row you want to delete.
- Click the delete row icon (). The row is deleted from the table.
- Click **Save**.

To add a column:


- With the custom section in edit mode, click **Add Column**. GSM displays a dialog box listing columns that can be added.
- Select a column, and then click the add selected data icon ().
- Repeat step 2 to add additional columns.
- Click **Done**. GSM closes the dialog box. The added columns display in the table.
- Click **Save**.

To delete a column:

1. With the custom section in edit mode, click **Remove Column**. GSM displays a dialog box listing columns that can be deleted.
2. Select a column, and then click the add selected data icon ().
3. Repeat step 2 to delete additional columns.
4. Click **Done**. GSM closes the dialog box. The selected columns no longer appear in the table.
5. Click **Save**.

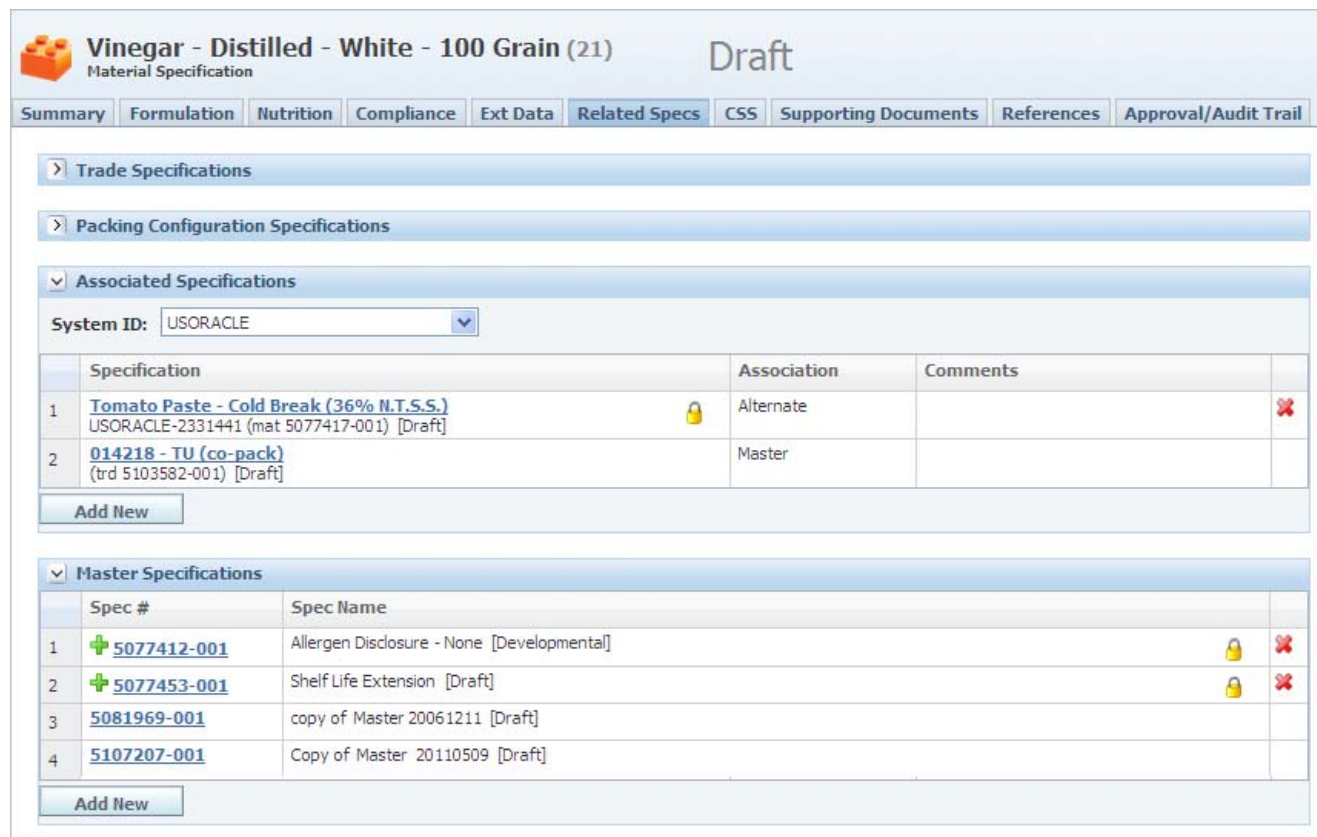
Deleting a Custom Section

To remove a custom section:

1. With the page in edit mode, click **Remove Sections**. GSM displays a dialog box listing custom sections available for deletion. Select the custom sections to delete on the left, holding down the **Ctrl** key to select multiple items.
2. Click the add selected data icon () to move your selections to the right.
3. When you have made all of your selections, click **Done**. The custom sections are removed.
4. Click **Save**.

Related Specs Tab

Figure 3–9 Related Specs tab



Vinegar - Distilled - White - 100 Grain (21) Draft

Material Specification

Summary Formulation Nutrition Compliance Ext Data **Related Specs** CSS Supporting Documents References Approval/Audit Trail

> Trade Specifications

> Packing Configuration Specifications

▼ Associated Specifications

System ID: USORACLE

	Specification	Association	Comments
1	Tomato Paste - Cold Break (36% N.T.S.S.) USORACLE-2331441 (mat 5077417-001) [Draft]	Alternate	
2	014218 - TU (co-pack) (trd 5103582-001) [Draft]	Master	

Add New

▼ Master Specifications

	Spec #	Spec Name
1	5077412-001	Allergen Disclosure - None [Developmental]
2	5077453-001	Shelf Life Extension [Draft]
3	5081969-001	copy of Master 20061211 [Draft]
4	5107207-001	Copy of Master 20110509 [Draft]

Add New

Associated Specifications Section

In this section you can relate the current specification to one or more specifications in the system. The Associated Specifications section, shown in [Figure 3–9](#), provides a context for that relationship. You can define pairs of contexts (such as "source/by-product" or "primary/alternate") and can apply these contexts to both sides of an association. These relationships will depend on your system configuration.

For example, "Formulation Specification ABC" could be associated to one or more formulation specifications as alternates. These formulations would be declared and visible as "alternates of Formulation Specification ABC." On the individual formulation specifications, "Formulation Specification ABC" would be automatically displayed as a "Primary."

System ID is a code that identifies an external system. Select a system ID to display the cross reference of the specification listed in the specification column. The equivalent number will appear before the specification number.

This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Master Specifications Section


This section displays all master specifications that have been implicitly associated to the specification, as shown in [Figure 3–9](#). You can also explicitly associate one or more master specifications to the specification using this section. See [Chapter 17, "Master Specifications"](#) for more information.

CSS Tab

The sole section in the CSS (content synchronization and syndication) tab, Initial Publication, contains the list of publications related to the specification.

You can create initial publications only from within GSM. Using the CSS application, you can syndicate these publications to an internal or external target system. Once created, these publications can be managed on the CSS tab of the specification or they can be managed inside the CSS application. As shown in [Figure 3–10](#), this section contains additional data about each publication.

Figure 3–10 CSS tab


BBQ Beef and Vegetable Dinner - 11 oz (501)
 Trade Specification

Packaging Engineering Review

Summary | Packaging | Compliance | Ext Data | Related Specs | **CSS** | Supporting Documents | References | Approval/Audit Trail

Initial Publication

	Trading Partner	Publication Type	Target Market	Initial Publication	Last Updated	Info Provider	Manufacturer	Current Status	
1	US » UCC » SuperValu (Champaign, IL) - 0041130051616	Initial Load	US	-----	3/21/2011	CPI	CPI	Draft GS1:	✖
2	US » UCC » Albertsons - 0041163000001	Initial Load	US	-----	3/21/2011	CPI	CPI	Draft GS1:	✖
3	US » UCC » SuperValu (Anniston, AL) - 0041130051623	Initial Load	US	-----	3/21/2011	CPI		Draft GS1:	✖
4	US » PDK » Prodika Syndication WebService PDK_WS	Initial Load	US	-----	3/21/2011	CPI	CPI	Draft GS1:	✖
5	US » UCC » SuperValu (Eastern Region) - 0041130029004	Initial Load	US	-----	3/21/2011	CPI	CPI	Draft GS1:	✖

Add New

Validate For Publication

Adding a Publication

To add an initial publication:

1. Click **Add New** under the Initial Publication table. The publications requirements dialog box displays.
2. Specify the following required data:
 - **Manufacturer** — Defines the source of the data being syndicated. For Global Data Synchronization Network (GDSN) compliant target systems, this is the Global Locator Number or GLN of the information provider.
 - **Publication Type** — Used for GDSN compliant target systems. Typically this is used to tell retailers if it is the first time they have received this product information or if they already have it and should update their information.
 - **Target Market**—Defines the destination for the syndicated data. Publications are organized by target market. Target market is a GDSN term used to indicate the country where the trade item is available for sale. For example, the US and Canada are two different target markets.

Note: This information resides on the Summary tab of the saved publication.

3. Click **Done**. The publication appears in the Initial Publication table. The default starting status for publications depends on the configuration of the publication workflow.

Note: You cannot view publications with a current status of "Draft." Statuses are controlled and updated automatically by the publication workflow.

Validating a Publication

When you validate a publication, the validation rules defined for that publication are investigated against the related specification data.

To validate a publication:

Click **Validate For Publication** under the Initial Publication table. If there is more than one publication on a specification, the validation rules configured for the publications are run and the error messages that exist display at the top of the CSS tab. You can tell which specification is causing the error condition because the error messages contain the specification number. Once all of the errors are resolved and the validation routine passes, a message that states that the publication is valid for publication is displayed


For more information, please see the *Agile Product Lifecycle Management for Process Content Synchronization and Syndication User Guide*.

Supporting Documents Tab

The Supporting Documents page includes sections which vary depending on specification type. The following sections are found on most specification types:

- "Supporting Documents Section" on page 3-18
- "DRL Documents Section" on page 3-23
- "Testing Protocols Section" on page 3-25
- "% Breakdown (Formula) Section" on page 3-25

Figure 3–11 Supporting Documents tab


Vinegar - Distilled - White - 100 Grain (21)
Draft

Summary Formulation Nutrition Compliance Ext Data Related Specs CSS **Supporting Documents** References

Supporting Documents

	Supporting Documents for this Specification	Security Classification	
1	Attachments/Procedures - test - EC1.1-User-Guide.pdf		✖
2	Attachments/Procedures - test - Batch Record AP100.doc		✖
3	Attachments/Procedures	Attachments -- Contextual	✖

Attachments/Procedures
URL
Rich Text
View Thumbnails

DRL Documents

	Name	Type	
1	test	Document	✖
2	Corporate	Catalog	✖

Add - Browse
Add - Search

Testing Protocols

	Protocol #	Testing Protocol	Scope	Status	
1	0001006	Auburn Heights Plant - Local tp (12/28/2005)	Spec	Active	✖
2	0001012	(5/22/2008)	Spec	Active	✖
3	17	Dallas DC, Bellingham - test (3/1/2005)	Global	Inactive	✖

Add New
Pull from Library

Supporting Documents Section

The Supporting Documents section enables you to add unique documents to the specification. You can add the following document types:

- Attachments/Procedures
- URL
- Rich Text

Note: The Supporting Documents section is unique to each specification type. Not all document types can be found on all specification types.





Creating a Supporting Document

The specification needs to be in edit mode before you can add a supporting document to it.

To create a supporting document:

1. Click **Edit** in the action menu. The page reloads with several buttons displayed below the table in the Supporting Documents section, as [Figure 3–12](#) shows.

Figure 3–12 Supporting Documents section (*Printed Packaging Specification example*)

Supporting Documents		
	Supporting Documents for this Specification	Security Classification
1	Attachments/Procedures - attachment - Attach.txt	
2	Attachments/Procedures - pict - pict1.bmp	
3	Attachments/Procedures - test - European rounding.doc	
4	Rich Text - RTF-Doc	
Attachments/Procedures URL Rich Text View Thumbnails		

2. From the buttons below the supporting documents table, click the type of document to create. GSM displays a dialog box for the type you selected.
3. Provide information for the supporting document, and then click **Done**. The supporting document is added to the table.


Managing Supporting Documents

To view a supporting document, click the hyperlinked document name. You can only edit supporting documents when the specification is in edit mode.

To edit a supporting document:

1. When the specification is in edit mode, open the document by clicking the hyperlinked document name. GSM displays a dialog box for the document you selected.
2. Make changes to your document, and then click **Done**.
3. Click **Save** to save your changes.

To delete a supporting document:

1. When the specification is in edit mode, click the delete icon () next to the supporting document. The document is deleted from the specification.
2. Click **Save** to save your changes.

Document Types

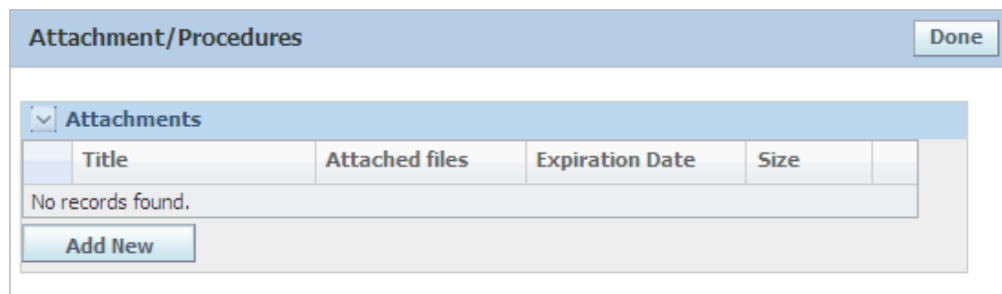
Attachments/Procedures Document Type

An attachment/procedures document is a collection of attachments. Use the Security Classification field to assign a security level to the document. This field appears when object level security (OLS) is configured on.

To add an attachment to a document:

1. Click **Attachments/Procedures** below the attachments table. The Attachment/Procedure dialog box displays, as shown in [Figure 3–13](#):

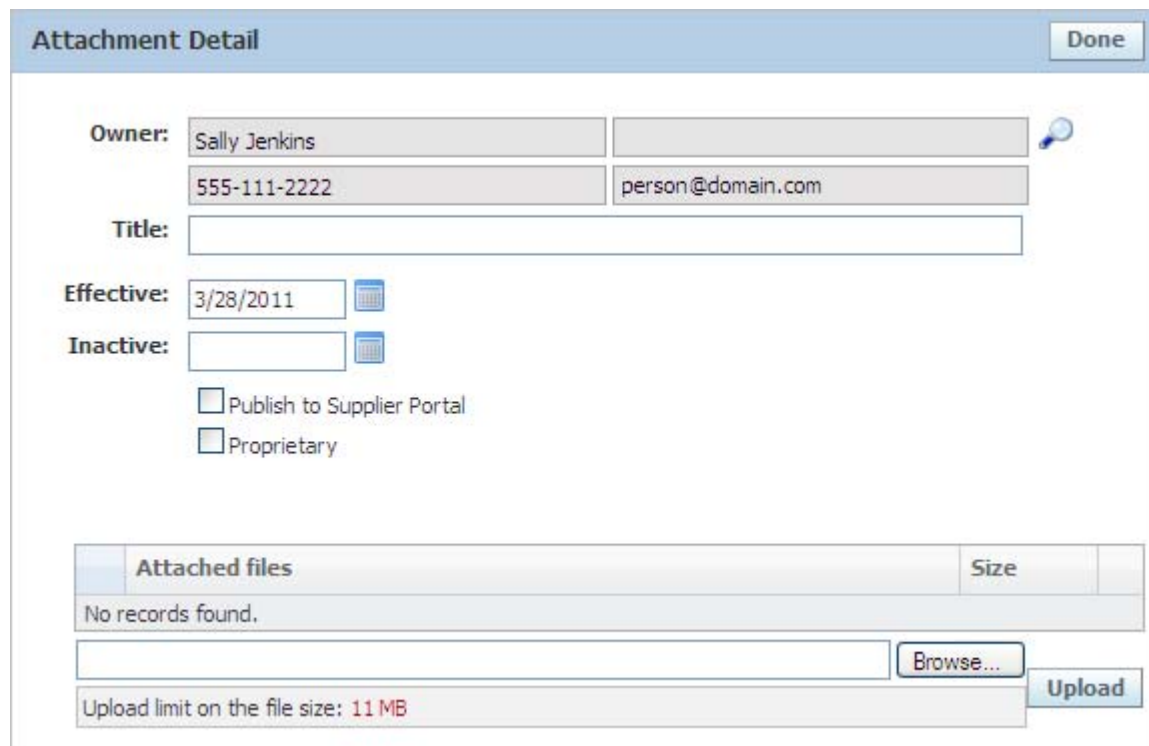
Figure 3–13 Attachment/Procedures dialog box



The dialog box has a title bar "Attachment/Procedures" with a "Done" button. Below the title bar is a section titled "Attachments" with a dropdown arrow. Underneath is a table with columns: Title, Attached files, Expiration Date, and Size. The table is empty, and the text "No records found." is displayed below it. At the bottom of the section is an "Add New" button.

2. If Object Level Security is enabled, select a **Security Classification** from the drop-down list.
3. Click **Add New**. GSM displays the Attachment Detail dialog box, shown in [Figure 3–14](#).

Figure 3–14 Attachment Details dialog box



The dialog box has a title bar "Attachment Detail" with a "Done" button. The main area contains several fields: "Owner:" with a text box containing "Sally Jenkins" and a search icon; a text box containing "555-111-2222"; a text box containing "person@domain.com"; "Title:" with a text box; "Effective:" with a date picker showing "3/28/2011"; "Inactive:" with a date picker; and two checkboxes: "Publish to Supplier Portal" and "Proprietary". Below these fields is a table with columns "Attached files" and "Size". The table is empty, and the text "No records found." is displayed below it. At the bottom of the section is a text box, a "Browse..." button, and an "Upload" button. Below the text box is a message: "Upload limit on the file size: 11 MB".

4. Complete the following fields, as shown below:

Table 3–2 Attachment Detail fields

Field	Definition
Owner	Owner of the attachment
Title	Title of the attachment
Effective	Effective date of the attachment
Inactive	Inactive date of the attachment. When you select an inactive date, GSM displays the Notify Prior to to Expiration Date checkbox field and the Number of Days Prior field. If desired, use these fields to set a notification for an expiration date.
Publish to Supplier Portal	Check this box if you want to publish the attachment on Supplier Portal
Proprietary	Check this box to prevent the attachment from being exposed in Supplier Portal or from being printed

5. Attach the file by clicking **Browse** to search for the file, and then click **Upload**. Click **Done** on the Attachment Details dialog box and then click **Done** on the Attachment/Procedures dialog box.
6. Click **Save**.

URL Document Type

You can store a URL link as a document by clicking **URL** below the Supporting Documents table. GSM displays the URL Detail dialog box, displayed in [Figure 3–15](#).

Figure 3–15 URL Detail dialog box

The screenshot shows a 'URL Detail' dialog box. At the top, there's a title bar with 'URL Detail' and buttons for 'Done' and 'Cancel'. Below the title bar, there's a dropdown menu currently set to 'URL'. Underneath the dropdown, there are several input fields: 'Title' (empty), 'Effective' (containing '3/28/2011' with a calendar icon to its right), 'Inactive' (empty with a calendar icon to its right), a checkbox labeled 'Publish to Supplier Portal' which is unchecked, and a 'URL' field containing 'http://'.

These URLs will not be available through the print model, eQ, or Supplier Portal. Key fields include:

Title—Name for the web page link

URL—Address for the URL

Rich Text Document Type

You can store a rich text document as a document by clicking **Rich Text** below the Supporting Documents table. The rich text document type is a way to create a formatted attachment to the specification that can be printed in line with the printed specification. The rich text document includes a title and an enriched textual entry.

Figure 3–16 Rich Text dialog box

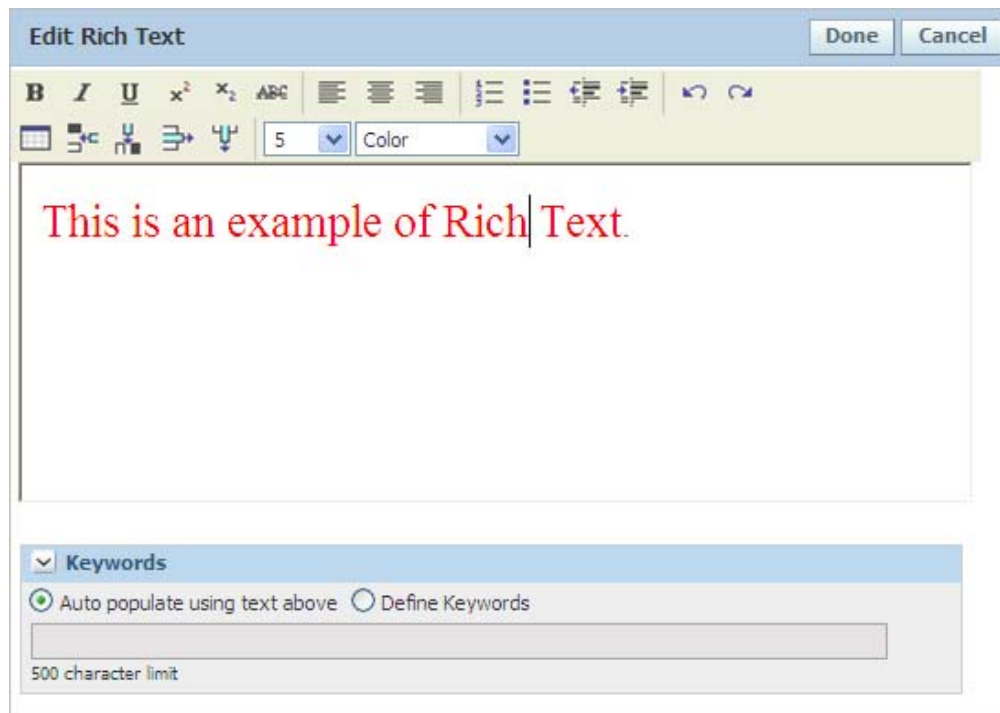


The dialog box is titled "Rich Text" and has "Done" and "Cancel" buttons in the top right corner. It contains a "Title:" label followed by a text input field. Below this, there are two labels: "Rich Text:" and "Keyword(s):", both of which are underlined and appear to be hyperlinks.

To add rich text:

1. Enter a **Title** (optional).
2. Click **Rich Text**. The rich text dialog box opens.

Figure 3–17 Rich text formatting dialog box



The dialog box is titled "Edit Rich Text" and has "Done" and "Cancel" buttons in the top right corner. It features a rich text editor toolbar with icons for bold (B), italic (I), underline (U), subscript (x²), superscript (x₂), text color (ABC), bullet points, numbered lists, indent, and outdent. Below the toolbar is a text input field containing the text "This is an example of Rich Text" in red. At the bottom, there is a "Keywords" section with a checkbox and two radio buttons: "Auto populate using text above" (selected) and "Define Keywords". Below the radio buttons is a text input field with a "500 character limit" label.

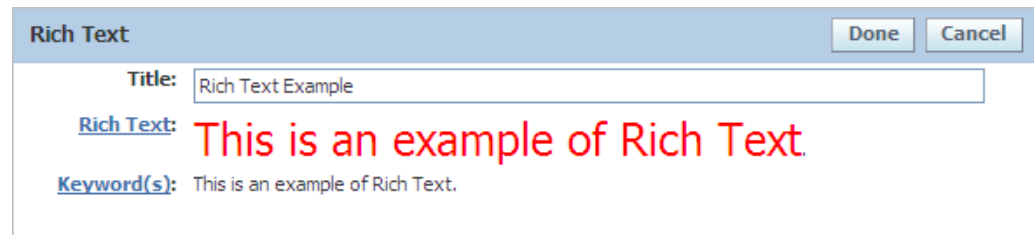
3. Use the rich text formatting dialog box to enter text and apply simple formatting (boldface, font color, font size, bullets, numbering, and so on.)
4. Click **Done**, or to enter keywords, complete the Keywords section as described below.

Keywords can be used to search against specifications that have rich text. To add keywords:

1. Click the **Keywords** header. Select one of the following radio buttons:

- **Auto populate using text above**—Selected by default, the first 500 characters entered in the rich text field are automatically added to the Keywords section.
 - **Define Keywords**—Select to manually enter keywords.
2. Click **Done**. GSM closes the rich text formatting dialog box, and your changes are reflected in the Rich Text dialog box, as [Figure 3–18](#) shows:

Figure 3–18 Sample Rich Text dialog



View Thumbnails

In some specifications, you can view attached images in a thumbnail view for supported file formats:

.jpeg
.bmp
.jpg
.gif
.wmf

Click the **View Thumbnails** link to open a dialog box showing all supported image types in thumbnail format.

DRL Documents Section

In the DRL Documents section you can link the specification to existing DRL (Document Reference Library) catalog and document references. All referenced catalogs and documents are read only. DRL catalogs and documents are created and managed using the DRL application. For more information about the DRL application, see the *Agile Product Lifecycle Management for Process Document Reference Library User Guide*.

A DRL catalog is a collection of DRL documents and child catalogs. The DRL table consists of two columns: Name and Type. Name displays the DRL document or catalog name. The type column identifies the linked DRL item as either document or a catalog.

Viewing DRL Catalogs and Documents

You can view a DRL document or catalog by clicking on the linked name.

Viewing a Catalog Reference

A catalog opens the DRL catalog viewer dialog box. In this view you can expand the catalog to view its contents. Select a document name to open the DRL document viewer.

Viewing a Document Reference

Documents open the DRL document viewer dialog box. A DRL document contains the following sections:

- ["Description Section"](#) on page 3-24
- ["Version/Revision Section"](#) on page 3-24
- ["Attachments Section"](#) on page 3-24

Description Section

This section contains the overall identifying information of the DRL document. It includes the document name, description, and status. It also lists which catalogs, business units, and classifications the document is assigned to.

Version/Revision Section

Use this information to track versions and revisions for the document. This section includes:

- Document ID
- Version and reason for revision, if revised
- Originator of the document
- Document date
- Effective date
- Expiration date
- Whether or not the document is publishable to the Supplier Portal

Attachments Section

This table lists all of the attachments added to the document. It includes attachment name, file name, and file size. You can view an attachment by anywhere in the row.

Adding DRL Catalog and Document References

In order to add a DRL catalog or document, you need to place the specification in edit mode. You can add DRL catalogs and/or documents to the DRL section in two ways: browsing and searching.

Browsing — Click **Add - Browse**. The DRL browse dialog box displays. You can link an entire catalog of documents or a specific individual document. Each linked node is a catalog. Click the link to expand the catalog and view its contents. A catalog can hold other catalogs and individual documents.

Searching — Click **Add - Search**. The DRL search dialog box opens. You can search for documents using the provided criteria. Refer to the *Agile Product Lifecycle Management for Process Getting Started Guide* for more information about searching.

Testing Protocols Section

In the Testing Protocols section you can link testing protocols to the specification. For a more detailed discussion of testing protocols, please see [Chapter 19, "Testing Protocol Library"](#).

The specification needs to be in edit mode before you can add a testing protocol. You can add testing protocols to the section in two ways:

Add a new protocol—Click **Add New**. The testing protocol dialog box displays, allowing you to create a new testing protocol. This testing protocol will be specific to this specification.

Add an existing protocol—Click **Pull from Library**. The testing protocol search dialog box displays. You can search for testing protocols using the provided criteria. Refer to the *Agile Product Lifecycle Management for Process Getting Started Guide* for more information about searching.

Note: Protocols from the testing protocol library are managed centrally. Changes made in the testing protocol library will be reflected on any specification which consumes that testing protocol.

Select protocols from your search results by clicking anywhere in a row, thereby adding the protocol to the selection box below it. When you are finished adding protocols, click **Done** to add the testing protocols to the specification.



% Breakdown (Formula) Section

The % Breakdown (Formula) section describes the composition of the material at the component level. For example, a "Spice Blend" material specification would contain a breakdown with the components black pepper, salt, red pepper and garlic powder.

Regulatory breakdowns added to the material specification will be used when creating ingredient statements. All material specifications should have a regulatory breakdown defined before using it in a formulation specification. Materials that can't be broken down further into components still need a breakdown. For example, the specification "Black Pepper" would have a breakdown with one component of "Black Pepper" at 100%.

Note: For trade specifications, this section only appears when the item type is "co-pack." When it is available, this section appears on the Supporting Documents tab. For product and material specifications, this section is available on the Formulation tab.

Figure 3–19 % Breakdown section

▼ % Breakdown					
	% Breakdown	Restrictions	Formulation Classifications	Tags	
1	 formula 1			Do Not Publish to Supplier	
2	Breakdown	USA	Internal Private	Suppress Printing, Do Not Publish to Supplier	
Add New					

Key fields include:

Restrictions—This is used to help categorize different versions of the breakdowns for usage in the Listed Ingredient Order (LIO) tool

Formula Classifications—Formula classifications can be used to enforce security for individual specifications. Classifications can be managed in the Admin Tool and are tied to user groups. Only users in the associated groups can view formulas that have a formulation classification.

Tags—Breakdowns can be tagged. Tags help identify breakdowns and most tags help define how you want the system to react to the breakdown. Available tags are listed below in "Tags" on page 3-27.

Click **Add New** to add a breakdown. GSM displays the Formula detail page, shown in [Figure 3-20](#).

Figure 3–20 *Formula detail page*

Formula
Done Cancel

▼ Publish Settings

Description: Regulatory Breakdown

Restrictions: USDA

Formulation Classifications:

Internal Private X

Tags:

Master Formula X Regulatory X

▼ Related Sourcing Approvals

Company Name	Facility Name	Receiving Facilities	Status
No records found.			

Add New

▼ Formula

	Component	Description	Formulation Tags	Formulation	Range	Total Moisture	Function	Critical	
1	+ Water	Water Processing Aid ●	Processing Aid	60.00000%	min: 60.00000% max: 75.00000%	100.00000%		<input type="checkbox"/>	✖
2	+ Wheat Oats	dried wheat oats ●		25.00000%	min: 25.00000% max: 30.00000%	3.00000%		<input checked="" type="checkbox"/>	✖
3	+ salt	standard salt ●		2.00000%	min: 1.00000% max: 4.00000%	0.00000%		<input type="checkbox"/>	✖
4	+ Sugars	Sweetner ●		13.00000%	min: 10.00000% max: 25.00000%	2.00000%		<input type="checkbox"/>	✖
				Total : 100%	min: 96% max: 134%				

Add New
Multi Add
Order

Formula Detail

On the Formula detail page you can capture header information about the breakdown, such as publication, sourcing, and formulation information. This page is where the itemized % breakdown is captured and defined.

Publish Settings Section

In this section you can capture information that helps determine how to use this breakdown elsewhere in the system. Key fields include:

Description—Name of the breakdown that will be used to identify the breakdown in the breakdown section and LJO.

Restrictions—A list of configurable tags that you can assign to the disclosure to prevent use in the LIO process. LIO will only use disclosures with the same restriction(s) or no restrictions applied.

Formula Classification—You can use formula classifications to enforce security for individual specifications. Your Agile administrator can manage classifications in the admin tool. Classifications are tied to user groups. Only users in the associated groups can view formulas that have a formulation classification.

Tags

- **Master Formula**—Denotes that this formula is considered the master formulation. Only one breakdown can be marked as master per specification. This tag is for informational purposes only; no system behavior is tied to this tag.
- **Regulatory**—Designates which breakdown will be used during formulation specification theoretical breakdown creation. Only one breakdown can be marked as regulatory per specification. Breakdowns created by a formulation specification will be automatically tagged as regulatory.

Warning: If the breakdown is on a formula output, this breakdown could be possibly overwritten during formulation. See [Chapter 5, "Formulation Specifications"](#) for more information.

- **Do Not Publish to Supplier**—Denotes that this breakdown will not appear in Supplier Portal and eQ.
- **Suppress Printing**—Keeps the breakdown from being included in the specification print out.

Note: Depending on your configuration , the system will automatically add specific tags to a breakdown when it is created.

Related Sourcing Approval Section

In this section you can associate an existing supplier with this formulation. You can select a supplier from any of the current sourcing relationships that are related to the specification. These relationships help determine visibility to the % breakdown in the Supplier Portal.

Formula Section

In this section you can declare the breakdown along with associated information such as moisture or function.

Using material specifications as components is intended for Food Service specifications and Co-Pack trade specifications. When creating breakdowns for raw materials that will be used inside formulation specifications or breakdowns for output materials, component catalog terms or free text components should be used.

The Formula grid contains the following fields:

Component—Name of the breakdown component. This is generally a component catalog term, however it is possible to configure your system to allow free text components. Component Catalog terms are recommended, allowing you to take full advantage of LIO. See [Chapter 18, "LIO Profiles"](#) for more information.

Description—Description of the breakdown component.

Formulation Tags—These tags help further define and classify the component and can be used during formulation and labeling. When a component is added, tags defined in component catalog will automatically be added.

Note: Depending on your configuration you may see the following legacy fields. These fields are used only for descriptive purposes and are not included in formulation calculations.

Country of Origin—Country of origin for the breakdown

Complies With—Compliance items related to the breakdown

Formulation—The percentage of the material that is made up of this component.

Range—Some components are defined as a range instead of a specific value. For example, it is between 5% and 10% of the material.

Total Solids—Percentage of the specification that is not water. Based on your configuration, this might display as **Total Moisture**.

Function—Defines the function of the particular component to the overall material. For example, acid, color, or preservative.

Critical—Denotes if the component is critical to the material's formulation.

References Tab

The Reference page contains the list of all reference data linked to a specification. The following sections appear on most specification types:

- ["Suppliers Section"](#) on page 3-29
- ["Substitute Materials Section"](#) on page 3-30
- ["Activities Section"](#) on page 3-31
- ["LIO Profiles Section"](#) on page 3-31
- ["Related Documents Section"](#) on page 3-31
- ["Specification Dependencies Section"](#) on page 3-31

Suppliers Section

Supply Chain Relationship Management (SCRM) is the application dedicated to managing supplier information. However, you can manage some supplier-related tasks from within GSM. For detailed information on SCRM, see the *Agile Product Lifecycle Management for Process Supply Chain Relationship Management User Guide*.

The Suppliers section of the References tab displays a summary of sourcing approval documents that are associated with the specification. If you initiate the creation of a sourcing approval from within GSM, you can add new suppliers.

Note: A specification must be assigned to a workflow before it can be associated with a sourcing approval.

To add a new supplier to the specification:

1. With the specification in read mode, click **Add New > Blank**. The SCRM facility search dialog box opens.

Note: If you are not assigned the roles to create sourcing approvals from templates, you will not see the panel > Blank option. Instead you will only see the standard Add New button.

2. Search for the facility that will supply this specification. Refer to the *Agile Product Lifecycle Management for Process Getting Started Guide* for help with searching.
3. Select a facility. The SCRM application opens, displaying a new specification-related sourcing approval, with prepopulated specification and sourcing facility fields.

Note: Sourcing approvals can also be created directly from Supply Chain Relationship Management.

For more information on creating specification-related sourcing approvals, refer to the *Agile Product Lifecycle Management for Process Supply Chain Relationship Management User Guide*.

The **Add New > From Template** option is available to users with a create from template role. You can use this option to create a sourcing approval from a template.

To add a sourcing approval from a template:

1. With the specification in read mode, click **Add New > From Template**. The SCRM template search dialog box opens.
2. Search for the template the sourcing approval is tied to. Refer to the *Agile Product Lifecycle Management for Process Getting Started Guide* for help with searching.
3. Once a template is selected, you are directed to the new sourcing approval in SCRM. Enter any required data and click **Save**. You can follow the specification link on the sourcing approval to get back to your material.

You can also import sourcing approvals from an existing specification. This action creates a copy of an existing sourcing approval (referenced in the previous issue), linking it to your active specification.

To import a sourcing approval from an existing specification:

1. With the specification in read mode, click **Import**. GSM opens the Import Sourcing Approvals dialog box. If the previous issue of the specification has sourcing approvals, the dialog box will be populated with references to the sourcing approvals from the prior issue.
2. Click **Add Specs**. GSM opens the Specification Search dialog box.
3. Find the specifications that reference the sourcing approvals that you would like to import.
4. Once all of the specifications are selected, click **Add Specs** to apply your selections and close the dialog box. The Import Sourcing Approvals dialog box should now contain any sourcing approvals that existed on the selected specifications.
5. Select the sourcing approvals to add and click **Done**. The system creates new instances of sourcing approvals and populates them with data from the selected sourcing approvals.

The Suppliers section displays important identifying information from the specification. You can click the add data icon (+) to go directly to the sourcing approval. You can click the hyperlinked company or facility name to go directly to the SCRM company or facility profile.

Substitute Materials Section

The Substitute Materials section allows users to capture substitute materials for the raw materials. Substitutes can be added in read or edit modes. Users must have the role [SUBSTITUTE_MATERIAL_DEFINER] to create new or modify existing raw materials.

Key fields include:

- **Ranking**—Allows substitutes to be ranked. (ex: 1, 2, 3, 4)
- **Substitute Materials**—Substitute materials associated with this raw material.
- **Factor**—The factor to apply during the substitution process.
- **Substitute Restrictions**—Lists substitute restrictions, which are maintained in the Data Administration application. These restrictions will work to filter the substitutions available to the formulator. For more information about substitute restrictions, refer to the ["Formulation Attributes Section"](#) on page 5-8 in [Chapter 5, "Formulation Specifications"](#).
- **Tags**—Allows further indicators around substitutes to help guide selection (ex: Preferred, Summer Seasonal, Rare).

Activities Section

The Activities section displays all GSM activities that contain this specification as the primary object. The description of an activity is the activity's name and number. To view an associated activity, click anywhere in the row. This section also displays any activities where the specification is listed as a related object and the activity asked for it to be displayed on the specification. For more information on GSM activities, refer to [Chapter 20, "Activities"](#).

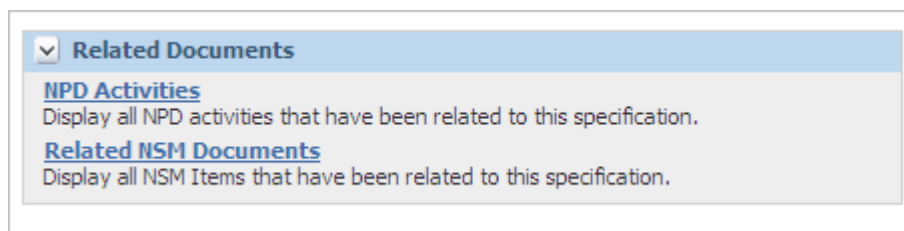
LIO Profiles Section

The LIO Profiles section displays for trade specifications, material specifications, and nutrient profiles, and lists related LIO profiles. Fields are LIO #, LIO Name, Status, Description, and Final Statement. Refer to [Chapter 18, "LIO Profiles,"](#) for more information.

Related Documents Section

The Related Documents section contains links to a listing of NPD activities and NSM documents that are related to a specification. This list contains system-generated information that is read only. Note that some specifications do not include the Related NSM Documents link.

Figure 3–21 Related Documents section



Click the **NPD Activities** link to open the NPD Activities dialog box. The dialog box displays all related NPD activities.

Refer to the *Agile Product Lifecycle Management for Process New Product Development User Guide* for more information.

Click the **Related NSM Documents** link to open the Related NSM Documents dialog box. The dialog box displays two sections: Nutrient Analysis and Nutrient Composite. The Nutrient Analysis section displays a table that contains the analysis number, date of analysis, source facility, and description. The analysis number is a link to the actual analysis associated with the specification. The Nutrient Composition section displays a table with composite number, date of composite, title, and description. The composite number is linked to the actual composite associated with the specification. Refer to the *Agile Product Lifecycle Management for Process Nutrient Surveillance Management User Guide* for more information.

Specification Dependencies Section

The Specification Dependencies section contains a Where Used link. When clicked, GSM displays a dialog box listing parent and child specifications that are directly or indirectly related on this specification. This information is read only.

The dialog box displays a table that contains the parent or child specification type and the number of specifications of that type that are related with the specification that you

are viewing. If you click the specification type hypertext link, the table expands and displays the specification number and name of all the dependent specifications.

Note: The specifications listed in the popup are configurable. For more information, please see the *Agile Product Lifecycle Management for Process Configuration Guide*.

You can go directly to a related specification by clicking on the linked specification name.

Figure 3–22 Specification Dependencies dialog box, expanded

Close			
Master	(1)		
Labeling	(23)		
Material	(10)		
5093215-001 TSN - Chicken Breast Filet - 114 g Target (Draft)	Child	Input	(frm) 5093338-001
5093216-001 TSN - Batter, Dry 1st Test (Draft)	Child	Input	(frm) 5093338-001
5093218-001 TSN - Breader 1st Test (Draft)	Child	Input	(frm) 5093338-001
5093212-001 TSN - Water (Draft)	Child	Input	(frm) 5093338-001
5093219-001 TSN - Oil - Soybean (Refined, Bleached, Deodorized) (Draft)	Child	Input	(frm) 5093338-001
5093214-001 TSN - Sodium Tripolyphosphate (Draft)	Child	Input	(frm) 5093338-001
5093213-001 TSN - Salt - Granulated - Food Grade (Draft)	Child	Input	(frm) 5093338-001
5088436-001 Lemon Juice - Single Strength (Draft)	Child	Output	(frm) 5093338-001
Packing Configuration	(6)		
Delivered Material Packing	(16)		

Trade Specifications

This chapter presents an overview of GSM capabilities regarding trade specifications. Topics in this chapter include:


- [Summary Tab](#)
- [Packaging Tab](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [CSS Tab](#)
- [Supporting Documents Tab](#)
- [Regulatory/Legislation Detail Page](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

Key sections in the Summary tab include:

- ["Summary Information Section"](#) on page 4-3
- ["Product Identification Section"](#) on page 4-3
- ["Product Classification Section"](#) on page 4-4
- ["Brand Information Section"](#) on page 4-5
- ["Cross References Section"](#) on page 3-5
- ["Approved for Use in Section"](#) on page 3-6

Figure 4–1 Summary tab


BBQ Beef and Vegetable Dinner - 11 oz (5077539-008)
 Trade Specification

CSS Syndication

Summary | Packaging | Compliance | Ext Data | Related Specs | CSS | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: BBQ Beef and Vegetable Dinner - 11 oz
Short Name: BBQ Beef and Vegetable Dinner - 11 oz
Access Level:
Spec Status: CSS Syndication - In this Workflow Step the tip will transition into the Initial Non-Ghost state.
Spec #: 5077539-008
Category: Meat, Poultry and Game
Sub Category: Meat, Poultry and Game - Prepared and Processed
Group: Meat, Poultry and Game - Prepared and Processed (Frozen)
Supercedes: 5077539-001 - BBQ Beef and Vegetable Dinner - 11 oz
Reason for Change:

Originator:
Effective: 1/31/2007
Available Date: 3/2/2005
End Available Date: 1/11/2006
Last Edit: Sunday, August 08, 2010

Product Identification

Item Type: Consumer Unit (co-pack)
Description: frozen dinner, BBQ beef and vegetables
GTIN/UPC/EAN: 00000000000123
PLU Description: BEEF BBQ DINNER
POS Description: BEEF BBQ DINNER

Product Classification

UDEX Classification: Frozen Foods - 14
 Meat/Poultry/Meat Substitutes With Additions (Frozen) - 435
 Beef With Additions (Frozen) - 144352387
GPC Code:
Country Of Origin: USA
Tax Type/Rate: 5 %
 VAT

Brand Information

Trading Company: CPI Company Ltd
Brand: Hearty Steaks
Sub Brand: Frozen Dinner
Product Name: BBQ Beef Dinner
Brand Description: Mr. Sky's BBQ Beef Dinner
Label Owner: Branded Manufacturer Label

Cross References

	System Name	System ID	Equivalent	Externally Managed	
1	SAP System	USSAP	5010040800AA	<input type="checkbox"/>	
2	BPCS System	USBPCS	ADD_2009071709184314727_0	<input type="checkbox"/>	

Add New

Approved for Use In

	Business Unit(s)	Countries	
1	CPI North America, CPI Syndication	USA	

Add New

Summary Information Section

Fields in the Summary Information section are described in "[Summary Information Section](#)" on page 3-3. For trade specifications, two additional fields are included:

Available Date—Indicates when the product will be available for a retailer to order.

End Available Date—Indicates when the product will no longer be available to order.

Product Identification Section

In this section you can document product identifiers like GTIN (Global Trade Item Number). Additionally, the Item Type chosen here determines which fields and sections appear elsewhere in the specification. Key fields include:

Item Type—The item type selected determines which fields and sections are visible on specification. For example, co-pack items have sections available to create supply associations and formulation breakdowns. These sections are unavailable for other trade item types. Available item types are as follows:

- **Consumer Unit**—Represents the lowest levels of the item hierarchy. This type can be used to represent Eaches and Inner Packs depending on what other specifications are linked to it.
- **Consumer Unit (co-pack)**—Represent the lowest level of the hierarchy that is produced for you by someone else. This type has the ability to record percent breakdown information and might be used for a can of green beans produced on your company's behalf.
- **Consumer Unit (not for resale - co-pack)**—Represents the lowest level of the hierarchy that is produced for you by someone else but is not intended for individual sale. This type might be used for a bottle of pickle relish in a picnic pack that is produced on your company's behalf.
- **Consumer Unit (not for resale)**—Represents the lowest level of the hierarchy that is not intended for individual sale.
- **Traded Unit**—Represents the orderable units of the item hierarchy. This type can be used to represent Cases, Pallets, Display Shippers, or Mixed Modules depending on what other specifications are linked to it.
- **Traded Unit (co-pack)**—Represents the orderable units of the hierarchy that are produced for you by someone else. This type has the ability to record percent breakdown information and might be used for a case or pallet of green beans produced on your company's behalf.
- **Traded Unit (no children - co-pack)**—Represents a specification that is both the orderable unit and the consumer unit all in one. It does not have any children linked to it but can have a percent breakdown. This type might be used for a barrel of vegetable oil that is produced on your company's behalf.
- **Traded Unit (no children)**—This type would represent a specification that is both the orderable unit and the consumer unit all in one. It does not have any children linked to it.

GTIN/UPC/EAN—This field is not visible for "Consumer Unit - Not for Resale" trade items.

PLU Description—This field is not visible for "Consumer Unit - Not for Resale" trade items.

POS Description—This field is not visible for "Consumer Unit - Not for Resale" trade items.

Most other specifications are static in nature, but the trade item is dynamic. The trade item specification can display different attributes, fields, or sections based on the item type selected.

Note: Item type options available will vary based on your configuration.

Product Classification Section

In this section you can declare any relevant product classification information. The trade item type declared on the specification affects which of these fields are visible (based on relevance).

Figure 4–2 *Product Classification section, Traded Unit example*

Product Classification

UNSPSC Code: [Empty field] [Search icon]

UDEX Classification: [Frozen Foods - 14] [Search icon]
[Meat/Poultry/Meat Substitutes With Additions (Frozen) - 435]
[Beef With Additions (Frozen) - 144352387]

GPC Code: [Empty field] [Search icon]


Country Of Origin: [USA] [Search icon]

Tax Type/Rate: [GST] [3] % [Search icon]


Key fields include:

UNSPSC Code—This field is not visible on Traded Unit (no children - co-pack), Traded Unit (no children), Consumer Unit (co-pack), or items not meant for resale.

UDEX Classification—Search against categories used by UDEX Electronic Exchange.

GPC Code—Click the search icon () to display a dialog box from which you can choose a GPC code taxonomy.

Note: If the UDEX Classification chosen has a direct mapping to a GPC Code, the GPC Code defaults to that value. Otherwise you can select the value.

Tax Type/Rate—Click the search icon () to display a dialog box from which you can choose a tax type. This field is not visible on items not meant for resale.

Brand Information Section

In this section you can declare any relevant brand information. Key fields include:

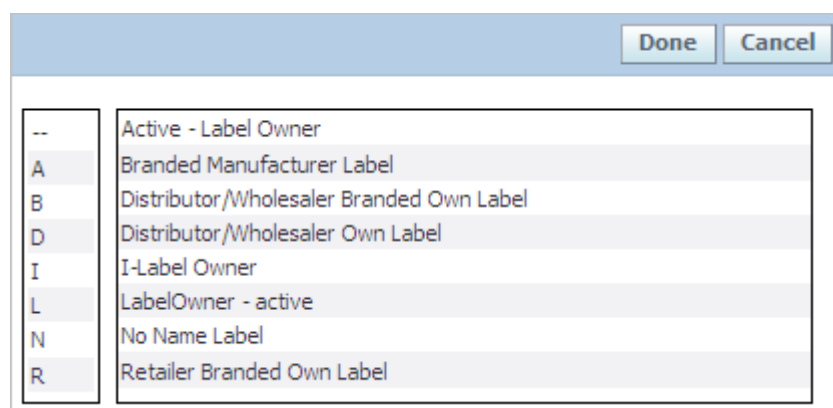
Trading Company—Click the search icon (🔍) to display a dialog box from which you can choose a company from a prepopulated list (configured by your administrator).

Brand—Enter a brand in the free text entry field, or click the search icon (🔍) to display a dialog box from which you can choose a brand name from a prepopulated list (configured by your administrator).

SubBrand—Free text entry field that you can use for a more granular level of information about brand, for example.

Label Owner—Click the search icon (🔍) to display a dialog box from which you can choose a label owner from a prepopulated list (configured by your administrator), as shown in [Figure 4–3](#).

Figure 4–3 *Label Owner dialog box*




Packaging Tab

This tab hosts all of the attributes necessary to describe the traded or consumer unit information, including dimensional and weight information, shelf life, and packaging details.

Key sections in the Packaging tab include:


- ["Packaging Attributes \(Consumer Unit\) Section"](#) on page 4-8
- ["Packaging Attributes \(Traded Unit\) Section"](#) on page 4-8
- ["Stacking Height Section"](#) on page 4-9
- ["Packaging Materials Section"](#) on page 4-10
- ["Alternate Packaging Section"](#) on page 4-10
- ["Storage Requirements Section"](#) on page 4-10
- ["Shelf Life Section"](#) on page 4-10
- ["Environmental Waste \(per item sold\) Section"](#) on page 4-10

Figure 4-4 Packaging tab

 **BBQ Beef and Vegetable Dinner - 11 oz (5077539-008)** CSS Syndication
Trade Specification

Summary **Packaging** Compliance Ext Data Related Specs CSS Supporting Documents References Approval/Audit Trail

Packaging Attributes (Consumer Unit)

Packaging Type: 

Label Weight:

Label Volume:

Container Net Weight:


Tare Weight:

Gross Weight:

Inner Pack:



Inner Pack Label Text:

Product Dimensions: Length Width Height Volume



Coding: 

Packaging Materials


ERP System:

	Pkg Type	Packaging Material Specification	Units	Scrap Factor	
1	Intermediate	 Carton - Beef w/BBQ Sauce (5077541-001) [CSS Syndication]	1 units	1.00000	

Alternate Packaging

	Packaging Material Specification	Units	Substitutes	Scrap Factor	
2	 Carton - Paper Board - Frozen Meal - 7 x 1.25 x 9 (5077540-001) [Draft]	1.02		1.00000	

Storage Requirements

Storage Requirements: 



Minimum Storage Temp:

Maximum Storage Temp:

Shelf Life


Shelf Life:

Environmental Waste (per item sold)

	Material Class	Weight	Percent Recyclable	% Composed of Recycled Materials	
1	 PAPER/BOARD	10 g	50.00%	50.00%	

Packaging Attributes (Consumer Unit) Section

Depending on the item type of the specification, different packaging attributes can appear in this section. The attributes below are designed to capture information about a consumer unit. Key fields include:

Packaging Type—Click the search icon () to display a dialog box from which you can choose a packaging type from a list of available types

Variable Weight—Select this flag if the traded unit is best represented by a min/max weight.

Variable Weight Type—"Pre-packed" and "Loose" represent how the product content is packaged.

Min Net Weight—The least weight that is acceptable for the product.

Max Net Weight—The greatest weight that is acceptable for the product.

Tare Weight—This section appears when the item type is a "consumer unit" or a "traded unit (no children)." For more information on tare weight and gross weight, see ["Tare Weight Section"](#) on page 11-2.

Gross Weight—Net weight + tare weight. Click the hyperlinked field label to choose.

Note: Net weight is defined as the weight of the food content or non-packaging related material.

Packaging Attributes (Traded Unit) Section

As with consumer units, depending on the item type of the specification, different packaging attributes can appear in this section. This section appears when the item type is a "traded unit." The attributes below are designed to capture information that help describe a traded unit, such as case and pallet information.

The Net Weight calculations for case and pallet on a traded unit trade specification use the net weight of the lower level item and the net weight of the case as packaging is accounted for in the tare weight value.

The Tare Weight calculation takes into account packaging at all levels of the hierarchy. If the user calculates the tare weight of the lowest level (no child trade items) consumer unit trade specification, GSM adds the packaging associated directly with the consumer unit and any packaging associated with the formulation specification that is linked directly to the consumer unit trade specification. The inclusion of the packaging associated with the formulation specification is dependent on a configuration.

The Gross Weight calculation has been modified so that it adds the net weight and the tare weight of the specification. Users can select the UOM prior to calculating. This allows them to select the final UOM instead of returning in the default UOM.

Figure 4–5 Packaging Attributes (Traded Unit) section

▼ Packaging Attributes (Traded Unit)

Packaging Type:

Bale-non-compressed

Product Type:

CASE

Variable Weight:

☐

Units Per Case:

12

Cases/Layer:

3

Standard Pallet

Number of Layers:

5

Cases/Pallet:

15

Case Size:

Length

7.00000

ft

Width

6.00000

ft

Height

5.00000

ft

Volume

210.00000

Cu. Ft

Net Weight

125.00000

lb

Tare Weight

Gross Weight

130.00000

lb

Pallet Size:

Length

7.00000

ft

Width

6.00000

ft

Height

5.00000

ft

Volume

210.00000

Cu. Ft

Net Weight

50.00000

lb

Gross Weight (w/o Pallet)

130.00000

lb

Gross Weight (w/ Pallet)

180.00000

lb

Coding:

coding

Key fields include:

Packaging Type—Click the search icon (🔍) to choose a packaging type from a list of available types.

Product Type—Choose a product type by selecting from a list of available types.

Stacking Height Section

In this section you can describe the stacking height information relevant to this specification. This section appears when the item type is a "traded unit."

Figure 4–6 Stacking Height section

▼ Stacking Height

Mode Stacking Height:

15

Warehouse Stacking Height:

17

Key fields include:

Mode Stacking Height—Enter the number of levels that the product can be stacked.

Warehouse Stacking Height—Enter the number of units that can be stacked in warehouse storage.

Packaging Materials Section

In this section you can describe the packaging associated with this specification by associating and categorizing packaging and printed packaging specifications.

Key fields include:

ERP System—This enables you to select the relevant cross-reference from the system so that the system's equivalent package identification number can be seen along with the Agile PLM for Process number. Changing this selection toggles the presentation of that equivalent number, but the preference is not stored as part of the specification.

Pkg Type—Enables you to categorize how the packaging is applied to this item, for example, whether it is considered inner, intermediate, label, or outer packaging.

Alternate Packaging Section

In this section you can describe the alternate packaging associated with this specification. You can do so by associating packaging and printed packaging specifications to the packaging that they are allowed to substitute for.


Key fields include:

Substitutes — Choose which piece of packaging (from the Packaging Materials section) that this alternate is meant to substitute for.

Storage Requirements Section

This section is for describing the storage requirements relevant to this specification.

Key fields include:

Storage Requirements—Click the search icon () to display a dialog box from which you can choose the storage requirements from a list of options.

Shelf Life Section

This section is for describing the shelf life relevant to this specification.

Environmental Waste (per item sold) Section

This section provides a place to log known waste materials for this specification along with other relevant attributes required for environmental waste reporting.

Key fields include:

Material Class—Click **Add New** to display a dialog box from which you can choose a material class from a prepopulated list.

Compliance Tab

Key sections in the Compliance tab include:

- "Label Claims Section" on page 4-11
- "Complies With Section" on page 3-7
- "Additives, Allergens, and Intolerances Sections" on page 3-9

Label Claims Section

The Label Claims section contains the label claims linked to a trade specification, as [Figure 4-7](#) shows. The label claims values and calculation rules are maintained by an administrator.

Figure 4-7 Label Claims section

The screenshot displays the 'Label Claims' section of a software interface. It features two primary input areas: 'Potential' and 'Actual'. The 'Potential' field has a dropdown menu showing 'Fat Free'. The 'Actual' field has a dropdown menu showing 'Lite or Light (w/ Total Fat disclosure)'. A green arrow points from the 'Potential' field to the 'Actual' field, indicating a relationship or flow. Search and calculate icons are present on the right side of each field.

Key fields include:

Potential—Select all of the possible label claims for the finished good. This field can be populated two ways. You can either use the search icon (🔍), or calculate the label claims by using label claims determination. To calculate label claims, select the calculate icon (🧮). GSM opens the label claims determination popup, shown in [Figure 4-9](#). See "Label Claims Determination" on page 4-11 for more information.

Actual—Select the actual label claims declared on the finished good. This field can be populated two ways. You can either use the search icon (🔍) or the copy field icon (📄). When you click the copy field icon, GSM displays a multi select dialog box containing all values in the potential label claims field. You can use the dialog box choices to populate the actual field only with potential options.

Label Claims Determination

Using the label claims determination feature, you can interrogate a product for claims applicability based on a centralized group of rules segregated by label claims authority.

1. Click the calculate icon (🧮). GSM opens the Label Claim Determination dialog box.
2. Some claims require another product to compare to, such as Low Fat. The system can evaluate comparative claims if you provide additional nutrient information that describes the comparative product. Select the Comparative/Reference Product tab and fill in the appropriate information needed. You can also import data from another trade specification by selecting the **Reference Product** using the search icon (🔍). Data will be imported from the trade specification's active nutrient profile. See [Figure 4-8](#).

Figure 4–8 Label Claim Determination dialog box, Comparative/Reference Product tab

Label Claim Determination [Close]

Claims Determination **Comparative/Reference Product**

Comparative/Reference Product

Reference Product: [Text Field]

Reference Amount: [0.00000] [g] [Unit Dropdown]

Serving Size: [0.00000] [g] [Unit Dropdown]

Classification: [IE8-Label Claims Classifications] [Dropdown]

Nutrient Composition

Nutrient	Ratio
Calories	[0.00000] kcal
Total Fat	[0.00000] g
Saturated Fat	[0.00000] g
Trans Fatty Acid	[0.00000] g
Cholesterol	[0.00000] mg
Sodium	[0.00000] mg
Dietary Fiber	[0.00000] g
Sugars	[0.00000] g

- On the Claims Determination tab, from the **Label Claim Authority** drop-down list, select a specific rule group to use for considering claims applicability.
- Click **Display Label Claims** to display the Applicable Claims table.

The system evaluates label claims against rules that you previously defined. All selected claims based on the label claims authority appear in the Applicable Claims table with color coding to show whether the claim may be made for the product.

When the system evaluates a claim as compliant, the Comments column displays supporting information for the claim along with one or more user-defined values supporting the assessment in the Calculation(s) column, as shown in Figure 4–9. If the system finds that the claim is invalid, no such information appears in the Comments column.

- Select the claims you want to push to the specification. All compliant claims are automatically selected. You can unselect any claims you do not want to push to the specification. Once you have all the claims selected, click the **Push Label Claims** button at the bottom of the grid. This action will close the dialog window and populate the potential label claims field with the selected claims. This action will replace all existing potential label claims in the field; if you would like to just

append to the list make sure the "Append to existing list" checkbox is selected. See Figure 4–9.

Figure 4–9 Label Claims Determination dialog box

Label Claim Determination

Close

Claims Determination

Comparative/Reference Product

☒ Applicable Claims

Label Claim Authority: US FDA Nutrient Claims 2005 Display Label Claims

<input checked="" type="checkbox"/>	Label Claim/Type of Claim	Yes/No	Comments	Calculations
<input checked="" type="checkbox"/>	Saturated Fat (Low)	Yes	Individual foods: 1 g or less per reference amount and 15% or less of calories from saturated fat. ATTENTION: Next to all saturated fat claims, must declare the amount of cholesterol if 2 mg or more per reference amount; and the amount of total fat if more than 3 g per reference amount (or 0.5 g or more of total fat for "Saturated Fat Free").	.5 g Saturated Fat (per RACC) 8.910891 % Calories from Saturated Fat
	Sodium (Light in Sodium)	No		
<input checked="" type="checkbox"/>	Total Fat (Low)	Yes	Individual foods: 3 g or less per reference amount (and per 50 g if reference amount is small).	.5 g Fat (per RACC)
	Sodium (Reduced/Less)	No		
	Sodium (Salt Free)	No		

Push Label Claims

☐ Append to existing list

Ext Data Tab

The Ext Data tab includes the following sections:


- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11.
- **Custom Sections**—For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11.

Related Specs Tab

The Related Specs tab contains the following sections:

- ["Material Specification Section"](#) on page 4-15.
- ["Next Lower Level Items Section"](#) on page 4-15.
- ["Parent Items \(Calculated\) Section"](#) on page 4-15.
- ["Nutrient Profile Section"](#) on page 4-15.
- ["Associated Specifications Section"](#) on page 3-15.
- ["Master Specifications Section"](#) on page 3-15.

Figure 4–10 Related Specs tab


Trade Consumer Unit 20090810 (5096371-001)
 Trade Specification

Approved

Summary | Packaging | Compliance | Ext Data | **Related Specs** | CSS | Supporting Documents | References | Approval/Audit Trail

Material Specification

Spec Name	Pack Size	Context	Qty
1 BBQ Sauce Dry Mix (5077419-001) [Certified]	USSAP-34193		500.00000 kg

Add New

Next Lower Level Items

Spec #	Spec Name	Quantity	GTIN/UPC/EAN
1 5077539-001	BBQ Beef and Vegetable Dinner - 11 oz [Packaging Engineering Review]	1	00000000000123

Add New

Parent Items (Calculated)

Spec #	Spec Name	GTIN/UPC/EAN
No records found.		

Nutrient Profile

Profile #	Nutrient Profile	Active Profile	Effective Date	Status
1 5077538-003	Beef w/BBQ Sauce [Draft]	<input type="checkbox"/>	Wednesday, January 17, 2007	Draft

Add New

Add Existing

Associated Specifications

Master Specifications

Material Specification Section

This section represents the material that was produced as a result of a formulation specification.

Key fields include:

Pack Size—A specific pack size can be selected using the pack size dropdown. For example, salt may be purchased in 5lb, 10lb, and 20lb bags. The pack size dropdown allows you to specify which pack size is being used in the formulation. When a pack size is selected the input quantity will be updated to reflect the unit of measures associated to the pack size.

Pack sizes are defined on the material inside the Cross References grid. See the "[Cross References Section](#)" on page 3-5 for more information.

Context—Used to specify which formulation specification actually produced the material.

Qty—Indicates how much of the produced material is actually going into the trade specification. The tare weight calculation uses this ratio when calculating the amount of packaging.

Next Lower Level Items Section

In this section you can capture the next lower level in the trade item hierarchy along with quantity information. This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Note: This section does not appear when the item type is a "Traded Unit (no children)" or "Traded Unit (no children - co-pack)."

Parent Items (Calculated) Section

This section shows the derived relationships based on other specifications that have referenced this specification as a lower level item.

Nutrient Profile Section

In this section you can create new or associate existing nutrient profiles for this specification.

Nutrient profiles are actually separate documents from the trade specification with their own workflows.

More than one nutrient profile can exist on a trade specification, but one of the nutrient profiles must be flagged as the "Active Profile" for usage in rollups elsewhere in the system and label claim determination. Only one nutrient profile can be marked as active.

CSS Tab

The CSS tab contains the data related to the list of publications of a specification to any internal or external target system. For discussion of this tab, please see "[CSS Tab](#)" on page 3-15.

Supporting Documents Tab

Key sections in the Supporting Documents tab include:

- **Supporting Documents**—The document types available are Attachments/Procedures, URL, and Rich Text. For discussion of this commonly used section, please see ["Supporting Documents Tab"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.
- **Testing Protocols**—For discussion of this commonly used section, please see ["Testing Protocols Section"](#) on page 3-25.
- **% Breakdown**—This section only appears on trade items that are identified as "co-pack." For discussion of this commonly used section, please see ["% Breakdown \(Formula\) Section"](#) on page 3-25.
- **Regulatory/Legislation**—Discussed below, at ["Regulatory/Legislation Section"](#) on page 4-16.

Regulatory/Legislation Section

The Regulatory/Legislation section displays summary details of the regulatory documents that have been created for this trade specification.

Key fields include:

Filing # — A system-assigned number associated with the regulatory filing.

Approval # — An internal tracking number that you can enter in the Regulatory/Legislative Detail page, Cover Page tab, Application Summary section. (See ["Application Summary Section"](#) on page 4-17.)

Regulatory/Legislation Detail Page

On the Regulatory Legislation Detail page you can generate and document data that supplements the trade specification in order to produce regulatory filing documentation.

This page is unusual in that you access it from within another tab (Supporting Documents). To access the Regulatory/Legislation Detail window, click anywhere in the row in the Regulatory/Legislation grid of the Supporting Documents tab. A new window opens with five tabs:

- ["Cover Page Tab"](#) on page 4-17
- ["Product Formula Tab"](#) on page 4-17
- ["Processing Procedures Tab"](#) on page 4-18
- ["Comments Tab"](#) on page 4-18
- ["Attachments Tab"](#) on page 4-18

Cover Page Tab

On the Cover Page tab you can define the application summary data including the application type. The application type in turn drives some of the relevant fields on the rest of the cover page.

Cover Page has the following sections:

- ["Application Summary Section"](#) on page 4-17
- ["\[Application Type\] Cover Page Section"](#) on page 4-17

Application Summary Section

In this section you can identify information that will help classify and generate a regulatory filing application such as the name of the product, the status, and the formulation specification to use to generate the procedures.

Key fields include:

Application Type— Controls which cover page attributes are visible and the printed format of the filing

Status—You can alter the status when the specification is in edit mode


Material Specification—Defines the produced material that the regulatory filing is being created for

Formulation Specification—Choose from a list of formulation specifications that are tied to this trade item. The formulation specification identified here is the one that the system uses to generate data elsewhere in the filing document.

[Application Type] Cover Page Section

This section enables you to capture information necessary for generating different regulatory forms.

Key fields include for the USDA sample include:

Agent Name, Address, Telephone No. — Click the search icon () to open a dialog box from which you can choose a company from a prepopulated list. When you select the company, the dialog box closes and the company name, address, and telephone number appear in the text box to the right of the field label.

HACCP Process Category — From the drop-down list, select an HACCP (Hazard Analysis and Critical Control Point) process category.

Click **Generate Formula/Procedures** to pull information from the selected formulation specification and nutrient profile to build the filing.

Product Formula Tab

The Product Formula tab contains only one section: Product Formula.

Product Formula Section

In the Product Formula section you can store an enriched text rendering of the product formulation for use when generating the document. Using the **Generate Formula** button, you can automatically generate an enriched text version of the formulation information from the label composition of the attached nutrient profile. This label composition will be generated when the LIO statement is pushed from the LIO profile to the nutrient profile. If LIO has not been performed, the label composition will not be present and the automatic rendering will not be available.

Processing Procedures Tab

Processing Procedures, the sole section in this tab, is for storing an enriched text rendering of the processing procedures that can be used when generating the document. You can use the **Generate Procedures** button to automatically generate an enriched text version of the processing procedures information from the formulation specification selected on the Cover Page tab.

Comments Tab

In Comments, the sole section in this tab, you can store enriched text comments for use when generating the document.

Attachments Tab

The Attachments tab contains the following sections:

- **Related Specifications**
- **Attachments**

Related Specifications Section

The section allows you to reference attachments from material and packaging specifications related to the product.

Attachments Section

In this section you can attach binary documents such as Adobe™ Acrobat (PDF) documents and Microsoft Office documents.

References Tab

The trade specification References tab contains the list of all reference data linked to a specification. Key sections in the References tab include:

- **Suppliers**—This section only appears on trade items that are identified as "co-pack." For discussion of this commonly used section, please see "[Suppliers Section](#)" on page 3-29.
- **Activities**—For discussion of this commonly used section, please see "[Activities Section](#)" on page 3-31.
- **LIO Profiles**—For discussion of this commonly used section, please see "[LIO Profiles Section](#)" on page 3-31.
- **Related Documents**—For discussion of this commonly used section, please see "[Related Documents Section](#)" on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see "[Specification Dependencies Section](#)" on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Formulation Specifications

This chapter presents an overview of the capabilities of GSM regarding formulation specifications. Topics in this chapter include:

- [Overview](#)
- [Concepts and Definitions](#)
- [Page-Level Functions](#)
- [Summary Tab](#)
- [Formulation Tab](#)
- [Process Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [CSS Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)
- [Costing](#)
- [Basis \(Input Attribute Overrides\)](#)
- [Snapshots](#)
- [Optimization](#)

Overview

Agile PLM for Process is commonly used for capturing data similar to the following:

- **General Recipe**—Defines the raw materials, quantities, and recipe to make a product without specific knowledge of a particular site or the equipment used to manufacture an item.
- **Site Recipe**—Derived from the general recipe to meet specific conditions or constraints for a site manufacturing an item. The site recipe might also contain local raw materials. The recipe is still not specific to a particular set of equipment, but may be specific to on site processing and storage capacity and constraints.

PLM for Process defers the following business processes to manufacturing execution systems. These requirements are commonly managed by the Master Recipe and Control Recipe found with manufacturing systems and are described as follows:

- Targeting a recipe to a specific manufacturing area or line.
- Differentiating recipes by equipment types or classes.
- Managing detailed scheduling scenarios.
- Preparing templates for individual batches.
- Creating real time manufacturing execution recipes modified to create a batch, defining a specific batch size, and defining lot level items and actual equipment Providing lot level tracking and tracing.

For additional information regarding these concepts please reference the following:

- S88 Standard—An industry standard methodology describing terminology and approaches for defining batch process recipes.
- Manufacturing Systems—Oracle provides software such as Oracle Process Manufacturing for execution scenarios.

Using a Formulation Specification

The formulation specification is where we document the process or recipe for one or more inventoried items. The formulation specification describes:

- The name of the formulation, which is often associated with the output item(s).
- The required materials with their quantities needed to make the item(s).
- The ordered preparation steps and instructions describing when and how to mix materials.
- Descriptive information about the formulation specification and the output item(s). Examples include:
 - Documents
 - Custom Data
 - Related Specifications
 - And various core attributes used to describe specific elements of the specification

In addition the formulation specification is the foundation for a number of tools that we use throughout the lifecycle of the specification. Examples of organizational goals and the tools provided by the formulation specification to help achieve these goals include:

- Capturing accurate data:
 - Modeling operational and moisture gain/loss to better reflect manufacturing conditions.
 - Describing the various items created by a formula including Products, Co-Products, and Waste.
 - Identifying alternate inputs and outputs that are available at the time of production.
- Making better decisions:
 - Rolling up an output's theoretical values for nutrition, compliance information, yield, and custom data in order to understand and verify if a recipe's goals have been achieved.

- Performing material substitutions using predefined and approved substitute items.
- Modeling appropriate batch sizes to better understand the impact of scaling.
- Optimizing a formula to achieve identified goals and constraints. See ["Optimization"](#) on page 5-43 for more information.
- Efficiently managing information:
 - Finding and reviewing historical recipes.
 - Creating new issues of formulations to reflect specification changes over time.
 - Capturing "Snapshots" of a given formula while developing a new or modified item, as described in ["Snapshots"](#) on page 5-41.
 - Verifying and approving accuracy through a formal workflow process.

Concepts and Definitions

Outputs

When material specifications are added to the formula and processing occurs, an output is created. The output should be considered the result of a manufacturing process or formulation specification.

Data associated with an output material includes:

- Material specification attributes such as Nutrition, Compliance, Custom Data, Supporting Documents, % breakdown, etc.
- Formulation and step specific information including:
 - Gain/Loss Adjusters, Qty, Yield, etc.
 - % Step
 - Composition (inputs)
 - Packaging

For more information, including information about output types and sub-types, and the two parts to every output, see [Chapter 6, "Formulation Outputs"](#).

"Designable" Workflow Status

Formulation specifications provide a number of powerful tools. These tools are often used during the early steps in a formulation specification's workflow. As a formulation specification moves past the initial workflow steps, it is expected that the organization will focus their efforts on minor changes and approving the specification for use by the greater organization.

Therefore in Workflow Administration, an administrator can designate or tag a given step of a workflow as "Designable". When a specification is in that designable workflow step, the following design features will be available to that specification:

- Costing, described further in ["Costing"](#) on page 5-33
- Optimization, described further in ["Optimization"](#) on page 5-43
- Snapshots, described further in ["Snapshots"](#) on page 5-41

- Adjusters (moisture, solids, material loss), described further in ["Adjusters"](#) on page 6-18
- Batch tuning, described further in ["Batch Tuning"](#) on page 6-17
- Theoretical Rollups, as described in ["Theoretical Output \(Output Dialog Box\)"](#) on page 6-3
- Basis (Instance Level Material Attribute Overrides), as described in ["Basis \(Input Attribute Overrides\)"](#) on page 5-35
- Substitute Materials, as described beginning on page 5-8

Note: When using a formulation specification, if you are not able to access the above features please verify that the specification is in a workflow step marked as "Designable."


Remaining Concepts and Definitions

The Formulation Specification page consists of the following tabs. Remaining features and concepts will be described as we review the specific screen elements of the formulation specification in the following sections.


- ["Summary Tab"](#) on page 5-7
- ["Formulation Tab"](#) on page 5-8
- ["Process Tab"](#) on page 5-19
- ["Ext Data Tab"](#) on page 5-32
- ["Related Specs Tab"](#) on page 5-32
- ["CSS Tab"](#) on page 5-32
- ["Supporting Documents Tab"](#) on page 5-32
- ["References Tab"](#) on page 5-32
- ["Approval/ Audit Trail Tab"](#) on page 5-32
- ["Costing"](#) on page 5-33
- ["Basis \(Input Attribute Overrides\)"](#) on page 5-35
- ["Snapshots"](#) on page 5-41
- ["Optimization"](#) on page 5-43

Page-Level Functions

The following page level functions are specific to formulation specifications. For a complete list of functions available through the action menu or action icons, see ["Page-Level Functions"](#) on page 2-1.

- **Calculate** ()—Performs all custom data calculations. Calculation also happens when you save your specification. For formulation specifications, calculations include:
 - **BOM Calculation**—Updates values associated with the formulation and step BOMs. BOM Calculations also update:
 - Yield
 - Theoretical Nutrition
 - Theoretical Compliance Data
 - Theoretical Composition Data
 - **Custom Data**—Executes custom calculations which are defined in ADMN and associated with Calculated Extended Attributes which are then placed on the specification as either simple extended attributes or as part of a custom section.

Note: By default, calculation is turned off when the specification is in read mode. See the *Agile Product Lifecycle Management for Process Configuration Guide* for more information.

- **Settings** ()—The fields displayed in this drop-down list drive specific functionality throughout the formulation specification. The default values are derived upon the creation of a new specification from a user's Profiles and Preferences. The values are then associated to the formulation specification upon saving the specification. You can change these settings at any time while working with your formulation.

Key fields include:

- **UOM**—The default unit of measure for steps in a formulation specification.
- **Path**—The default BOM Calculation path to use when creating formulation specifications. Examples include: Input Percent, Fixed Input Percent, Input Quantity, and Input Yield.
- **Density UOM**—The default unit of measures used when calculating density.
- **Combine Like Items**—When checked, combines like input items when viewing the formulation specification's Formulation tab in read mode.
- **Set new outputs as fixed**—When selected, all manually created outputs will be marked as fixed. Refer to the "Drop-down arrow" text on page 5-17 for more information surrounding the fixed tag.
- **Assign Pack Size**—When selected, the pack size cross reference will be selectable in the formulation BOM. See ["Assigning Pack Size"](#) on page 5-12 for more information.
- **Cross Reference**—The cross references system equivalent used for presenting alternate identities for attached specifications. This field will be the equivalent number that is defined on the referenced specification.

- **Cost UOM**—Cost will be displayed in this currency and unit of measure.
- **Cost Type**—Type associated with the cost set.
- **Cost Set**—The actual facility costs that will be used for viewing and optimizing the formulation.

Tools Submenu

Access the Tools submenu by selecting **Tools > [option]**. For options common to all or most specification types, see "[Tools Submenu](#)" on page 2-2. For formulation specifications, these options are defined as follows:

- **Optimization** — Optimize the formulation by defining goals and establishing constraints related to material costs, nutrients, and extended attributes. See "[Optimization](#)" on page 5-43 for more information. Is this in action menu
- **CACS** — Screen the formulation specification using Computer Aided Compliance Screening (CACS), an application that you can use to inspect materials for fitness against any number of user-defined screens. (Appears only if your installation includes CACS.) For more information on CACS, please refer to the *Agile Product Lifecycle Management for Process Computer Aided Compliance Screening User Guide*.

Note: CACS provides limited functionality when run on a formulation specification due to the fact that most material data is defined on the output material. Therefore CACS can perform screening for extended attributes defined on the formulation specification (as opposed to an output material) and approved for use in business units.

- **Formula Compare** —Allows users to compare the input bill of materials between two or more formulation specifications or snapshots. Users must have read access to the specifications as set in WFA. In addition, using the Formula Basis, users can choose to compare based on the following options:
 - **Quantity - Recursive 100%**—Provides items from the exploded bill of materials and determines percentage based on the input quantity.
 - **Yield - Recursive 100%**—Provides items from the exploded bill of materials and determines percentage based on the yielded quantity.
 - **Quantity - Top Level Only**—Provides items from the selected specifications only and determines percentage based on the input quantity.
 - **Yield - Top Level Only**—Provides items from the selected specifications only and determines percentage based on the yielded quantity.
- **Snapshot**—A tool used to take a picture of a specification at a given point in time. "Snapshots" can be retrieved at any point in time while a specification is in edit mode. Snapshots are considered useful during early design when a developer is refining a formula and wants to protect data.
- **Refresh**—Replaces override values on the Basis with input material specification values. Upon clicking this button the system prompts you to confirm the global update. When you select **OK**, the system pulls the information from the input specifications for all items in your formulation specification. This is only available in edit mode. If you do not want to perform a global refresh, then use the Basis screen to select specific sections for a given input specification to refresh.

Summary Tab

Key sections in the Summary tab include:

- "Summary Information Section" on page 3-3
- "Formulation Attributes Section" on page 5-8
- "Facility Information Section" on page 5-8
- "Cross References Section" on page 3-5
- "Approved for Use in Section" on page 3-6

Figure 5–1 Summary tab

Mango/Orange Juice Drink (5090138-001)
Formulation Specification

Design

Summary | Formulation | Process | Ext Data | Related Specs | CSS | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: Mango/Orange Juice Drink

Short Name: Mango and Orang Juice drink

Spec Status: Design - test

Spec #: 5090138-001

Category: * No Category Available (Formulation)

Sub Category: * No Category Available

Group: * No Category Available

Supercedes:

Reason for Change:

Originator: [User]

Effective: 4/6/2013

Inactive:

Last Edit: Wednesday, April 08, 2009

Formulation Attributes

Project Name: 5001886 - Orange Fizzy

Substitute Restrictions: USA

Description: Instructions for juice drink

Facility Information

	Facility Name	Company Name	Country
1	ABC Foods - Atlanta	ABC Foods	USA

Add New

Cross References

	System Name	System ID	Equivalent	Externally Managed	Status
1	Oracle System	USORACLE		<input type="checkbox"/>	

Add New

Approved for Use In

Concept(s): Concept - Active

Business Unit(s): CPI Antarctica

Formulation Attributes Section

This section allows users to describe the formula being created, associate the formula to a specific project, and filter data by defining substitute restrictions. Key fields include:

Project Name—A reference to a project associated with the formulation specification. This field is configurable to either:

- Allow users to link the formulation specification to a project defined in NPD, or
- Enter free text to describe the project in an appropriate manner.

Substitute Restrictions—Links to a multi-select dialog box containing substitute restrictions. Chosen restrictions filter the list of available substitutes that will be presented while designing. This field is only available when the specification is in a workflow status that is marked with a system action of "Designable."

If a formulation specification is not marked with any substitute restrictions, all substitutes defined for raw materials in the BOM are available for design use. If a formulation specification is marked with a USDA restriction, only substitutes marked with a restriction of USDA will be available for design use.

Description—An appropriate definition or explanation of the formulation specification. It is common for the description to describe what the formulation is producing and occasionally methods used during production.

Facility Information Section

The Facility Information section contains the list of facilities linked to a formulation specification. This information is useful for identifying plants that use or are approved to use a given formulation when performing production.

Formulation Tab

The Formulation Tab is useful for:

- Building entire formulations from scratch
- Viewing:
 - All input items associated with the formulation
 - The total number of steps and descriptive data related to steps
 - Processing step assigned to a given input material
 - Input quantities, input yield, and relative percentages
 - All output items (internal, external and referenced)
- Updating most aspects of the material bill of materials, outputs, and processing steps

The Formulation tab was designed to help users build formulations faster. Therefore some functions such as defining multiple outputs and re-sequencing steps must be performed using the Process tab.

It is also important to note that many of the features available on the Formulation tab are also available on the Process tab. Therefore it is recommended that users interact with both tabs to determine which best fits their needs when creating formulations.

The Formulation tab contains the following sections:

- ["Inputs Section"](#) on page 5-9
- ["Outputs Section"](#) on page 5-17
- ["Steps Section"](#) on page 5-19

Figure 5–2 Formulation tab

Organic Wheat Frozen Waffles (5113879-001) Draft
Formulation Specification

Summary **Formulation** Process Ext Data Related Specs CSS Supporting Documents References Approval/Audit Trail

Inputs

Step	Material	Qty	G/L	Yld	% Batch	USD/100lb	EXT Cost		
1	Organic Wheat Flour 569032 (5113782-001)	472.41913 lb	1.00000	472.41913 lb	29.66016	0.00000	0.00000		
1	Water (5087791-001)	755.87061 lb	1.00000	755.87061 lb	47.45625	0.00000	0.00000		
1	Sweetener Sugar Blend (5081427-001)	120.00000 lb	1.00000	120.00000 lb	7.53403	0.00000	0.00000		
1	Salt - Granulated - Food Grade (5077504-001)	30.00000 lb	1.00000	30.00000 lb	1.88351	0.00000	0.00000		
1	Processing Aid Sodium Stearoyl Lactylate (5113881-001)	94.48383 lb	1.00000	94.48383 lb	5.93203	0.00000	0.00000		
2	Sweetener Brown Sugar - Light (5092565-001)	50.00000 lb	1.00000	50.00000 lb	3.13918	0.00000	0.00000		
2	Water (5087791-001)	70.00000 lb	1.00000	70.00000 lb	4.39485	0.00000	0.00000		
		1592.77358 lb		1592.77358 lb	100.00000		0.00000		

Outputs

Output	Input	Material	Output Type	Qty	Material G/L	Moisture G/L	Solids G/L	Yld	% Formula
1	2	Wheat Mixture	Internal	1472.77358 lb	1.00000	1.00000	1.00000	1472.77358 lb	92.46597
2		Organic Wheat Frozen Waffles (5113914-001) [Draft]	External - Product	1592.77358 lb	1.00000	1.00000	1.00000	1592.77358 lb	100.00000
				1592.77358 lb				1592.77358 lb	

Steps

Step name	Step Qty	Step Yield		
1 Step 1	1472.77358 lb	1472.77358 lb	↓	✖
2 Step 2	1592.77358 lb	1592.77358 lb	↑	✖

Inputs Section

Adding Materials To The Inputs Grid

There are two primary methods for adding materials to the inputs grid. The two approaches are:

1. Adding Materials—Allows the user to add multiple BOM items using a search window.

2. Adding Rows And Then Using Auto Complete—Allows the user to add one or many rows and then enter the information about the BOM item and have GSM look up available entries leveraging the existing search model. You can tailor auto complete to lookup based on specification name, specification number, cross reference, and by how many characters the user must enter before auto complete starts. These settings are configurable. See the *Agile Product Lifecycle Management for Process Configuration Guide* for more information.

Adding Materials

To add materials:

1. With the page in edit mode, click the **Add New** button leaving the field to the left of the button null. GSM opens a search page.
2. When you have found all the specifications you wish to add, click **Done** to return to the populated Inputs grid.

Figure 5–3 Populated Inputs grid

Step	Material	Qty	G/L	Yld	% Batch	U
1	Lemon Flavor (5094464-001)	10.00000 lb	1.00000	10.00000 lb	24.80857	
1	Vitamin Pack (5094465-001)	30.00000 lb	1.00000	30.00000 lb	74.42572	
2	Water (5094463-001)	60.00000 g	1.00000	60.00000 g	0.32816	
2	Granulated Sugar (5094462-001)	00 g	1.00000	80.00000 g	0.43755	
2	Caramel Color - Acid Proof - Single Strength (5077424-001)	0.00000 lb	1.00000	0.00000 lb	0.00000	
		40.30865 lb		40.30865 lb	100.00000	

Newly added specification

Add New Calculate

Adding Rows and Then Materials

To add rows and then materials:

1. Enter the number of rows you wish to add to the left of the **Add New** button.

Figure 5–4 Inputs grid, number of rows to add

2	Caramel Color - Acid Proof - Single Strength (5077424-001)
---	---

Add New Calculate

2. Click the **Add New** button. In the example below, the two rows are added without a material assigned.

Figure 5–5 Two rows added

Step	Material
1	+ Lemon Flavor (5094464-001)
1	+ Vitamin Pack (5094465-001)
2	+ Water (5094463-001)
2	+ Granulated Sugar (5094462-001)
2	+ Caramel Color - Acid Proof - Single Strength (5077424-001)
2	+
2	+

Buttons: Add New, Calculate

- Next, click on the first blank row and start to type the name of the material. As you type, a GSM search is performed and specifications are presented for your selection. Use your mouse or up/down arrow to select the desired material. We refer to this feature as "Auto-Complete."

Note: Once materials are defined for a given row, the grid will re-sequence, often placing the material at the bottom of the grid.

Figure 5–6 Auto Complete feature

Spec #	Spec Name	Equivalent	Status	USD/100g
5077505-001	Sugar - Granulated		Draft	
5077506-001	Sugar - Liquid - 67.5%		Draft	
5077423-001	Sugar (Sucrose) - Granulated - Extra Fine		Draft	
5092432-001	Sugar Sugar Water		Draft	
5092434-001	Sugar Water with Lemon Packet 2		Draft	
5092433-001	Sugar Water with Orange Flavor Packet		Draft	
5099667-001	SUGAR_OPM		CSS Draft	

Buttons: Add

- Repeat the previous step for each row to populate the entire grid.

Additional Notes Regarding Adding Materials To The Inputs Grid

Changing a BOM Item: To change the specification for an item in the inputs grid, click the add data icon (+) in the Material column. GSM displays the search page where you can search for and select a material specification.

Using either approach, the grid is placed in an "edit all" mode, so the user can easily continue to enter data in the grid.

Note: Auto-Complete can be configured to search based on specification name, specification number, cross reference, and by how many characters the user must enter before auto complete starts. Refer to the *Agile Product Lifecycle Management for Process Configuration Guide* for more information.

Assigning Pack Size

A specific pack size can be selected using the pack size drop down. For example, salt may be purchased in 5lb, 10lb, and 20lb bags. The pack size dropdown allows you to specify which pack size is being used in the formulation. When a pack size is selected the input quantity will be updated to reflect the unit of measures associated to the pack size.

Pack sizes are defined on the material inside the Cross References grid. See the Cross References field "[Cross References Section](#)" on page 3-5 for more information.

Establishing Quantities Within The Inputs Grid

Once one or more materials are established, the user can describe the amount of each material for each row.

Material Quantity Fields Defined

Quantity—The amount of material gathered and placed into the manufacturing process. A total field is presented as the final row of this column.

G/L (Gain/Loss)—A factor used to describe the amount of material either gained or lost during a manufacturing process. As an example, when cookie dough is placed in a bowl some amount sticks to the bowl and is lost. Loss can also be applied at the output level using adjusters. See "[Adjusters](#)" on page 6-18 for more information.

Yield—The amount of material contributing to the output item(s).

Quantity * G/L = Yield. A total field is presented as the final row of this column.

Percent Batch—The percent yielded for a given material as compared to the total yield.

Entering Material Quantity Data Using BOM Calculation Paths

When the formulation specification is in edit mode, the user is limited to enter data based on predefined BOM calculation paths. The paths are described as follows:

- **Input Quantity**—The user enters data by typing in the quantity. As needed, the user can adjust gain/loss to establish the yield. The remaining fields including yield are populated when the application recalculates.
- **Input Quantity Range**—This path acts like the input quantity path and allows the user to capture a min/max percentage range.

- **Input Yield**—The user enters data by typing in the yield. As needed, the user can adjust gain/loss to establish the quantity. The remaining fields including the quantity are populated when the application recalculates.
- **Input Yield Range**—This path acts like the input yield path and allows the user to capture a min/max percentage range.
- **Input Percent**—This path allows the user to formulate based on percentage. What the user can edit depends on which tab the user is on. On the Formulation tab the user will define the total batch size and then enter data by the % Batch column. On the Process tab the user will define the total step yield and then enter data by the % Step column. The remaining fields are calculated. When changes are made to the weight of a step whose output is consumed in another step, then the consuming step's percentages will be adjusted.

For Example:

Step 1 creates 100lbs of a Output 1.

Step 2 consumes Output 1 at 100lbs and 100lbs of water. Step 2's percentages are 50%/50%.

Step 1 is adjusted and now makes 300lbs of output 1. Step 2 will be adjusted, Output 1 will now be 300lbs and Water will remain the same at 100lbs. The percentages will be changed to 75%/25%.

- **Input Percent Range**—This path acts like the input percent path and allows the user to capture a min/max percentage range.
- **Fixed Input Percent**—This path acts like the input percent path however when changes are made to the weight of a step who's output is consumed in another step then the consuming step's percentages will remain fixed and the quantities of the inputs will be adjusted.

For Example:

Step 1 creates 100lbs of a Output 1.

Step 2 consumes Output 1 at 100lbs and 100lbs of water. Step 2's percentages are 50%/50%.

Step 1 is adjusted and now makes 300lbs of output 1. Step 2 will be adjusted, Output 1 will now be 300lbs and Water will also be adjusted to 300lbs. The percentages will remain the same 50%/50%.

- **Fixed Input Percent Range**—This path acts like the fixed input percent path and allows the user to capture a min/max percentage range.

Selecting a BOM Calculation Path—When a formulation specification is created, the BOM calculation path is immediately assigned using the path found in the user's Profile and Preferences. Once the formulation specification is saved, the BOM calculation path for the formulation specification is managed via the formulation specifications Settings button. A user may change the formula's BOM calculation path at any time via the Settings button and the path will be saved when the formulation specification is saved. Profile and Preferences is described in detail in the *Agile Product Lifecycle Management for Process Getting Started Guide*.

Calculation paths control the following:

- Which fields are editable
- Certain system actions

- Which type of user messages display based on the calculation
- Tags and rules
- **Units Of Measure**—When a formulation specification is created, the default unit of measure (UOM) is derived from the user's Profile and Preferences. Therefore any rows added to the Inputs grid will initially be presented using the UOM.

Similar to BOM calculation paths, the default UOM for a formula can be changed via the Settings button. Upon making a change within Settings, any new row added will correspond to the formula's default UOM.


For a given material, a standard list of UOMs is presented by default. This list can change if:

- Density is/is not defined on a given input material specification. If it is defined, additional UOMs associated with volume will appear in the UOM drop down.
- Explicit UOMs are defined on a given input material specification. If explicit UOMs are defined, they will also appear in the UOM drop down.
- If your site is configured to only use explicit UOMs, then the material will only display UOMs described on the material specification.

Working With Cost In The Inputs Grid

Two columns present cost data in the inputs grid. They are:

Cost Per UOM—This column displays the material cost based on the unit of measure and currency you select in formulation settings. This cost is derived and presented in one of two ways.

- **Cost Library**—Cost can be loaded to the cost library via an API. If this is performed then the data presented on the screen is controlled through settings found on Profiles and Preferences, Preferences under the Cost Preferences section.
- **Override**—Also, within GSM, you can change cost using the Settings action button, Cost Preferences section. If a cost override has been entered, the override icon () displays.

EXT Cost—The calculated cost for the input material based on the quantity. A total field is presented as the final row of this column representing the total material cost for the formula specification.

Figure 5–7 Cost data

USD/100g	EXT Cost		
1.00000	45.35924	⬇	✖
0.25000	34.01943	⬇	✖
0.00000	0.00000	⬇	✖
0.00000	0.00000	⬇	✖
0.00000	0.00000	⬇	✖
0.00000	0.00000	⬇	✖
0.00000	0.00000	⬇	✖
	79.37866		

Figure 5–8 Edit Adjusted Cost dialog box

Edit Adjusted Cost
Done
Close


Materials

Name	ADJ Cost	
Water (5094463-001)	0.00000 USD / 100.0000 g	⬇
Granulated Sugar (5094462-001)	0.00000 USD / 100.0000 g	⬇
Lemon Flavor (5094464-001)	0.25000 USD / 100.0000 g	⬇
Vitamin Pack (5094465-001)	1.00000 USD / 100.0000 g	⬇

Packaging

Additional Tools Found in the Input Grid




- Steps**—If steps have been defined, then the user can assign a given material to the step in which it will be used. Please note the grid will refresh and reorder materials based on the step assigned.

- **Annotations**—You can click the annotations icon () to add BOM annotations. Added annotations display in read mode and are included in printing.
- **Context**—When a material is added to the Input grid as a material and the material itself is the output of another formulation specification, an additional field will appear. This field allows the user to directly associate this input to the formulation that created it.

Context is important because it provides the link between formulas. Context impacts:

- **Formulation Printing:** If context is not defined, then the exploded BOM will not present lower level formulations.
- **Integration:** When integrating formulation data through APIs or other forms of integration, context provides the link to formulas.
- **Basis**—A tool used to capture overrides to input material data fields. The overrides are specific to a given material in a given formulation specification. Therefore the override values are not associated with the input material and are not available when using the input material as an input to other formulation specifications. Refer to ["If changes are made to the base material specifications the formulation will not automatically pick those up. The basis must be refreshed to pick up those changes. Three methods of refresh are available:"](#) on page 5-35 for a detailed explanation of basis.
- **Get Latest Issue**—When the user adds a material specification to the inputs grid, by default the relationship is specific to the material's issue number, i.e. issue 001. Later if the material is changed and a new issues is created (002), then some form of change management must be performed to update the formulation specification.

However if Get Latest Issue is used when creating the relationship between input material and the formulation specification, the relationship is only based on specification number and workflow status. Therefore the next time the specification is viewed, the BOM will return the maximum issue number that is in a workflow status marked with the "Is Approved" system action.

- **Substitute Material**—Displays the substitution icon () if substitutes have been defined on the material specification. When you click the icon, GSM displays the Substitute Material dialog box. Use this dialog box to swap out materials with available selections and to update quantities.
- **Item history**—Displays the item history icon (). Click on the icon to view a list of BOM items, their issues, and their statuses.
- **Delete**—Click the delete icon () to delete the BOM item.

Three columns containing the substitute material icon, item history icon, and the delete icon display at the end of the inputs grid, as [Figure 5-9](#) shows:

Figure 5-9 Inputs grid columns



Outputs Section

Use the Outputs section on the Formulation tab to manage the materials that are created from a given step on a formulation specification. The Formulation tab has simplified functionality in the area of managing outputs. Some examples of features related to outputs available on the Process tab that are not available on the Formulation tab include:

- Creating more than one output for a given step.
- Dispersing an internal output so that it can be used as an input into more than one of the following steps.
- Defining alternate outputs.

If these scenarios are important for your organization, then you will want to consider using the Process tab.

Note: An output is automatically created when a new step is defined.

Figure 5–10 shows the Outputs section.

Figure 5–10 Outputs section

▼ Outputs									
Output	Input	Material	Output Type	Qty	Material G/L	Moisture G/L	Solids G/L	Yld	% Formula
1	2 ▼	Wheat Mixture <input type="checkbox"/>	Internal	1472.77358 lb	1.00000	1.00000	1.00000	1472.77358 lb	92.46597
2		Organic Wheat Frozen Waffles (5113914-001) [Draft] <input type="checkbox"/>	External - Product	1592.77358 lb	1.00000	1.00000	1.00000	1592.77358 lb	100.00000
				1592.77358 lb				1592.77358 lb	

Key fields include:

Output—The corresponding step that this output created from.

Input—The step number where the output will be consumed. This field is only available when output type is Internal.

Material—The name of the output. When the creation of a step automatically creates an output a name is generated. The naming convention is:

Step+{Step Number}+Output+{Specification Number}+{Issue Number}

The name can be updated via the Output dialog box.

Output dialog box—The primary tool for managing data related to the output such as nutrition, compliance, and other rolled up data. See [Chapter 6, "Formulation Outputs"](#) for more information.

Drop-down arrow (▼)—This arrow represents an extensibility point that has been leveraged to help BOM calculations treat this output. It is primarily useful when managing multiple outputs on the Process tab. By default, the outputs are variable and should adjust linearly to the formula. For example, 2 outputs each consume a half. Add two more, and all four outputs receive 25%. By choosing "Fixed" the specified quantity to the output will remain fixed regardless of adjustments made to the input BOM. The default state can be set in Profile and Preferences and/or formulation settings. See the Settings section, "Set new outputs as fixed" on page 5-5 for more information.

Output Type—Available types are Internal, External/Owned, and Referenced as defined in "Outputs" on page 5-3.

Note: The Get Latest Issue functionality is available only for referenced outputs.

Qty—Total amount of inputs for that output. This field is not shown for Internal types because the quantity associated with the material is accounted for in the final output.

Material G/L—Factor that represents the material loss or gain that was applied to the output using the adjusters tool, described on page 6-18.

Moisture G/L—Factor that represents the moisture loss or gain that was applied to the output using the adjusters tool, described on page 6-18.

Solids G/L—Factor that represents the solids loss or gain that was applied to the output using the adjusters tool, described on page 6-18.

Link to adjusters section % Formula—Percentage of the formula that this output represents compared to the total Formula Output.


Data associated with output that can be viewed and modified using the Output dialog box, shown in Figure 5-11. To access the Output dialog box, click the document icon (). The output dialog box is described in more detail in Chapter 6, "Formulation Outputs".

Figure 5-11 Output dialog box

Output

Settings

Adjusters

Label Claims

Batch Tuning

Calculate

Done

Cancel

Summary

Yield

Composition

Nutrition

Compliance

Ext Data

Summary Information

Spec Name: Wheat Mixture

Short Name: Step 1 Output 5113915-001

Material Classification:

Output Type: Internal

Spec #: 5113915-001

Category: * No Category Available (ing)

Sub Category: * No Category Available

Group: * No Category Available

Status: Draft

Originator: Burrier, Randal

Effective: 12/14/2012

Inactive:

Last Edit: Friday, December 14, 2012

Composition Map

Spec Name	Yield Available	Yield Consumed	
Organic Wheat Flour 569032 (5113782-001)	472.41913 kg	472.41913 kg	100.00000 %
Water (5087791-001)	755.87061 kg	755.87061 kg	100.00000 %
Sugar Blend SWN63463 (5081427-001)	20.41166 kg	20.41166 kg	100.00000 %
Salt - Granulated - Food Grade (5077504-001)	30.00000 kg	30.00000 kg	100.00000 %
Sodium Stearoyl Lactylate (5113881-001)	94.48383 kg	94.48383 kg	100.00000 %

Steps Section

You can use the Steps section of the Formulation tab to describe procedures that must be performed to create an output material. Steps themselves are merely natural milestones in the manufacturing process. To further differentiate steps, you can add step instructions to clearly articulate the actions that are being performed during the step.

This section offers multi add capability. GSM automatically names added steps as “Step X,” where X is name of step. Key fields include:

Step name—Name of step.

Step Qty—Total amount of inputs assigned to the step.

Step Yield—Total amount of inputs used in the step after gain loss has been factored in.

Use the delete icon (✖) to delete a step. You cannot delete a step that creates items being used.

Click the step instructions icon (📝) to add instructions for each step. These instructions will display on Process tab and in print details.

Process Tab

The Process tab has many of the same uses as the Formulation tab in that you can add/remove, view and update inputs, outputs, steps and the various pieces of data associated with these areas. However the Process tab does provide the user additional capabilities that are not available on the Formulation tab. Examples of these items include:

Advanced modeling of outputs, including:

- Creating more than one output for a given step.
 - Dispersing an internal output so that it can be used as an input into more than one of the following steps.
 - Identifying alternate materials for both inputs and outputs.
- Working with packaging that associated to the formulation.
- Generally developing a formulation by step. We have found that some types of products are easier to organize and design by step. Therefore the detail provided on the Process tab is considered useful for these types of products.

The tab is primarily structured in three parts:

- **Steps Section**—This section is identical to the Steps section described on the Formulation tab. On the Process tab it acts as summary information for each step.
- **Process Navigation**—This is the gateway to the information found within each step. This tool can also be used to create, delete, and reorder steps.
- **Step Details**—Describes a given step at the most granular level. The elements found in this section make up the majority of the content for our discussion on the Process tab.

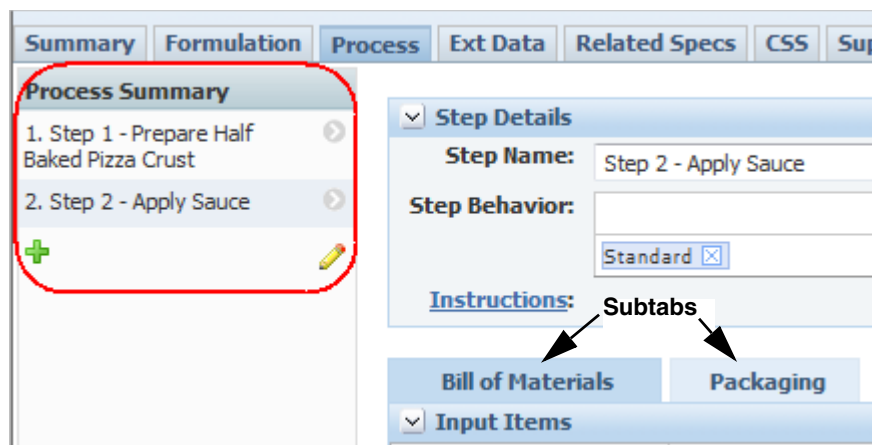
Steps Section

See [Formulation Tab, "Steps Section"](#) on page 5-19.

Interacting With Process Navigation

Process Navigation displays in the left side of the page, as [Figure 5-12](#) shows. Steps are displayed under the Process Summary heading. Click on the step to view details about the step.

Figure 5-12 Process Summary panel



The following icons are used in process navigation:

- Add data icon (✚)—Adds a step. New steps are reflected on the Formulation tab.
- Edit icon (✎)—Puts process navigation in edit mode, allowing you to delete a step using the delete icon (✖) if the step meets the delete step criteria, or reorder steps using the up and down arrow icons (⬆️⬇️⬆️). When process navigation is in edit mode, you cannot select a different step to display in the Step Details section.

Interacting With The Step Details Section

This section represents the area where we will collect and present the most detail regarding an individual manufacturing step.

Key Fields:

Step Name—The name of the step.

Step Behavior—This defines how the step and it's outputs will behave during the calculations. There are 3 system behaviors that can be selected.

- a. **Standard**—This is the default behavior for every step. A standard step will behave as a normal step in the formulation.
- b. **Consumer Prep**—When this is selected it indicates that this step is a consumer preparation step. The purpose for marking a step as consumer preparation is that it allows you to perform additional modeling using the external or referenced outputs created by the formulation.

The standard use case is cereal and milk. The external output for a given formulation is cereal. However the industry usually describes the nutrition based on how a consumer will prepare the item. In this case, the industry considers it common that the consumer will add a cup of whole milk to the cereal.

Therefore after the user defines the steps needed to create the output, in this example cereal, the user will add one more step. In this step the cereal and the whole milk will be added as inputs. The output from the consumer prep step will describe the theoretical data for the item as used by the consumer.

Specific functionality provided by the Consumer Prep flag:

- A consumer preparation step can consume external outputs from the same specification.
- Any additional materials added to the consumer preparation step will not affect the general formulation specification i.e. inputs to a consumer prep step will not appear on the Formulation tab's BOM and will not impact quantity, yield, or percentages.

A consumer preparation step can consume a normal output. Once you mark a step as consumer preparation, you can add external outputs from the same specification. Anything you add will not affect the standard formula.

- c. Isolated Step**—When this is selected it indicates that this step is isolated from the rest of the formulation. Isolated step allows you to model a separate process without creating an additional formulation specification. Because this step is isolated it cannot consume internal outputs from other steps. The outputs created by this step can be used in other steps and remain internal. Since this step is isolated if the weight of the isolated output is adjusted it will not affect the isolated step. The isolated output will act just like an output created from an intermediate formula.

For example:

Step 1 creates 300lbs of output 1.

Step 2 consumes output 1 at 300lbs. If step 1 is marked as isolated and output 1 in step 2 is changed from 300lbs to 200lbs step 1 will remain 300lbs and not be adjusted. If step 1 is marked as standard it's weight would be changed to 200lbs, because step 1 isn't isolated Step 2 would affect Step 1.

Instructions—Information describing the actions being performed during the step. Click the hyperlinked field to display the Edit Rich Text dialog box, as [Figure 5-13](#) shows. Enter instructions about the step, and then click **Done** to close the dialog box.

Figure 5–13 Edit Rich Text dialog box

In addition, GSM displays two sub tabs in the Step Details section:

- **Bill of Materials**—Made up of input items for material and alternate input items for materials, as [Figure 5–14](#) shows. Bill of Materials will be further described in this document in the section titled "[Bill Of Materials Sub-Tab](#)" on page 5-23.
- **Packaging**—Made up of input items for packaging and alternate input items for packaging, as [Figure 5–15](#) shows. Packaging will be further described in this document in "[Packaging Sub-Tab](#)" on page 5-30.

Figure 5–14 Bill of Materials sub tab

Bill of Materials		Packaging							
▼ Input Items									
Material	Qty	G/L	Yld	% Step	% Batch	USD/100lb	EXT Cost		
Sweetener	50.00000 kg	1.00000	50.00000	3.33829	3.33829	0.00000	0.00000	⬇	✖
<div><div>+</div><div>Brown Sugar - Light</div><div>(5092565-001)</div></div>			kg						
Water	70.00000 kg	1.00000	70.00000	4.67360	4.67360	0.00000	0.00000	⬇	✖
<div><div>+</div><div>Water</div><div>(5087791-001)</div></div>			kg						
Wheat Mixture	3037.47078 lb	1.00000	3037.4707	91.98811	--	0.00000	0.00000	⬇	✖
<div><div>+</div><div>Wheat Mixture</div><div>(5113915-001)</div></div>			lb						
Total	1497.77357 kg		1497.77357 kg	100.00000			0.00000		
Add New		Consume from Step		Order Items		Calculate			

Figure 5–15 Packaging sub tab

Bill of Materials		Packaging									
Input Items											
Packaging Material Specification			Type	Level	Qty	Scrap Factor	Yld	% Step	% Batch	USD/100lb	EXT Cost
<div><div><div>+</div><div>IQF TRAY FILM</div></div><div><div></div><div></div></div></div> <div><div></div><div></div></div>			Packaging Material	Inner	10.00000 in	1.00000	<div><div>10.00000</div><div>in</div></div>	24.85121	24.85121	0.00000	0.00000
PKG23462 (5083907-001)											
<div><div><div>+</div><div>Carton - Paper Board - Frozen Meal - 7 x 1.25 x 9-2</div></div><div><div></div><div></div></div></div> <div><div></div><div></div></div>			Packaging Material	Inner	1.00000 lb	1.00000	<div><div>1.00000</div><div>lb</div></div>	75.14879	75.14879	0.00000	0.00000
(5106159-001)											
Total					0.60359 kg		0.60359 kg	100.00000	100.00000		0.00000
Add New		Order Items		Calculate							

Bill Of Materials Sub-Tab

At initial glance the Bill Of Materials Grid appears very similar to the Formulation tab's Input Section. It is important to note that all aspect of this grid relate only to one step in the overall formulation. In this portion of the document we will describe how to use the Bill Of Materials grid to organize and present data related to the step.

Key sub-sections:

Input Items—Described below, in "[Input Items Sub-Section](#)" on page 5-23

Alternate Input Items—Described below, in "[Alternate Input Items Sub-Section](#)" on page 5-25

Output Items—Described below, in "[Output Items Sub-Section](#)" on page 5-27

Alternate Output Items—Described below, in "[Alternate Output Items Sub-Section](#)" on page 5-29

Input Items Sub-Section

Adding Materials To The Input Items Sub-Section For the most part, adding materials to the Input Items Sub-Section is handled in the same manner as adding items to the Formulation tab's Input Item section. Therefore please review "[Adding Materials To The Inputs Grid](#)" on page 5-9.

Additional features are available in this sub-section include:

- Consume From Step**—Using Consume From Step you can link steps together to reflect how material moves from step to step. This button specifically allows you to associate the internal output from a previous step to the step you are currently defining.

Figure 5–16 Consume From Step dialog box

Consume From Step					Done	Cancel										
<div> <input checked="" type="checkbox"/> Inline Outputs </div> <table border="1"> <thead> <tr> <th></th> <th>Spec Name</th> <th>Yield Available</th> <th>Yield Consumed</th> <th>Yield Remaining</th> </tr> </thead> <tbody> <tr> <td><input type="checkbox"/></td> <td>Wheat Mixture</td> <td>1377.77357 kg</td> <td>0.00000 kg 0.00000 %</td> <td>1377.77357 kg</td> </tr> </tbody> </table>								Spec Name	Yield Available	Yield Consumed	Yield Remaining	<input type="checkbox"/>	Wheat Mixture	1377.77357 kg	0.00000 kg 0.00000 %	1377.77357 kg
	Spec Name	Yield Available	Yield Consumed	Yield Remaining												
<input type="checkbox"/>	Wheat Mixture	1377.77357 kg	0.00000 kg 0.00000 %	1377.77357 kg												
<div> <input checked="" type="checkbox"/> Isolated Outputs </div> <table border="1"> <thead> <tr> <th></th> <th>Spec Name</th> </tr> </thead> <tbody> <tr> <td></td> <td></td> </tr> </tbody> </table>								Spec Name								
	Spec Name															

There are two sections in the Consume From Step dialog box: Inline Outputs and Isolated Outputs.

- a. **Inline Outputs**—This list represents all standard internal outputs. These outputs need to be consumed for the formulation to be balanced. Use the following fields in this dialog box to provide amounts and pull in the specified steps' outputs.
 - **Spec Name**—Name of the specification to consume
 - **Yield Available**—The yielded amount from the step that created the output
 - **Yield Consumed**—A portion of the yielded amount already used by another step
 - **Yield Remaining**—The amount that is available for use in one or more steps
- b. **Isolated Outputs**—This list represents all isolated outputs created by the formulation. Select the isolated output you want to consume. Isolated outputs can be consumed at any weight regardless of what was produced.

Select the step to consume, and then click **Done**. The dialog box closes, and GSM updates the Input Items section with the updated quantities.

- **Order Items**—Click to change the sort order of the inputs. GSM displays the Order Inputs dialog box, as [Figure 5–17](#) shows.

Figure 5–17 Order Inputs dialog box

Material	% Step	% Batch	
Spice Oil - Pork and Beans (5077509-001)	66.66667	1.70844	↓
Soluble Black Pepper on Dextrose (5077447-001)	33.33333	0.85422	↑↓
Salt - Granular - Not Iodized (5077441-001)	0.00000	0.00000	↑

Use the up and down arrow icons (↑↓) to change the order of input items, and then click **Done**. GSM closes the dialog box and the new sort order is reflected in the Inputs grid.

Establishing Quantities Within The Input Items Sub-Section

Establishing quantities for the most part is similar to the methods described on the Formulation tab. Therefore please review "[Establishing Quantities Within The Input Items Sub-Section](#)" on page 5-24. However it is worth noting that all values are specific to a single step.

Additional features available in this sub-section include:

- **Pack Size**—Pack size as described in "[Assigning Pack Size](#)" on page 5-12.
- **% Step**—The percent yielded for a given material in a given step as compared to the total yield for the step.
- **Consume From Step**—Quantities for consume from step items are established when adding the material to the grid. Additional information is available on page 5-23.

Remaining Fields and Tools within the Input Items Sub-Section Due to the fact that many of the fields and tools are used by both the Formulation and Process tabs, the remaining fields will point you to the appropriate definitions.

Annotations—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

Context—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

Basis—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

Get Latest Issue—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

Substitute Material—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

Item history—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

Delete—See Formulation Tab, "[Additional Tools Found in the Input Grid](#)" on page 5-15

USD/100g—See Formulation Tab, "[Working With Cost In The Inputs Grid](#)" on page 5-14

EXT Cost—See Formulation Tab, "[Working With Cost In The Inputs Grid](#)" on page 5-14

Quantity—See Formulation Tab, "[Establishing Quantities Within The Input Items Sub-Section](#)" on page 5-24

G/L (Gain/Loss)—See Formulation Tab, "[Establishing Quantities Within The Input Items Sub-Section](#)" on page 5-24

Yield—See Formulation Tab, "[Establishing Quantities Within The Input Items Sub-Section](#)" on page 5-24

Percent Batch—See Formulation Tab, "[Establishing Quantities Within The Input Items Sub-Section](#)" on page 5-24

Alternate Input Items Sub-Section

Use the Alternate Input Items subsection to define an alternate item for a BOM item (when the Bill of Materials sub tab is selected) or a packaging item (when the Packaging sub tab is selected). Each alternate material is related to an original material and allows for a substitution factor. This subsection uses the get latest revision capability.

Figure 5–18 Alternate Input Items subsection (for BOM)

Alternate Input Items			
Orig Material(s)	Factor --- G/L --- Material(s)		Description
+ 5077415-002 [Granulated Sugar (Sucrose)]	+ 1.00000 2.00000	Liquid Sugar (mat 5113834-001) [Draft]	Liquid Sugar
		Pack Size: ---	
+ 5077413-003 [Vinegar - Distilled - White - 100 Grain]	+ 1 1.5	vinegar blend output (mat 5113057-001) [Draft]	Vinegar
		Context: ---	
Add New			

Key fields include:

Orig Materials—The original BOM item.

Factor—Factor of the original quantity that will be used with new material.

G/L—Factor applied to the initial quantity to account for material loss. This field displays for BOM items only.

Scrap Factor—Percentage of the quantity that will be lost. This field displays for packaging items only.

Materials—The alternate material.

Description—Free text comments about the alternate item.

Pack Size—Select the specific pack size of the material. For example, if you purchase sugar in 5lb and 10lb bags you may want to say an alternate to the 10lb bag is 2 5lb bags.

To add an alternate item, click **Add New**. GSM displays the input items dialog box, as Figure 5–19 shows.

Figure 5–19 Alternate input items dialog box (BOM example)

DoneCancel

☐ Organic Wheat Flour (5113782-001)

☐ Salt - Granulated - Food Grade (5077504-001)

☐ Sodium Stearoyl Lactylate (5113881-001)

☐ Sugar Blend (5081427-001)

☐ Water (5087791-001)

Select the input item(s) you are designating an alternate for, and then click **Done**. The dialog box closes, and your selections are added to the Alternate Input Items grid. Provide additional details for the alternate item using the fields defined above.

You can now continue to the Output Items and Alternate Output Items subsections. These sections apply to the entire step and are independent of the Bill of Material and Packaging sub tabs.

Output Items Sub-Section

The Output Items subsection displays all the outputs that come from the current step.


This sub-section is especially important if you need to model disassembly, i.e. You place an orange in a machine and the results are an orange peel, orange slices, and orange juice. In this example the orange is an input and the remaining items are outputs.

Figure 5–20 Output Items subsection

Outputs									
Output	Input	Material	Output Type	Qty	Material G/L	Moisture G/L	Solids G/L	Yld	% Formula
1	2 ▼	Wheat Mixture 	Internal	1373.18523 kg	1.00000	1.00000	1.00000	1373.18523 kg	91.96349
2		Organic Wheat Frozen Waffles (5113914-001) [Draft] 	External - Product	1493.18523 kg	1.00000	1.00000	1.00000	1493.18523 kg	100.00000
				1493.18523 kg				1493.18523 kg	

Key fields include:

Material—The name of the output.

- When the user clicks on the document icon () , GSM displays the Output dialog box, shown in [Figure 5–20](#). The Output dialog box is used to describe nutrition, compliance, and other rolled up data, as described in ["Theoretical Output \(Output Dialog Box\)"](#) on page 6-3.
- **Drop-down arrow** (▼)—This arrow represents an extensibility point that has been leveraged to help BOM calculations treat this output. By default, the outputs are variable and should adjust linearly to the formula. For example, 2 outputs each consume a half. Add two more, and all four outputs receive 25%. By choosing “Fixed,” the specified quantity to the output will remain fixed regardless of adjustments made to the input BOM.

Qty—Total amount of inputs for that output. This field is not shown for Internal types because the quantity associated with the material is accounted for in the final output.

Material G/L—Factor that represents the material loss or gain that was applied to the output using the adjusters tool, as described on ["Adjusters"](#) on page 6-18.

Moisture G/L—Factor that represents the moisture loss or gain that was applied to the output using the adjusters tool, as described on ["Adjusters"](#) on page 6-18.


Solids G/L—Factor that represents the solids loss or gain that was applied to the output using the adjusters tool, as described on ["Adjusters"](#) on page 6-18.

Yld—Final output quantity after all losses and gains have been accounted for.

% Step —Percentage of the step that this output makes.

EXT Cost—Calculated cost for the output quantity.

The following column displays at the end of the Output Items grid:

Delete—Click the delete icon () to delete the output item. GSM displays confirmation dialog box. Click **OK** to delete the item. The item is removed from the grid.

The following button is found at the bottom of the Output Items grid:

Add New—Click to add a new output. GSM displays the Output dialog box, as [Figure 5–21](#) shows. Add weights to the Composition Map to establish the output.

Figure 5–21 Output dialog box

Output

Settings Adjusters Label Claims Calculate Done Cancel

Summary

Summary Information

Spec Name:Step 2 Output 5113927-001

Short Name:Step 2 Output 5113927-001

Material Classification:

Output Type:Internal

Spec #:5113927-001

Category* No Category Available (ing)

Sub Category:* No Category Available

Group:* No Category Available

Status:Originator:Burrier, RandalEffective:12/20/2012Inactive:Last Edit:Thursday, December 20, 2012

Composition Map

Spec Name	Yield Available	Yield Consumed	
Brown Sugar - Light (5092565-001)	50.00000 kg	0.00000 kg	0.00000 %
Water (5087791-001)	70.00000 kg	0.00000 kg	0.00000 %
Wheat Mixture (5113915-001)	1373.18523 kg	0.00000 kg	0.00000 %

Packaging Composition Map

Spec Name	Yield Available	Yield Consumed	
...	0.15000 kg		

You can add multiple outputs from a single step.

Note: The Yield Consumed can be less than the Yield Available when an additional output is modeled. Therefore, use the Composition Map to describe the quantity or percentage of each input needed to make a given output.

Packaging inputs can be mapped and follow the same concept as material inputs.

Refer to ["Summary Tab"](#) on page 5-7 for more details on this dialog box.

Adding Materials To The Outputs Grid By default, when a step is created an output is also created for that step. Therefore if you work with products that only produce one output per step you will rarely need to work with this feature.

On the other hand, if you often find yourself describing how materials are disassembled or describing how multiple items are created from a single process, then this feature will help you model your products.

An important concept to understand when working with multiple outputs is related to the initial output. It is assumed that input materials will initially be assigned to the first output. Therefore all subsequent outputs reduce the amount of material

associated with the initial output. In GSM we describe the first output as variable (or deselected Fixed) using the drop down feature described in the Key Fields above.

These concepts will become clearer as we review an example:

1. Prior to clicking **Add New** it is expected that you will have input materials defined and the automatically generated output.
2. Click **Add New** to create the second output and you will be presented with the Output dialog box.

Figure 5–22 Output dialog box

The screenshot shows the 'Output' dialog box with the 'Summary' tab selected. The 'Summary Information' section contains fields for Spec Name, Short Name, Material Classification, Output Type (Internal), Access Level (Theoretical, Specification), Spec # (5109270-001), Category (* No Category Available (Ing)), Sub Category (* No Category Available), and Group (* No Category Available). The Status field is empty. The Originator is listed as 'BOM, BOM'. The Effective date is 11/10/2012, and the Last Edit is Saturday, November 10, 2012. The 'Composition Map' section shows a table with columns for Spec Name, Yield Available, and Yield Consumed. The first row shows 'Cane Sugar - Granulated(DWB Test) (5081427-001)' with a Yield Available of 0.50000 kg and a Yield Consumed of 0.00000 kg (0.00000 %). The 'Packaging Composition Map' section is also visible but empty.

Spec Name	Yield Available	Yield Consumed
Cane Sugar - Granulated(DWB Test) (5081427-001)	0.50000 kg	0.00000 kg 0.00000 %

3. Populate the Yield Consumed. At this point you are assigning the portion of the inputs to be taken from the initial input and assigned to the output you are working with.

Note that once the Yield Consumed is entered and you click out of the field, BOM Calculation is performed. Also the remaining tabs associated with the Output Dialog Box appear.

In this example only one input exists. If more inputs were present then the user would need to define by input the amount of material that contributes to this output. This level of detail helps the application model theoretical data.

4. Upon clicking **Done** the output is now presented in the output subsection. You may also notice that it is very useful to take the time to properly name your outputs.

Alternate Output Items Sub-Section

This section allows you to define an output that could be used instead of the one you created in the step. This subsection uses the get latest revision capability.

Key fields include:

Orig Materials—The original output item.

Factor—Factor of the original quantity that will be used with new material.

G/L—Factor applied to the initial quantity to account for loss. This field displays for BOM items only.

Materials—The alternate material.

Pack Size—Select the pack size of the material.

Description—Free text comments about the alternate item.

To add an alternate item, click **Add New**. GSM displays the output items dialog box.

Select the output item(s) you are designating an alternate for, and then click **Done**. The dialog box closes, and your selections are added to the Alternate Output Items grid. Provide additional details for the alternate item using the fields defined above.

Packaging Sub-Tab

The Packaging Sub-Tab allows users to describe Packaging Material specifications used in a manufacturing process. Some important items to note regarding packaging:

- It is commonly recommended to model packaging used to ship products to customers on the trade specification. This provides the user the ability to define a material using output materials and reuse it across many different trade specifications. It is on the various trade specifications that you distinguish the product via packaging.
- Packaging on a formulation specification is used to describe how an output material is packaged. The output of a formulation specification cannot be a packaging material or printed packaging material specification.

Input Items Sub-Section

Adding Materials To The Input Item Sub-Section Unlike other areas of the formulation specification, there is only one path for adding items to this sub-section and that is by clicking the **Add New** button. Upon doing so you are presented with a standard search page.

The fields in this section are carried over from the Inputs section on the Formulation tab. As you add additional steps and details on this tab, the Formulation tab reflects those changes.

This section behaves much like the Input Items section on the Formulation tab, using the quick entry and edit all features.

Figure 5–23 *Input Items section, Packaging subtab*

Bill of Materials		Packaging										
Input Items												
Packaging Material Specification		Type	Level	Qty	Scrap Factor	Yld	% Step	% Batch	USD/100lb	EXT Cost		
<div><div><div>+</div><div>IQF TRAY FILM</div><div>(5083907-001)</div></div><div></div></div>	<div><div></div><div></div></div>	Packaging Material	Inner	10.00000 in	1.00000	<div><div>10.00000</div><div>in</div></div>	90.90909	90.90909	0.00000	0.00000	<div><div></div><div></div></div>	<div><div></div><div></div></div>
<div><div><div>+</div><div>Carton - Paper Board - Frozen Meal - 7 x 1.25 x 9-2</div><div>(5106159-001)</div></div><div></div></div>	<div><div></div><div></div></div>	Packaging Material	Inner	1.00000 units	1.00000	<div><div>1.00000</div><div>units</div></div>	9.09091	9.09091	0.00000	0.00000	<div><div></div><div></div></div>	<div><div></div><div></div></div>
Total				0.36376 lb		0.36376 lb	100.00000	100.00000		0.00000		
Add New		Order Items		Calculate								

Key fields include:

Packaging Material Specification—Packaging material specification that is being added as an input item for the formulation specification. This field can contain additional icons:

- By default, GSM gets the latest approved revision of an input item's specification and issue. This is indicated by an unlocked lock icon (🔓). If the lock icon is open, GSM respects the specification number and latest issue. When the lock icon (🔒) is closed, the user has tied a precise issue of a specification to a BOM, which will always be used on the formulation specification.
- You can click the annotations icon (💬) to add annotations. Added annotations display in read mode and are included in printing.

Type—Type is defined on the packaging specification. See "[Packaging Material Specifications](#)" on page 11-1 for more information.

Level—The level of packaging specification selected. The four choices are: Inner, Outer, Intermediate and Label.

Qty—Amount of the packaging that goes into the formula.

Scrap Factor—Percentage of the quantity that will be lost. This field displays for packaging items only.

Yld—Actual amount of the packaging used in the formula.

% Step—That packaging's percentage as it relates to the step.

% Batch—Percentage that packaging makes up in the total.

USD/100g—This is the cost of the material for a specific unit of measure and currency. To learn more about formulation cost see "[Costing](#)" on page 5-33.

EXT Cost—Calculated cost for the input quantity.

Three columns display at the end of the inputs grid, as [Figure 5-24](#) shows:

Figure 5-24 Inputs grid columns



Substitute material—Displays the substitution icon (🔄) if substitutes have been defined on the packaging specification. When you click the icon, GSM displays the Substitute Material dialog box. Use this dialog box to swap out materials with available selections and to update quantities.

Item history—Displays the item history icon (🕒). Click on the icon to view a list of input items, their issues and their statuses.

Delete—Click the delete icon (✖) to delete the input item. The step must meet the delete step criteria for the icon to appear.

The following buttons are found at the bottom of the inputs grid:

Add New—Click to display the packaging specification search dialog box, where you can select a specification for the step.

Order Items—Click to change the sort order of the inputs. GSM displays the Order Inputs dialog box. Use the up and down arrow icons (↑↓) to change the order of input items, and then click **Done**. GSM closes the dialog box and the new sort order is reflected in the Inputs grid.

Calculate—Click to perform a manual calculation.

Ext Data Tab

The Ext Data tab includes the following sections:

- **Extended Attributes** — For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Manage Custom Sections** — For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- ["Associated Specifications Section"](#) on page 3-15
- ["Master Specifications Section"](#) on page 3-15

CSS Tab

For discussion of this tab, please see ["CSS Tab"](#) on page 3-15.

Supporting Documents Tab

The Supporting Documents tab contains the following sections:

- **Supporting Documents** — The document types available are Attachments/Procedures, URL and Rich Text. For discussion of this commonly used section, please see ["Supporting Documents Section"](#) on page 3-18
- **DRL Documents** — For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23
- **Testing Protocols** — For discussion of this commonly used section, please see ["Testing Protocols Section"](#) on page 3-25

References Tab

The References tab contains the following sections:

- **Activities**—For discussion of this commonly used section, please see ["Activities Section"](#) on page 3-31
- **Related Documents**—For discussion of this commonly used section, please see ["Related Documents Section"](#) on page 3-31
- **Specification Dependencies**—For discussion of this commonly used section, please see ["Specification Dependencies Section"](#) on page 3-31

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

Costing

Cost is shown for formulation inputs in the formulation bill of materials. Cost will be shown automatically inside the USD/100g column if it is available. The EXT Cost column displays the calculated cost based on the amount of input consumed in the formulation. The cost of the entire bill of materials is displayed in the total row of the EXT Cost column.

Figure 5–25 Cost displayed

Inputs									
Step	Material	Qty	G/L	Yld	% Batch	USD/100g	EXT Cost		
1	<div> <div>+</div> <div>Parmesan Cheese</div> <div>(5084233-001)</div> </div>	1.56519 kg	1.00000	1.56519 kg	86.95652 kg	0.00000	0.00000		
1	<div> <div>+</div> <div>Unsulphured Molasses - Imported</div> <div>34969 (5077427-001)</div> </div>	0.15652 kg	1.00000	0.15652 kg	8.69565 kg	0.10000	0.15652		
1	<div> <div>+</div> <div>Pepper - Red - Ground - 36-44M - Not Sterilized</div> <div>(5077502-001)</div> </div>	0.07826 kg	1.00000	0.07826 kg	4.34783 kg	0.29892	0.23394		

Cost Per Unit Overrides

If cost is not available or you would like to override it, the USD/100g cost fields are editable. Once overridden the override icon (↔) displays. You can remove the override and refresh values by clicking on the USD/100g header and opening the Edit Adjusted Cost window. Refresh cost values by clicking the refresh icon (↺). The Edit Adjusted Cost popup also allows you to apply overrides using a different currency and UOM set.

Figure 5–26 Cost override

Edit Adjusted Cost					Done	Close
Materials						
Name	ADJ Cost					
Parmesan Cheese (5084233-001)	0.00000	USD	/	100 g		↺
Unsulphured Molasses - Imported 34969 34969 (5077427-001)	0.10000	USD	/	100.0000 g	↔	↺
Pepper - Red - Ground - 36-44M - Not Sterilized IP011 (5077502-001)	0.29892	USD	/	100 g		↺

Currency and Unit of Measure

The currency and unit of measure that cost is displayed in on the formulation can be adjusted. Inside profile and preferences there is a cost book preferences section. Any values set here will be your default values for every formulation created. These defaults can be overridden at the formulation level by adjusting the cost book preferences in formulation settings (✔).

Cost Books

Which cost is displayed is determined by 3 factors that are set in your profile and preferences and/or formulation settings: Cross Reference, Cost Type and Cost Set (Facility). Each cross reference system has their own cost types and each cost type has specific facilities (cost sets) that you can choose from. Your selections will determine which specific cost is returned. You can view the cost of a formulation based on which facility will be manufacturing it. In the example below I can choose to see how much it will cost to produce my formulation at Peedmont, Fort Worth, Marshall, Angus or Brookfield facilities. When you select a cost set the formulation will refresh with new costs. Overridden cost values will remain.

Figure 5–27 Cost Set field

The screenshot displays the Oracle Formulation Specification interface for a formulation named '16915 Cheese Pizza'. The interface is divided into several sections:

- Formulation Specification Header:** Shows the formulation name '16915 Cheese Pizza (509)' and the 'Formulation' tab selected.
- Inputs Table:** A table with columns 'Step' and 'Material'. It lists two materials: '16915 Pizza Dough' (Step 1) and '16915 Tomato Sauce' (Step 1). Each material has a 'Pack Size' field and a 'Context' field. The context for '16915 Tomato Sauce' is '16915 Tomato Sauce (50)' with ID '(5098023-001)'.
- General Preferences Panel:** Contains settings for UOM (kg), Path (Input Percent), Density UOM (g/mL), and checkboxes for 'Combine Like Items', 'Set new outputs as fixed', and 'Assign Pack Size'.
- Identity Preferences Panel:** Shows 'Cross Reference' set to 'USBPCS'.
- Cost Book Preferences Panel:** Shows 'Cost UOM' as 'USD', 'Cost Type' as 'Std Cost', and 'Cost Set' as 'Fort Worth Facility'.


Output Cost

The system calculates output cost and displays the cost of the output on the process tab output grid inside the EXT Cost column. For external outputs the cost will be added to the Theoretical cost book. If the external output is not yet commercialize and a final cost per facility can't be provided then the system will pull the cost from the theoretical cost book. This theoretical cost is overridden every time the output is saved. For example, if you looked at the formulation for a cheese pizza produced in the Brookfield plant and saved the formulation the cost in the theoretical cost book would be for the Brookfield facility. However, if you change to the Marshall facility and save the formulation the cost in the theoretical cost book will now be based on Marshall facility data. A referenced output will have a different cost per formulation that produces it. This unique cost will be pulled when the user selects context.

Note: Cost is loaded into the database using a web service. See the extensibility pack web services guide for more information around loading cost into the database.

Basis (Input Attribute Overrides)

You create a basis on an instance of a formulation specification. You can provide information on the basis that supplements the specification, or you can provide custom data on the basis for the current formulation specification. The basis allows you to provide instance level input attribute overrides. This allows you to perform "what if" type scenarios.

The system creates a basis automatically when you add items to the Inputs section of the formulation specification. At that time a snapshot is made of the input material. You can access a basis from either the Formulation or Process tab. To open a basis, click the document icon () in the Material column of the inputs grid. GSM displays the Basis dialog box, as described below.

If changes are made to the base material specifications the formulation will not automatically pick those up. The basis must be refreshed to pick up those changes. Three methods of refresh are available:


1. Click **Refresh** at the top right of the dialog box to perform a global basis refresh. Using the global refresh feature, you can update all of the information about a specific formula item on your formulation specification. GSM prompts you to confirm the global update. When you select **OK**, the system pulls the information from the specifications for all items.
2. Use a sections refresh icon () to refresh a single section in the Basis dialog box independently. GSM pulls the requested information from the specification and displays it in the section. After working with bases, click **Done** to close the Basis dialog box.
3. Once you close the Basis dialog box and return to the main tab, you can use the **Refresh** action button under **Tools >Refresh** to update all of the information about all of the formula items on your formulation specification. The system prompts you to confirm the global update. When you select **OK**, the system pulls the information from the specifications for all items in your formulation specification. This is only available in edit mode.

Figure 5–28 Basis dialog box

Basis Refresh Done

Sugar - Granulated (5077505-001)

Specification Attributes | % Breakdown | Nutrition | Compliance | Ext Data

☒ **Combined Ingredient Statement**

From Spec (4/15/2011)	Override
Sugar	<input type="text"/>

☒ **Material Attributes**

From Spec (4/15/2011)	Override
Total Solids:	<input type="text"/> %
Final Density:	<input type="text"/> g <input type="button" value="v"/> = <input type="text"/> mL <input type="button" value="v"/>
Edible Portion: 100 %	<input type="text"/> %

☒ **Reconstitution/Equivalency**

Declare As	Target %/Factor	Comments
No records found.		

Add New

The Basis dialog box consists of the following tabs:

Specification Attributes—Described below, in "[Specification Attributes Tab](#)" on page 5-36

% Breakdown—Described below, in "[% Breakdown Tab](#)" on page 5-38

Nutrition—Described below, in "[Nutrition Tab](#)" on page 5-38

Compliance—Described below, in "[Compliance Tab](#)" on page 5-39

Ext Data—Described below, in "[Ext Data Tab](#)" on page 5-40

Specification Attributes Tab

This tab gives attributes of the material specification and includes the following sections:

- **Combined Ingredient Statement**—Described below, in "[Combined Ingredient Statement Section](#)" on page 5-36
- **Material Attributes**—Described below, in "[Material Attributes Section](#)" on page 5-37
- **Reconstitution/Equivalency**—Described below, in "[Reconstitution/Equivalency Section](#)" on page 5-37

Combined Ingredient Statement Section

The data in the From Spec column is pulled directly from the specification from which you created the formulation specification.

Material Attributes Section

This section provides material attributes.

Key fields include:

Total Solids/Total Moisture—Describes as a percentage the amount of solids or moisture present in a given material. The field is configurable to present information as either:

- **Total Solids:** The amount of non-water content found in a material; for example, a value of 60% means the material is 60% solid (non-water). It is assumed the remaining 40% is water.
- **Total Moisture:** The amount of water content found in a material; for example, a value of 60% means the material is 60% water. It is assumed the remaining 40% is solid.

Note: This calculation impacts the nutrition calculation performed on a formulation specification. The field specifically focuses on the concentration of nutrients for a material based on moisture. If water gain/loss scenarios are modeled the moisture defined in this field will contribute to the calculation. As water is removed from a formulation it is expected nutrition per 100g will increase. As water is added to a formulation it is expected that nutrition per 100g will decrease.

Final Density—Conversion factor applied when converting the specification from mass to volume.

Edible Portion—Describes the amount of edible content associated with a material. For example, a t-bone steak may represent 90% meat and 10% bone. Therefore 1000kg of t-bone steak represents 900kg meat and 100kg bone. In this example the edible portion for t-bone steak is 90%.

Note: This calculation impacts the nutrition calculation performed on a formulation specification.

Reconstitution/Equivalency Section

You can set up reconstitution/equivalency rules to assist in the management of the reconstitution process in the listed ingredient order (LIO) feature. These rules define how the water percentage of a given material affects the label naming of a product. For example, you could set up a rule by which, if the percentage of water in a material called “reconstituted orange juice” meets or exceeds a preset level, the name of that material changes to “orange juice.”

To add a new reconstitution/equivalency rule, click **Add New** under the Reconstitution/Equivalency section. GSM adds to the grid a new row for you to fill out. Key fields include:

Declare As—The name that GSM will assign to the product after you have performed the defined reconstitution.

Target % / Factor—The adjustment amount required to perform the reconstitution.

% Breakdown Tab

The % Breakdown tab defines the contents of a material specification. Percent breakdowns are composed of breakdown components and their composition of the total material. In the Component % Breakdown(s) section, shown in [Figure 5–29](#), you can modify breakdowns that exist on the specification or add new breakdowns for use in listed ingredient order (LIO).

Figure 5–29 Basis dialog box, % Breakdown tab

Basis					
Refresh Done					
Sugar - Granulated (5077505-001)					
Specification Attributes % Breakdown Nutrition Compliance Ext Data					
Component % Breakdown (s)					
	From Spec (4/15/2011)	Restrictions	Formulation Classifications	Tags	
1	Sugar Breakdown			Do Not Publish to Supplier	X
Add New					

Component % Breakdowns Section

The Component % Breakdowns section is the only section on the % Breakdown tab. Use this section to define the contents of a material specification using the following fields:

From Spec—The value that exists for that field on the material specification.

Restrictions—This is used to help categorize different versions of the breakdowns for usage in the Listed Ingredient Order (LIO) tool.

Formulation Classifications—Formula classifications can be used to enforce security for individual specifications. Classifications can be managed in the Admin Tool and are tied to user groups. Only users in the associated groups can view formulas that have a formulation classification.

Tags—Breakdowns can be tagged. Tags help identify breakdowns and most tags help define how you want the system to react to the breakdown. Available tags are listed on ["Tags"](#) on page 3-27.

Nutrition Tab

In the Nutrition tab of the Basis dialog box you can modify the nutritional information that is stored on the specification, as shown in [Figure 5–30](#).

You can edit the existing nutritional information by providing a custom value or you can add new nutrients. You can add nutrients from the standard nutrient list, NSM, or from the data that is stored in the Food Composition Library. You cannot change the per UOM value displayed on this screen.

Note: The Food Composition Library will need to be configured as a part of your implementation.

Figure 5–30 Basis dialog box, Nutrition tab

Basis Refresh Done

Sugar - Granulated (5077505-001)

Specification Attributes % Breakdown **Nutrition** Compliance Ext Data

▼ Nutrient Composition

	From Spec (4/15/2011) ↻	Per 100g	Overrides -OR- Gain/Loss Factor
1	Calories	275.00000 kcal	
2	Protein	123.00000 g	
3	Carbohydrates	99.90000 g	
4	Dietary Fiber	0.00000 g	

Add New Import NSM

The Nutrition tab consists of the Nutrient Composition section.

Nutrient Composition Section

This section shows the nutrient composition that is stored on the specification.

From Spec—The nutrients that exist on the specification.

Per 100g/Per100mL—The 100g or 100mL per UOM value as set on the raw material.

Overrides—You can enter a new value for the nutrient and the Gain/Loss factor column.

Gain/Loss Factor—You can specify a gain loss factor to be applied to the original nutrient value.

Compliance Tab

In the Compliance tab you can enhance or modify specification information related to compliance. You can add or modify the following compliance items:

Complies With

Allergens - Known to Contain

Allergens - May Contain

Allergens - Does Not Contain

Intolerances - Known to Contain

Intolerances - May Contain

Intolerances - Does Not Contain

Additives - Known to Contain

Additives - May Contain

Additives - Does Not Contain

Figure 5–31 Basis dialog box, Compliance tab

Basis				Refresh	Done
Sugar - Granulated (5077505-001)					
Specification Attributes		% Breakdown	Nutrition	Compliance	Ext Data
<input checked="" type="checkbox"/> Complies With					
From Spec (7/27/2011) ↻			Overrides		
1	Kosher				
2	Organic				
Add New					
<input checked="" type="checkbox"/> Allergens					
Known to Contain					
From Spec (7/27/2011) ↻			Overrides		
1	Ascorbic Acid	12.00000 g			
2	Aspergillus niger	1.00000 µg			
3	azo dyes	44.00000 mg			
Add New					

Key sections in the Compliance tab include:

- **Complies With**
- **Allergens**
- **Additives**
- **Intolerances**

Ext Data Tab

This tab shows extended attributes stored on the specification.

Figure 5–32 Basis dialog box, Ext Data tab

Basis				Refresh	Done
Sugar Blend (5081427-001)					
Specification Attributes		% Breakdown	Nutrition	Compliance	Ext Data
<input checked="" type="checkbox"/> Extended Attributes					
From Spec (12/19/2012) ↻			Overrides		
khc Brix	40 °Brix			°Brix ▼	
khc Range	target: 40 min: 35 max: 45 mg	target:	min:	max:	--- ▼
RGS Calc Half RGS_Nm_Ms	g			g ▼	
RGS calc Ln D0	800 mm			mm ▼	
RGS Calc Ms to Vol	ratio			ratio ▼	
RGS Calc Twice NmVolD2	15.0 mL			mL ▼	

Snapshots

When a formulation specification is in design mode you have the ability to create snapshots using the Snapshot feature.

This feature allows you to take and store a copy of your formulation specification at any time during the development process. Using snapshots, you can capture incremental changes that are made during the formulation process and then revert back to them later.

To create a snapshot:


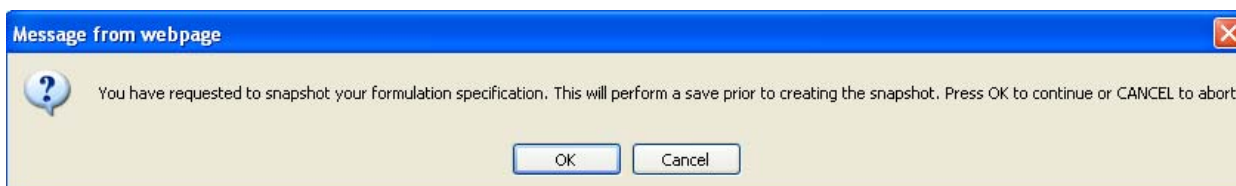
1. Once you have an instance of a specification that you want to snapshot, select **Tools > Snapshot** from the action menu or the snapshot icon (). The Snapshots dialog box opens, as [Figure 5–33](#) shows.

Figure 5–33 Snapshots dialog box



2. Click **Add New**. GSM displays the following confirmation message.

Figure 5–34 Snapshot confirmation



3. Click **OK** to save the specification and take the snapshot.
4. Type a new snapshot name in the **Name** field and any details about the snapshot in the **Comments** field, as [Figure 5–35](#) shows.

Figure 5–35 Snapshots detail

Snapshot Manager							Compare	Close
Snapshots								
			Created	Name	Comments			
1	<input type="checkbox"/>	Apply	11/10/2012 7:06:09 PM	Prototype 2	Extra Salt			
2	<input type="checkbox"/>	Apply	11/10/2012 7:04:25 PM	Prototype 1	Extra Sweetner			

Add New

- Click **Close**.

Applying a Snapshot

You can revert back to a snapshot at anytime by clicking the **Apply** button next to the specific snapshot you would like to revert to.

Previewing a Snapshot

You can preview a snapshot by clicking on the view details icon ().

Comparing Snapshots

You can compare your snapshots with your current formulation by selecting the checkboxes next to the snapshots you would like to compare. Once the checkboxes are selected click **Compare** in the top right to open the formulation compare tool.

Figure 5–36 Comparing snapshots

Basis for Comparison							
Formula Basis:		Quantity - Recursive 100%					
Base Specification:		5113910-001 (frm) -- Organic Wheat Frozen Blueberry Waffles					
Compare With:		1) (Snapshot) -- Sugar Blend 25% 2) (Snapshot) -- Sugar Blend 20% 3) (Snapshot) -- Sugar Blend 15%					
Compare							
Formula Comparison							
	5113910-001 (frm)	1) (Snapshot) -- Sugar Blend 25%		2) (Snapshot) -- Sugar Blend 20%		3) (Snapshot) -- Sugar Blend 15%	
Material/Process Specification	% Quantity	% Quantity	% Diff	% Quantity	% Diff	% Quantity	% Diff
Water	39.46220 %	42.54197 %	+3.07977 %	44.72345 %	+5.26126 %	47.65592 %	+8.19373 %
Sugar Blend	29.86242 %	24.38863 %	-5.47379 %	20.51139 %	-9.35103 %	15.29941 %	-14.56301 %
Organic Wheat Flour	22.40157 %	24.14987 %	+1.74830 %	25.38824 %	+2.98667 %	27.05291 %	+4.65135 %
Sodium Stearoyl Lactylate	4.48031 %	4.82997 %	+0.34966 %	5.07765 %	+0.59733 %	5.41058 %	+0.93027 %
Brown Sugar - Light	2.37094 %	2.55598 %	+0.18504 %	2.68705 %	+0.31610 %	2.86323 %	+0.49229 %
Salt - Granulated - Food Grade	1.42257 %	1.53359 %	+0.11102 %	1.61223 %	+0.18966 %	1.71794 %	+0.29537 %
Step 2 Output 5113913-001	100.00000 %	100.00000 %	----	100.00000 %	----	100.00000 %	----

Optimization

Optimization can be used to adjust an output of a formulation specification based on any number of constraints related to material costs, nutrients, and extended attributes. It uses a linear optimization algorithm to generate the most optimal formulation based on the constraints, guidelines, and optimization methods.

Optimization is started from the Tools action submenu of a formulation specification and opens the optimization scenario in a popup. As shown in [Figure 5-37](#), the Optimization dialog box is composed of the following sections:

- "Target Specification Section" on page 5-43
- "Constraints Section" on page 5-43
- "Guidelines Section" on page 5-47
- "Optimization Method Section" on page 5-48

Figure 5-37 Optimization dialog box

Done

Target Specification

Specification: Lemonade - (mat) 5094457-001 (External - Product)

Constraints

	Type	Condition	Design Conformance (99.99999% accurate)
1	Objective	Minimize Cost - per 100g	0.00000 USD per 100g

Add

Guidelines

Inputs

	Material Equivalent (Type Prodika #)	Yield	Scalability ▲▲ Limit	Scalability ▲ Control	Scalability ▼ Control	Scalability ▼▼ Limit	Adjust	Last Optimization
1	Lemon Juice - Single Strength (5077421-001)	21.04623 lb	30.0000	15.0000	15.0000	30.0000	None	+0.00000%

Optimization Method

Formulation	Constraints	Distribution
<input type="radio"/> Minimize Change	<input checked="" type="radio"/> All Constraints Required	<input checked="" type="radio"/> Isolated Output Distribution
<input checked="" type="radio"/> Emphasize Objective	<input type="radio"/> Incremental Constraints	<input type="radio"/> Related Output Distribution

Optimize

Refresh


Target Specification Section

The Target Specification section allows you to pick the output of the formulation specification the optimization engine will try to optimize.

Constraints Section

In the Constraints section you can build rules for the optimization engine to use when searching for an optimal formulation. The Constraint table includes a Type, Condition, and Design Conformance column. In the Type column you can describe what kind of

constraint you are adding and in the Condition column you can describe the details about the constraint. The optimizer calculates the value in the Design Conformance column based on data that is on the specification and shows what level of conformance your specification is in currently with regard to that constraint.

The first rule that you must define is the objective constraint. The system automatically includes the objective constraint place holder. This objective is the main goal for your optimization scenario. To edit the objective place holder constraint, click the edit icon () on your objective constraint.

You can configure the objective constraint to any one of the following, which are further explained below:

- Minimize Cost
- Minimize/Maximize a Nutrient
- Minimize/Maximize an Extended Attribute

Minimize Cost—Optimize based on the cost of your formulation.


GSM can display this information per 100g, per Serving, per Consumer Unit, or per Traded Unit.

Minimize/Maximize a Nutrient—Optimize based on minimizing or maximizing a selected nutrient.

GSM pulls the nutrient list from the selected output. You can display this information per 100g, per serving, per consumer unit, and per traded unit.

Minimize/Maximize an Extended Attribute—Optimize based on minimizing or maximizing a selected extended attribute.

GSM pulls the theoretical extended attribute list from the selected output. You can display this information per 100g, per serving, per consumer unit, and per traded unit.

Once you have selected your optimization objective, click the apply changes icon () to save your objective. GSM displays the current value for the objective in the Design Conformance column.

After you have defined the objective of your optimization scenario, you can begin to build constraints to help the optimization engine produce a solution that is in line with your requirements. To add a new constraint, click **Add**. A dialog box opens, from which you can select the type of constraint you want to add.

GSM supports the following constraint types:

- Extended Attribute, defined in "[Extended Attribute](#)" on page 5-44
- Material Cost, defined in "[Material Cost](#)" on page 5-45
- Nutrient Value, defined in "[Nutrient Value](#)" on page 5-45
- Spec: Output Ratio, defined in "[Spec: Output Ratio](#)" on page 5-46
- Spec: Spec Ratio, defined in "[Spec: Spec Ratio](#)" on page 5-46
- Total Solids, defined in "[Total Solids](#)" on page 5-47

Extended Attribute

Using the Extended Attribute constraint type, you can set up a condition to monitor the amount of a selected extended attribute associated with your formula.

The Extended Attribute constraint is composed of:

Extended Attribute—The extended attribute to constrain. GSM pulls the list of extended attributes from the theoretical extended attributes on the output dialog.

Operator—Logical operator used for comparison purposes. Options are:

- = (equal)
- <= (less than or equal)
- >= (greater than or equal)

Value—The value for extended attribute that you want to optimize towards.

UOM—The unit of measure for the extended attribute.

Display as—GSM can display this information per 100g.

Design Conformance—The current value of the constraint and an icon signifying if the constraint is met.

When you have finished creating the Extended Attribute constraint, click the apply changes icon (✔) to save your row. GSM redisplay the row showing the current value in the Design Conformance column.

Material Cost

Using the Material Cost constraint type, you can set up a condition to monitor the total material cost associated with your formula.

The Material Cost constraint is composed of:

Operator—Logical operator used for comparison purposes. Options are:

- = (equal)
- <= (less than or equal)
- >= (greater than or equal)

Value—The value for cost that you want to optimize to.

UOM—The unit of measure for the cost.

Display as—GSM can display this information per 100g, per Serving, per Consumer Unit or per Traded Unit.

Design Conformance—The current value of the constraint and an icon signifying if the constraint is met.

When you have finished creating the Material Cost constraint, click the apply changes icon (✔) to save your row. GSM redisplay the row showing the current value in the Design Conformance column.

Nutrient Value

Using the Nutrient Value constraint type, you can set up a condition to monitor the amount of a selected nutrient associated with your formula.

The Nutrient Value constraint is composed of:

Nutrient—The nutrient you want to constrain. GSM pulls the list of nutrients from the theoretical nutrients on the selected output.

Operator—Logical operator used for comparison purposes. Options are:

- = (equal)

- <= (less than or equal)
- >= (greater than or equal)

Value—The value for nutrient that you want to optimize towards.

UOM—The unit of measure for the nutrient.

Display as—GSM can display this information per 100g, per Serving, per Consumer Unit, or per Traded Unit.

Design Conformance—The current value of the constraint and an icon signifying if the constraint is met.

When you have finished creating the Nutrient Value constraint, click the apply changes icon (✔) to save your row. GSM redisplay the row showing the current value in the Design Conformance column.

Spec: Output Ratio

Using the Spec: Output Ratio constraint type, you can set up a condition to monitor the amount of an input to the amount of the selected external output. Use this type to define the number of times one input contains or is contained within the selected external output.

The Spec: Output Ratio constraint is composed of:

Output—The external output to constrain.

Operator—Logical operator used for comparison purposes. Options are:

- = (equal)
- <= (less than or equal)
- >= (greater than or equal)

Value—The percentage value for external output that you want to optimize towards.

Design Conformance—The current value of the constraint and an icon signifying if the constraint is met.

When you have finished creating the Spec: Output Ratio constraint, click the apply changes icon (✔) to save your row. GSM redisplay the row showing the current value in the Design Conformance column.

Spec: Spec Ratio

Using the Spec: Spec Ratio constraint type, you can set up a condition to monitor the amount of an input to the amount of another input associated with your formula. Use this type to define the number of times one input contains or is contained within the other input.

The Spec: Spec Ratio constraint is composed of:

Operator—Logical operator used for comparison purposes. Options are:

- = (equal)
- <= (less than or equal)
- >= (greater than or equal)

Value—The value for input that you want to optimize towards.

Specification—The input to constrain.

Value—The value for input that you want to optimize towards.

Specification—The input to constrain.

Design Conformance—The current value of the constraint and an icon signifying if the constraint is met.

When you have finished creating the Spec: Spec Ratio constraint, click the apply changes icon (✔) to save your row. GSM redisplay the row showing the current value in the Design Conformance column.

Total Solids

Using the Total Solids constraint type, you can set up a condition to monitor the percent of total solids after adjusting for water gain/loss that is associated with your formula.

The Total Solids constraint is composed of:

Operator—Logical operator used for comparison purposes. Options are:

- = (equal)
- <= (less than or equal)
- >= (greater than or equal)

Total Solids Value—The percentage value for total solids that you want to optimize towards.

Design Conformance—The current value of the constraint and an icon signifying if the constraint is met.

When you have finished creating the Total Solids constraint, click the apply changes icon (✔) to save your row. GSM redisplay the row showing the current value in the Design Conformance column.

Ordering

Once you have created all of the constraints to guide the optimization engine, you can order them using the re-order row icons (↕) at the right side of each constraint row. Click the re-order row upwards icon (⬆) to move the constraint toward the top of the list and the re-order row downwards icon (⬇) to move it toward the bottom of the list. The order of constraints represents the rank (priority) of the constraints during optimization.

Guidelines Section

In the Guidelines section you can give the optimization engine additional information about how far it can go with certain items to reach a solution. You can supply the necessary information using scalability factors and the Adjust column. The Guidelines section is always in edit mode so you can quickly adjust guidelines on a formula item.

Scalability factors set upper and lower controls and limits on the optimization engine. The Scalability Control columns tell the optimization engine the range of adjustment that you are comfortable with. The Scalability Limit columns tell the optimization engine the biggest adjustment that you will enable it to make.

In the Adjust column you can give the optimization engine even more granular information about how to handle each item during the optimization scenario. Use it to restrict the optimizer for a particular BOM Item.

The available options in the Adjust drop-down list are:

- **None**—No restrictions

- **Fix**—Do not change this item's yield.
- **Raise**—Do not change this item's yield in a negative manner.
- **Lower**—Do not change this item's yield in a positive manner.

The Last Optimization column shows the percent change due to the last optimization performed.

Optimization Method Section

In the Optimization Method section you can further tailor the optimization scenario to meet your goals. You have control over the method that is used from a formulation standpoint, a constraint standpoint, and a distribution standpoint.

Formulation Column

The Formulation section is where you determine to what degree the optimization engine will use the scalability factors set in the Guidelines section. You can set it to either "Minimize Change" or "Emphasize Objective."

- **Minimize Change**—The optimization engine changes the formula as little as possible and uses the scalability controls as the boundaries.
- **Emphasize Objective**—The optimization engine uses the scalability limits in addition to the scalability controls as the boundaries.

Constraints Column

The Constraints section is where you determine to what degree the optimization engine will use the constraints set in the Optimization Method section. You can set it to either "Incremental Constraints" or "All Constraints Required."

- **Incremental Constraints**—The optimization engine meets as many of the constraints as possible. It processes the constraints based on their rank. The optimization scenario stops when a constraint fails to meet the defined criteria.
- **All Constraints Required**—The optimization engine meets every constraint defined.

Distribution Column

The Distribution section is where you determine how the results will be applied to the optimized formula. You can set it to either "Isolated Output Distribution" or "Related Output Distribution."

- **Isolated Output Distribution** —The optimization engine applies formula changes to the selected output only.
- **Related Output Distribution**—The optimization engine applies formula changes to all of the formulation outputs in the same manner.

Once you have defined all of the constraints, adjusted the necessary guidelines, and defined the optimization method, you can start your optimization scenario by clicking Optimize at the bottom of the page.

The optimization engine will try to provide a solution to the optimization problem with the rules that you have defined. If the constraints are too aggressive, the optimization engine will be unable to find a feasible solution and will return an error message.

If the optimization engine cannot find a feasible solution, make your constraints less restrictive and optimize again. When GSM has obtained an optimized solution, the

system displays the changes that it has made in order to achieve the optimized solution.

To reset the optimization scenario to the original formulation, click **Refresh**.

The Refresh button pulls the original information from the formulation specification as it relates to the selected output.

Optimization Action Buttons

Optimization action buttons are defined below:

Reset—Pulls the original information from the formulation specification as it relates to the selected output and clears all constraints and guideline adjustments.

Snapshot—Stores the optimized formula as a snapshot on the original formulation specification.

Save—Saves the optimization scenario without adjusting the original formulation.

Done—Pushes the optimized formula (if one exists) to the formulation specification based on the selected distribution method and returns the user to the formulation specification. If no optimized formula exists, this will simply close the optimization popup.

Cancel—Closes the optimization popup.

Formulation Outputs

This chapter presents an overview of the output capabilities of GSM formulation specifications. Topics in this chapter include:

- [Concepts and Definitions](#)
- [Output Types/Sub-Types](#)
- [Theoretical Material Versus Output Material](#)
- [Theoretical Output \(Output Dialog Box\)](#)
- [Batch Tuning](#)
- [Adjusters](#)

Concepts and Definitions

When material specifications are added to the formula and processing occurs, an output is created. The output should be considered the result of a manufacturing process or formulation specification.

Data associated with an output material includes:

- Material specification attributes such as Nutrition, Compliance, Custom Data, Supporting Documents, % breakdown, etc.
- Formulation and step specific information including:
 - Gain/Loss Adjusters, Qty, Yield, etc.
 - % Step
 - Composition (inputs)
 - Packaging

Output Types/Sub-Types

Outputs can be classified as one of the following types:

- **Internal**—Used to describe the material that moves from one step to another within a single formulation specification. Internal outputs are not available for use by other formulation specifications.
- **External/Owned**—Represents the result of the formulation. External/Owned outputs can be used by other specifications for various purposes. To help describe these purposes External/Owned outputs are further described by Sub-Types. Sub-Types available include:

- **Product**—The primary material created from the formulation specification. A product can be used in further processing by another formulation specification or linked to a trade specification and thought of as a finished good.
- **By Product**—A material that is created as a result of creating a product. A by product output can be linked to a trade specification and sold as a finished good. However it cannot be linked to other formulation specifications for further processing.
- **Waste**—A material that is created as a result of making a product. A waste output cannot be linked to a trade or formulation specification. Therefore it is merely a tool to help accurately reflect inefficiencies or loss during a manufacturing process.
- **Referenced**—Materials can exist outside the context of a single formulation. Examples include:
 - The item is both purchased and manufactured: An organization buys the item and can choose to resell it. In this case, the material can and would exist whether a formulation specification was ever created.
 - The item can be manufactured using different processes or procedures: Multiple formulas can point to a single output material. Each formula can represent acceptable alternatives for manufacturing the output. In this situation, the technical data for the output represents the goal for any given formulation rather than the result. Therefore technical data does not transfer from the formulation to the referenced output.
 - Separate and distinct approval process or security: Some companies manage formulation/processing instructions differently than materials. These differences can include different approval processes and/or different security rights. By referencing a material as an output, the output maintains all the functionality related to raw material materials including its own workflow and security permissions. Therefore the output material can be approved using a different workflow and follow different security rules than the formulation specification that produces the output.

Referenced outputs can be described by Sub-Types similar to External/Owned outputs. Because the referenced output material lives independent of the formulation, the Sub-Types merely describe the role the output plays in relation to the formulation specification.

Theoretical Material Versus Output Material

There are two parts to every output:

- **Theoretical Material**—Describes how the inputs of a formulation come together and create technical definition for composition, nutrition, custom data, and other data elements. This technical definition represents a rollup of data from the input materials. The theoretical material is described by a given formulation and is considered part of the formulation specification. The theoretical material is represented on an output's BOM Item Definition screen.
- **Output Material**—The formal definition of the material. This portion is represented using a material specification. When a material specification is owned by a formulation specification, theoretical data is pushed from the formulation specification to the material specification. When a material specification is referenced the formulation specification is not able to push data. Therefore users manage updates and changes.

Using both the Theoretical and Output Material, it is possible to have multiple formulation specifications that create the same output. Each of the formulation specifications would have its own context specific data however they would each point to the same Referenced Output Material.

Note: Depending on your configuration you may be able to push theoretical values to referenced outputs when the formulation is in design mode. This functionality should be used with extreme caution. When pushing values to referenced output materials it is up to you to confirm that the material attribute changes are accurate for all formulations that produce that material.

Theoretical Output (Output Dialog Box)


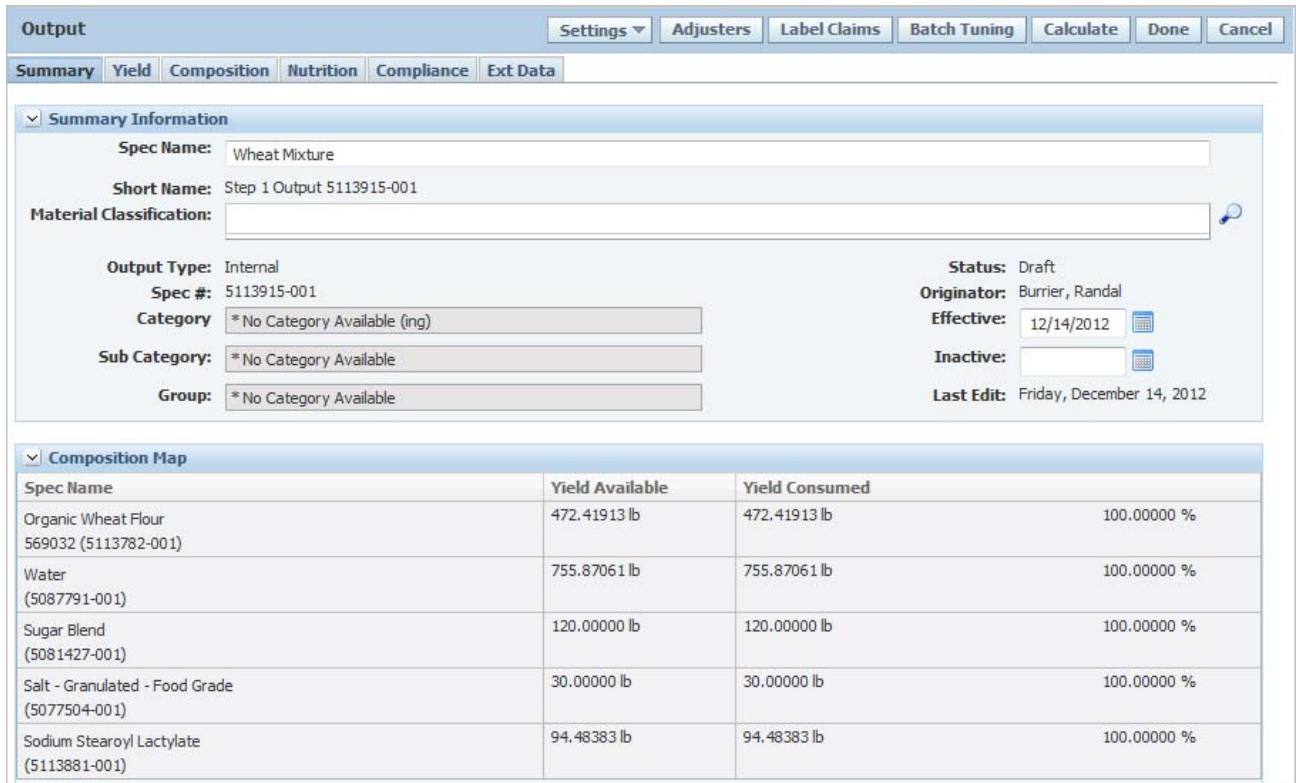
Data associated with output that can be modified using the Output dialog box, shown in [Figure 6-1](#). To access the Output dialog box, click on the document icon ().

Figure 6-1 Output dialog box



The screenshot shows the 'Output' dialog box with several tabs: Summary, Yield, Composition, Nutrition, Compliance, and Ext Data. The 'Summary' tab is active, displaying 'Summary Information' and 'Composition Map' sections.

Summary Information:

- Spec Name:** Wheat Mixture
- Short Name:** Step 1 Output 5113915-001
- Material Classification:** (empty field with a magnifying glass icon)
- Output Type:** Internal
- Spec #:** 5113915-001
- Category:** * No Category Available (ing)
- Sub Category:** * No Category Available
- Group:** * No Category Available
- Status:** Draft
- Originator:** Burrier, Randal
- Effective:** 12/14/2012 (calendar icon)
- Inactive:** (empty field with a calendar icon)
- Last Edit:** Friday, December 14, 2012

Composition Map:

Spec Name	Yield Available	Yield Consumed	
Organic Wheat Flour 569032 (5113782-001)	472.41913 lb	472.41913 lb	100.00000 %
Water (5087791-001)	755.87061 lb	755.87061 lb	100.00000 %
Sugar Blend (5081427-001)	120.00000 lb	120.00000 lb	100.00000 %
Salt - Granulated - Food Grade (5077504-001)	30.00000 lb	30.00000 lb	100.00000 %
Sodium Stearoyl Lactylate (5113881-001)	94.48383 lb	94.48383 lb	100.00000 %

The output dialog displays the output created from the formulation specification. It contains the following tabs:

- **Summary**—Described below, at "[Summary Tab](#)" on page 6-4
- **Yield**—Described below, at "[Yield Tab](#)" on page 6-6
- **Composition**—Described below, at "[Composition Tab](#)" on page 6-9
- **Nutrition**—Described below, at "[Nutrition Tab](#)" on page 6-12

- **Compliance**—Described below, at "[Compliance Tab](#)" on page 6-13
- **Ext Data**—Described below, at "[Ext Data Tab](#)" on page 6-14

The Output dialog has the following action buttons:

- **Label Claims**—Runs label claim determination against the output's nutrition. The claims can run against Theoretical Nutrition and Overrides, Theoretical Nutrition Only, or Specification Values. This option is selected in the output's settings panel; by default all claims are run against theoretical nutrition and overrides. Label claims are explained more fully in [Chapter 4, "Trade Specifications"](#), in "[Label Claims Section](#)" on page 4-11.
- **CACS**—Runs the compliance screener against the output. This feature is described in "[Formulation Tab](#)" on page 5-8.
- **Batch Tuning**—Allows users to increase or decrease the yielded quantity through various options. The tuning affects only the inputs tied to the output being tuned. This button displays when the formulation specification is in a workflow status that is marked as designable in WFA. See "[Batch Tuning](#)" on page 6-17 for more information.
- **Adjusters**—Allows users to apply losses or gains to the output by material, moisture or solids. See "[Adjusters](#)" on page 6-18 for more information.
- **Done**—Runs the BOM calculation and performs the approximate yield and extended attribute calculations and closes the dialog box.
- **Cancel**—Closes the dialog box without saving any data to the specification.
- **Calculate**—Calculates all theoreticals and custom data.
- **Settings**—Use the Settings button to manage which data is pushed to the material specification when the formulation is in design mode.

Summary Tab

The Summary tab, shown in [Figure 6-1](#) above, shows the identity information about the output, including name, specification number, and specification issue number. If the output is owned, the tab shows the workflow status of the parent formulation specification. If the output is referenced, the tab shows the status from the material specification.


The Summary tab contains the following sections:

- **Summary Information**—Described below, in "[Summary Information Section](#)" on page 6-4
- **Composition Map**—Described below, in "[Composition Map Section](#)" on page 6-6
- **Packaging Composition Map**—Described below, in "[Packaging Composition Map Section](#)" on page 6-6

Summary Information Section

The Summary Information section contains the identity information about the output, including:

Specification—The name of the output item. By default, the system automatically names the output "Step X Output [Spec #]" where "X" is the number of the step and [Spec #] represents the system assigned number given to the output item. This can be edited by the user. When an output is marked as External this will be the name given to the material specification as well as the specification number. Select the search icon

() to reference an existing material specification. When a specification is referenced this field displays a read only view of the specification name.

Short Name—Short name of the output item. By default, the system automatically fills in this field with “Step X Output [Spec #]” where “X” is the number of the step and [Spec #] represents the system assigned number given to the output item. This field can be edited by the user and when the output is marked as external it will be the short name of the material specification. When a specification is referenced this field displays a read only view of the referenced specification short name.

Material Classification—A classification field that allows users to further categorize the material. This corresponds to the classification field found on the material specification. If the output type is External, it will be a required field.

Output Type—Captures whether the output is Internal, External, or Referenced and if it is classified as product, by-product, or waste.

Access Level—Used by object level contextual security to help determine if the user has access to the data on the output item and material specification. This grid displays two values:

- a. **Theoretical Access Level**—This value is rolled up from the access level of the material specifications used to create it. Theoretical access level will always roll up using the highest available access level. For example, if Spec A [100], Spec B [400], and Spec C [300] were used to create output ABC the theoretical access level would be 400. This access level is used when deciding which custom data on the output item the user can see. Theoretical access level is always calculated by the system regardless whether the formulation specification is in design mode or not.
- b. **Specification Access Level**—This is the read only view of the External or Referenced Material specification. By default when an output item is typed as external, the theoretical access level is pushed to the specification. This value can be overridden on the material specification itself. For example, with output ABC, even though the theoretical access level is 400, its corresponding material specification can be set to 200.

Note: After the specification access level is set it can still be reset by the system. This happens if the output composition is changed resulting in a different theoretical access level than it previously had. At this time, the new access level value will be pushed to the material specification regardless whether the formulation specification is in design mode or not. For example, if Spec D [500], was added to Output ABC the specification access level of 400 will be replaced with 500 when the formulation specification is saved.

If you are not familiar with access level and object level security in general, refer to the *Agile Product Lifecycle Management for Process Security Configuration Guide* for more information.

Category—The category of the output item. This category selection uses the material specification category listing. When an output is marked as External this will be the category given to the material specification. When an output is referenced this is a read only view of the referenced specification’s category.

Subcategory—The subcategory of the output item. This category selection uses the material specification category listing. When an output is marked as External this will

be the category given to the material specification. When an output is referenced this is a read only view of the referenced specification's category.

Group—The group of the output item. This category selection uses the material specification category listing. When an output is marked as External this will be the category given to the material specification. When an output is referenced this is a read only view of the referenced specification's category.

Originator—Displays the first and last name of the user who created the output item. When an output is marked as External this will be the originator given to the material specification.

Spec #—Displays the system defined number for the output item and/or material specification.

Status—Displays the workflow status of the output item. If the output is internal or external it shares the same workflow and status as the formulation specification. The output item's workflow status will be updated when the formulation specification's status is updated.

Effective—Date the output item becomes effective. By default the system automatically assigns the date the output was created.

Inactive—Date the output item could inactive.

Last Edit—Last edit date of the output item or specification.

Composition Map Section

This section shows what amount of each material input goes into the output. The Name column displays the same information that is displayed when a BOM item is displayed on a formulation specification.

Packaging Composition Map Section

This section shows what amount of each packaging input goes into the output. The Name column displays the same information that is displayed when a BOM item is displayed on a formulation specification.

Yield Tab

The Yield tab, shown in [Figure 6-2](#), contains the packaging configuration and approximate yield information as it relates to the output and formulation specification.

The Yield tab contains the following sections:

- **Packaging Configuration**—Described below, in "[Packaging Configuration Section](#)" on page 6-7
- **Approximate Yield**—Described below, in "[Approximate Yield Section](#)" on page 6-7
- **Design Attributes**—Described below, in "[Design Attributes Section](#)" on page 6-8

Figure 6–2 Output dialog, Yield tab

Output Settings Adjusters Label Claims Batch Tuning Calculate Done Cancel

Summary **Yield** Composition Nutrition Compliance Ext Data

Warning
One or more formula items have missing design attributes information that may affect yield calculations. Please review the warnings for details.

Packaging Configuration

Claims Classification: Individual Food Reference Amount: 50.00000 g

Container Net Contents: 500.00000 g Serving Size: 50.00000 g

Quantity/Traded Unit: 15 Servings: 10.00000

Tare Weight: 0.00000 lb

Approximate Yield

Beginning Batch Size: 1472.77358 lb Beginning % Total Moisture: 58.53735 %

Material Gain/Loss Factor: 1.00000 Moisture Gain/Loss Factor: 1.00000

Approximate Yield: 1472.77358 lb Solids Gain/Loss Factor: 1.00000

Final % Total Moisture: 58.53735 % Labeled Units/Batch: 1336.07771

Final % Total Solids: 41.46265 % Traded Units/Batch: 89.07185

Design Attributes

Attribute	Theoretical	Override	Specification
Total Moisture:	58.53735 %	%	58.53735 %
Final Density:	1.36364 g = 1.00000 mL	g = mL	1.36364 g = 1.00000 mL

Packaging Configuration Section

In the Packaging Configuration section you can enter high-level packaging information about this formulation. With this section, you can populate your output with reference amount and classification data that would be used by Label Claims. You can also set the net weight and serving size and see the calculated tare weight for your output material.

Key fields in the Packaging Configuration section include:

Claims Classification—Type of food product. The system uses this information when you run Label Claims Determination against the specification.

Container Net Contents—The weight, volume, or share of total of the contents, excluding the container.

Quantity/Traded Unit—The number of consumer units in each traded unit.

Reference Amount—The amount customarily consumed for this type of product.

Approximate Yield Section

In the Approximate Yield section, you can view all attributes that affect the final yield. Key fields include:

- **Beginning Batch Size** — The batch size calculated from the specification.
- **Beginning % Total Solids** — The percent of total solids, not including moisture or solids gain/loss. Depending on your configuration, Beginning % Total Moisture may be shown instead of solids.

- **Material Gain/Loss Factor** — Estimated total material gain/loss for that process step. Material adjustments are applied using the adjusters tool. See ["Adjusters"](#) on page 6-18 for more information.
- **Moisture Gain/Loss Factor** — Estimated total moisture gain/loss for that process step. Moisture adjustments are applied using the adjusters tool. See ["Adjusters"](#) on page 6-18 for more information.
- **Solids Gain/Loss Factor** — Estimated total solids gain/loss for that process step. Solids adjustments are applied using the adjusters tool. See ["Adjusters"](#) on page 6-18 for more information.
- **Approximate Yield** — The calculated yield based on the batch size and all losses and gains.
- **Final % Total Solids** — Estimated total solids after all gain/loss is applied.
- **Final % Total Moisture** — Estimated total moisture after all gain/loss is applied.
- **Labeled Units/Batch** — The calculated number of consumer units per batch.
- **Traded Units/Batch** — The calculated number of traded units per batch.

See the ["Summary Information Section"](#) on page 6-4 to learn more about how losses can be applied. .

Design Attributes Section

This section includes three columns:

- **Theoretical**—Shows rolled up data from the formulation specification. If any of the BOM items are missing data elements that are used for rollups, the error icon (⚠) is displayed. Click on the icon for more information about offending specification(s).
- **Override**—Allows the user to enter a value different than the rolled up value.
- **Specification**—Shows the data that already exists on the specification.

This section displays three attributes:

- **Total Moisture (or Solids)**—This is the rolled up total moisture for the output. This value is calculated using the regulatory breakdowns' component moisture values. If no regulatory breakdown is found or if the total moisture value is missing for any component in the regulatory breakdown then the system will use the raw material's total moisture. Depending on your configuration, a warning will appear if any components are missing moisture values.
- **Final Density**—This is the rolled up density attribute. This value is calculated using the input materials' density. The Unit of Measures used will be decided from Profile and Preferences and/or formulation settings.
- **Edible Portion**—This is the rolled up edible portion attribute. This value is calculated using the input materials' edible portion.

Composition Tab

The Composition tab contains the regulatory BOM, composition listing, and generated breakdown that will be written to the material as the regulatory breakdown.

The tab consists of the following sections:

- **Regulatory BOM**—Described below, in "[Regulatory BOM Section](#)" on page 6-10
- **Theoretical Breakdown**—Described below, in "[Theoretical Breakdown Section](#)" on page 6-11
- **Regulatory Breakdown**—Described below, in "[Regulatory Breakdown Section](#)" on page 6-11

Note: To view the Composition tab, users must have the formula classifications associated with all regulatory % breakdowns for the formula items. An error message displays for users without access.

[Figure 6-3](#) shows the Composition tab.

Figure 6–3 Output dialog, Composition tab

Output			Settings ▾	Adjusters	Label Claims	Batch Tuning	Calculate	Done	Cancel																																																																						
<div>Summary Yield Composition Nutrition Compliance Ext Data</div>																																																																															
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Regulatory BOM Section

This section displays a label composition-like version of the formulation as it relates to the output. This view includes any % breakdown information for items in the formulation. Only the % breakdown that is tagged with the "Regulatory" tag will be included in this view.

The declaration method for this view mimics the (X,Y) method from LIO. If a regulatory breakdown does not exist or only uses range values, the specification name is used. The data in this section is read-only and will not be included when written to the material specification. It will be printed with the formulation specification/output material print.

When regulatory breakdowns are used properly this section shows the formulation input material and its corresponding breakdown. Component tags will also be displayed here. Only tags marked as available in "breakdown" will be rolled up here.

Theoretical Breakdown Section

This section displays the system created theoretical breakdown. It combines all items and displays the breakdown at the component level. It will combine like components. See [Figure 6-3](#) and compare the Regulatory BOM with the theoretical breakdown section to see the differences. Component tags will also be combined here. Only tags marked as available in "breakdown" will be rolled up here.

Regulatory Breakdown Section

This section displays the breakdown that will be pushed to the output material specification.

Description—Name of the regulatory breakdown. The string "Regulatory Breakdown" is the default displayed.

Restrictions—This is used to help categorize different versions of the breakdowns for usage in the Listed Ingredient Order (LIO) tool.

Formulation Classifications—Classifications are used to secure the breakdown. If a classification is added, a user must be in a specific group assigned to a classification to see the breakdown. The classification is calculated based on all breakdowns used to create this one. This grid displays the following:

- **Theoretical**—Displays the theoretical rolled up classifications.
- **Override**—Select the add data icon (+) to select classifications from a dialog box. When the classification is pushed to the material specification, if an override exists, this data should be pushed; otherwise the theoretical is pushed.

Click the **Leave Classification Blank** field to indicate theoretical classifications will not be pushed. The Classification field will be left blank on the material specification, and any overrides already selected are cleared.

- **Specification**—Displays the classifications tied to the regulatory breakdown on the specification.

Tags—Breakdowns can be tagged. Tags help identify breakdowns and most tags help define how you want the system to react to the breakdown. Available tags are listed on ["Tags"](#) on page 3-27.

Automatically Refresh— This denotes that the breakdown will be automatically refreshed every time the formulation is adjusted. During design this section should continue to automatically refresh. When finalizing your formulation, if you need to override the breakdown you would unselect this field. Once unselected the calculation will stop and the breakdown will be editable.

Component grid contains the following fields:

Component—Name of the component. This is generally a component catalog term or free text.

Description—Description of the component.

Formulation Tags—These tags help guide adjusters and other system features. See ["Adjusters"](#) on page 6-18. Tags can be defined at the component catalog level, material specification level, and even the formulation process level. Only tags marked as available in "breakdown" will be rolled up here.

Formulation—Percentage of the breakdown that is made up of the component.

Total Moisture—Amount of water found in the component.

Function—Function of the component. No system behavior is tied to this function. This is not calculated and must be set on the material specification after the output is no longer in design mode. If you need an attribute that is calculated, formulation tags should be used.

Critical—Indicates whether the component is a critical component to the breakdown. No system behavior is tied to this. This is not calculated and must be set on the material specification after the output is no longer in design mode.

Nutrition Tab

This tab displays the rolled up nutrient information as it relates to the output and formulation specification. The tab consists of one section: Nutrient Composition.

Nutrient Composition Section

All of the nutrients that are present in BOM items are automatically included in this section.

If you click on an individual nutrient, GSM displays the nutrient composition dialog box, which contains the formula items where the nutrient is present. 100mL nutrition is supported.

When child specifications do not have specified nutrients, the rolled up value may be incorrect. Warning icons (⚠) display next to nutrients in error conditions.

Figure 6–4 Output dialog, Nutrition tab

Output

Settings

Adjusters

Label Claims

Batch Tuning

Calculate

Done

Cancel

Summary

Yield

Composition

Nutrition

Compliance

Ext Data

Warning

One or more formula items have missing nutrient information that may affect theoretical rollups. Please review the warnings on the individual nutrients for details.

Nutrient Composition

	Nutrient	Theoreticals (100g)	Overrides	Specification (100g)	Per Serving	Source	Comments	
1	Calories	128.33320 kcal		128.33320 kcal	64.16660 kcal	Theoretical		
2	Protein	0.64154 g		0.64154 g	0.32077 g	Theoretical		
3	Carbohydrates	14.89344 g		14.89344 g	7.44672 g	Theoretical		
4	Dietary Fiber	0.64154 g		0.64154 g	0.32077 g	Theoretical		
5	Total Sugar	8.55529 g		8.55529 g	4.27764 g	Theoretical		
6	Total Fat	0.00000 g		0.00000 g	0.00000 g	Theoretical		
7	Saturated Fat	0.00000 g		0.00000 g	0.00000 g	Theoretical		
8	Cholesterol	<div>Warning</div> 0.00000 mg		0.00000 mg	0.00000 mg	Theoretical		
9	Vitamin A - Total	0.00000 IU		0.00000 IU	0.00000 IU	Theoretical		
10	Vitamin A - IU	<div>Warning</div> 0.00000 IU		0.00000 IU	0.00000 IU	Theoretical		
11	Vitamin C	0.00000 mg		0.00000 mg	0.00000 mg	Theoretical		
12	Calcium	5.90722 mg		5.90722 mg	2.95361 mg	Theoretical		
13	Potassium	0.40739 mg		0.40739 mg	0.20370 mg	Theoretical		
14	Sodium	<div>Warning</div> 804.05884 mg		804.05884 mg	402.02942 mg	Theoretical		

Add New

Import

NSM

The nutrient composition follows previously defined functionality around overrides, namely:

- **Theoreticals (100g/100mL)**—This column shows the rolled up data from the formulation specification.
- **Overrides**—This column allows you to enter a value different than the rolled up value.
- **Specification (100g/100mL)** —This column shows the data as it exists on the specification.
- **Per Serving**—This column displays a value calculated from the value to be stored on the specification and the serving size (from the Packaging Configuration section). This is an un-rounded value.
- **Source**—The original location of the nutrition. If the user provides an override the rolled up value, the user must pick a source. Otherwise it defaults to theoretical.
- **Comments**—Free text comments around the nutrition.

Note: Comments are only persisted for nutrient items that have been manually added or overridden.

The default source for all rolled up items is "Theoretical." If you provide an override, the source is blanked out. If you delete an override value, the source defaults back to "Theoretical." "Theoretical" cannot be selected from the list.

You cannot remove items from the grid if the items are rolled up from the child items. However, if you added an item to the specification or to the Output dialog box, you can remove the item using the delete icon (✖).

Click **Add New** to add new nutrient items. GSM displays the nutrient item list in a dialog box. You can then enter a value in the Overrides field for the new item.

Click **Import** to add nutrient items that are tied to existing food composition items, FCL items, material specifications, or nutrient profiles.

Click **NSM** to import nutrient items from nutrient analyses or composites.

Compliance Tab

This tab displays the rolled up compliance information for the output and formulation specification.

All of the compliance items (allergens, additives, intolerances, complies with) that are present in child items are displayed by default.

If you click on a compliance item, a composition dialog box displays. The dialog box contains formula items where the compliance items are and are not present. The following columns are included:

- **Theoreticals**—Shows the rolled up data from the formulation specification.
- **Overrides**—Allows you to enter a value different than the rolled up value.
- **Specification**—Shows the data as it exists on the specification.
- **Comments**—Free text comments.

Click **Add New** to add compliance items to the grid.

You cannot remove items from the grid if the items are rolled up from the child items. If you added an item to the specification or to the Output dialog box, you can remove the item using the delete icon (✖).

The Complies With section displays whether the item is compliant or non-compliant. You can click the complies with item to view a dialog box showing the formula items where the compliance items are present.

Figure 6–5 Output dialog, Compliance tab

Output Settings Adjusters Label Claims Batch Tuning Calculate Done Cancel

Summary Yield Composition Nutrition **Compliance** Ext Data

Allergens

Known to Contain

Item	Theoreticals	Overrides	Specification	Comments
1 Honey	1.22218 ppm		1.22218 ppm	

Add New

May Contain

Item	Theoreticals	Overrides	Specification	Comments
No records found.				

Add New

Does not Contain

Theoreticals	Overrides	Specification
No records found.		

Add New

Additives

Known to Contain

Item	Theoreticals	Overrides	Specification	Comments
No records found.				

Add New

May Contain

Item	Theoreticals	Overrides	Specification	Comments

Ext Data Tab

This tab includes the rolled up custom data information for the output and formulation specification. Distinct custom data (tagged with the "Is Design Attribute" tag in ADMN) which are present on formula items are included. Two sections are included: Extended Attributes and Custom Sections.

When rolling up distinct extended attributes added to the Output dialog box, only the security classification on the extended attribute will be used. The security classification on the custom section where the extended attribute may have existed on the raw material will be ignored.

Figure 6–6 Output dialog, Ext Data tab

Output						Settings ▼	Adjusters	Label Claims	Batch Tuning	Calculate	Done	Cancel
Summary Yield Composition Nutrition Compliance Ext Data												
▼ Extended Attributes												
Item	Theoreticals	Overrides	Specification	Method	Comments							
khc Brix	3.25915678874547 °Brix	<input type="text"/> °Brix ▼	3.25915678874547 °Brix	allow null ▼	<input type="text"/>							
khc Range	target: 3.25915678874547 min: 2.85176219015228 max: 3.66655138733865 mg	target: <input type="text"/> min: <input type="text"/> max: <input type="text"/> ▼	target: 3.25915678874547 min: 2.85176219015228 max: 3.66655138733865 mg	allow null ▼	<input type="text"/>							

Extended Attributes Section

In the Extended Attributes section, you can select from a list a number of extended attributes related to the formulation. This list is the aggregate of the extended attributes listed at the BOM item level on the basis.

Once you have selected the extended attribute values, GSM automatically rolls them up from the BOM items to the formulation level, taking into account the following:

- Formulation composition
- Gain/loss factor for each BOM item within each step
- Processing gain/loss factor at the batch level
- Water gain/loss factor at the batch level

Note: The only types of extended attributes that can be rolled up are numeric and quantitative range.

You can choose a rollup method of “allowing null” to allow GSM to roll up data even though data may be missing at the BOM item level. You can also choose “not allowing null,” in which case GSM will not roll up the data if there is missing data at the BOM item level.

The following columns are included:

- **Item**—When clicked, displays the extended attribute composition dialog box. The dialog box shows the formula item where the attribute is present.
- **Theoreticals**—Shows the rolled up data from the formulation specification.
- **Overrides**—Allows the user to enter a value different than the rolled up value.
- **Specification**—Shows the data as it exists on the specification.
- **Method**—This value defines how to treat the occurrence of nulls when the system is trying to roll up the extended attribute value. “Allow Null” will provide the user a value even if all specifications in the formula do not have the extended attribute defined. “Do Not Allow Null” will not return a value if any of the formula items do not have the extended attribute defined.
- **Comments**—Comments about the extended attribute.

Click **Add New** to add extended attributes. If an attribute has already been rolled up, it cannot be added again.

You cannot remove items from the grid if the items are rolled up from the child items. If you added an item to the specification or to the Output dialog box, you can remove it using the delete icon (✖).

Custom Sections Section

This section displays custom sections for the formula item.

Batch Tuning

Batch tuning allows you to adjust the formulation batch size based on specific criteria. This tool will not alter the composition of your formulation; it merely applies a factor to all inputs to increase or decrease the batch size. There are six ways to adjust your batch size:

1. **Target Batch Size Based on Approximate Yield**—This option allows you to provide a target batch size and the formula will be adjusted to reach that batch size. For example, you have a formulation that produces 150kg, you want to product 300kg. You would type in the target of 300kg and the system would adjust all formulation inputs proportionally to reach 300kg.
2. **Target Batch Size with % Total Solids**—This option allows you to adjust the batch size by % total solids. This allows you to specify a target % total solids and a batch size. The system will adjust the batch size and apply a moisture gain/loss factor to reach the targets.
3. **Target Input Yield**—This option allows you to adjust the batch size by providing a target input yield. Input Yield is the weight of the formulation before any gain/loss factors are applied. It is the weight of all materials going into the formulation.
4. **Proportional Batch Size Using Input Item Yield**—This option allows you adjust the batch size based on one input material weight. For example, your formulation is currently using 25kg of input A but you want to create the batch using 15kg of input A. The system will adjust the formulation proportionally setting input A to 15kg and adjust all other inputs by the same factor.
5. **Labeled Unit Quantity**—This option allows you to adjust the batch based on a target labeled unit quantity. It uses the data provided in the packaging configuration section of the theoretical output yield tab. For example, if your current formulation creates 5 labeled units, you can ask the system to adjust the batch size to create 15 labeled units.
6. **Traded Unit Quantity**—This option allows you to adjust the batch based on a target traded unit quantity. It uses the data provided in the packaging configuration section of the theoretical output yield tab. For example, if your current formulation creates 2 traded units, you can ask the system to adjust the batch size to create 5 traded units.

Adjusters

Adjusters can be used to manage in gains or loss you would like to apply to the product. Formulation adjusters are applied at the output level. The adjusters are only available when the formulation is in design mode and can be used on internal, external or referenced outputs. When selected, the button opens the Adjuster Manager dialog box. When reading the formulation, if adjusters have been set, the button will appear so you can see what adjusters have been applied. If no adjusters have been applied the button will not appear.

Adjuster Manager

The Adjuster Manager is where adjustments are made and stored. There are four things a user can control in the adjuster manager window: Type, Behavior, Path, and Value.

Figure 6–7 Adjuster Manager

Type	Behavior	Path	Value	
Moisture	Moisture	Approximate Yield	100.00000 kg	✖

Buttons: Add New, Close

Key fields include:

Type—The type of adjuster being applied. There are five overall types of adjusters.

1. **Material**—Allows you to adjust the entire output.
2. **Moisture**—Allows you to adjust ALL moisture in the output.
3. **Solids**—Allows you to adjust ALL solids in the output.
4. **Tags**—You make see multiple tags here that can be used to adjust the output. Tags are defined tags for a single or a group of inputs. You would tag the input(s) inside the inputs grid, see "Selecting Formulation Tags" section for more information. Once an input is tagged you will see the tag listed in the type dropdown. This tag can then be used to control adjustments. For example, a formulation includes 2 inputs that merely act as processing aids. These processing aids are 100% moisture. When the product is processed it loses 100% of just the processing aids and no other moisture.
5. **Specific Inputs**—All inputs used to make that output will also be listed. You can select a specific input and adjust material, moisture or solids for that single input.

Behavior—The behavior represents the specific attribute that is being targeted for loss. The following behaviors are supported:

1. **Material**—This represents the entire material (solids + moisture). You can apply a material loss to represent processing loss. For example, when making cookie dough some dough may get stuck on the processing equipment. This lost material never becomes part of the batch. This material loss can be handled using the material adjuster.

2. **Moisture**—Represents all moisture content in the product. A material is made up of solids and moisture. For example, an apple is made up of 75% moisture and 25% solids. When you bake an apple you lose moisture but not solids. So you could apply a moisture loss to represent the baking process. When this occurs the moisture is removed from the formulation, the batch size is updated and the calculated total solids/moisture percentage is adjusted accordingly.
3. **Solids**—Represents all solids in the product. This allows you to adjust the product based on its total solids.

Note: Depending on your configuration on certain behaviors may be available per tag.

Path—There are multiple ways to calculate an adjustment; this is represented by path. The type of adjuster determines which path(s) are applicable. Here are the paths currently available:

1. **Factor**—This is available for all types. It is a single factor that will be used to calculate the gain/loss. For example, if you want to lose half of the moisture you would pick the Moisture Type and set the factor to .5 and the appropriate moisture loss will be applied and your batch size will be adjusted.
2. **Approximate Yield**—This represents the approximate yield of the output. For example, your current batch size is 500kg, but after you bake it you know it weighs 450kg. In this path you can type in your target approximate yield and the system will calculate the moisture loss needed to reach that target.
3. **Total Weight**—This represents the total weight of the item(s) in the formulation. For example, if you have 3 inputs tagged as "processing aid" and each went into the formulation at 75lbs. When you select the path of "Weight". You will see the weight of all processing aid inputs added together, which would be 225lbs. You can then adjust the weight and the appropriate loss would be applied removing moisture, solids or total material weight from just the items tagged as "processing aid".
4. **% of Formula**—This is the percent of the formula that the item(s) take up. For example, if you have 4 items added to a formulation all at 50lbs each. Two inputs where tagged as "processing aid" If you were to look at the percentage of processing aid in your formula you would see 50%. You could then decide you want processing aids to only make up 45% of your formulation and the appropriate loss would be applied removing moisture, solids or total material weight from just the items tagged as "processing aid".
5. **Target**—This represents the percent total solids or percent total moisture value. For example, if your product is 45% moisture and after you bake it you know it is 30% moisture you would select this path. When the adjuster is applied at 30% the appropriate moisture loss will be applied and your batch size will be adjusted.

Value—This field is where you will adjust your loss value.

Adjustment Display

Once adjustments are applied the gain/loss factors will be shown on the output's Yield tab. All adjustments are combined and each behavior type is shown as a single factor (Material, Moisture and Solids).

Figure 6–8 Output Yield Tab

Approximate Yield	
Beginning Batch Size: 200.00000 lb	Beginning % Total Solids: 62.50000 %
Material Gain/Loss Factor: 1.00000	Moisture Gain/Loss Factor: 0.50000
Approximate Yield: 162.50000 lb	Solids Gain/Loss Factor: 1.00000
Final % Total Moisture: 23.07692 %	Labeled Units/Batch:
Final % Total Solids: 76.92308 %	Traded Units/Batch:

Factors will also be displayed for external outputs in the outputs grid on the formulation and process tabs. Depending on your configuration, factors may also be displayed for internal outputs.

Figure 6–9 Outputs grid

Outputs										
Output	Input	Material		Output Type	Qty	Material G/L	Moisture G/L	Solids G/L	Yld	% Formula
1	2	Step 1 Output 5113719-001	<input type="checkbox"/>	Internal	--	--	--	--	--	--
2	3	Step 2 Output 5113720-001	<input type="checkbox"/>	Internal	--	--	--	--	--	--
3		Step 3 Output 5113721-001 (5113721-001) [Draft]	<input type="checkbox"/>	External - Product	200.00000 lb	1.00000	0.50000	1.00000	162.50000 lb	100.00000
					200.00000 lb				162.50000 lb	

Menu Item Specifications

This chapter presents an overview of the capabilities of GSM regarding menu item specifications. Topics in this chapter include:


- [Summary Tab](#)
- [Build Tab](#)
- [Packaging Tab](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

Key sections in the Summary tab include:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Menu Item Description**—Discussed below, at ["Menu Item Description Section"](#) on page 7-2
- **Cross References**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5
- **Approved for Use In**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5

Figure 7-1 Summary tab


Prodika Burger (5082107-001)
 Menu Item Specification

Approved

Summary | Build | Packaging | Compliance | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: Prodika Burger
Short Name: PMD
Access Level: No Access (Global) (0)
Spec Status: Approved - Approved
Spec #: 5082107-001
Category: Menu Item A
Sub Category: Menu Item B
Group: Menu Item C
Supercedes:
Reason for Change:

Originator: [Example: Michael Smith \(2010-10-10\)](#)
Effective: 12/1/2010
Inactive: 12/1/2011
Last Edit: Friday, February 11, 2011

Menu Item Description

Standard: Local - Meets Global Standard
Menu Item Class: AOW Emerging "Brand Identified"
Menu Item: Big Stuff Hamburger
Packaging: Paper Cover
Appearance:
Sensory:

Cross References

	System Name	System ID	Equivalent	Externally Managed	
1	+ BPCS System	USBPCS		<input type="checkbox"/>	✖

Add New

Approved for Use In

	Business Unit(s)	Countries	
1	+ CPI North America	+	✖

Add New

Menu Item Description Section


This section provides fields that you can use to categorize and classify menu items. Additionally, it has enriched text fields that enable descriptions of menu items, packaging, and appearance, as well as sensory descriptions.

Build Tab

The Build tab consists of the following sections:

- "Menu Item Build Section" on page 7-3
- "Alternate Products/Menu Items Section" on page 7-4













Figure 7–2 Build tab


Prodika Burger (5082107-001)
 Menu Item Specification

Approved




Summary | **Build** | Packaging | Compliance | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Menu Item Build

	Product / Menu Item	Quantity	Weight	Build %	Comments		
1	 Prodika Bun - Fresh (5082111-001) [Approved] 	30 g	30 g	10.91%			
2	 Prodika 4:1 Beef Patty - US (5082108-001) [Approved] 	200 g	200 g	72.73%			
3	 Prodika Cheese Slice (5082117-001) [Approved] 	45 g	45 g	16.36%			
	Total		275 g				

Add New | Order | Calculate

Alternate Products/Menu Items

	Orig Material(s)	Substitute Factor / Substitute Material(s)	Description	
1	5082108-001	1 Bun - Fresh - US (5080383-001) [Draft]		
2	5082111-001	1 Prodika Bun - Fresh (5082111-001) [Approved]		
3	5082117-001	1 Restaurant Style Hamburger Bun - MB (5089376-001) [Draft]		

Add New

Menu Item Build Section

The Menu Item Build section contains the products or menu items that make up a menu item. You can adjust the quantity and comments around that item in the build when the specification is in edit mode. GSM calculates the weight and build percentage when you edit that row. This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision. The following buttons are available when the specification is in edit mode:

Add New—Adds menu build items.

Order—Adjusts the sort order of menu build items.

Calculate—Calculates the Weight column and Build % columns.

Figure 7-3 Menu Item Build section detail showing one item, in edit mode

Menu Item Build							
	Product / Menu Item		Quantity	Weight	Build %	Comments	
	Bun (5084162-001) [Draft]		<input type="text" value="1"/> g	1 g	33.33%		
	4:1 Beef Patty (5084160-001) [Draft]		1 g	1 g	33.33%		
	Cheese Slice (5084161-001) [Draft]		1 g	1 g	33.33%		
			Total	3 g			
<div> <div>Add New</div> <div>Order</div> <div>Calculate</div> </div>							

The units of measure (UOMs) for the build quantities may vary. By default, mass-based units of measure are available for each product specification. If the product specification has a relative density, then volume-based UOMs are also available. If the product specification also has a unit conversion factor, then a unit/count unit of measure will be available. You can use unit/count units of measure when referring to menu items that are represented in the build.

Alternate Products/Menu Items Section

The Alternate Products/Menu Items section contains the product and menu item specification data that you can use as a substitute for one of the items in a build. You can replace each item in the primary build with one or more alternate items.

In this section you can define alternate products or menu items that may be used. You can replace each item in this section with one or more alternate items. You assign to each alternate a substitution factor to denote how users doing formulation work should use the alternate item to replace the original.

Packaging Tab

The Packaging tab contains information related to the packaging of a specific menu item specification and consists of the following sections:

- "Packaging Materials Section" on page 7-5
- "Alternate Packaging Section" on page 7-5

Figure 7–4 Packaging tab

Prodika Burger (5082107-001)
Menu Item Specification

Approved

Summary Build **Packaging** Compliance Ext Data Related Specs Supporting Documents References Approval/Audit Trail

Packaging Materials

Level	Packaging Material Specification	Item Type	Units	Scrap Factor
1 Inner	+ PROMO CARTON (5077609-001) [CSS Syndication]		1.00000 units	1.00000
2 Inner	+ Corrugated Case1 (5077482-001) [CSS Syndication]	Packaging Material	2.00000 kg	1.00000

Add New Order

Alternate Packaging

Packaging Material Specification	Units	Substitutes	Scrap Factor
1 + rqs 20060818 1211 DR 5019 (5080679-001) [Approved]	1.00000 kg	5077609-001	1.00000

Add New

Packaging Materials Section

In this section you can describe the packaging associated with this specification by associating and categorizing packaging and printed packaging specifications. This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Key fields include:

Level — Enables you to categorize how the packaging is applied to this item, for example, whether the packaging is considered inner, intermediate, or outer packaging.

Item Type — The type designated on the packaging specification.

Alternate Packaging Section

The Alternate Packaging section contains information related to any acceptable alternative packaging options. This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Compliance Tab

The Compliance tab includes the following sections:

- **Label Claims**—Discussed below, at "[Label Claims Section](#)" on page 7-7
- **Compliance With**—For discussion of this commonly used section, please see "[Complies With Section](#)" on page 3-7
- **Allergens, Intolerances, and Additives**—For discussion of this commonly used section, please see "[Additives, Allergens, and Intolerances Sections](#)" on page 3-9

Figure 7-5 Compliance tab

Prodika Burger (5082107-002)
Menu Item Specification

Draft

Summary Build Packaging **Compliance** Ext Data Related Specs Supporting Documents References Approval/Audit Trail

☒ **Label Claims**

Potential:

Actual:

☒ **Complies With**

☒ **Allergens**

Known to Contain

	Allergens		Max / 100g	Source / Comments
1	Allspice	<=	5.00000 g	
2	Anise	<=	2.00000 mg	

May Contain

	Allergens		Max / 100g	Source / Comments
1	Annatto	<=	4.00000 g	



Does not contain



☒ **Intolerances**

Label Claims Section

The Label Claims section contains the label claims linked to a menu item specification. The label claims values and calculation rules are maintained by an administrator.

Key fields include:

Potential—Select all of the possible label claims for the finished good. This field can be populated in several ways. You can click on the search icon () to select label claims, type into the **Potential** field, or calculate the label claims by using label claims determination. To calculate label claims, select the calculate icon (). GSM opens the label claims determination popup, shown in [Figure 7-7](#), on page 7-9. See "[Label Claims Determination](#)" on page 7-7 for more information.

Actual—Select the actual label claims declared on the finished good. This field can be populated several ways. You can either click on the search icon () to select actual label claims, type into the **Actual** field, or use the copy field icon (). When you click the copy field icon, GSM displays a multi select dialog box containing all values in the potential label claims field. You can use the dialog box choices to populate the actual field only with potential options.

Label Claims Determination

Using the label claims determination feature, you can interrogate a product for claims applicability based on a centralized group of rules segregated by label claims authority.



1. Click the calculate icon (). GSM opens the Label Claim Determination dialog box.
2. Some claims require another product to compare to, such as Low Fat. The system can evaluate comparative claims if you provide additional nutrient information that describes the comparative product. Select the Comparative/Reference Product tab and fill in the appropriate information needed. You can also import data from another menu item specification by using the search icon () to select the **Reference Product**. Data will be imported from the menu item specification's active nutrient profile. See [Figure 7-6](#).

Figure 7–6 Label Claim Determination dialog box, Comparative/Reference Product tab

Nutrient Composition	
Nutrient	Ratio
Calories	<input type="text"/> kcal
Total Fat	<input type="text"/> 15.00000 g
Saturated Fat	<input type="text"/> g
Trans Fatty Acid	<input type="text"/> g
Cholesterol	<input type="text"/> 81.00000 mg
Sodium	<input type="text"/> mg
Dietary Fiber	<input type="text"/> 2.00000 g
Sugars	<input type="text"/> g

3. On the Claims Determination tab, from the **Label Claim Authority** drop-down list, select a specific rule group to use for considering claims applicability.
4. Click **Display Label Claims** to display the Applicable Claims table.

The system evaluates label claims against rules that you previously defined. For more information on those rules, refer to the *Agile Product Lifecycle Management for Process Data Administration Toolkit Guide*. All selected claims based on the label claims authority appear in the Applicable Claims table with color coding to show whether the claim may be made for the product.

When the system evaluates a claim as compliant, the Comments column displays supporting information for the claim along with one or more user-defined values supporting the assessment in the Calculation(s) column, as shown in [Figure 7–7](#). If the system finds that the claim is invalid, no such information appears in the Comments column.

5. Select the claims you want to push to the specification. All compliant claims are automatically selected. You can unselect any claims you do not want to push to the specification. Once you have all the claims selected click the **Push Label Claims** button at the bottom of the grid. This action will close the dialog window and populate the potential label claims field with the selected claims. This action will replace all existing potential label claims in the field; if you would like to just append to the list make sure the "Append to existing list" checkbox is selected. See [Figure 7–7](#).

Figure 7–7 Label Claims Determination dialog box

Label Claim Determination Close

Claims Determination Comparative/Reference Product

☒ Applicable Claims

Label Claim Authority: US FDA Nutrient Claims 2005 Display Label Claims

<input checked="" type="checkbox"/>	Label Claim/Type of Claim	Yes/No	Comments	Calculations
<input checked="" type="checkbox"/>	Saturated Fat (Low)	Yes	Individual foods: 1 g or less per reference amount and 15% or less of calories from saturated fat. ATTENTION: Next to all saturated fat claims, must declare the amount of cholesterol if 2 mg or more per reference amount; and the amount of total fat if more than 3 g per reference amount (or 0.5 g or more of total fat for "Saturated Fat Free").	.5 g Saturated Fat (per RACC) 8.910891 % Calories from Saturated Fat
	Sodium (Light in Sodium)	No		
<input checked="" type="checkbox"/>	Total Fat (Low)	Yes	Individual foods: 3 g or less per reference amount (and per 50 g if reference amount is small).	.5 g Fat (per RACC)
	Sodium (Reduced/Less)	No		
	Sodium (Salt Free)	No		

Push Label Claims ☐ Append to existing list

Ext Data Tab

The Ext Data tab includes the following sections:

- **Extended Attributes** — For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Manage Custom Sections** — For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- **Nutrient Profile**—Discussed below, at "[Nutrient Profile Section](#)" on page 7-10
- **Global/Regional Standard**—Discussed below, at "[Global/Regional Standard Section](#)" on page 7-11
- **Alternate Standards**—Discussed below, at "[Alternate Standards Section](#)" on page 7-11
- **Associated Specification**—For discussion of this commonly used section, please see "[Associated Specifications Section](#)" on page 3-15
- **Master Specifications**—For discussion of this commonly used section, please see "[Master Specifications Section](#)" on page 3-15

Figure 7–8 *Related Specs tab*

Prodika Burger (5082107-001) Menu Item Specification Approved

Summary Build Packaging Compliance Ext Data **Related Specs** Supporting Documents References Approval/Audit Trail

Nutrient Profile

	Profile #	Nutrient Profile	Active Profile	Effective Date	Status	
1	5082125-001	Prodika Burger [Approved]	<input checked="" type="checkbox"/>	Thursday, December 14, 2006	Approved	

▼ Add New Add Existing

Global/Regional Standard

	Spec #	Spec Name	
1	5082128-001	Prodika Meal Deal [Approved]	

Alternate Standards

	Spec #	Spec Name	
2	5082126-001	Prodika Meal Deal [Approved]	

Master

Nutrient Profile Section

In this section you can create new or associate existing nutrient profiles for this specification.

Nutrient profiles are actually separate documents from the menu item specification with their own workflows.

More than one nutrient profile can exist on a menu item specification, but one of the nutrient profiles must be flagged as the "Active Profile" for usage in rollups elsewhere in the system and label claim determination. Only one nutrient profile can be marked as active.

Global/Regional Standard Section

The Global/Regional Standard section contains any specifications that are global/regional standards related to the menu item specification. You can associate only one global/regional standard to each specification.

Alternate Standards Section

The Alternate Standards section lists any alternate standard specifications for the menu item specification. GSM locates and displays any alternates that are linked to any other specification that references the current specification as a global/regional standard.

Supporting Documents Tab

The Menu Item Specification Supporting Documents tab consists of the following sections:

- **Supporting Documents** —The document types available are Attachments/Procedures, URL, and Rich Text. For discussion of this commonly used section, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents** — For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.
- **Testing Protocols** — For discussion of this commonly used section, please see ["Testing Protocols Section"](#) on page 3-25.

Figure 7–9 Supporting Documents tab

Prodika Burger (5082107-002)
Menu Item Specification

Draft

Summary | Build | Packaging | Compliance | Ext Data | Related Specs | **Supporting Documents** | References | Approval/Audit Trail

Supporting Documents

Supporting Documents for this Specification

1	Attachments/Procedures	
---	--	--

Attachments/Procedures | URL | Rich Text | View Thumbnails

DRL Documents

Name	Type
1 North America	Catalog

Add - Browse | Add - Search

Testing Protocols

Protocol #	Testing Protocol	Scope	Status
No records found.			

Add New | Pull from Library

References Tab

The Menu Item Specifications References tab consists of the following sections:

- **Activities** — For discussion of this commonly used section, please see "[Substitute Materials Section](#)" on page 3-30.
- **Related Documents**—For discussion of this commonly used section, please see "[Related Documents Section](#)" on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see "[Specification Dependencies Section](#)" on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Nutrient Profiles

This chapter presents an overview of the capabilities of GSM regarding nutrient profiles. Topics in this chapter include:


- [Summary Tab](#)
- [Nutrition Panel Tab](#)
- [Label Composition Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Summary tab consists of the following sections:

- ["Summary Information Section"](#) on page 3-3
- ["Weight/Volume/Serving Information Section"](#) on page 8-2
- ["Ingredient Statements Section"](#) on page 8-3
- ["Approved for Use in Section"](#) on page 3-6

Figure 8–1 Summary tab


Orange Flavored Sugar Water (5081694-001)
 Nutrient Profile

Draft

Summary | Nutrition Panel | Label Composition | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: Orange Flavored Sugar Water
Short Name: Orange Flavored Sugar Water
Access Level: No Access (Global) (0)
Spec Status: Draft - Draft
Spec #: 5081694-001
Category: * No Category Available (Trade)
Sub Category: * No Category Available
Group: * No Category Available
Supersedes:
Reason for Change:

Originator: [User]
Effective: 11/28/2006
Inactive:
Last Edit: Tuesday, April 10, 2007

Weight/Volume/Serving Information

Density: [] [] = [] []
Label Volume: [] [] [] []
Label Weight : 12 oz [] []
Reference Amount: [] []
Classification: []
Amount Per Serving: 4 oz [] []
Servings Per Pack: 3
Serving Size (label):
Servings/Pack (label):
Special Attributes:

Ingredient Statements

Ingredient Statement: Water, Sugar - Granulated, Maltodextrin, Natural Flavors, Orange Juice - Concentrated, Mango Juice, Carbonation, Flavor, Tricalcium Phosphate, Citric Acid

Approved for Use In

Business Unit(s)	Countries
1 + CPI North America	+

Add New

Weight/Volume/Serving Information Section

Key fields in this section include:

Density—Captures the density, which value is used in volumetric nutrient declarations. You can define nutrients per 100 g or per 100 ml. Density is used in the conversion between these two.

Label Volume—The volume that is intended to show up on the label. There are two entry fields, to accommodate two units of measure, for example, 1 gal (US) 5 fl oz (US).

Label Weight—The weight that is intended to show up on the label. There are two entry fields, to accommodate two units of measure, for example, 3 lb 8 oz (US).

Reference Amount—Also known as Reference Amount Customarily Consumed (RACC), the value in this field is the typical amount that someone consumes in one sitting. Click the search icon (🔍) to search for a RACC set forth by an authority such as the U.S. Food and Drug Administration. This data is used in determining label claims.

Classification—Used to determine label claim eligibility. This is also used to filter label claim determination rule comments so the user can view only the comments that pertain to the selected classification.

Amount Per Serving—Used to determine the Per Serving values on the nutrition panel.

Serving Size (label) Serving/Pack (label)—Used for labeling.

Special Attributes—Choose from a prepopulated list of special attributes maintained by your administrator using the search icon (🔍). You can also use the Type Ahead feature, which displays matches based on the characters you type.

Ingredient Statements Section

The Ingredient Statements section contains the ingredient statement for general use in labeling.

Nutrition Panel Tab

Figure 8–2 Nutrition Panel tab

Orange Flavored Sugar Water (5081694-001) Draft

Nutrient Profile

	Nutrient	Per 100g	Source	Per Serving	Comments
1	Calories	101.41965 kcal		115.00795 kcal	
2	Energy kJ			0.00000 kJ	
3	Protein	3.96000 g		4.49056 g	
4	Protein (Nx6.25)			0.00000 g	
5	Casein (Nx6.38)			0.00000 g	
6	Whey (Nx6.38)			0.00000 g	

Add New Import NSM

Nutrient Profile Section

Nutrient Profile, the sole section in the Nutrition Panel tab, stores the nutritional information for the related specifications. You can declare nutrient data by volume (if density has been defined) or by mass.

This data can appear within formulation specifications, and you can use this data when determining label claims.

Key fields include:

Nutrient—The name of the nutrient.

Per 100g / Per 100mL—The mass or volume-based declaration for the nutrient. Volume (per 100mL) column can be displayed only if the density has been defined in the Summary tab. See "[Managing 100mL Nutrition](#)" for more information.

Source—The source system that nutrient data was retrieved from. When nutrition is imported, the source displays the object it was imported from.

Per Serving—Per Serving nutritional information. GSM calculates this field from the Per 100g/100ml field and the Amount Per Serving data field.

Managing 100mL Nutrition

You can control nutrition using per 100mL if you have a density declared in the design attributes of the Summary tab.

1. After density is set, select the **Per 100g** link. This opens the Per 100mL transition dialog box.
2. Select **Per 100mL** to show the Per 100mL column.
3. Select one of the following:
 - **Keep Entered Values**—The per 100g values displayed currently will be used as the per 100mL values.
 - **Convert Entered Values to UOM**—The per 100g values will be converted using the density declared on the Summary tab.
4. Click **Done**. The Composition grid is updated and displays the Per 100mL column as well as the Per 100g column. When the nutrient composition is set to capture per 100mL, all nutrients captured must be entered as per 100mL.

To calculate the value of the Per Serving field:

1. Click **Edit** to put the specification in edit mode.
2. Click **Calculate**. If you have a serving size specified, GSM will calculate the per serving column.

To add a nutrient manually:

1. Click **Edit** to put the specification in edit mode.
2. Click **Add New** and select the nutrients from the dialog box that appears.

To import nutritional data from a material specification:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Material Specifications** in the Search Source drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values from the material specification's nutrient composition.

4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutritional data from the Food Composition Library:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Food Composition Library** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutritional data from another nutrient profile:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Nutrient Profile** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutrient analysis or nutrient composites from the Nutrition Surveillance Management application (NSM):

1. From the action menu, click **Edit**. The Nutrient Profile page reloads in edit mode.
2. Click **NSM**. The Import Nutrient Items search page appears.
3. Select **Nutrient Analysis** or **Nutrient Composite** in the Search Source drop-down list, enter search criteria, and click **Search**. A Search Results section appears, with a table of search results.
4. Click an analysis or composite in the first column of the search results table. The Compare Nutrition dialog box opens, displaying the nutrient information and the difference between what you selected and the current nutrient profile, as shown in [Figure 8-3](#).

Figure 8–3 Compare Nutrition dialog box

Compare Nutrition					Close
Nutrient	Per 100g	Specification Per 100g	Change Per 100g	% Change	Accept Value(s)
Calories	500.00000 kcal	101.41965 kcal	+ 398.58035 kcal	393.00 %	<input type="checkbox"/>
Energy kJ		0.00000 kJ			
Protein		3.96000 g			
Protein (Nx6.25)		0.00000 g			
Casein (Nx6.38)		0.00000 g			
Whey (Nx6.38)		0.00000 g			
Carbohydrates	20.00000 g	12.00000 g	+ 8.00000 g	66.67 %	<input type="checkbox"/>
Carbohydrate (Available)		0.00000 g			
Dietary Fiber		12.00000 g			
AOAC Fibre		0.00000 g			
Oligosaccharides		0.00000 g			
Total Sugar		12.00000 g			
Sugars: Mono		0.00000 g			
Glucose		0.00000 g			
Sugars: Di		0.00000 g			
Sucrose		0.00000 g			
Maltose		0.00000 g			
Lactose		0.00000 g			
Sugars: Other		0.00000 g			
Organic Acids		0.00000 g			
Total Fat		10.00000 g			
Saturated Fat		10.00000 g			
Monounsaturated Fat		10.00000 g			
Polyunsaturated Fat		10.00000 g			
Omega-3		0.00000 g			
Omega-6		0.00000 g			
Trans Fatty Acid		10.00000 g			
Cholesterol	5.00000 mg	20.00000 mg	-15.00000 mg	-75.00 %	<input type="checkbox"/>

5. Select the items to import and click **Import Nutrient Items**. GSM imports the selected items and displays them in the Nutrient Profile section.
6. To roll up nutrient data for menu items only, click **Rollup**.

Note: This button is present only in nutrient profiles that have been associated with a menu item specification.

A dialog box displays the following, as [Figure 8–4](#) shows:

- Theoretical nutrient data rolled up from the inputs of the menu item's build
- The ingredient statement from the nutrient profile
- Compliance data broken out by specification

Figure 8–4 Nutrient profile Rollup screen

Calculate Print Close

Note: Values displayed on this screen are calculated from lower-level specification data and should be considered theoretical. These values may not match the information that has been formally declared on the Specification or the Nutrient Profile.

Grand child menu item (5079865-001)

Product/Menu Item	Quantity
<input checked="" type="checkbox"/> 4:1 Beef Patty	0.5 lb
<input checked="" type="checkbox"/> Cheese Slice	0.125 lb
<input checked="" type="checkbox"/> Lettuce Slice	0.125 lb
<input checked="" type="checkbox"/> Bun	0.25 lb

Nutrient Rollup

Nutrients	Per 100 g	Total
Calories	18.49231 kcal	85.19032 kcal
Protein	2.36923 g	10.91457 g
Carbohydrates	24.44615 g	112.61848 g
Total Fat	3.69231 g	17.00971 g
Sodium	9.38769 mg	43.24720 mg

ADDITIONAL ITEMS

Product/Menu Item	Quantity
Ketchup - US	0.25 oz

Add New

Ingredient Statement (as declared on Nutrient Profile)

Ingredient Statement: Blended Vegetables, Corn/Carrot/Pea:
 Corn - Whole Kernel - Grade A - IQF, Carrots - Shoestring - IQF, X887

Potato, Sliced, Seasoned:
 Potato Half Slices - Skin-on - IQF, Oil - Soybean (Refined, Bleached, Deodorized), BBQ Sauce Dry Mix, Salt - Granular - Not Iodized

Beef - Seasoned Cooked Strips & Binder Product - Reduced Sodium - IQF

Sauce, BBQ:
 Water, Wheat Oats, 1, Salt, Sugar, Lemon Juice - Single Strength, Unsulphured Molasses - Imported, Modified Food Starch - Perma-Flo, Component 1 - 25%, Component 2 - 25%, Salt - Granular - Not Iodized, Carbonation, Flavor - Liquid Smoke - Mesquite, Xanthan Gum, Mustard Flour, Garlic - Granulated - Standard Grade, Granulated Onion - Standard, comp1, comp2, Paprika - Ground - 134 ASTA, Water Rules

Sweet Water, 2%:
 Water, Sugar (Sucrose) - Granulated - Extra Fine, Carbonation

Total Mass (selected items): 460.679750775 g

Calculate

To change the source specifications of the nutrient rollup data:

1. Select only the desired menu items and products in the tables on the left. You can also add menu items or products by selecting **Add New**.
2. Click the **Calculate** link at the top right of the page or under the Total Mass field to recalculate the rollup data and total mass of the selected items.

Label Claims

Using the label claims determination feature, you can interrogate a product for claims applicability based on a centralized rule base segregated by label claims authority. Potential and Actual label claims are stored on the trade specification.

Label claim determination from the nutrient profile is for evaluation purposes only. You can only view label claims when the specification is in read mode.

To view label claims:

1. Click the **Nutrition Panel** tab.
2. Click **Label Claims**.

Some claims require another product to compare to, such as Low Fat. The system can evaluate comparative claims if you provide additional nutrient information that describes the comparative product. Select the comparative reference product tab and fill in the appropriate information needed. You can also import data from another trade specification by using the search icon (🔍) to select the Reference Product. Data will be imported from the trade specification's active nutrient

profile. You can also import data from another menu item specification. See [Figure 8–5, "Label Claim Determination dialog box"](#), on page 8-8.

3. On the Claims Determination tab, from the **Label Claims Authority** drop-down list, select a specific rule group to use for considering claims applicability.
4. Click **Display Label Claims** to display the Applicable Claims table. The system evaluates label claims against rules that you previously defined. All selected claims based on the label claims authority appear in the Applicable Claims table with color coding to show whether the claim may be made for the product.

When the system evaluates a claim as compliant, the Comments column displays supporting information for the claim along with one or more user-defined values supporting the assessment in the Calculation(s) column, as shown in [Figure 8–6, "Label Claim Determination, Claims Determination tab"](#), on page 8-9. If the system finds that the claim is invalid, no such information appears in the Comments column. When you click the **Comments** column head within the Applicable Claims table, the Comments column of those claims that are not applicable displays additional information about claims that may not be made for the product. The Comments column also includes error information.

Figure 8–5 Label Claim Determination dialog box

Label Claim Determination	
Close	
<div>Claims Determination Comparative/Reference Product</div>	
<div> <input checked="" type="checkbox"/> Comparative/Reference Product </div>	
Reference Product:	5084163-001 - Cheeseburger
Reference Amount:	0.00000 g
Serving Size:	215.00000 g
Classification:	Meal
<div> <input checked="" type="checkbox"/> Nutrient Composition </div>	
Nutrient	Ratio
Calories	<input type="text"/> kcal
Total Fat	15.00000 g
Saturated Fat	<input type="text"/> g
Trans Fatty Acid	<input type="text"/> g
Cholesterol	81.00000 mg
Sodium	<input type="text"/> mg
Dietary Fiber	2.00000 g
Sugars	<input type="text"/> g

Figure 8–6 Label Claim Determination, Claims Determination tab

Label Claim Determination
Close

Claims Determination
Comparative/Reference Product

▼ Applicable Claims

Label Claim Authority:
US FDA Nutrient Claims 2005 ▼
Display Label Claims

<input checked="" type="checkbox"/>	Label Claim/Type of Claim	Yes/No	Comments	Calculations
<input checked="" type="checkbox"/>	Saturated Fat (Low)	Yes	Individual foods: 1 g or less per reference amount and 15% or less of calories from saturated fat. ATTENTION: Next to all saturated fat claims, must declare the amount of cholesterol if 2 mg or more per reference amount; and the amount of total fat if more than 3 g per reference amount (or 0.5 g or more of total fat for "Saturated Fat Free").	.5 g Saturated Fat (per RACC) 8.910891 % Calories from Saturated Fat
	Sodium (Light in Sodium)	No		
<input checked="" type="checkbox"/>	Total Fat (Low)	Yes	Individual foods: 3 g or less per reference amount (and per 50 g if reference amount is small).	.5 g Fat (per RACC)
	Sodium (Reduced/Less)	No		
	Sodium (Salt Free)	No		

Push Label Claims
☐ Append to existing list


Label Composition Tab

If you have created a label composition in the Listed Ingredient Order (LIO) tool and have transferred it to the nutrient profile, then this tab displays the label composition.

Note: Depending on your configuration, you may not see this tab.

Label Composition, the sole section in the Label Composition tab, displays the composition of the specification for labeling purposes. This information can be pushed to the nutrient profile from the LIO process. The data pushed to the Nutrient Profile is read only.

Figure 8–7 Label Composition section



Orange Flavored Sugar Water (5081694-001)

Nutrient Profile

Draft

Summary

Nutrition Panel

Label Composition

Ext Data

Related Specs

Supporting Documents

References

Approval/Audit Trail

▼

Label Composition

	Item	Formulation
1	Water - Carbonated	75.0000%
2	-Water	99.0000%
3	-Carbonation	1.0000%
4	Orange C	8.3333%
5	-Water	69.9744%
6	-Orange Juice - Concentrated	10.5470%
7	-Mango Juice	9.7143%
8	-Sugar - Granulated	6.7151%
9	-Flavor	2.3424%
10	-Carbonation	0.6897%
11	-Citric Acid	0.0171%
12	Orange Flavor 123	8.3333%
13	-Maltodextrin	40.0000%
14	-Corn Syrups Solids	21.0000%
15	-Modified Corn Starch	20.0000%
16	-Natural Flavors	18.5000%
17	-Tricalcium Phosphate	0.5000%
18	Sugar - Granulated	8.3333%

Ext Data Tab

This page includes the following sections:

- ["Extended Attributes Section"](#) on page 3-11
- ["Custom Sections"](#) on page 3-11

Related Specs Tab

This page includes the following sections:

- ["Related Specs Section"](#) on page 8-10
- ["Associated Specifications Section"](#) on page 3-15

Related Specs Section

Related Specs displays the menu item and trade specifications that use the current nutrient profile. The system automatically generates the list of specifications to which this nutrient profile is tied and displays them in this section. Click anywhere in a row to open the specification. A checkmark (✓) may be displayed next to the specifications in the Active column. The checkmark signifies that the nutrient profile is marked as the active on the trade or menu item specification.

Supporting Documents Tab

In Supporting Documents, the only section in this tab, you can attach any background documents that may help to explain the nutrient profile. The document types available are Attachments/Procedures, URL, and Rich Text. For discussion of this commonly used section, please see "[Supporting Documents Section](#)" on page 3-18.

References Tab

The References tab consists of the following sections:

- **Activities**—For discussion of this commonly used section, please see "[Substitute Materials Section](#)" on page 3-30.
- **LIO Profiles**—For discussion of this commonly used section, please see "[LIO Profiles Section](#)" on page 3-31.
- **Related Documents**—For discussion of this commonly used section, please see "[Related Documents Section](#)" on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Product Specifications

This chapter presents an overview of the capabilities of GSM regarding product specifications. Topics in this chapter include:


- [Summary Tab](#)
- [Formulation Tab](#)
- [Nutrition Tab](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Product Specification Summary tab contains the following sections:

- ["Summary Information Section"](#) on page 3-3
- ["Product Attributes Section"](#) on page 9-3
- ["Design Attributes Section"](#) on page 9-3
- ["Cross References Section"](#) on page 3-5
- ["Approved for Use in Section"](#) on page 3-6

Figure 9–1 Summary tab

 **My Burger (5079816-002)**
Product Specification

Draft

Summary | Formulation | Nutrition | Compliance | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: My Burger

Short Name: burger

Access Level: No Access (Global) (0)

Spec Status: Draft - Draft

Spec #: 5079816-002

Category: Beef

Sub Category: Ground

Group: Frozen

Supercedes: 5079816-001 - Product Spec 3

Reason for Change:

Originator: [User]

Effective: 10/5/2006

Inactive: []

Last Edit: Friday, February 11, 2011

Product Attributes

Standard: []

Description: []

Classification: []

Primary Shelf Life: 1 [] Cool []

Secondary Shelf Life: 2 Days [] Dark []

Tertiary Shelf Life: 3 [] []

Storage Instructions: shipping conditions

Shipping Conditions: []

Not Exposed to Sunlight [x] Sanitary Conditions [x] Refrigerated [x] Frozen [x]

Shipping Instructions: Shipping Instructions



Design Attributes

Density: 2 g = 1 dL

Unit Conversion: 3 g




Total Solids: 4.50000 %

Cross References

	System Name	System ID	Equivalent	Externally Managed	
1	 BPCS System	USBPCS		<input type="checkbox"/>	

Add New

Approved for Use In

	Business Unit(s)	Countries	
1	 CPI North America	 Canada,	

Add New

Product Attributes Section

The Product Attributes section contains the specific core attributes of a product specification.

Design Attributes Section

The Design Attributes section contains product information that is used for mass conversions elsewhere in Agile PLM for Process.

Key fields include:

Density—Allows for the entry of mass-to-volumetric conversion factor.

Unit Conversion—Allows the declaration of an actual weight or measurement for a particular unit. For example: 1 slice cheese = 3.2 oz.

Total Solids—Allows for the declaration of the material's "% total solid" composition.

Formulation Tab

The Formulation tab contains the data related to the ingredient statements and formulations of a product specification and consists of two sections:

- ["Ingredient Statements Section"](#) on page 9-3
- ["% Breakdown \(Formula\) Section"](#) on page 3-25

Figure 9–2 Formulation tab

My Burger (5079816-002)
Product Specification

Draft

Summary | **Formulation** | Nutrition | Compliance | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Ingredient Statements

Ingredient Statement:

Combined Statement:

Formula

	Formula	Restrictions	Formulation Classifications	Tags
1	Main Formula			Suppress Printing, Do Not Publish to Supplier
2	Secondary Formula	FDA		Suppress Printing, Do Not Publish to Supplier

[Add New](#)

Ingredient Statements Section

The Ingredient Statements section contains the ingredient statement for the product specification. You can input the ingredient statement in two ways:

GSM can derive it from a formulation that you select. To select a formulation, click the search icon () and select one of the formulas on your product specification. The page refreshes and the ingredient statement will be populated based on the components and their composition listed in the formula you selected.

You can manually enter this information in the Ingredient Statement field.

Nutrition Tab

The Nutrition tab includes the Nutrient Composition section.

Figure 9–3 Nutrition tab

	Nutrient	Per 100mL	Per 100g	Method	Source	Comments
1	Calories	5.00000 kcal	250.00000 kcal	Calculated		
2	Energy kJ	123214.00000 kJ	6160700.00000 kJ			
3	Carbohydrates	4.00000 g	200.00000 g	Calculated		
4	Carbohydrate (Available)	3.00000 g	150.00000 g			
5	Calcium	2.00000 mg	100.00000 mg	AOAC Methods 984.27, 985.01 (Mod.)		
6	d-Biotin	40.00000 mg	2000.00000 mg			
7	Molybdenum	µg	µg			
8	Carotene	0.20000 µg	10.00000 µg		From M & W Database	
9	Nitrogen	g	g			
10	Starch	g	g			

Buttons: Add New, Import, NSM

Nutrient Composition Section

Use this section to create a new a nutrient composition and enter the composition data for the specification. A specification can have only one nutrient composition.

Key fields include:

Nutrient—The name of the nutrient.

Per 100g / Per 100mL—The mass or volume-based declaration for the nutrient. Volume (per 100mL) column can be displayed only if the density has been defined in the Summary tab. See "[Managing 100mL Nutrition](#)" for more information.

Source—The source system that nutrient data was retrieved from. When nutrition is imported, the source displays the object it was imported from. When per 100g values are changed from an imported source, the source selected automatically clears forcing the user to specify an accurate source.

Note: Values imported from the Food Composition Library will not be cleared.

Method—Select the method for determining this value; methods are configured per nutrient item.

Managing 100mL Nutrition

You can control nutrition using per 100mL if you have a density declared in the design attributes of the Summary tab.

1. After density is set, select the **Per 100g** link. This opens the Per 100mL transition dialog box.
2. Select **Per 100mL** to show the Per 100mL column.
3. Select one of the following:
 - **Keep Entered Values**—The per 100g values displayed currently will be used as the per 100mL values.
 - **Convert Entered Values to UOM**—The per 100g values will be converted using the density declared on the Summary tab.
4. Click **Done**. The Composition grid is updated and displays the Per 100mL column as well as the Per 100g column. When the nutrient composition is set to capture per 100mL, all nutrients captured must be entered as per 100mL.

Adding Nutrient Values

Use the buttons below the Nutrient Composition table to add nutrient values:

- Click **Add New** to add a nutrient manually.
- Click **Import** to select and import nutrient values from other nutrient profiles, other material specifications, or from the Food Composition Library (FCL) items.

Note: The Food Composition Library will need to be configured as a part of your implementation.

- Click **NSM** to select and import nutrient values from nutrient analyses or nutrient composites in the Nutrient Surveillance Management (NSM) application.

These options are described in more detail below.

To add a nutrient manually:

1. Click **Edit** to put the specification in edit mode.
2. Click **Add New** and select the nutrients from the dialog box that appears.

To import nutritional data from a material specification:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Material Specifications** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values from the material specification's nutrient composition.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutritional data from the Food Composition Library:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Food Composition Library** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values.

4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutritional data from another nutrient profile:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Nutrient Profile** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutrient analysis or nutrient composites from the Nutrition Surveillance Management application (NSM):

1. Click **Edit**.
2. Click **NSM**. The Import Nutrient Items search page appears.
3. Select **Nutrient Analysis** or **Nutrient Composites** in the Search Source drop-down list, enter search criteria, and click **Search**. A Search Results section appears, with a table of search results.
4. Click a row in the search results table to select an analysis or composite. The Compare Nutrition dialog box opens, displaying the nutrient information and the difference between what you selected and the current composition, as shown in [Figure 9–4](#).

Figure 9–4 Compare Nutrition dialog box

Compare Nutrition					Close
Nutrient	Per 100g	Specification Per 100g	Change Per 100g	% Change	Accept Value(s)
Calories	500.00000 kcal	101.41965 kcal	+ 398.58035 kcal	393.00 %	<input type="checkbox"/>
Energy kJ		0.00000 kJ			
Protein		3.96000 g			
Protein (Nx6.25)		0.00000 g			
Casein (Nx6.38)		0.00000 g			
Whey (Nx6.38)		0.00000 g			
Carbohydrates	20.00000 g	12.00000 g	+ 8.00000 g	66.67 %	<input type="checkbox"/>
Carbohydrate (Available)		0.00000 g			
Dietary Fiber		12.00000 g			
AOAC Fibre		0.00000 g			
Oligosaccharides		0.00000 g			
Total Sugar		12.00000 g			
Sugars: Mono		0.00000 g			
Glucose		0.00000 g			
Sugars: Di		0.00000 g			
Sucrose		0.00000 g			
Maltose		0.00000 g			
Lactose		0.00000 g			
Sugars: Other		0.00000 g			
Organic Acids		0.00000 g			
Total Fat		10.00000 g			
Saturated Fat		10.00000 g			
Monounsaturated Fat		10.00000 g			
Polyunsaturated Fat		10.00000 g			
Omega-3		0.00000 g			
Omega-6		0.00000 g			
Trans Fatty Acid		10.00000 g			
Cholesterol	5.00000 mg	20.00000 mg	-15.00000 mg	-75.00 %	<input type="checkbox"/>

Select the items to import and click **Import Nutrient Items**. GSM imports the selected items and displays them in the Composition grid.

Compliance Tab

The Compliance tab includes the following sections:

- ["Complies With Section"](#) on page 3-7
- ["Additives, Allergens, and Intolerances Sections"](#) on page 3-9

Figure 9–5 Compliance tab

Daisy Land Apples (5079804-004)
Product Specification

Draft

Summary | Formulation | Nutrition | **Compliance** | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Compliance

Complies With:

Allergens

Known to Contain

	Allergens		Max / 100g	Source / Comments
1	Abalone	<=	5.00000 g	

May Contain

	Allergens		Max / 100g	Source / Comments
No records found.				

Does not contain

Intolerances

Known to Contain

	Intolerances		Max / 100g	Source / Comments
No records found.				

Ext Data Tab

The Ext Data tab includes the following sections:

- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Manage Custom Sections**—For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- "Global/Regional Standard Section" on page 9-9
- "Alternate Standards Section" on page 9-10
- "Packing Configurations Specifications Section" on page 9-10
- "Associated Specifications Section" on page 3-15
- "Master Specifications Section" on page 3-15

Figure 9–6 Related Specs tab

My Burger (5079816-002) Product Specification **Draft**

Summary Formulation Nutrition Compliance Ext Data **Related Specs** Supporting Documents References Approval/Audit Trail

Global/Regional Standard

	Spec #	Spec Name	
1	5079828-001	Product Spec [Draft]	✖

Alternate Standards

Spec #	Spec Name
No records found.	

Packing Configuration Specifications

	Spec #	Spec Name	Equivalent	Comments
1	5077480-001	Case Pack - 60 lbs - Meat [Developmental]		✖

[Add New](#)

Associated Specifications

System ID: [USORACLE](#)

Specification	Association	Comments
No records found.		

[Add New](#)

Master Specifications

	Spec #	Spec Name	
1	5077412-001	Allergen Disclosure - None [Developmental]	🔒 ✖
2	5077454-001	Kosher Certifications [Draft]	🔒 ✖

[Add New](#)

Global/Regional Standard Section

The Global/Regional Standard section contains any product specifications that are global/regional standards related to the product specification. You can associate only one global/regional standard to each specification.

Alternate Standards Section

The Alternate Standards section lists any alternate standard specifications for the product specification. GSM locates and displays any alternates that are linked to any other specification that references the current specification as a global/regional standard.

Packing Configurations Specifications Section

The Packing Configurations Specifications section contains the packing configurations specifications associated with the product specification. In this section you can describe the multiple ways in which your specified material can be delivered (for instance, case/packaging variants). Key fields include:

Equivalent—Use this field to associate a cross-reference equivalent per packing configuration.

Supporting Documents Tab

The Product Specifications Supporting Documents tab consists of three sections:

- **Supporting Documents**—The document types available are Attachments/Procedures, URL, and Rich Text. For discussion of this commonly used section, please see "[Supporting Documents Section](#)" on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see "[DRL Documents Section](#)" on page 3-23.
- **Testing Protocols**—For discussion of this commonly used section, please see "[Testing Protocols Section](#)" on page 3-25.

References Tab

The Product Specifications References tab consists of the following sections:

- **Suppliers**—For discussion of this commonly used section, please see "[Suppliers Section](#)" on page 3-29.
- **Activities**—For discussion of this commonly used section, please see "[Substitute Materials Section](#)" on page 3-30.
- **Related Documents**—For discussion of this commonly used section, please see "[Related Documents Section](#)" on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see "[Specification Dependencies Section](#)" on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Material Specifications

This chapter presents an overview of the capabilities of GSM regarding material specifications. Topics in this chapter include:

- [Summary Tab](#)
- [Formulation Tab](#)
- [Nutrition Tab](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [CSS Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Summary tab contains the following sections:

- ["Summary Information Section"](#) on page 3-3
- ["Material Attributes Section"](#) on page 10-2
- ["Design Attributes Section"](#) on page 10-3
- ["Shelf Life Section"](#) on page 10-3
- ["Available UOM Section"](#) on page 3-4
- ["Cross References Section"](#) on page 3-5
- ["Approved for Use in Section"](#) on page 3-6

Figure 10–1 Summary tab

Summary

Formulation

Nutrition

Compliance

Ext Data

Related Specs

CSS

Supporting Documents

References

Approval/Audit Trail

Summary Information

Spec Name: Spice Oil for Pork & Beans

Short Name: SPO23423

Spec Status: Draft - This specification is currently in draft status

Spec #: 5077414-001

Category: Food Additives

Sub Category: Flavors/Bases

Group: Other

Supercedes: 012433

Reason for Change: Initial specification

Originator: Warren, Angela

Effective: 2/27/2001

Inactive:

Last Edit: Monday, July 23, 2012

Material Attributes

Material Type: Raw Material

Description: Definition: Spice Oil for Pork and Beans is a blend of Pimento, Clove, Mace and Cinnamon Oil. Spice Oil is a Natural and Artificial Flavor.
Alternate Supplier Approval Category: 2

Classification: Micro Sensitive

Country Of Origin:

Shipping Requirements:

Shipping Instructions: Deliver in 35 lb. pail.

Design Attributes

Density: 15 g = 25 mL

Total Moisture: 30.00000 %

Formulation Tags:

Material Attributes Section

The Material Attributes section contains specific, core attributes of a material specification. The Classification field may be required, depending on the configuration of your installation.

Note: The graduate icon () is available on material specifications with a output type of "External" for a user with the [SPEC_GRADUATOR] role. Clicking on the icon changes the external output to a "Referenced" material and resolves the workflow to a material specification workflow. The Sourcing Approval section becomes available for an item that has been graduated.

Key fields include:

- **Material Type**—Defined by the system. There are two types of materials:
 - **Raw Material**—General material specification representing a sourced material
 - **Formula Output**—Material specification created by a formulation specification

If you purchase as well as produce a material, the material will be considered both a raw material and a formula output. If a material is created by a

formulation specification and is also sourced (has an attached sourcing approval) then it's material type will be Raw Material, Formula Output.


- **Output Type**—See [""Designable" Workflow Status"](#) on page 5-3 for a list of output types. This field displays when Material Type is designated as "Formula Output."
- **Classification** —Depending on your configuration this could be a required field. This field could potentially drive workflow resolution.

Design Attributes Section

The design attributes in this section can be used by formulation specifications.

Key fields include:

- **Density**—Necessary for calculating density in formulation specifications.
- **Unit Conversion**—Necessary for calculating mass in some areas of the application in which units are used as a UOM. This is also used to convert between mass and volume in formulation specifications.
- **Total Solids**—This field is used to capture the total solids percentage for the material. This value is used by the formulation specification when calculating total solids and breakdown composition.

Use the calculate icon () to calculate the total solids for the material. The system will use the regulatory breakdown and the components' total moisture amount to calculate the material's total solids.

Notes:

1. Depending on your configuration this field may be used to capture total moisture instead of solids, if configured it will be labeled "Total Moisture".
 2. Depending on your configuration this field may be uneditable. The system may be automatically calculating this value on save using the regulatory breakdown values.
- **Edible Portion** (material specification only)—Percentage of the material that is edible.
 - **Formulation Tags**—These tags help further define the function of the material as it relates to formulations. The system will display these tags in the formulation bill of material to help further categorize them. For example, if this material is always a solvent regardless of how it is used in a formulation and the concept of solvent is important to you while you formulate, then the tag should be added here.

Shelf Life Section

Shelf lives can be declared in multiple contexts, usually based on storage conditions. You can store one set of shelf life conditions for frozen material and another for refrigerated material. For each separate context you can store values such as storage requirements and instructions, relative humidity, and supplier and internal shelf life.

Key fields include:

- **Type**—Describes the context for the shelf life. Each specification can have only one shelf life record for each type. The type is displayed under the storage requirement.

- **Tags**—These tags describe how the shelf life will be used elsewhere in the system. The following tags are available:
 - **Suppress Printing**—Prevents the shelf life record from being printed.
 - **Do Not Publish to Supplier**—Prevents the shelf life record from being included in eQ and Supplier Portal.

Formulation Tab

The Formulation tab contains the data related to the ingredient statements and formulations of a material specification. This tab has two sections:

- ["Ingredient Statements Section"](#) on page 10-4
- ["% Breakdown \(Formula\) Section"](#) on page 3-25

Figure 10–2 Formulation tab

Ingredient Statements				
Ingredient Statement: <input type="text" value="Vegetable Oil, Pimento, Clove, Mace, Cinnamon Oil, test"/>				
Combined Statement: <input type="text"/>				
% Breakdown				
	% Breakdown	Restrictions	Formulation Classifications	Tags
1	Sample Formula			Suppress Printing, Do Not Publish to Supplier
2	Master formula			Do Not Publish to Supplier
3	Master formula			Suppress Printing, Do Not Publish to Supplier
Add New				

Ingredient Statements Section

The Ingredient Statements section contains the ingredient statement for the material specification. You can input the ingredient statement in the following ways:

- GSM can derive it from a formulation that you select. To select a formulation for the Ingredient Statement field, click the search icon () and select your choice.
- You can manually enter this information in the Ingredient Statement field.
- You can also push the ingredient statement from LIO as described in [Chapter 18, "LIO Profiles"](#).

Nutrition Tab

The Nutrition tab includes the Nutrient Composition section.

Figure 10–3 Nutrition tab

Nutrient Composition					
	Nutrient	Per 100g	Method	Source	Comments
1	Calories	335.00000 kcal		From Manufacturer	
2	Energy kJ	10.00000 kJ		From Manufacturer	

Buttons: Add New, Import, NSM

Nutrient Composition Section

Use this section to create a new a nutrient composition and enter the composition data for the specification. A specification can have only one nutrient composition.

Key fields include:

Nutrient—The name of the nutrient.

Per 100g / Per 100mL—The mass or volume-based declaration for the nutrient. Volume (per 100mL) column can be displayed only if the density has been defined in the Summary tab. See "[Managing 100mL Nutrition](#)" for more information.

Method—Select the method for determining this value; methods are configured per nutrient item.

Source—The source system that nutrient data was retrieved from. When nutrition is imported, the source displays the object it was imported from. When per 100g values are changed from an imported source, the source selected automatically clears forcing the user to specify an accurate source.

Note: Values imported from the Food Composition Library will not be cleared.

Managing 100mL Nutrition

You can control nutrition using per 100mL if you have a density declared in the design attributes of the Summary tab.

1. After density is set, select the **Per 100g** link. This opens the Per 100mL transition dialog box.
2. Select **Per 100mL** to show the Per 100mL column.
3. Select one of the following:
 - **Keep Entered Values**—The per 100g values displayed currently will be used as the per 100mL values.
 - **Convert Entered Values to UOM**—The per 100g values will be converted using the density declared on the Summary tab.

4. Click **Done**. The Composition grid is updated and displays the Per 100mL column as well as the Per 100g column. When the nutrient composition is set to capture per 100mL, all nutrients captured must be entered as per 100mL.

Adding Nutrient Values

Use the buttons below the Nutrient Composition table to add nutrient values:

- Click **Add New** to add a nutrient manually.
- Click **Import** to select and import nutrient values from other nutrient profiles, other material specifications, or from the Food Composition Library (FCL) items.

Note: The Food Composition Library will need to be configured as a part of your implementation.

- Click **NSM** to select and import nutrient values from nutrient analyses or nutrient composites in the Nutrient Surveillance Management (NSM) application.

These options are described in more detail below.

To add a nutrient manually:

1. Click **Edit** to put the specification in edit mode.
2. Click **Add New** and select the nutrients from the dialog box that appears.

To import nutritional data from a material specification:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Material Specifications** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values from the material specification's nutrient composition.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutritional data from the Food Composition Library:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Food Composition Library** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutritional data from another nutrient profile:

1. Click **Edit** to put the specification in edit mode.
2. Click **Import** and select **Nutrient Profile** in the drop-down list.
3. Search and select the item to import. A dialog box displays a list of nutrients and their values.
4. Select the nutrients to import and click **Done**. The nutrient profile displays the selected nutrients, along with their values.

To import nutrient analysis or nutrient composites from the Nutrition Surveillance Management application (NSM):

1. Click **Edit**.
2. Click **NSM**. The Import Nutrient Items search page appears.
3. Select **Nutrient Analysis** or **Nutrient Composites** in the Search Source drop-down list, enter search criteria, and click **Search**. A Search Results section appears, with a table of search results.
4. Click a row in the search results table to select an analysis or composite. The Compare Nutrition dialog box opens, displaying the nutrient information and the difference between what you selected and the current composition, as shown in [Figure 10-4](#).

Figure 10-4 Compare Nutrition dialog box

Compare Nutrition Close					
Nutrient	Per 100g	Specification Per 100g	Change Per 100g	% Change	Accept Value(s)
Calories	500.00000 kcal	101.41965 kcal	+ 398.58035 kcal	393.00 %	<input type="checkbox"/>
Energy kJ		0.00000 kJ			
Protein		3.96000 g			
Protein (Nx6.25)		0.00000 g			
Casein (Nx6.38)		0.00000 g			
Whey (Nx6.38)		0.00000 g			
Carbohydrates	20.00000 g	12.00000 g	+ 8.00000 g	66.67 %	<input type="checkbox"/>
Carbohydrate (Available)		0.00000 g			
Dietary Fiber		12.00000 g			
AOAC Fibre		0.00000 g			
Oligosaccharides		0.00000 g			
Total Sugar		12.00000 g			
Sugars: Mono		0.00000 g			
Glucose		0.00000 g			
Sugars: Di		0.00000 g			
Sucrose		0.00000 g			
Maltose		0.00000 g			
Lactose		0.00000 g			
Sugars: Other		0.00000 g			
Organic Acids		0.00000 g			
Total Fat		10.00000 g			
Saturated Fat		10.00000 g			
Monounsaturated Fat		10.00000 g			
Polyunsaturated Fat		10.00000 g			
Omega-3		0.00000 g			
Omega-6		0.00000 g			
Trans Fatty Acid		10.00000 g			
Cholesterol	5.00000 mg	20.00000 mg	-15.00000 mg	-75.00 %	<input type="checkbox"/>

Select All
Deselect All
Import Nutrient Items

5. Select the items to import and click **Import Nutrient Items**. GSM imports the selected items and displays them in the Composition grid.

Compliance Tab

The Compliance tab includes the following sections:

- **Compliance Information**—For discussion of this commonly used section, please see ["Complies With Section"](#) on page 3-7.
- **Additives, Allergens, and Intolerances**—For discussion of this commonly used section, please see ["Additives, Allergens, and Intolerances Sections"](#) on page 3-9.

Ext Data Tab

The Ext Data tab includes the following sections:

- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Manage Custom Sections**—For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- **Produced By**—Discussed below, at ["Produced By Section"](#) on page 10-9
- **Trade Specifications**—Discussed below, at ["Trade Specifications Section"](#) on page 10-9
- **Packing Configurations Specifications**—Discussed below, at ["Packing Configurations Specifications Section"](#) on page 10-9
- **Associated Specifications** —For discussion of this field, please see ["Associated Specifications Section"](#) on page 3-15
- **Master Specifications**—For discussion of this field, please see ["Master Specifications Section"](#) on page 3-15

Figure 10–5 Related Specs tab

Ing BBQ Beef 0630 (5094870-001) Approved

Material Specification

Summary | Formulation | Nutrition | Compliance | Ext Data | **Related Specs** | CSS | Supporting Documents | References | Approval/Audit Trail

Produced By

	Spec #	Formulation Spec Name
1	5094876-001	BBQ Beef [Approved]
2	5094876-002	Shredded Beef [Draft]
3	5094876-003	Spicy Sauce [Draft]
4	5094876-004	Smoke Flavoring [Draft]

Trade Specifications

	Spec Name	Context
1	Ing BBQ Beef 0630 (5107050-001) [Global Read]	

Packing Configuration Specifications

Associated Specifications

Master Specifications

Produced By Section

The Produced By section shows formulation specifications that produced this material specification. This section is displayed only when producing specifications exist and is view-only.

Trade Specifications Section

This section shows all trade specifications that this material has been linked to. It displays the trade specification and the formulation that was used as context on the trade specification.

You can click **Add New** to create a new trade specification with this material already linked. The trade will automatically inherit the name and business unit from the material specification.

Note: Make sure to save your material specification before clicking **Add New**. When the trade specification is created, GSM takes you directly to the trade specification. Any unsaved changes to your material specification will be lost.

Packing Configurations Specifications Section

The Packing Configurations Specifications section contains the Packing Configurations Specifications associated with the material specification. In this section you can describe the multiple ways in which this material can be delivered (for instance, case/packaging variants).

Key fields include:

Equivalent—In this field you can associate a cross-reference equivalent per packing configuration.

CSS Tab

For discussion of this commonly used tab, please see ["CSS Tab"](#) on page 3-15.

Supporting Documents Tab

The Material Specification Supporting Documents tab contains the list of all supporting documents associated with a material specification. The Supporting Documents tab consists of three sections:

- **Supporting Documents**—The document types available are attachments/procedures, URL, and rich text. For discussion of this commonly used section, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.
- **Testing Protocols**—For discussion of this commonly used section, please see ["Testing Protocols Section"](#) on page 3-25.

References Tab

The Material Specification References tab contains the list of all the reference data linked to a material specification. The References tab includes the following sections:

- **Suppliers**—For discussion of this commonly used section, please see ["Suppliers Section"](#) on page 3-29. This section only appears for materials typed as "Raw Material."
- **Substitute Materials**—For discussion of this commonly used section, please see ["Substitute Materials Section"](#) on page 3-30.
- **Activities**—For discussion of this commonly used section, please see ["Activities Section"](#) on page 3-31.
- **LIO Profiles**—For discussion of this commonly used section, please see ["LIO Profiles Section"](#) on page 3-31.
- **Related Documents**—For discussion of this commonly used section, please see ["Related Documents Section"](#) on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see ["Specification Dependencies Section"](#) on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

Packaging Material Specifications

This chapter presents an overview of the capabilities of GSM regarding packaging material specifications. Topics in this chapter include:

- [Summary Tab](#)
- [Printed Packaging Material Section](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [CSS Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Packaging Material Specification Summary tab contains the following sections:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Packaging Attributes**—Discussed below, at ["Packaging Attributes Section"](#) on page 11-2
- **Tare Weight**—Discussed below, at ["Tare Weight Section"](#) on page 11-2
- **Available UOM**—For discussion of this commonly used section, please see ["Available UOM Section"](#) on page 3-4
- **Cross References**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5
- **Approved for Use In**—For discussion of this commonly used section, please see ["Available UOM Section"](#) on page 3-4

Figure 11–1 Summary tab

Corrugated Case (5083174-001) Draft
Packaging Material

Summary | Compliance | Ext Data | Related Specs | CSS | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: Corrugated Case
Short Name: CC343245
Spec Status: Draft - Draft
Spec #: 5083174-001
Category: Paper Based
Sub Category: Corrugated
Group: Cartons/Cases
Originator: [User]
Effective: 3/29/2007
Inactive: []
Last Edit: Saturday, November 10, 2012
Supercedes: []
Reason for Change: []

Packaging Attributes

Packaging Item Type: Packaging Material
Packaging Description: Corrugated Case using Adhesive 234125
Storage Requirements: Dry
Relative Humidity: []
Storage Instructions: []
Formulation Tags: []

Tare Weight

Reference Weight: []
Tare Weight: [] per []

Available UOM

UOM Category: None
Base UOM: []

UOM Conversions

UOM	Status

Packaging Attributes Section

A packaging material specification has a number of core attributes, such as description, storage requirements, and relative humidity. List those attributes in this section.

Packaging Item Type describes the type of packaging material. This type is displayed when the packaging specification is associated to other specifications. For example, this field can be used to distinguish between printed packaging materials and base packaging materials.

Tare Weight Section

The Tare Weight section for a packaging material or printed packaging specification is shown in the figure below. Use this section to define the mass to unit/count conversion.

In addition, UOM Conversions can define tare weight. Please note that the Tare Weight fields must be populated in addition to the UOM Conversion fields for this to calculate properly.

From within a trade specification Packaging Attributes section, click the hyperlinked Tare Weight field label to have GSM calculate the appropriate tare weight. If you have supplied the net weight, GSM can also calculate the gross weight of the product (net weight + tare weight).

Printed Packaging Material Section

Note: Depending on your configuration you may see the printed packaging material tab. This is a legacy feature.

The Printed Packaging Material section, the only section in the Printed Packaging Material tab, contains the list of printed packaging specifications linked to a packaging material specification. This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Compliance Tab

The Compliance tab contains the compliance data related to a packaging material specification. It includes the following section:

- **Environmental Waste**—Discussed below, at "[Environmental Waste Section](#)" on page 11-4.

Figure 11-2 Compliance tab

Environmental Waste (per unit sold)				
	Material Class	Weight	Percent Recyclable	% Composed of Recycled Materials
1	GREEN GLASS	12.00000 g	10.00000%	5.00000%

Environmental Waste Section

This section provides a place to log known waste materials for this specification material, along with other relevant attributes required for environmental waste reporting.

Ext Data Tab

The Ext Data tab includes the following sections:


- **Extended Attributes**—For discussion of this commonly used section, please see "[Extended Attributes Section](#)" on page 3-11
- **Manage Custom Sections**—For discussion of this commonly used section, please see "[Custom Sections](#)" on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- **Sub Components**—Discussed below, at "[Sub Components Section](#)" on page 11-5
- **Packing Configurations Specifications**—Discussed below, at "[Packing Configuration Specifications Section](#)" on page 11-5
- **Equipment Specifications**—Discussed below, at "[Equipment Specifications Section](#)" on page 11-5
- **Associated Specifications**—For discussion of this field, please see "[Associated Specifications Section](#)" on page 3-15
- **Master Specifications**—For discussion of this field, please see "[Master Specifications Section](#)" on page 3-15





Figure 11–3 Related Specs tab


Corrugated Case1 (5082590-001)
 Packaging Material

CSS Syndication


Summary | Compliance | Ext Data | **Related Specs** | CSS | Supporting Documents | References | Approval/Audit Trail

Sub Components

	Level	Packaging Material Specification	Type	Quantity
1	Intermediate	 IQF TRAY FILM 123311 (5077545-001) [CSS Syndication] 	Packaging Material	0.00000
2	Intermediate	 Sport Bottle 090908 (5077544-001) [Draft (Review)] 	Packaging Material	0.00000


Add New
 Order Packaging Materials

Packing Configuration Specifications

	Spec #	Spec Name	Equivalent	Comments
1	 5077480-001	Case Pack - 60 lbs - Meat [Developmental]		

Add New

Equipment Specifications

	Spec #	Spec Name
1	 5080193-001	Sample Equipment Spec [Requested for Certification]

Add New

Master Specifications

Sub Components Section

The Sub Components section contains any packaging material specifications that are subcomponents of this specification. You can categorize each subcomponent based on packaging level, for example, "inner," "outer," "label," and "intermediate." Additionally, you can declare the quantity of each subcomponent.

This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Packing Configuration Specifications Section

The Packing Configuration Specifications section contains the packing configuration specifications associated with the packaging material specification. In this section you can describe the multiple ways in which your material can be delivered (for instance, case/packaging variants).

Key fields include:

Equivalent—In this field you can associate a cross-reference equivalent per packing configuration.

Equipment Specifications Section

The Equipment Specifications section contains the list of equipment specifications linked to a packaging material specification.

CSS Tab

For discussion of this commonly used tab, please see ["CSS Tab"](#) on page 3-15.

Supporting Documents Tab

The Packaging Material Specification Supporting Documents tab contains the list of all supporting documents associated with a packaging material specification. The Supporting Documents tab consists of three sections:

- **Supporting Documents**—The document types available are Attachments/Procedures, URL, and Rich Text. For discussion of this commonly used section, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.
- **Testing Protocols**—For discussion of this commonly used section, please see ["Testing Protocols Section"](#) on page 3-25.

References Tab

The Packaging Material Specification References tab contains the list of all the reference data linked to a packaging material specification. It includes the following sections:

- **Suppliers**—For discussion of this commonly used section, please see ["Suppliers Section"](#) on page 3-29.
- **Substitute Materials**—For discussion of this commonly used section, please see ["Substitute Materials Section"](#) on page 3-30.
- **Activities**—For discussion of this commonly used section, please see ["Activities Section"](#) on page 3-31.
- **Related Documents**—The available related documents include only NPD activities. For discussion of this commonly used section, please see ["Related Documents Section"](#) on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see ["Specification Dependencies Section"](#) on page 3-31. Note that packaging sub components as the children of a packaging specification appear in Where Used.

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

Equipment Specifications

This chapter presents an overview of the capabilities of GSM regarding equipment specifications. Topics in this chapter include:

- [Summary Tab](#)
- [Compliance Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

Equipment specifications are used to describe vending equipment only. Key sections in the Summary tab include:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Equipment Identification**—Described below, at ["Equipment Identification Section"](#) on page 12-2
- **Available UOM**—For discussion of this commonly used section, please see ["Available UOM Section"](#) on page 3-4
- **Cross References**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5
- **Approved for Use In**—For discussion on this commonly used section, please see ["Cross References Section"](#) on page 3-5

Figure 12–1 Summary tab

ROYAL VENDORS - RVCC 780-9 (5079996-001)
Equipment Specification

Requested for Certification

Summary | Compliance | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Summary Information

Spec Name: ROYAL VENDORS - RVCC 780-9

Short Name: rvcc

Spec Status: Requested for Certification - Requested for Certification

Spec #: 5079996-001

Category: Vending Machines

Sub Category: Cold

Group: Single Package

Supersedes:

Reason for Change: Conversion to new Spec System

Originator: [Redacted]

Effective: 10/18/2005

Inactive:

Last Edit: Friday, March 11, 2011

Equipment Identification

Model: RVCC 780-9

Description: ROYAL VENDORS - RVCC 780-9, single package coin and bill transaction vender for 355mL cans.

> Available UOM

> Cross References

> Approved for Use In

Equipment Identification Section

This section provides model information about the equipment.

Compliance Tab

The Equipment Specification Compliance tab consists of the following section:

- **Environmental Waste (per unit sold)**—Discussed below, at "[Environmental Waste \(per unit sold\) Section](#)" on page 12-3

Figure 12–2 Compliance tab

ROYAL VENDORS - RVCC 780-9 (5079996-001)
Equipment Specification

Requested for Certification

Summary | Compliance | Ext Data | Related Specs | Supporting Documents | References | Approval/Audit Trail

Environmental Waste (per unit sold)

	Material Class	Weight	Percent Recyclable	% Composed of Recycled Materials
1	GREEN GLASS	13 kg	98.00%	12.00%

Add New

Environmental Waste (per unit sold) Section

This section provides a place to log known waste materials for this specification material along with other relevant attributes required for environmental waste reporting.

Ext Data Tab

The Ext Data tab includes the following sections:


- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Manage Custom Sections**—For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- **Packaging Specifications**—Discussed below, at ["Packaging Specifications Section"](#) on page 12-4
- **Sub Components**—Discussed below, at ["Sub Components Section"](#) on page 12-4
- **Associated Specifications**—For discussion of this field, please see ["Associated Specifications Section"](#) on page 3-15
- **Master Specifications**—For discussion of this field, please see ["Master Specifications Section"](#) on page 3-15





Figure 12–3 *Related Specs tab*


ROYAL VENDORS - RVCC 780-9 (5079996-001)
 Equipment Specification

Requested for Cer



Summary | Compliance | Ext Data | **Related Specs** | Supporting Documents | References | Approval/Audit Trail

▼ Packaging Specifications

	Spec #	Spec Name	
1	 5080186-001	BOTTLE600ML [Approved]	
2	 5080089-001	PET Bottle - Monolayer - 300 mL - Clear [Draft (Review)]	

Add New

▼ Sub Components

	Spec Name	Model	Quantity	
1	 cooler Assy PartNo:1 (5080194-001)		1	

Add New

> Associated Specifications

> Master Specifications

Packaging Specifications Section

In this section you can associate this specification with one or more packaging material specifications.

Sub Components Section

In this section you can look up and add other equipment specifications as sub components.

Supporting Documents Tab

The Equipment Specification Supporting Documents tab contains the list of all supporting documents associated with an equipment specification. This tab consists of three sections:

- **Supporting Documents**—The document types available are Attachments/Procedures, URL, and Rich Text. For discussion of this commonly used section, please see "[Supporting Documents Section](#)" on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see "[DRL Documents Section](#)" on page 3-23.
- **Testing Protocols**—For discussion of this commonly used section, please see "[Testing Protocols Section](#)" on page 3-25.

References Tab

The Equipment Specification References tab contains the list of all the reference data linked to an equipment specification and includes the following sections:

- **Suppliers**—For discussion of this commonly used section, please see "[Suppliers Section](#)" on page 3-29.
- **Activities**—For discussion of this commonly used section, please see "[Activities Section](#)" on page 3-31.
- **Related Documents**—The available related documents include only NPD Activities. For discussions of this commonly used section, please see "[Related Documents Section](#)" on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see "[Specification Dependencies Section](#)" on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Printed Packaging Specifications

Important Note: Printed Packaging Specifications are a legacy specification type and are disabled by default. These specifications should not be used. The packaging material specification should be used to represent printed packaging. The packaging type should be used to classify printed packaging materials.

This chapter presents an overview of the capabilities of GSM regarding printed packaging specifications. Topics in this chapter include:

- [Summary Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [CSS Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Printed Packaging specification Summary tab contains the following sections:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Label Information**—Discussed below, at ["Label Information Section"](#) on page 13-2
- **Tare Weight**—Discussed below, at ["Tare Weight Section"](#) on page 13-2
- **Available UOM**—For discussion of this commonly used section, please see ["Available UOM Section"](#) on page 3-4
- **Cross References**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5
- **Approved for Use In**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5

Figure 13–1 Summary tab

CSS Syndication

Summary
Ext Data
Related Specs
CSS
Supporting Documents
References
Approval/Audit Trail

Summary Information

Spec Name:

Corrugate Case - Beef w/ BBQ Sauce

Short Name:

Corrugate Case - Beef w/ BBQ Sauce

Spec Status:

CSS Syndication - In this Workflow Step the tip will transition into the Initial Non-Ghost state.

Spec #:

5077542-001

Category:

Paper Based

Sub Category:

Corrugated

Group:

Cartons/Cases

Supersedes:

Reason for Change:

Originator:

Effective:

10/3/2004

Inactive:

Last Edit:

Thursday, July 16, 2009

Label Information

Brand:

Ades

Variety Title:

Beef and Vegetable Dinner

Description:

Language(s):

English

Tare Weight

Reference Weight:

Tare Weight:

1.00000

kg

per

1.00000

units

Available UOM

Cross References

Approved for Use In

Label Information Section

This section contains identifying information for the printed packaging label.

Note: The languages in the Language(s) field are different from the application languages that you can specify in the user profile. These languages refer to the languages that are represented on the physical label.

Tare Weight Section

Use the Tare Weight section to define the mass to unit/count conversion for a packaging material or printed packaging specification.

In addition, UOM Conversions can define tare weight. Please note that the Tare Weight fields must be populated in addition to the UOM Conversion fields for this to calculate properly.

From within a trade specification Packaging Attributes section, click the hyperlinked Tare Weight field label to have GSM calculate the appropriate tare weight. If you have supplied the net weight, GSM can also calculate the gross weight of the product (net weight + tare weight).

Ext Data Tab

The Ext Data tab includes the following sections:

- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Custom Sections**—For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11

Related Specs Tab

The Related Specs tab contains the following sections:

- **Parent Packaging Material**—Discussed below, at ["Parent Packaging Material Section"](#) on page 13-3.
- **Master Specification**—For discussion of this field, please see ["Master Specifications Section"](#) on page 3-15.

Figure 13–2 Related Specs tab

Corrugate Case - Beef w/ BBQ Sauce (5077542-001)
Printed Packaging Specification

CSS Syndication

Summary | Markings | Ext Data | **Related Specs** | CSS | Supporting Documents | References | Approval/Audit Trail

Parent Packaging Material

	Spec #	Spec Name	
1	+ 5077482-001	Corrugated Case1 [CSS Syndication]	

Master Specifications

	Spec #	Spec Name	
1	5083956-001	master [Approved]	

[Add New](#)

Parent Packaging Material Section

In this section you can connect the printed packaging specification to a parent packaging material specification.

The printed packaging specification can have only one parent packaging material specification.

CSS Tab

For discussion of this commonly used tab, please see ["CSS Tab"](#) on page 3-15.

Supporting Documents Tab

The Supporting Documents tab consists of the following sections:

- **Supporting Documents**—Document types available for use in the Printed Packaging Specifications Supporting Documents tab are Attachments/Procedures, URL and Rich Text. For more information, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.
- **Testing Protocols**—For discussion of this commonly used section, please see ["Testing Protocols Section"](#) on page 3-25.

References Tab

The Printed Packaging Specification References tab includes the following sections:

- **Suppliers**—For discussion of this commonly used section, please see ["Suppliers Section"](#) on page 3-29
- **Substitute Materials**—For discussion of this commonly used section, please see ["Substitute Materials Section"](#) on page 3-30
- **Activities**—For discussion of this commonly used section, please see ["Activities Section"](#) on page 3-31
- **Related Documents**—For discussion of this commonly used section, please see ["Related Documents Section"](#) on page 3-31
- **Specification Dependencies**—For discussion of this commonly used section, please see ["Specification Dependencies Section"](#) on page 3-31

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

Delivered Material Packing Specifications

This chapter presents an overview of the capabilities of GSM regarding delivered material packing specifications. Topics in this chapter include:


- [Summary Tab](#)
- [Compliance Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

Key sections in the tab include:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Packing Description**—Described below, at ["Packing Description Section"](#) on page 14-2
- **Approved for Use In**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5










Figure 14–1 Summary tab


Wax Lined Boxes (5077514-001)
 Delivered Material Packing Specification


Draft

Summary | Compliance | Related Specs | Supporting Documents | References | Approval/Audit Trail




Summary Information

Spec Name: Wax Lined Boxes 
Short Name: Wax Lined Boxes 
Access Level: No Access (Global) (0) 
Spec Status: Draft - This specification is currently in draft status
Spec #: 5077514-001 **Originator:** 
Category: Multi Material  **Effective:** 3/4/2010 
Sub Category: Primary **Inactive:** 
Group: * No Category Available **Last Edit:** Thursday, May 21, 2009
Supersedes: 
Reason for Change: 

Packing Description

Description: Clean, new, staple free boxes; wax lined and no poly liners when possible. 

Approved for Use In

	Business Unit(s)	Countries	
1	 CPI USA Retail Seattle	 USA	

Add New

Packing Description Section

Use this section to describe the packing material.

Compliance Tab

This tab contains the following sections:

- **Environmental Waste**—Described below, in ["Environmental Waste Section"](#) on page 14-3

Figure 14–2 Compliance tab

Wax Lined Boxes (5077514-001)
Delivered Material Packing Specification

Draft

Summary Compliance **Related Specs** Supporting Documents References Approval/Audit Trail

☒ Environmental Waste

	Material Class	Weight	Percent Recyclable	% Composed of Recycled Materials	
1	PAPER/BOARD	0.5 lb	50.00%	25.00%	

Environmental Waste Section

This section provides a place to log known waste materials for this specification material, along with other relevant attributes required for environmental waste reporting.

Related Specs Tab

This tab contains the following sections:

- **Labeling Specifications**—Described below, in "[Labeling Specifications Section](#)" on page 14-4
- **Associated Specifications**—For discussion on this commonly used section, please see "[Associated Specifications Section](#)" on page 3-15

Figure 14–3 Related Specs tab

Wax Lined Boxes (5077514-001)
Delivered Material Packing Specification

Draft

Summary Compliance **Related Specs** Supporting Documents References Approval/Audit Trail

☒ Labeling Specifications

	Spec #	Spec Name	
1	5077513-001	Pallet Label Type A [Draft]	

☒ Associated Specifications

System ID:

	Specification	Association	Comments	
1	Salt for Brining (mat 5077503-001) [Approved]	By-Product		

Labeling Specifications Section

In Labeling Specifications you can associate this specification with one or more labeling specifications that describe the labeling requirements for delivered items.

Supporting Documents Tab

The Supporting Documents tab contains two sections:

- **Supporting Documents**—The document types available for use are Attachments/Procedures, URL, and Rich Text. For more information, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.

References Tab

The References tab includes the following sections:

- **Activities**—For discussion of this commonly used section, please see ["Substitute Materials Section"](#) on page 3-30
- **Specification Dependencies**—For discussion of this commonly used section, please see ["Specification Dependencies Section"](#) on page 3-31

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

Packing Configuration Specifications

This chapter presents an overview of the capabilities of GSM regarding packing configuration specifications. Topics in this chapter include:


- [Summary Tab](#)
- [Packing Tab](#)
- [Ext Data Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

This tab contains the following sections:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Packing Description**—Discussed below, at ["Packing Description Section"](#) on page 15-2
- **Cross References**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5
- **Approved for Use In**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5

Figure 15–1 Summary tab

**Case Pack - 60 lbs - Meat (5077480-001)**
Packing Configuration Specification

Developmental

SummaryPackingExt DataRelated SpecsSupporting DocumentsReferencesApproval/Audit Trail

Summary Information

Spec Name:

Case Pack - 60 lbs - Meat

Short Name:

case pack

Access Level:

No Access (Global) (0)

Spec Status:

Developmental - This specification is currently in developmental status

Spec #:

5077480-001

Category:

* No Category Available (pcfg)

Sub Category:

* No Category Available

Group:

* No Category Available

Supersedes:

Reason for Change:

Originator:

Effective:

9/8/2008

Inactive:

Last Edit:

Friday, August 03, 2007

Packing Description

Description:

60 lbs, or as designated by CFFC Purchasing. Weight tolerance of 1/2 of 1% net weight will be allowed.

Cross References

Approved for Use In

Packing Description Section

Use this section to describe the packing material.

Packing Tab

This tab contains the following sections:

- **Packing Attribute (inner pack)**—Discussed below, at "[Packing Attribute \(Inner Pack\) Section](#)" on page 15-3
- **Packing Attribute (master case)**—Discussed below, at "[Packing Attribute \(Master Case\) Section](#)" on page 15-3

Figure 15–2 *Packing tab*

Case Pack - 60 lbs - Meat (5077480-001) Developmental
Packing Configuration Specification

Summary **Packing** Ext Data Related Specs Supporting Documents References Approval/Audit Trail

Packing Attribute(inner pack)

Label Weight: 2 oz

Label Volume: 1.22 Cu. cm

Container Net Weight: 3 lb 12 oz

Gross Weight: 15 lb

Inner Pack:

Product Dimensions: Length 20 in Width 14 in Height 2 in

Packing Attribute(master case)

Packaging Type: Carton

Units Per Case: 24

Cases/Layer: 6 Standard Pallet

Number of Layers: 3

Cases/Pallet:

Case Size: Length 350 cm Width 450 cm Height 15 cm Gross Weight 5 kg

Pallet Size: Length 1 m Width 0.980 m Height 2 m Gross Weight 220 kg

Coding:

Packing Attribute (Inner Pack) Section

In this section you can capture attributes that describe the inner packing of the delivered material. For example, if you have a case that contains six smaller bags of material, this section would describe the bags.

Packing Attribute (Master Case) Section

In this section you can capture attributes that describe the master case attributes of the delivered material. For example, if you have a case that contains six smaller bags of material, this section would describe the case.

Key fields include:

Packaging Type—Describe the packaging type by selecting from a list of options.

Ext Data Tab

The Ext Data tab includes the following sections:

- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11
- **Manage Custom Sections**— For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11


Related Specs Tab

The Related Specs tab contains the following sections:

- **Inner-Delivered Material Packing Specifications**—Discussed below, at ["Inner-Delivered Packing Specifications Section"](#) on page 15-5
- **Intermediate-Delivered Material Packing Specifications**—Discussed below, at ["Intermediate-Delivered Material Packing Specifications Section"](#) on page 15-5
- **Outer-Delivered Material Packing Specification**—Discussed below, at ["Outer-Delivered Material Packing Specification Section"](#) on page 15-5
- **Associated Specifications**—For discussion of this section, please see ["Associated Specifications Section"](#) on page 3-15

In the sections in this tab you can further describe the packing configuration by distinguishing among inner, intermediate, and outer packing materials where relevant.



Figure 15–3 Related Specs tab


Case Pack - 60 lbs - Meat (5077480-001)
 Packing Configuration Specification

Developmental



Summary | Packing | Ext Data | **Related Specs** | Supporting Documents | References | Approval/Audit Trail

☒ Inner-Delivered Material Packing Specifications

	Spec #	Spec Name	Labeling Spec(s)	
1	 5077514-001	Wax Lined Boxes [Draft]	5077513-001	



Add New

☒ Intermediate-Delivered Material Packing Specification

	Spec #	Spec Name	Labeling Spec(s)	
1	 5077481-001	Corrugated Case Pack with Poly Liner [Developmental]	5082311-001 5083255-001 5085011-001 5083722-001 5084428-001	

Add New

☒ Outer-Delivered Material Packing Specifications

	Spec #	Spec Name	Labeling Spec(s)	
1	 5077514-001	Wax Lined Boxes [Draft]	5077513-001	

Add New

☒ Associated Specifications

Inner-Delivered Packing Specifications Section

In this section you can associate this packing configuration specification with one or more delivered material packing specifications to describe the inner packing.

The associated labeling specification numbers display automatically based on their relationship with the delivered material packing specifications.

Intermediate-Delivered Material Packing Specifications Section

In this section you can associate this packing configuration specification with one or more delivered material packing specifications to describe the intermediate packing.

The associated labeling specification numbers display automatically based on their relationship with the delivered material packing specifications.

Outer-Delivered Material Packing Specification Section

In this section you can associate this packing configuration specification with one or more delivered material packing specifications to describe the outer packing.

The associated labeling specification numbers display automatically based on their relationship with the delivered material packing specifications.

Supporting Documents Tab

The Supporting Documents tab contains two sections:

- **Supporting Documents**—The document types available are Attachments/Procedures, URL, and Rich Text. For more information, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.

References Tab

The References tab includes the following sections:

- **Activities**—For discussion of this commonly used section, please see ["Substitute Materials Section"](#) on page 3-30
- **Specification Dependencies**—For discussion of this commonly used section, please see ["Specification Dependencies Section"](#) on page 3-31

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

Labeling Specifications

This chapter presents an overview of the capabilities of GSM regarding labeling specifications. Topics in this chapter include:

- [Summary Tab](#)
- [Compliance Tab](#)
- [Related Specs Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Label Specifications Summary tab contains the following sections:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Labeling Description**—Discussed below, at ["Labeling Description Section"](#) on page 16-2
- **Approved for Use In**—For discussion of this commonly used section, please see ["Cross References Section"](#) on page 3-5

Figure 16–1 Summary tab

The screenshot shows a web-based interface for managing a labeling specification. At the top, the title is "Standard Produce Label 4x4 (5077519-001)" with a "Draft" status. Below the title is a navigation bar with tabs: "Summary", "Compliance", "Related Specs", "Supporting Documents", "References", and "Approval/Audit Trail". The "Summary" tab is selected. The main content area is divided into two sections: "Summary Information" and "Labeling Description".

Summary Information

Spec Name:	Standard Produce Label 4x4
Short Name:	Standard Produce Label 4x4
Access Level:	No Access (Global) (0)
Spec Status:	Draft - This specification is currently in draft status
Spec #:	5077519-001
Category:	Global Standards
Sub Category:	Standard Labeling Requirements
Group:	All Ingredients
Supersedes:	
Reason for Change:	
Originator:	
Effective:	9/1/2009
Inactive:	
Last Edit:	Tuesday, April 03, 2007

Labeling Description

Description: Each container shall be clearly and properly labeled with the following information:

- Ingredient Name
- Ingredient Number
- Manufacturer's Name and Address
- Processing Date or equivalent lot number or date code.
- Net Weight
- Keep Frozen

Ingredient Number labeling is requested, but not required, on containers packed without prior knowledge or receipt of a order as long as this number is referenced on all paperwork involved with the purchase and shipment.

Approved for Use In

Labeling Description Section

This section provides a place to describe the labeling requirements for this specification.

Compliance Tab

This tab is not currently used but is present for legacy purposes only.

Related Specs Tab

The Related Specs tab contains the following sections:

- **Delivered Material Packing Specifications that rely on this Specification**—Discussed below, at "[Delivered Material Packing Specifications That Rely on This Specification Section](#)" on page 16-3.
- **Associated Specifications**—For discussion of this field, please see "[Associated Specifications Section](#)" on page 3-15.

Figure 16–2 *Related Specs tab*

Standard Produce Label 4x4 (5077519-001)		Draft						
Labeling Specification								
Summary	Compliance	Related Specs						
Supporting Documents								
References								
Approval/Audit Trail								
<div> <input checked="" type="checkbox"/> Delivered Material Packing Specifications that rely on this Specification </div> <table border="1"> <thead> <tr> <th></th> <th>Packing Spec #</th> <th>Packing Spec Name</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>5077481-001</td> <td>Corrugated Case Pack with Poly Liner</td> </tr> </tbody> </table>				Packing Spec #	Packing Spec Name	1	5077481-001	Corrugated Case Pack with Poly Liner
	Packing Spec #	Packing Spec Name						
1	5077481-001	Corrugated Case Pack with Poly Liner						
<div> <input type="checkbox"/> Associated Specifications </div>								

Delivered Material Packing Specifications That Rely on This Specification Section

Information in this section is read only so you cannot associate specifications here. The section displays the associations that have been made to this labeling specification from a delivered material packing specification.

Supporting Documents Tab

The Label Specifications Supporting Documents tab consists of the following sections:

- **Supporting Documents**—Document types available for use in the Supporting Documents tab are Attachments/Procedures, URL and Rich Text. For more information, please see "[Supporting Documents Section](#)" on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see "[DRL Documents Section](#)" on page 3-23.

References Tab

The Label Specifications References tab consists of two sections:

- **Activities**—For discussion of this commonly used section, please see "[Activities Section](#)" on page 3-31.
- **Specification Dependencies**—For discussion of this commonly used section, please see "[Specification Dependencies Section](#)" on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Master Specifications

This chapter presents an overview of the capabilities of GSM regarding master specifications. Topics in this chapter include:


- [Summary Tab](#)
- [Applies To Tab](#)
- [Ext Data Tab](#)
- [Supporting Documents Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Summary Tab

The Summary tab consists of the following sections:

- **Summary Information**—For discussion of this commonly used section, please see ["Summary Information Section"](#) on page 3-3
- **Master Description**—Discussed below, at ["Master Description Section"](#) on page 17-2
- **Approved for Use In**—For discussion of this commonly used section, please see ["Approved for Use in Section"](#) on page 3-6

Figure 17-1 Summary tab


Listeria Testing - Vegetables (5077483-001)
Draft

Master Specification

Summary Applies To Ext Data Supporting Documents References Approval/Audit Trail

Summary Information

Spec Name:

Listeria Testing - Vegetables

Short Name:

Listeria Testing - Vegetables

Access Level:

No Access (Global) (0)

Spec Status:

Draft - This specification is currently in draft status

Spec #:

5077483-001

Category:

* No Category Available (mast)

Sub Category:

* No Category Available

Group:

* No Category Available

Supersedes:

Reason for Change:

Originator:

Effective:

9/29/2004

Inactive:

Last Edit:




Monday, March 01, 2010

Master Description

Description:


A 25 gram sample representing each shipment, or each 40,000 lbs. of production, will be tested for Listeria. A certificate of analysis (COA) referencing all lots/code dates will be forwarded to Corporate Purchasing prior to shipment or transfer. One COA per purchase order or contract is acceptable.

Approved for Use In

	Business Unit(s)	Countries	
1	 CPI USA Retail Seattle	 USA	

Add New

Master Description Section

In this section you can describe the purpose of the master specification. Click the alternate wording icon () to provide the description in multiple languages.

Applies To Tab

Figure 17–2 Applies To tab

Listeria Testing - Vegetables (5077483-001) Draft

Master Specification

Summary Applies To Ext Data Supporting Documents References Approval/Audit Trail

▼ Specification Categories (if applicable)

- Material Specifications » Dairy Products
- Material Specifications » Dairy Products » Buttermilk
- Material Specifications » Dairy Products » Buttermilk » Chilled

Edit Applies To

Specification Categories Section

In Specification Categories, you can associate this master specification to other specifications in the system by choosing one or more categories that this master specification will automatically apply to.

You can apply specification categories from the highest to the lowest levels of the specification categories. For example, you can create and apply a master specification that will automatically apply to the following:

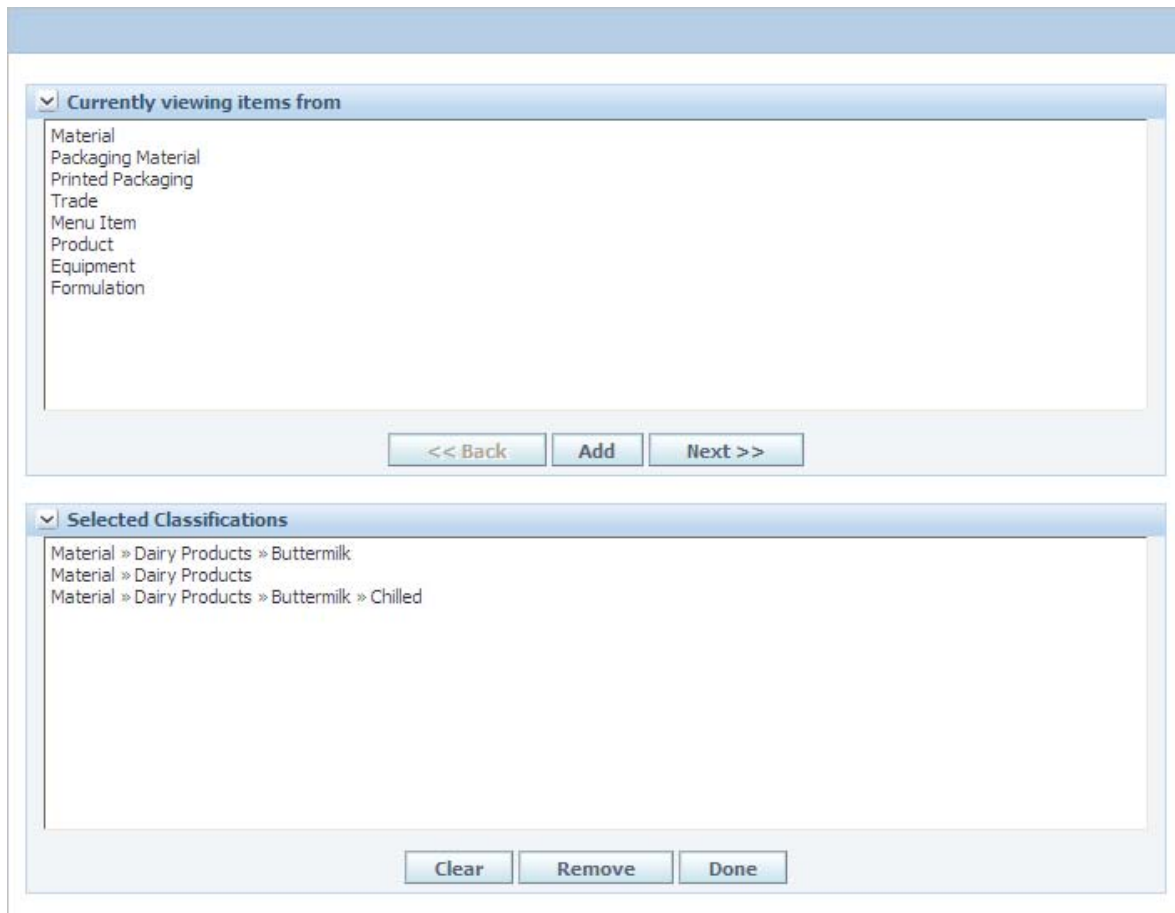
- All material specifications
- Material specifications exclusively for produce
- Material specifications for apples

Note: The business unit on the master specification must be the same on the associated specification for this master specification to be associated. The Business Unit field is set in the Approved for Use In section, as discussed in "[Approved for Use in Section](#)" on page 3-6.

Applied master specifications appear on the associated specification in the master specifications section of that specification. See "[Master Specifications Section](#)" on page 3-15 for more information.

To apply a specification category:

1. On the Applies To tab, click **Edit**. GSM reloads the page in editable mode, showing the **Edit Applies To** button as shown in [Figure 17–2](#) above.
2. Click **Edit Applies To**. GSM displays a dialog box with two large fields: "Currently viewing items from" and "Selected Classifications," as shown in [Figure 17–3](#).

Figure 17-3 The “Edit Applies To” dialog box

3. In the "Currently viewing items from" field, select one specification type.

Note: This dialog box does not support multiple-select.

4. To choose from a preset list of subcategories associated with the selected specification type, click **Next>>**. GSM displays the list of subcategories for your selected specification type. (Continue this process until you arrive at the subcategory that you need.)
5. Click **Add**. Your selected subcategory appears in the "Selected Classifications" box.
6. Click **Done**. GSM closes the dialog box and adds your selections to the list in the Specification Categories section of the Applies To tab.
7. Click **Save** or **Save & Close**.

Note: Master specifications can also be associated explicitly at the specification level. See "[Master Specifications Section](#)" on page 3-15 for more information.

Ext Data Tab

This tab consists of the following sections:

- **Extended Attributes**—For discussion of this commonly used section, please see ["Extended Attributes Section"](#) on page 3-11.
- **Custom Sections**—For discussion of this commonly used section, please see ["Custom Sections"](#) on page 3-11.

Supporting Documents Tab

This Supporting Documents tab consists of the following sections:

- **Supporting Documents**—Document types available for use in the Supporting Documents tab are Attachments/Procedures, URL and Rich Text. For more information, please see ["Supporting Documents Section"](#) on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see ["DRL Documents Section"](#) on page 3-23.

References Tab

For discussion of the Activities section, the only section in the References tab, please see ["Activities Section"](#) on page 3-31.

Approval/Audit Trail Tab

For discussion of this tab, please see ["Approval/Audit Tab"](#) on page 2-12.

This chapter presents an overview of the capabilities of GSM regarding LIO profiles. Topics in this chapter include:

- [Overview](#)
- [Summary Tab](#)
- [LIO Construction Tab](#)
- [Final Statement Tab](#)
- [Label Composition Tab](#)

Overview

Listed Ingredient Order (LIO) is the tool for labeling administrators to:

- View a food or beverage item based on its aggregated labeling composition;
- Manage the labeling composition to meet regulatory requirements using stored rules or manual overrides;
- Generate and push the final ingredient statement to a nutrient profile and/or a material specification so that the broader organization can further augment and complete the labeling business process.

LIO uses a material specification's percent breakdown and/or combined ingredient statement to describe labeling composition. This information can be presented using the top level output or the complete formulation and material specifications hierarchy to better understand and label a given item.

Using Percent Breakdown versus the Combined Ingredient Statement

In determining whether to use percent breakdown or the combined ingredient statement to describe label composition, it is important to properly form your raw material data so that it can assist you in generating the label. Consider the following scenario, which uses an example for an Ingredient called "Italian Spice Mix".

Scenario 1

In this scenario percentages are captured on an ingredient's %breakdown and requires target value representing 100% of the composition.

The ideal representation for composition describes the 100% composition and the components at a proper level of detail for labeling. The "Italian Spice Mix" has the following composition:

20%—Dried Basil
20%—Dried Marjoram
20%—Garlic Powder
10%—Oregano
10%—Thyme
10%—Rosemary
10%—Crushed Red Pepper

Scenario 2

However let's say this mix is considered proprietary and the supplier does not share all of the composition information with customers. The supplier does generally provide the following information:

40%—General Spice Mix (Or Unknown)
10 - 30%—Dried Basil
10 - 30%—Garlic Powder
5 - 15%—Rosemary
5 - 15%—Crushed Red Pepper

We would not directly use this information in the %Breakdown and in LIO. Some analysis must be performed first.

Scenario 3

If the supplier merely provides range percentages as presented above then a user must analyze the item and estimate the target values per component. The ranges can be captured in the fields provided on the breakdown.

40%—General Spice Mix (Or Unknown)
20%—Dried Basil (Min 10%, Max 30%)
20%—Garlic Powder (Min 10%, Max 30%)
10%—Rosemary (Min 5%, Max 15%)
10% —Crushed Red Pepper (Min 5%, Max 15%)

Scenario 4

If the supplier does not provide any percentages then someone from the customer's labeling team must estimate the composition for labeling purposes. When the data is presented as below then you may choose to use the Combined Ingredient Statement to hold the data. This provides visibility to the components but a user must still determine the impact on finished good labeling. The alternate approach is to estimate a target value for %Breakdowns as described in the examples above.

Summary Tab

The Summary tab consists of the following sections:

- **LIO Profile**—Discussed below, at ["Summary tab"](#) on page 18-3
- **Output Material Selection**—Discussed below, at ["Output Material Selection Section"](#) on page 18-3
- **Nutrient Profile**—Discussed below, at ["Nutrient Profile Section"](#) on page 18-4

Figure 18–1 Summary tab

Strawberry Cookie Dough (10468) Draft

LIO Profile

LIO #: 10468

LIO Name: Strawberry Cookie Dough

Description:

Status: Draft

Originator:

Created: 4/12/2013 3:35:47 AM

Last Edit: 4/12/2013 3:37:14 AM

Output Material Selection

Target Specification: Strawberry Cookie Dough (5114127-001)

Context: Strawberry Cookie Dough (5114126-001)

Nutrient Profile

Nutrient Profile X:

LIO Profile Section


Use the LIO Profile section to define the LIO profile. Key fields include:

- **LIO #**—Number assigned to the LIO profile by GSM.
- **LIO Name**—Name of the LIO profile. The LIO name will often be very similar to the trade specification or nutrient profile name as you are usually labeling a finished good. This field is required.

Output Material Selection Section

Use this section to define which material specification will be used as the basis for the LIO. Click the search icon () to search for and select the **Target Specification**. The Context drop-down list allows the user to select which formulation specification to pull the child items from when generating the LIO tree.

Nutrient Profile Section

This section allows the user to select which nutrient profile will be used if the user decides to push the LIO data to the material and nutrient profile using the Push to Spec functionality from the Final Statement tab. The clear field icon () removes the selected nutrient profile.

LIO Construction Tab

The LIO Construction tab consists of one section, LIO Construction, described below. This tab and section is where a labeling administrator will perform a majority of work by grouping, overriding, formatting and in the end creating the ingredient statement.

LIO Construction Section

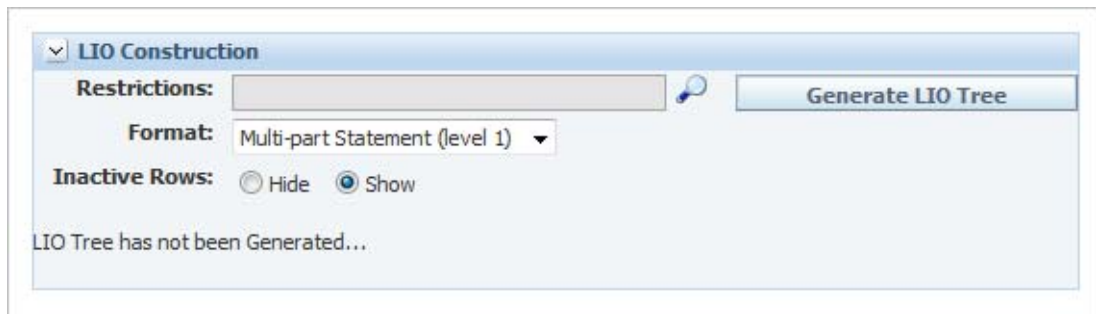
Use this section to build the ingredient statement. In the LIO Construction tab you can manipulate formula items based on certain constraints imposed by each item's underlying specification, LIO profile, and currently selected labeling restriction.

The first time you open the LIO tab of a profile, the LIO tree does not appear, because the system will not have generated it yet.

To prepare to generate the LIO tree:

1. In the action menu, click **Edit**. GSM reloads the page in editable mode, as shown in [Figure 18-2](#).

Figure 18-2 LIO Construction section in edit mode



2. Define the following summary-level information:

- [Restrictions](#)
- [Format](#)
- [Inactive Rows](#)

Restrictions

Restrictions are a configurable list that you can use to differentiate disclosures and groupings. Restrictions impact two major areas of functionality:

- **Component Catalog (CC)**—For example, in Canada you might be able to rename "salty beef" to "beef," but in the United States, because of tighter regulations around sodium, you could not. By setting the restrictions on the LIO tree to Canada, you could see disclosures and groupings set up in the Component Catalog with a restriction of Canada. LIO would be able to leverage this information to modify the ingredient statement in Canada to refer to "salty beef" as "beef." If you were creating an ingredient statement for

the United States, the "salty beef" would have to be labeled as such. For more information on restrictions, disclosures and groupings, see [Chapter 23, "Component Catalog"](#).

- **Material Breakdown**—Similar to the Component Catalog, breakdowns can contain regional or regulatory differences. Therefore restrictions can be assigned to breakdowns and then filtered upon when using LIO.

Format

From the Format drop-down list you can choose the level of detail to which the LIO tree will be created. After you change one of these options, GSM immediately reformats the Generate LIO and Final Statement fields. There are two options:

- Combined Statement (level 2)
- Multipart Statement (level 1)

Combined Statement (level 2) Omit top-level items in the LIO tree. For example, if you have seasoning that has a percent breakdown of "salt," "pepper," and "cinnamon" and you select this format, the resulting tree will contain salt, pepper, and cinnamon.

Multi-part Statement (level 1) Shows you all the levels in the LIO tree, as shown in [Figure 18-3](#), on page 18-6. In the example above, if you selected the "Multi-part Statement (Level 1)" format, you would see "seasoning" with "salt," "pepper," and "cinnamon" as child items.

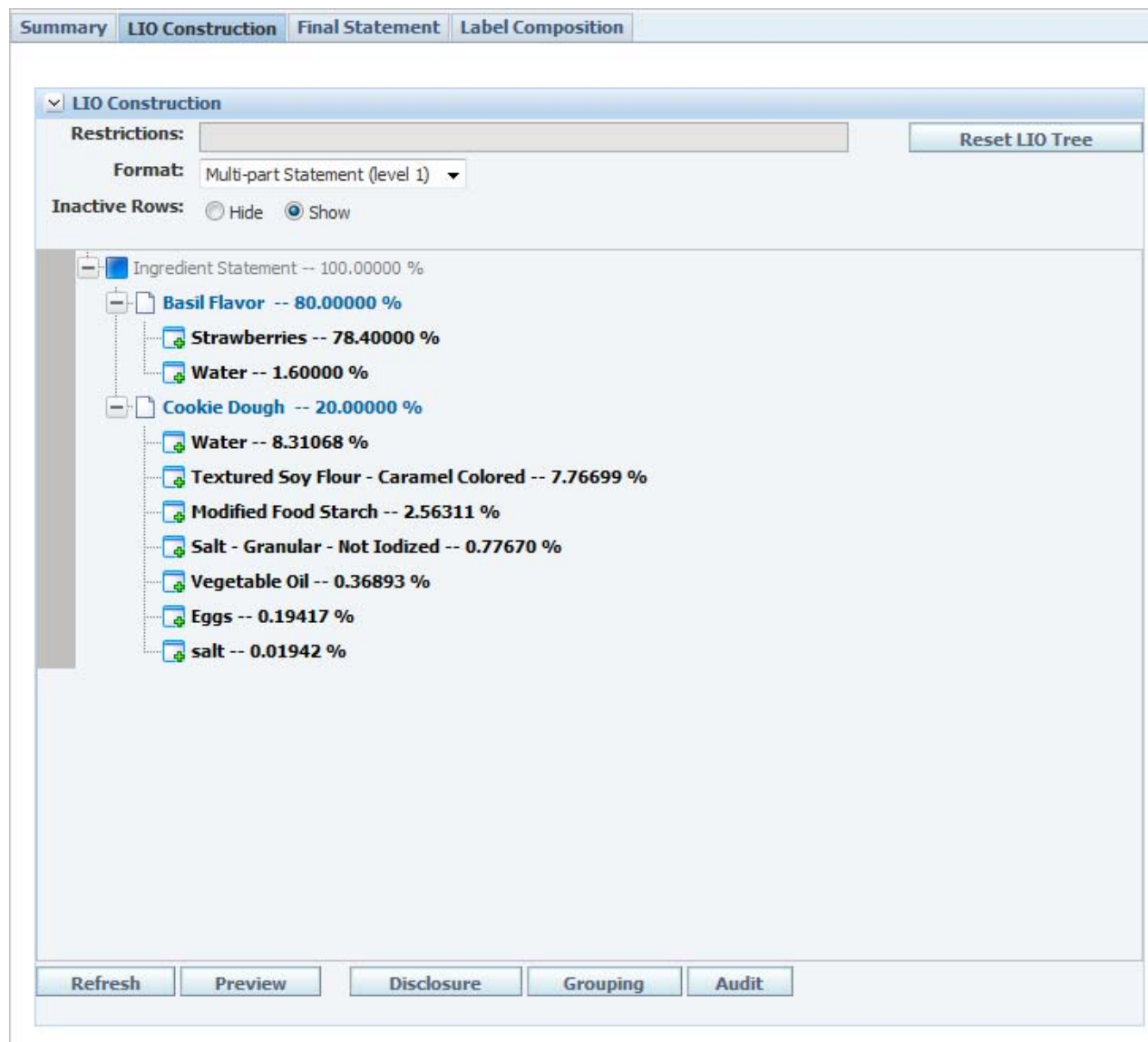
Inactive Rows

Use the Inactive Rows field to choose whether the tree will display or hide rows that are inactive. Hiding inactive rows is especially helpful if you are trying to pinpoint exactly what data will be shown in the ingredient statement.

Using the LIO Tree

Once you have defined the restrictions, format, and inactive row handling, click **Generate LIO Tree** to have the system create the requested tree, as shown in [Figure 18-3](#).

Figure 18–3 LIO Tree

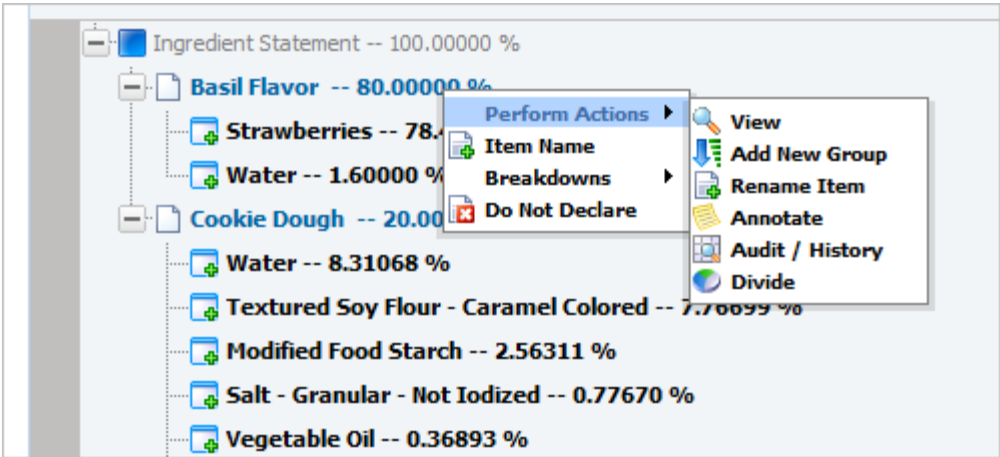


GSM displays the tree directly under the inactive row handling information and will display the entire formula tree.

Each item within the tree represents a material that may be considered for inclusion in the final ingredient statement. Each LIO item is represented by an icon indicating its type and current method of disclosure and includes its relative percent composition (yield based) within the final formula.

In the LIO tree, you can right-click an individual LIO item to reveal a number of declaration options/actions that you can use during LIO construction, as shown in [Figure 18–4](#).

Figure 18–4 LIO right-mouse menu



These options are contextual based on the type of item selected and the data inherited from its underlying specification, LIO profile, and the currently selected labeling restrictions. Using the described options/actions, you can build your ingredient statement.

Declaration Options and Actions

The table below describes the various presentations/methods for disclosing each LIO item and the corresponding declaration options and actions available:

Table 18–1 Declaration options/actions



Icon	Current Method for Disclosure	Declaration Options/Actions
	Base level for LIO authoring (does not appear in LIO)	Perform Action > Add new Group
	Ingredient that is listed as a single item in the LIO	Perform Action > View Perform Action > Add new Group Perform Action > Recon/Equiv Perform Action > Rename Item Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name Ingredient Statement Do NOT Declare

Table 18–1 Declaration options/actions







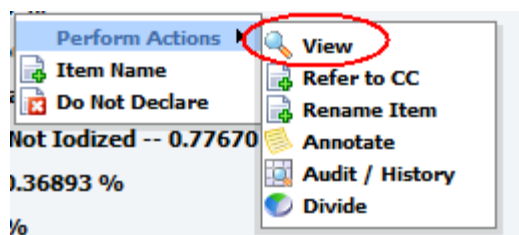
Icon	Current Method for Disclosure	Declaration Options/Actions
	Ingredient that is broken out into separate subitems in the LIO	Perform Action > View Perform Action > Add new Group Perform Action > Recon/Equiv Perform Action > Rename Item Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name Ingredient Statement Breakdown List ... x, y Breakdown List ...i(x,y) Breakdown List ...i(x%,y%) Context List ...x,y Context List ...i(x,y) Context List ...i(x%,y%)
	Ingredient that is flagged as "Do NOT Declare" and will not appear in the LIO	Perform Action > View Perform Action > Add new Group Perform Action > Rename Item Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name Ingredient Statement Do NOT Declare
	Component that is listed as a single item in the LIO	Perform Action > View Perform Action > Refer to CC Perform Action > Rename Item Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name Do NOT Declare
	Component that is listed as a single item in the LIO and whose title has been manually edited	Perform Action > View Perform Action > Refer to CC Perform Action > Rename Item Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name Do NOT Declare

Table 18–1 Declaration options/actions

Icon	Current Method for Disclosure	Declaration Options/Actions
	Component that is flagged as "Do NOT Declare" and will not appear in the LIO	Perform Action > View Perform Action > Refer to CC Perform Action > Rename Item Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name Do NOT Declare
	Group that has been added during the LIO process	Perform Action > Add new Group Perform Action > Rename Item Perform Action > Delete Group Perform Action > Annotate Perform Action > Audit/History Perform Action > Divide Item Name List ... x, y List ... i (x, y) List ... i (x%, y%) of Item List ... i (x%, y%) of Total Do NOT Declare

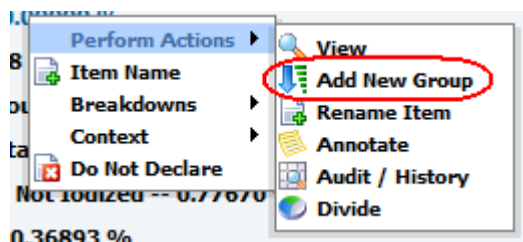
Right Menu Actions

View



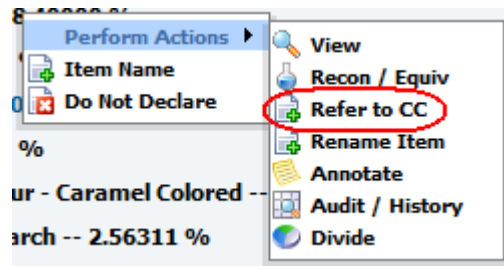
In the case of materials, click **View** to refer to the corresponding specification in GSM.
 In the case of Component Catalog components, click **View** to refer to the corresponding Component Profile of the item.

Add New Group



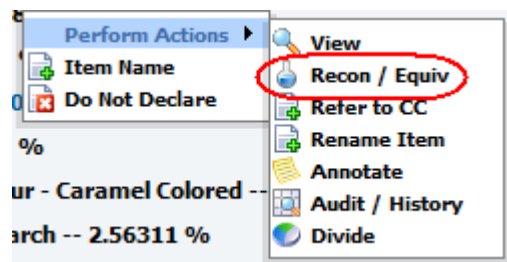
Click this menu option to create a new group directly under the current item. Once the group is created, you can delete it (if empty) or relocate it via drag-and-drop.

Refer to CC




Click this menu option to consider other options for disclosure based on the Component Catalog profile of the current item.

Recon/Equiv



Click this menu option to work with reconstitution and equivalency factors that will adjust the moisture content of the current item. Initially, GSM will display the dialog box shown in Figure 18–5:

Figure 18–5 Reconstitute Items, moisture

Reconstitute Items						Done	Cancel
Reconstitute Item	Target % Water	% Yield	% Total Solids	Water	% Water		
Modified Food Starch 	0.00000 % Water ▼	0.44345 %	100.00000 %	0.00000 g	0.00000 %		

Source Item	Using % From	Yield	Total Solids	Water	% Water
Water	<input type="text"/>	9.29036 %	0.00000 %	950.27602 g	100.00000 %
Eggs	<input type="text"/>	1.24167 %	21.42857 %	99.79032 g	78.57143 %
Strawberries	<input type="text"/>	29.74734 %	53.90796 %	1402.46225 g	46.09204 %
Vegetable Oil	<input type="text"/>	4.02324 %	95.28796 %	19.39107 g	4.71204 %
Preservatives	<input type="text"/>	0.04390 %	98.98990 %	0.04536 g	1.01010 %


From this dialog box you can manually adjust the moisture content for the selected item. To do so, first define a target "% Water" or "Factor," or "% Yield", and then declare one or more items from which to source the moisture. If one or more conversion factors have been previously defined for the current item, you can access/select a predefined factor by clicking the import data icon () , which GSM will display to the right of the field in the Reconstitute Item column. Click the icon to open the dialog box shown in Figure 18–6.

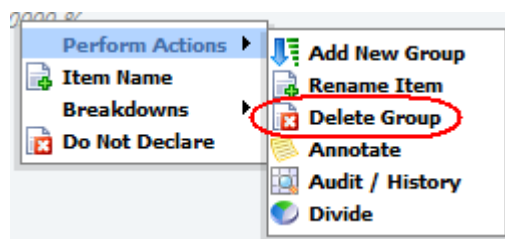
Figure 18–6 Reconstitution/Equivalency

Reconstitution/Equivalency		
Item Name	Target %/Factor	Comments
Liquid Starch	75.00000 % Water	

The Reconstitution/Equivalency Options for a given item are managed within the item's corresponding Component Catalog Term. GSM will use the selected factor/target % to populate the matrix as shown in [Figure 18–5](#).

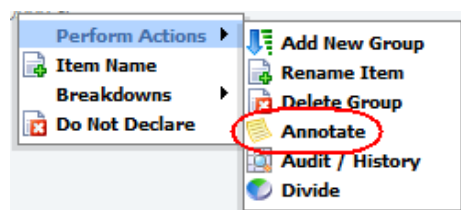
Enter the source from which to get the water necessary for performing the reconstitution and click **Done**. The results of your reconstitution appear in the LIO tree.

Delete Group

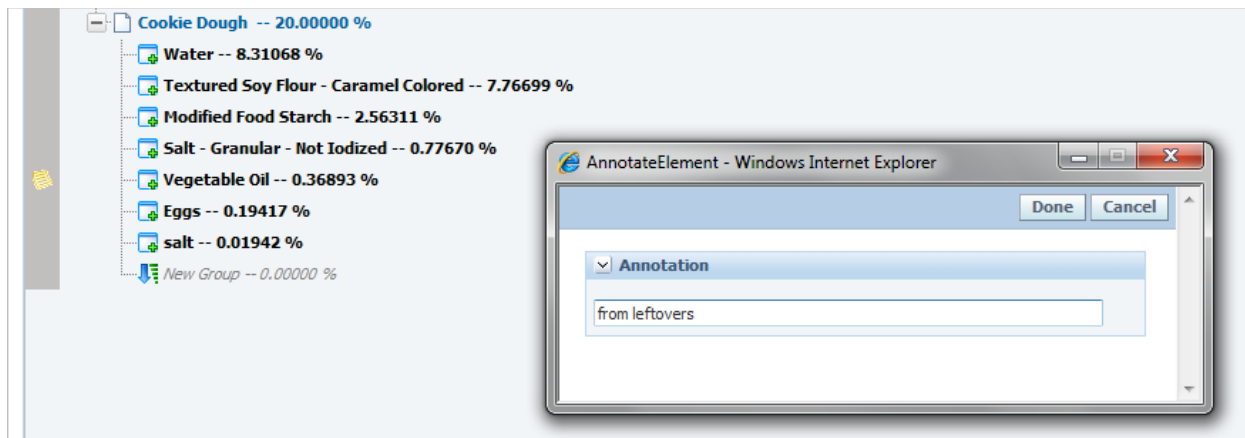


Click this menu option to delete the selected group. You can delete a group only if it has no subitems.

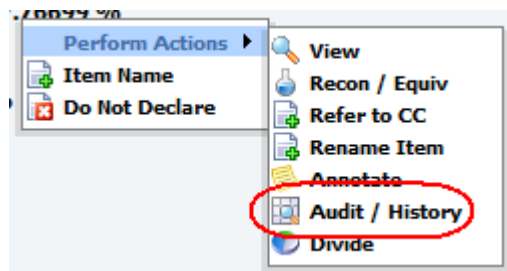
Annotate



Click this menu option to add a narrative comment to the item. Annotations are typically used to provide additional explanation/rationale to help others understand the decisions made during the LIO process. Any item containing an annotation will be denoted with a special icon in the left margin of the LIO tree, as shown in [Figure 18–7](#).

Figure 18–7 Annotation

Audit History

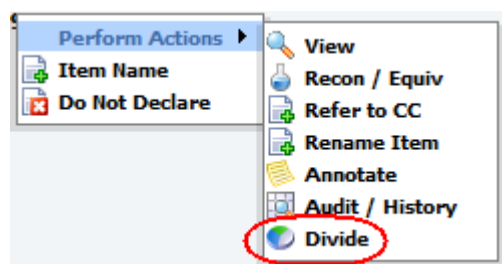



Click this menu option to get an accounting of the current disclosure method and any relevant actions that have been performed against the selected item. GSM displays a dialog box as shown in [Figure 18–8](#).

Figure 18–8 Audit/History dialog box

Note: The High Level Action column of the Audit/History dialog box will be recorded in the user's currently selected language and will not be language aware.

Divide



Click this menu option to create a new instance of the current item based on a percent or quantity of the original item (that is, to split an item into two separate instances). GSM prompts you to indicate a percentage or a quantity. Once you have created the new item, it will appear at the same level as the original item in the LIO hierarchy and you can move it via drag-and-drop to another area. Any item affected by a "divide" action will be flagged with a special divide icon () in the LIO tree left margin.

Declaration Descriptions

Item Name

Click this option to list the item as a single entry in the LIO using the default name of the current item.

Ingredient Statement

Click this option to list the item as a single entry in the LIO using the ingredient statement of the current item (if available).

List... x, y

Click this option to suppress the current item in the LIO disclosure and create individual entries for each lower level item, that is, "item one, item two, item three." For ingredients with multiple % Breakdown values and/or formulation specification contexts, there may be multiple options (the term "List" is replaced with the first 25 characters of each corresponding % Breakdown description or formulation specification name, for example, "From Supplier... x, y," "Canada Only ... x, y," and so on).

List... i (x, y)

Click this option to disclose as a combined statement using the current item and its lower-level items, that is, "Item Name (item one, item two, item three)". For ingredients with multiple % Breakdown values and/or formulation specification contexts, there may be multiple options (the term "List" is replaced with the first 25 characters of each corresponding % Breakdown description or formulation specification name, for example, "From Supplier... i (x, y)," "Canada Only... i (x y)," and so on).

List... i (x%, y%) of Item

Click this option to disclose as a combined statement with percentage using the current item and its lower-level items, for example, "Item Name (item one 50%, item two 25%, item three 25%)." For ingredients with multiple % Breakdown values and/or formulation specification contexts, there may be multiple options (the term "List" is replaced with the first 25 characters of each corresponding % Breakdown description

or formulation specification name, for example, "From Supplier ... i (x%, y%) of Item," "Canada Only ... i (x%, y%) of Item," and so on).

List... i (x%, y%) of Total

Click this option to disclose as a combined statement all of the item's subcomponents and the percentage of that subcomponent in the entire formula. It displays in the order of composition: Most to Least. For ingredients with multiple % Breakdown values and/or formulation specification contexts, there may be multiple options (the term "List" is replaced with the first 25 characters of each corresponding % Breakdown description or formulation specification name, for example, "From Supplier ...i(x%, y%) of Total", "Canada Only ...i(x%, y%) of Total", and so on).

Do Not Declare

Click this option to not disclose this item in the LIO. Items marked as "Do Not Declare" will not appear in the final ingredient statement.

LIO Operations

During the LIO process, you can perform a number of operations using the row of buttons beneath the LIO tree view.

Refresh Operation

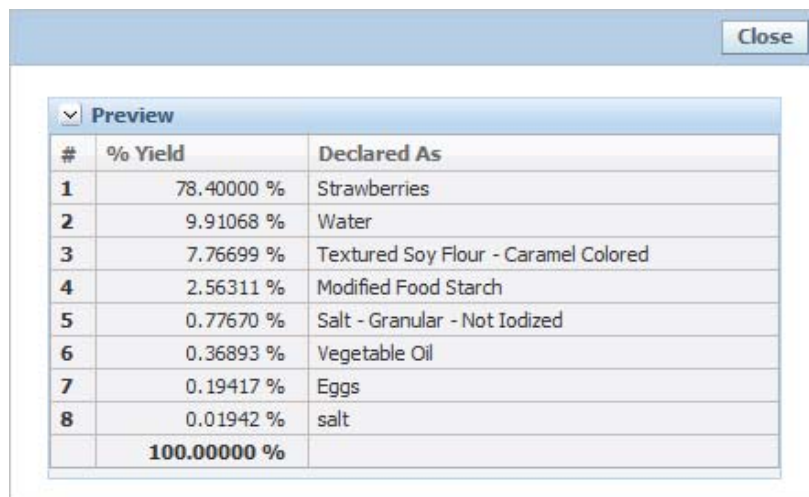
For performance reasons, many of the declaration options and actions are not executed immediately within the LIO tree view. Click **Refresh** to perform multiple actions before posting the tree view back to the server for rendering.

Once a Declaration Option/ Action has been selected, the affected LIO item will be flagged to inform you that a change will occur upon the next refresh. When you click **Refresh**, GSM posts the tree view back to the server for processing and re-renders it to reflect the desired changes.

Preview Operation

When you click **Preview**, GSM opens a dialog box with a table in it, shown in [Figure 18-9](#). This table indicates the order in which each LIO item will appear in the final ingredient statement.

Figure 18-9 Preview



#	% Yield	Declared As
1	78.40000 %	Strawberries
2	9.91068 %	Water
3	7.76699 %	Textured Soy Flour - Caramel Colored
4	2.56311 %	Modified Food Starch
5	0.77670 %	Salt - Granular - Not Iodized
6	0.36893 %	Vegetable Oil
7	0.19417 %	Eggs
8	0.01942 %	salt
	100.00000 %	

In addition, the Preview section shows the adjusted percent yield of each item (based on suppressed items).

Note: The preview will automatically combine like items (including group designations) based on LIO item name in the currently selected language.

Disclosure/CC Operation

Click **Disclosure** to open the disclosure dialog box shown in [Figure 18–10](#).

Figure 18–10 Disclosure dialog box

The screenshot shows a dialog box titled 'Disclosure' with 'Done' and 'Cancel' buttons. It contains two main sections: 'Restrictions' and 'LIO Disclosure(s)'. The 'Restrictions' section has a checked checkbox and a label 'Restrictions:'. The 'LIO Disclosure(s)' section contains a table with the following data:

Term or Alias		Disclosure	Priority	Constraints
Modified Food Starch -- 2.56311 % CC (1000001)	<input type="checkbox"/>	jxc		> 0.00000 % Composition
	<input type="checkbox"/>	Modified Food Starch Special Notes...	1	> 0.00000 % Composition
	<input type="checkbox"/>	Starches	2	> 0.00000 % Composition

The disclosure dialog box provides you with options for disclosing based on the labeling rules of each item derived from its corresponding Component Catalog Profile and its disclosures. GSM filters disclosure options based on matching restrictions and displays them in order of priority (also defined within the CC Profile). See [Chapter 23](#), "Component Catalog", for more information.

Grouping Operation

Click **Grouping** to display the grouping dialog box shown in [Figure 18–11](#).

Figure 18–11 Grouping dialog box

The screenshot shows a dialog box titled 'Grouping' with 'Done' and 'Cancel' buttons. It contains a 'Grouping' section with a checked checkbox. Below it is a table with the following data:

Target Group		LIO Item	Priority	Constraints
Eggs Group (From Component Catalog)	<input type="checkbox"/>	Eggs -- 0.77670 % CC (1000526)	Req	>= 11.00000 % Total Solids <= 12.50000 % Total Solids > 0.00000 % Composition
Spices (From Component Catalog)	<input type="checkbox"/>	Salt -- 3.18447 % CC (1000071)	2	> 0.00000 % Composition
Starches (From Component Catalog)	<input type="checkbox"/>	Modified Food Starch -- 0.31068 % CC (1000001)	Req	> 0.00000 % Composition

The grouping dialog box provides you with options for grouping based on each of the labeling rules of each item derived from its corresponding CC Profile and its groupings. GSM filters grouping options based on matching restrictions and displays

them in order of priority (also defined within the CC Profile). See [Chapter 23, "Component Catalog"](#), for more information.

Note: You can manually group LIO items using the drag-and-drop feature.

Audit Operation

Similarly to the preview operation, the audit operation opens a dialog box with a table that denotes the percent composition of each item with an accounting of the current disclosure method and any relevant actions that have been performed against that item.

Figure 18–12 Audit History dialog

Date	Item Name	Element Reference	% Yield	Declaration	High Level Action	Source	Destination	Message
4/12/2013 10:14 AM				Item Name	Delete Group			Removed Group with name of 'New Group'
4/12/2013 10:15 AM	Sugar		0.00000 %	Item Name	Add Group		Cookie Dough mat (5114116-001)	Group Added under [Cookie Dough]
4/12/2013 10:15 AM	Sugar		0.00000 %	Item Name	Rename			Renamed from [New Group] to [Sugar]
4/12/2013 9:56 AM				Item Name	Add Group		Cookie Dough mat (5114116-001)	Group Added under [Cookie Dough]

Note: The "High Level Action" column of the Audit/History table will be recorded in English and will not be language aware.

Once you have performed all required actions on your tree, click the **Final Statement** tab to finalize your ingredient statement.

Final Statement Tab

This Final Statement tab consists of the following sections:

- **Ingredient Statement Options**—Discussed below, at ["Ingredient Statement Options section"](#) on page 18-17
- **Final Ingredient Statement**—Discussed below, at ["Final Ingredient Statement Section"](#) on page 18-18

In the Final Statement tab you can further edit the generated statement for final label production. Once you have completed the LIO construction process, you can produce and edit the final ingredient statement using features found within the tab, then push the changes to the specification.

Figure 18–13 Final Statement tab

Strawberry Cookie Dough (10468) Draft

Summary LIO Construction **Final Statement** Label Composition

Ingredient Statement Options

Format: Multi-part Statement (level 1) ▼

Style: Linear ▼

Other: None ▼

Final Ingredient Statement

Generated LIO:

Basil Flavor :
Strawberries, Water

Cookie Dough :
Water, Textured Soy Flour - Caramel Colored, Modified Food Starch, Salt - Granular - Not Iodized, Vegetable Oil, Eggs, salt

Final Statement:

Basil Flavor :
Strawberries, Water

Cookie Dough :
Water, Textured Soy Flour - Caramel Colored, Modified Food Starch, Salt, Vegetable Oil, Eggs

Copy/Edit Push To Target

Ingredient Statement Options section

When editing the final statement, you can modify the statement using the Format, Style, and Other fields.

Format Field

GSM supports the following formats:

- **Multi-part Statement (level 1)**—Creates a multi-part statement using level one items as primary headers
- **Combined Statement (level 2)**—Creates a single, combined statement using all items beginning at level 2 within the LIO hierarchy

Style Field

GSM supports the following styles:

- **Columnar**—Arranges the final statement in a columnar list, separating each item with a new line
- **Columnar - Uppercase**—Arranges the final statement in a columnar list, separating each item with a new line, and converts all text to upper case
- **Linear**—Arranges the final statement as a linear paragraph
- **Linear - Uppercase**—Arranges the final statement as a linear paragraph and converts all text to upper case

Other Fields

GSM supports the following fields:

- **Contains Less than 2% of...**—Inserts “Contains Less than 2% of:” at the appropriate point in the statement based on the percent composition of each item

- **Contains Less than 3% of...**—Inserts “Contains Less than 3% of:” at the appropriate point in the statement based on the percent composition of each item

Once you have set the fields in the Ingredient Statement Options section and the generated LIO is displayed, you can click **Copy/Edit** to move the generated statement into the Final Statement field. At that time you can make any manual adjustments that are necessary.

Final Ingredient Statement Section

Use this section to review the ingredient statement, perform final editing, and push the changes to the specification.


Label Composition Tab

This tab displays the final label composition created from the generated LIO tree on the LIO Construction tab. If you haven’t generated an LIO tree then this section will be blank.

Note: This tab is enabled using the following configuration:
GSM.LabelComposition.Enabled

Label Composition, the sole section in the Label Composition tab, displays the composition of the specification for labeling purposes. This information can be pushed to the nutrient profile from the LIO process. The data pushed to the nutrient profile is read only and displays on the Label Composition grid on the Label Composition tab.

Figure 18–14 Label Composition tab

 Strawberry Cookie Dough (10468) LIO Profile		Draft
Summary LIO Construction Final Statement Label Composition		
Label Composition		
Item	Formulation	
1 Basil Flavor	80.00000 %	
2 - Strawberries	98.00000 %	
3 - Water	2.00000 %	
4 Cookie Dough	20.00000 %	
5 - Water	41.55340 %	
6 - Textured Soy Flour - Caramel Colored	38.83495 %	
7 - Modified Food Starch	12.81553 %	
8 - Salt - Granular - Not Iodized	3.88350 %	
9 - Vegetable Oil	1.84466 %	
10 - Eggs	0.97087 %	
11 - salt	0.09709 %	

Testing Protocol Library

This chapter describes the purpose and use of the Testing Protocol Library of GSM. Topics in this chapter include:

- [Overview](#)
- [Testing Protocol](#)

Overview

The Testing Protocol Library is a centralized location where you can document and manage quality and sampling procedures. Procedures are documented in GSM for specifications. Therefore you can capture protocols for raw materials (materials, products, packaging, printed packaging), work in process (materials and formulation), and finished goods (menu and trade).

Testing Protocols are then utilized in Product Quality Scorecard's Scorecards to assist in determining the quality of a specification.


A Testing Protocol can be created using one of two approaches:

- **Global (via Library)**—These testing protocols are global in scope and can be applied to many specifications. The protocols are created and maintained via the Testing Protocol Library and applied from a given specification by "Pulling from Library".
- **Spec (via Specification)**—Testing protocols created from an individual specification are limited in scope to that specification. You can view them in the library but cannot edit them from the library, as they are owned by the specification and can only be edited from that specification.






Testing Protocol

In the testing protocol you can define and categorize quality attributes to measure and the scoring method to use in evaluating the results. You can access the testing protocol library from the GSM left navigation panel.


Figure 19–1 Testing Protocol, top sections


Some Good Example Protocol (0000059)
Active











Summary Information

Protocol #: 0000059
Protocol Name: 
Description: 
Status: 
Scope: Global
Originator:  
Created: 8/25/2006
Edited: 9/4/2007

Facility Information

	Facility Name	Country	Business Unit(s)	
1	Prodika Europe	-Not Specified	CPI Facilities - Europe	

Sections

	Section Name	Section Description	Section Weight	Scoring Method		
1	Temperature 	This is the first section 	70	Simple Average		
2	Color 	This is the second section 	20	Simple Average	 	
3	Texture 	This is the third section 	10	Simple Average		

Extended Attributes

	Extended Attributes	Notes	

Summary Information Section

This section captures information pertaining to the testing protocol such as name, description, and status. The Status field controls whether or not you can use the protocol on specifications. The only testing protocols that you can add to a specification are those with a status of "active."

Facility Information Section

Some protocols are closely associated to facilities due to equipment or geography. In this section you can specify a set of facilities that you intend for this protocol to test.

Sections Section

In this section you can define a section for your protocol in which to group testing attributes for scoring. You can apply a scoring method and weight to each section to describe how GSM scores these attributes in the testing system.

Extended Attributes Section

Extended attributes define important features and characteristics of the testing protocol. You can build these attributes to meet specific needs.

Testing Protocol Section

Figure 19–2 Testing Protocol section

Testing Protocol																								
	ID	Property Description	Specification Limits	Scoring	Test Used	Protocol ID																		
1	1	<div><div><div><div><div></div><div>Cooling - After Processing - Internal Temperature</div></div></div><div>Material Characteristics</div><div>Section: Temperature</div></div></div>		<div><div><div><div><div></div><div>Qualitative</div></div></div><table><tr><th>If Measure</th><th>Score =</th></tr><tr><td>20 degrees</td><td>6</td></tr><tr><td>30 degrees</td><td>5</td></tr><tr><td>32 degrees</td><td>4</td></tr><tr><td>33 degrees</td><td>3</td></tr><tr><td>35 degrees</td><td>2</td></tr><tr><td>39 degrees</td><td>1</td></tr><tr><td>41 degrees</td><td>0</td></tr></table><div>Weight: 10</div><div>Non-Conformance: ≤ 3</div><div>Observations:</div><div>1. cold 4. moist 5. dry 3. cool 6. warm 2. hot</div></div></div>	If Measure	Score =	20 degrees	6	30 degrees	5	32 degrees	4	33 degrees	3	35 degrees	2	39 degrees	1	41 degrees	0	I-571	<div><div><div><div><div></div><div>X1 in every 1000000 U1 in every 1000 B1 in every 10 A1 in every 5 C1 in every 100</div></div></div></div></div>	<div><div>↓</div></div>	<div><div>✖</div></div>
If Measure	Score =																							
20 degrees	6																							
30 degrees	5																							
32 degrees	4																							
33 degrees	3																							
35 degrees	2																							
39 degrees	1																							
41 degrees	0																							
2	2	<div><div><div><div><div></div><div>Delivery Temperature</div></div></div><div>Material Characteristics</div><div>Section: Temperature</div></div></div>		<div><div><div><div><div></div><div>Qualitative</div></div></div><table><tr><th>If Measure</th><th>Score =</th></tr><tr><td>Frozen Solid</td><td>6</td></tr><tr><td>Mostly Frozen</td><td>5</td></tr><tr><td>Somewhat Slushy</td><td>4</td></tr><tr><td>Melted</td><td>3</td></tr><tr><td>Tepid</td><td>2</td></tr><tr><td>Warm</td><td>1</td></tr><tr><td>Hot</td><td>0</td></tr></table><div>Weight: 80</div><div>Non-Conformance: ≤ 3</div><div>Observations:</div></div></div>	If Measure	Score =	Frozen Solid	6	Mostly Frozen	5	Somewhat Slushy	4	Melted	3	Tepid	2	Warm	1	Hot	0		<div><div><div><div><div></div><div>B1 in every 3</div></div></div></div></div>	<div><div>↑</div><div>↓</div></div>	<div><div>✖</div></div>
If Measure	Score =																							
Frozen Solid	6																							
Mostly Frozen	5																							
Somewhat Slushy	4																							
Melted	3																							
Tepid	2																							
Warm	1																							
Hot	0																							
3	3	<div><div><div><div><div></div><div>Temperature - Bulk Receipt</div></div></div></div></div>		<div><div><div><div><div></div><div>Qualitative</div></div></div></div></div>		<div><div><div><div><div></div><div>Y1 in every</div></div></div></div></div>	<div><div>↑</div></div>	<div><div>✖</div></div>																

In this section you can define which properties of the specification to test in this protocol and the details around the definition and scoring of the tests. You can add a number of extended attributes and define the testing parameters for each.

To edit any data in this table, click **Edit** in the action menu. GSM reloads the page in editable form.

Key fields include:

- **Property Description/Section**—Click the add data icon (+) to open a search form with which you can select a different property description. From the Section drop-down list, choose a section defined above to categorize which section this testing item belongs to.
- **Specification Limits**—Click in the field and begin typing to define target, upper, and lower bounds for this test as well as a unit of measure.
- **Scoring**—Set up the scoring for the item in this subsection. This field defines how to score this item in the testing system. Click the add data icon (+) in this column to open the Scoring dialog box, from which you can make your selections, as shown in [Figure 19–3](#).

Figure 19–3 Scoring dialog box

The Scoring dialog box is titled "Scoring" and includes "Done" and "Cancel" buttons. It is divided into three main sections:

- Testing Protocol Analytical Property**:
 - Property Name: Cooling - After Processing - Internal Temperature
 - Property Classification: Physical - Material Characteristics
 - Section: Temperature
 - Record As: Qualitative (dropdown)
 - Scoring Weight: 10
 - Non-Conformance: <= 3
- Scoring**:

If Measure	Score =	
20 degrees	6	✖
30 degrees	5	✖
32 degrees	4	✖
33 degrees	3	✖
35 degrees	2	✖
39 degrees	1	✖
41 degrees	0	✖

calculated sequentially (poor) 0 - 6 (excellent)

Add New
- Observations**:

Description	
1. cold	✖
4. moist	✖
5. dry	✖
3. cool	✖
6. warm	✖
2. hot	✖

Add New

If you intend to use the testing protocol in PQS, then select **Qualitative** from the Record As drop-down list.

(For more information of PQS, please see the *Agile Product Lifecycle Management for Process Product Quality Scorecard User Guide*.) If you have the applicable administrative permissions, you can create observations that enable scorers to comment based on an administered list of options.

- **Protocol ID**—Describes how frequently to perform this test. Click the add data icon (+) in this column to display a dialog box in which to input test frequencies, as shown in [Figure 19–4](#). Click the **Add New** button to display a new row in the table, then type a protocol ID define the frequency. Click **Done** in the upper right of the dialog box to close it and display your additions in the table.

Figure 19–4 Setting Protocol IDs and frequency

☒ **Testing Protocol Analytical Property**

Property Name: Cooling - After Processing - Internal Temperature

Property Classification: Physical - Material Characteristics

Section: Temperature

☒ **Protocol IDs and Frequency**

	Protocol ID	Frequency	
1	X	1 in every 1000000	✖
2	U	1 in every 1000	✖
3	B	1 in every 10	✖
4	A	1 in every 5	✖
5	C	1 in every 100	✖

This chapter describes the purpose and use of the activities feature of GSM. Topics in this chapter include:

- [Overview](#)
- [Creating an Activity](#)
- [Summary Tab](#)
- [Supporting Documents Tab](#)
- [Ext Data Tab](#)
- [References Tab](#)
- [Approval/Audit Trail Tab](#)

Overview

An activity is a workflow enabled object that can be used with other specifications or objects. Activities can be useful in the following scenarios:

- **Managing Parallel Work**—As a material specification is moving through its workflow a user may choose to launch a nutritional review. This review can be modeled as a GSM activity working in parallel with the material specification's workflow. In addition you can choose to create a linkage between the activity and the specification to support business rules such as, "A specification cannot move to an "Approved" status if a nutritional review has been initiated and has not yet been completed."
- **Managing A Group Of Activities**—A given activity can be linked to one or many specifications or objects. This is useful if there is a single approval for all objects. Examples include: Linking multiple smart issue requests to an activity for approval or linking a number of specifications where a similar change must be performed.
- **Providing A Notification To Specification Readers**—Activities can be configured to provide an informational notification when users open a specification for reading. These notifications may be of value if a temporary condition exists impacting a group of specifications or an impending change is being considered.
- Activities are based on workflow templates managed in the Workflow Administration application (WFA). For more on WFA, please see the *Agile Product Lifecycle for Process Administrator User Guide*.

An activity is an additional workflow that may be tied to a specification. Activities are based on workflow templates managed in the Workflow Administration application

(WFA). For more on WFA, please see the *Agile Product Lifecycle for Process Administrator User Guide*.

Creating an Activity

You can create an activity from within GSM in two ways:

- **Primary Relationship**—A user can create an activity directly from another specification. We refer to this relationship as a Primary Relationship where the activity has a unique relationship to the originating specification.
- **Related Relationship**—A user can create a standalone activity and link it to one or more specifications or objects. We refer to this relationship as a Related Relationship and consider it to be generic in nature.

Creating a Primary Relationship from a Specification

You can create a primary relationship from an existing specification in GSM.

To create a primary relationship from an existing specification:

1. Access the specification to tie the activity to and select **Tools > Act** in the action menu. GSM displays an activity, opened to the Summary tab. By creating the activity in this manner, the activity has a primary relationship to the specification from which it originated.
2. Type a title for the activity in the **Activity Title** field.
3. Click the search icon (🔍) for the **Activity Type** field. A dialog box opens. Use this dialog box to select an activity workflow that will be used to manage the activity. The activity workflows are organized and presented by GSM business unit (BU). Please note, activities do not resolve to workflows similar to other specification types.
4. Select an activity type from the list of types in that dialog box and click **Done**. The box closes and your selection appears in the Activity Type field.
5. Continue filling out all required fields and any others that you wish to use as listed in the [Summary Tab](#), [Supporting Documents Tab](#), [Ext Data Tab](#), and [References Tab](#) sections, later in this chapter.
6. Click **Save** or **Save & Close**.

Creating an Activity That Is Independent of Specifications

If you have the necessary user role, you can create an activity that is independent of an individual specification.

To create a specification-independent activity:

1. From within GSM, click **New > GSM Activity > Blank** or **From Template** from the action menu. GSM displays an empty activity page opened to its Summary tab, as shown in [Figure 20-1](#).

Figure 20–1 Empty Activity creation page

The screenshot displays the 'Empty Activity creation page' with the 'Summary' tab selected. The page header shows '(5105815-001) Activity'. Below the header are tabs for 'Summary', 'Supporting Documents', 'Ext Data', 'References', and 'Approval/Audit Trail'. The 'Activity Summary' section contains fields for 'Activity Title', 'Activity#', 'Originator', 'Status', 'Activity Type', 'Special Notes', and 'Last Edit'. It also includes checkboxes for 'Notify Specification Reader of this activity' and 'Remove from specification when inactive', along with 'Effective' and 'Inactive' date pickers. The 'Related Items' section features a table with columns 'Type', 'Description', 'Status', and 'Comments', and a message 'No records found.' Below the table is an 'Add New' button and a checkbox for 'Reference this Activity on the above Specifications:'.

(5105815-001)
Activity

Summary Supporting Documents Ext Data References Approval/Audit Trail

Activity Summary

Activity Title:

Notify Specification Reader of this activity: ☐

Effective: 3/29/2011

Activity#: 5105815-001

Inactive:

Originator: Jones, Sally

Status: -

Activity Type:

Special Notes:

Last Edit:

☒ Remove from specification when inactive

Related Items

Type	Description	Status	Comments
No records found.			

Add New Reference this Activity on the above Specifications: ☐


- Follow the same steps as in the procedure for specification-dependent activities as described above (step 2 through step 6), keeping in mind that a specification-independent activity contains no Primary Action Item section.

Summary Tab

The Summary tab contains the following sections:

- Activity Summary**—Discussed below, at "[Activity Summary Section](#)" on page 20-4
- Primary Action Item**—Discussed below, at "[Primary Action Item Section](#)" on page 20-5 (for specification-dependent activities only)
- Related Items**—Discussed below, at "[Related Items Section](#)" on page 20-5

Figure 20–2 Summary tab


Labeling Activity (5083404-001)
Activity
Developmental

Summary
Supporting Documents
Ext Data
References
Approval/Audit Trail

Activity Summary

Activity Title: Labeling Activity

Notify Specification Reader of this activity: ☐

Activity#: 5083404-001

Originator: Jones, Sally

Status: Developmental - This specification is currently in developmental status

Activity Type: activity workflow

Special Notes: special notes

Last Edit: Friday, April 06, 2007

Primary Action Item

Item Name: Case Label Type C (5077478-001)

Process Dependency: Item Status dependent on this activity? No

Related Items

	Type	Description	Status	Comments
1	Menu Item Specification	Copy of Apple Sauce Menu Item 20070320 (5083038-001)	Draft	
2	Product Specification	Prod Spec 20070322 0910 (5083033-001)	Draft (Review)	

Reference this Activity on the above Specifications: ☐

Activity Summary Section

The Activity Summary section contains the identifying information for the activity and specifies which workflow template the activity is following.

Key fields include:

- **Activity Title**—Identifies the activity by name (required field).
- **Notify Specification Reader of this activity**—When checked, a notification panel will appear on the primary and/or related specification(s) informing the user that the activity exists. This panel will appear when the user opens the specification; the panel will disappear once the user places the specification in edit mode or switches tabs.
- **Activity #**—Identifies the activity by number (system-defined field).
- **Effective**—The date the activity becomes active. This date controls when the activity appears in the activity reference section on a related specification. This date is not available on a primary activity (an activity created from and possibly dependent on a specification).
- **Inactive**—The date the activity expires. This date controls when the activity is removed from the activity reference section on a related specification. If the inactive date is not set, then the activity will never expire and always appear on the specification(s). This date is not available on a primary activity (an activity created from and possibly dependent on a specification).

Note: For either of the effective or inactive dates to control visibility of the activity on the related specification(s), you must have the "Reference this Activity on the above Specifications" checkbox selected. For more information, see "[Related Items Section](#)" on page 20-5.

- **Remove from specification when inactive**—When checked, the inactive activity will not display on the specification. When unchecked, the activity will display on the specification. This field is only displayed on non-primary activities and by default is checked. The checkbox value is copied when creating a new copy or issue of the activity.
- **Originator**—Identify the person who created the activity (system-defined field).
- **Status**—WFA template-defined field displaying the workflow step that the activity is currently in.
- **Activity Type**—Link the activity to an activity workflow template (required field). Your workflow administrator manages activity workflow templates using the Workflow Administration application (WFA).

Note: For more information on managing workflow templates in WFA, please see the "Using WFA to Manage GSM Workflows" chapter in the *Agile Product Lifecycle for Process Administrator User Guide*.

Primary Action Item Section

The Primary Action Item section describes the specification participating in the primary relationship with the activity and allows users to create a dependency between the activity and the primary specification or item name.

Note: This section appears only in activities that are tied to a specific specification. It does not appear when you are creating a new specification-independent activity.

Key fields include:

- **Item Name**—Displays the name and number of the specification that the activity is tied to, hyperlinked to that specification.
- **Process Dependency**—Users choose whether to create a relationship between an activity workflow status and a specification workflow status. If a dependency is in place, the specification cannot move forward into a designated specification workflow status unless the activity first moves forward into the designated activity workflow status.

Related Items Section

The related items section contains the specifications participating in a related relationship to this activity. You can add one or more specifications and/or objects to this section. This section uses the get latest revision functionality. Note the locked icon (🔒), meaning the specification is tied to an exact specification/issue combination. If you want to use the get latest revision feature, unlock the specification (🔓). This action tells GSM to go and get the latest approved revision.

Note: Activities participating in a related relationship will not appear in a specification's Activities section unless you select "Reference this Activity on the above Specifications".

Supporting Documents Tab

The Supporting Documents tab contains the following sections:

- **Supporting Documents**—The document types available are Attachments/Procedures, URL, and rich text. For discussion of this commonly used section, please see "[Supporting Documents Section](#)" on page 3-18.
- **DRL Documents**—For discussion of this commonly used section, please see "[DRL Documents Section](#)" on page 3-23.

Ext Data Tab

The Ext Data tab can contain an Extended Attributes section, one or more custom sections, or it can be empty.

- **Extended Attributes**—For discussion of this commonly used section, please see "[Extended Attributes Section](#)" on page 3-11
- **Manage Custom Sections**—For discussion of this commonly used section, please see "[Custom Sections](#)" on page 3-11

References Tab

The Reference tab presents a list of primary and related activity relationships. Similar to other specification types, activities can participate in these relationships with other activities. Therefore a user can nest activities and view the relationships via this tab.

Approval/Audit Trail Tab

For discussion of this tab, please see "[Approval/Audit Tab](#)" on page 2-12.

Creating and Managing Templates

This chapter presents guidance on creating and managing templates in GSM. Topics in this chapter include:

- [Overview](#)
- [Creating Templates](#)
- [Consuming Templates](#)

Overview

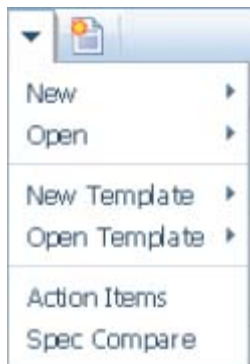
GSM templates provide the ability to create objects containing attributes which will be copied when creating specifications. Templates can be created for all specification types as well as activities. Once a specification template is created, it can be used to create objects. A specification template must be published before it can be used to create objects.

Creating Templates

Roles for Template Creation

A user will need the UGM role of TEMPLATE_CREATOR plus the base object creator role to create templates. For example, a user assigned the SPEC_CREATOR_1004 role can create "blank" material specifications. With the SPEC_CREATOR_1004 and TEMPLATE_CREATOR roles, the user can create material specification templates. For a list of spec_creator roles, please refer to the *Agile Product Lifecycle Management for Process Administrator User Guide*.

Users with the appropriate roles see the following options in the navigation menu.

Figure 21–1 *Template creation options*

New Template—Allows users to select the object type they would like to create and create a new template.

Open Template—Allows users to see templates that have already been created.

Template Attributes

Templates generally have the same attributes available for edit as their corresponding specification type. Many values added to these attributes will be copied to the specification when a user creates a specification from a template.

Templates also have some additional fields which can be found in the Template Configuration section.

Template Configuration

All templates have a Template Configuration section, as shown in [Figure 21–2](#). The template configuration section contains the Workflow field.

Figure 21–2 *Template Configuration section*

Workflow—The template creator uses the Workflow field to specify a specification workflow template. When a specification is created from a template, it will automatically resolve to this workflow. If this field is left blank, the specification created will use standard GSM workflow resolution.

Figure 21–3 Formulation Templates section

The screenshot shows a software interface titled "Formulation Templates" with a dropdown arrow on the left. It contains the following fields and options:

- Internal Output:** A text input field with a magnifying glass icon on the right.
- External Product Output:** A text input field with a magnifying glass icon on the right.
- Output Creator can override:** A dropdown menu currently set to "Yes".
- External By Product Output:** A text input field with a magnifying glass icon on the right.
- Output creator can override:** A dropdown menu currently set to "Yes".
- External Waste Output:** A text input field with a magnifying glass icon on the right.
- Output creator can override:** A dropdown menu currently set to "Yes".

Formulation templates have a Formulation Templates section. In this section the template editor provides templates that should be used when the formulation creates outputs. The formulation template creator can provide a material template for each type of output. These are the templates the formulation will use when creating outputs. Since most of the content on the output popup is theoretical and recalculated with BOM calculation, this mainly applies to spec category, manually added extended attributes, and custom sections.

For example, you would create "Material External Product Output Template A" and put the "Fact Panel" custom section on it. Then you would add "Material External Product Output Template A" to the External Product Output field on "Formulation Template A". When you create a formulation using "Formulation Template A," then every external product output that formulation creates will include the "Fact Panel" custom section automatically. This saves the users creating formulation from having to manually add the custom section every time they create an external output.

The system allows you to use a separate template for all of the different output types: Internal Outputs, External Products, External By Product, and External Waste. If no template is specified the system creates blank outputs.

In addition to content being automatically added to the output popup other content (Design Attributes, Shelf Life, etc.) on the material template will be copied to the external output material specification that is created by the formulation.

In addition to the output template options, each external template field includes an override option, "Output creator can override". When the user changes the output type from internal to external the system will refresh the output popup and apply the template designated replacing content (for example, custom sections and overrides) that may have been previously added. When **Yes** is selected, you are saying that the output creator can override the template. When the output type is changed the user will have the choice whether to load the template content or keep the existing output popup content.

"Do you want to refresh all values on this output using [Template Name]. You will lose any overrides or custom data you have added to the output thus far."

The user selects **OK** to refresh values or **CANCEL**.

If the override field is set to **No**, the user does not have a choice and the output is automatically refreshed replacing the specification category, custom sections, and manually added extended attributes.

Locked Fields

Template creators can lock key fields on a template. When these fields are locked they will be un-editable on a specification that has been created from this template.

Figure 21–4 Locked field

Summary Information

Template Name: formulation template internal output

Short Name:

Template Status: Draft (Review) - Please review and approve this specification.

Template #: 5108902-001 (Template)

Category: * No Category Available (frm)

Sub Category: * No Category Available

Group: * No Category Available

Supersedes:

Reason for Change:

Originator: Jones, Sally (USA)

Effective: 6/21/2011

Inactive:

Last Edit: Tuesday, June 21, 2011

The following fields can be locked:

- Spec Category
- Business Unit
- Approved For Use In > Country
- Concept
- Access Level
- Available UOMs
- For material specifications, Classification
- For product specifications, Standard and Classification
- For trade specifications, Item Type
- For menu specifications, Standard and Menu Item Classification
- For master specifications, Specification Categories
- GSM Activity - Workflow. Note that the locked field of workflow will be enabled after workflow is selected.

When locked, these fields remain locked throughout the specification's lifecycle. These fields remain locked even when the specification is issued.

Depending on a configuration, when a specification created from a template is copied, the user sees the following message:

"Do you want to keep this document linked to the template that created it? Click OK to keep it tied to the template. Click CANCEL to remove the template lineage."

If the user clicks **OK**, the specification copied will continue to be tied to the template that created it, and fields will be locked. If **Cancel** is selected, the specification will be created with no locked fields and no template ties.

Note: If a user has the role of `TEMPLATE_OVERRIDE` and edit rights to the specification, the user will be allowed to unlock or lock fields on a specification created from a template. Whatever the user sets the specification to will hold true throughout the rest of the specification's lifecycle.

Template Access

Templates resolve to WFA workflows. Along with the specific user roles discussed above, workflow controls read and write access to templates. WFA has a resolution criteria of "is Template", allowing templates to resolve to separate workflow templates than specifications. See the *Agile Product Lifecycle Management for Process Administrator User Guide* for more information.

Templates also respect GSM business unit security. Template creators that do not have access to the business unit assigned to a template cannot read the template. If the Business Unit field is left blank on the template, then all users will have access to it. See the GSM Business Unit Security section in the *Agile Product Lifecycle Management for Process Security Configuration Guide* for more information.

Template Availability

Templates for creating specifications are not instantly accessible. They must be in a "published" state before general users can start creating specifications using them. This setup allows a template to go through its own workflow and approval process before specifications are created based on them. A template is considered published when template is in a status that contains the "Publish Template" workflow tag. See the *Agile Product Lifecycle Management for Process Administrator User Guide* for more information.

Consuming Templates

Once a template is published, users can create specifications based on that template. A user must have the appropriate role, `CREATE_FROM_TEMPLATE_<OBJECT TYPE>`, to create a specification from a template. For example, users assigned the `CREATE_FROM_TEMPLATE_1009` role can create packaging material specifications from templates. See the roles appendix in the *Agile Product Lifecycle Management for Process Administrator User Guide* for a full list of roles.

Users with this role see the **New > OBJECT TYPE > From Template** option in the navigation menu.

The third panel displays the most recently used templates under the "From Template" header. Click on any of the most recently used templates to instantly create a specification using that template. You can also click the **More** link or the **From Template** header to open a template search screen.

Use this page to search for the template you would like to use. The template you select automatically creates the new specification based on that template and puts it in edit mode. You can preview the template using the view details icon (🔍) to the left of the template number.

For more information on creating specifications, see ["Creating Specifications"](#) on page 2-3.

Using Change Management Features

This chapter discusses the Change Management activities used to manage specifications. Topics in this chapter include:

- [Global Succession Tool](#)
- [Smart Issue Tool](#)

The Change Management feature provides tools for efficiently managing GSM specifications and for approving the modifications to specifications. The Change Management submenu in GSM contains choices for the two tools:

- **Global Succession**—Globally replace specifications without versioning the specifications
- **Smart Issue**—Replace and version specifications

Global Succession Tool

As an Agile PLM for Process administrator, from time to time you may need to globally replace specifications without versioning the host specifications. The Global Succession tool is designed to assist you in making non-material changes to relevant specifications in your Agile PLM for Process database. In this case, "non-material" refers to changes that do not affect the composition or labelling of the finished good.

Using this tool, you can request, tailor, approve, and execute (on a scheduled basis) mass changes affecting any number of product hierarchies. You can tailor the scope of target specifications (affected specifications) as required. Mass changes using this tool are not an all-or-nothing proposition; they are a kind of "find and replace" function.

Warning: Because this tool enables such sweeping changes, typically only an administrator with the highest security level will have access to it. Two roles are associated with the Global Succession tool:

[SUCCESSION_REQUEST_EDITOR]—Allows the user to edit and run global succession requests.

[SUCCESSION_REQUEST_READER]—Allows the ability to search and view global succession requests.

Table 22–1 Supported changes

Specification to Replace	Host Specification
Material specification	Formulation Inputs and Alternate Inputs
Material specification	Trade Specifications
Master specification	Equipment, Formulation, Material, Menu Item, Packaging Material, Printed Packaging, Product, and Trade specifications
Menu Item specification	Menu Item specification
Packaging Material specification	Formulation Inputs and Alternate Inputs
Packaging Material specification	Trade Packaging Materials and Alternate Packaging Materials
Packaging Material specification	Packaging Material specification
Printed Packaging specification	Formulation Inputs and Alternate Inputs
Printed Packaging specification	Trade Packaging Materials and Alternate Packaging Materials
Product	Menu Item specification

Accessing the Global Succession Tool

To access the Global Succession tool:

1. Click **GSM > Change Management > Global Succession**. Agile PLM displays a Global Successions search page with a Create New action button.

Finding the Specifications to Supersede

The process of identifying the specifications to supersede and the specification to replace them with includes these basic steps:

- Narrowing down the list of specifications
- Selecting the individual specifications to replace
- Executing the global succession
- Verifying the change

To narrow down the list of specifications:

1. Before entering search criteria, click **Create New**. A Select Object Type dialog box appears, as shown in [Figure 22–1](#).

Figure 22–1 Select Object Type dialog box

2. From the **Select Object Type** drop-down list, select the type of specification you are going to supersede.
3. Click the **Spec To Supersede** hyperlink to display a search form in a dialog box.
4. Use that search form to locate the specification you are going to replace and click that specification in the search results list.

The search box closes, and your selection displays in the Select Specification Type dialog box. The New Specification field label is now hyperlinked.

Note: If a specification to supersede or new specification is a material created from a formulation, a context drop-down appears. Use this optional field to designate which formulation created the material. If selected in Spec to Supersede, your search will be filtered by the formulation + material pairing, only showing parents that have that context selected. If selected for the new specification, then context will be defined along with the material when the succession is completed.

5. Click the **New Specification** hyperlink to display a search form in a dialog box.
6. As above, use that search form to locate the new specification and select it. The search box closes and the new specification displays in the Select Specification Type dialog box.
7. Select the parent specification type from the drop-down box with that name. The parent specification type will help further filter out your search results.
8. Enter a description of the global succession in the Reason for Change field, and click **Done**. The Global Successions tool queries the database and returns a list of target specifications on which you can perform a succession, as shown in [Figure 22–2](#).

Figure 22–2 Global Successions page showing Target Specifications section

The screenshot displays the 'Global Successions' page for 'Prodika Burger (5001192)'. The page is in 'Draft' status. The 'Succession Request' section shows details for request number 5001192, including a new specification for 'Cheeseburger' and its superceded status. The 'Target Specifications' section contains a table with one entry: '5082126-001' for 'Prodika Meal Deal', which is 'Approved' and 'Approved for Use In - BU' for 'CPI North America'.

Spec #	Spec Name	Status	Approved for Use In - BU
5082126-001	Prodika Meal Deal	Approved	CPI North America

You have now narrowed down the list of specifications to choose from and are ready to choose individual specifications to replace.

Performing the Global Succession

You can now select specifications to replace.

To select and replace individual specifications:

1. On the Global Successions page with the narrowed-down list of specifications in the Target Specifications section, click **Edit**. The page reloads in editable mode, showing the Run Global Succession button.
2. In the Target Specifications table, check the box next to each specification to replace and then click **Run Global Succession**. The tool replaces all selected specifications with the new specification and reloads the page showing the checked specifications and a status of "Complete," as shown in [Figure 22–3](#).

Figure 22–3 After a successful global succession request


Prodika Burger (5001192)
 Global Succession Request

Complete

Succession Request

Request Number: 5001192
New Specification: Cheeseburger (menu 5084163-001) - Draft (5/17/2007 1:40:41 PM)
To Supersede: Prodika Burger (menu 5082107-001) - Approved (1/14/2010 11:15:50 AM)
Scope: Menu Item Specification
Reason for Change:
Status: Complete

Target Specifications

<input type="checkbox"/>	Spec #	Spec Name	Status	Approved for Use In - BU
<input checked="" type="checkbox"/>	5082126-001	Prodika Meal Deal	Approved	CPI North America


The checked boxes represent specifications that have been replaced. The boxes are now dimmed, indicating the succession request is complete. To replace more specifications, run another global succession.

Verifying the Succession

To verify that the change has been made:

1. Find one of the targeted specifications in GSM, as explained in the procedure ["Finding the Specifications to Supersede"](#) on page 22-2.
2. Click the **Approval/Audit Trail** tab.
3. Look in the Event History table for a notation stating that the global succession was executed, as shown in [Figure 22–4](#).

Figure 22–4 Approval/Audit Trail tab, Event History section showing a record of a successful global succession


Prodika Burger (5082107-001)
Menu Item Specification

Approved

Summary
Build
Packaging
Compliance
Ext Data
Related Specs
Supporting Documents
References
Approval/Audit Trail

Current Status

Current Owner:

Current Workflow: Menu Item - Short Template

Current Status: Approved

Desired Action: Approved

Start Date: 1/14/2010

Amber Date: -----

Red Date: -----

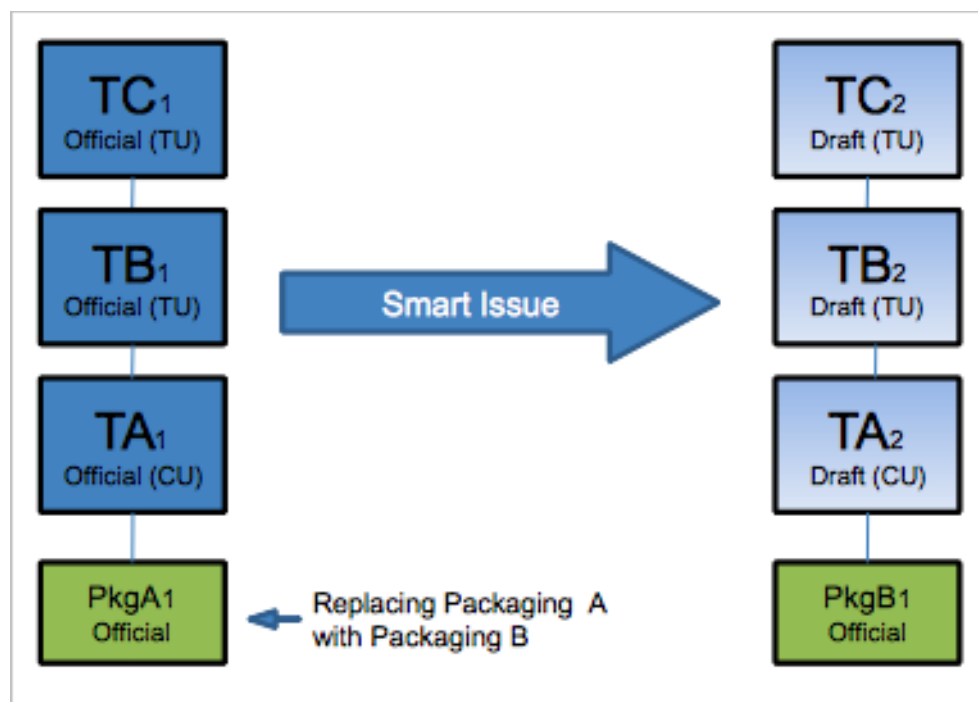
Event History

Status	User	Time	Comments
Approved	thunderkane	5/4/2011 10:49:31 AM	A Global Succession has been executed to replace (prod)5082111-001 with (prod) 5080383-002
Approved	thunderkane	4/20/2010 3:35:02 PM	A Global Succession has been executed to replace (mast)5085934-001 with (mast) 5083956-001
Draft	thunderkane	1/14/2010 11:15:50 AM	
Approved	thunderkane	1/14/2010 11:15:23 AM	
Draft	thunderkane	3/21/2008 10:16:19 AM	
Draft	thunderkane	8/8/2007 3:11:49 PM	Re-resolved to 'Menu Item - Short Template' (6).
Draft	thunderkane	12/14/2006 1:01:02 PM	

Smart Issue Tool

The Smart Issue tool allows you to create issues of entire hierarchies of specifications. You are able to just issue the hierarchy only, or replace specifications when issuing.

For example, you have a finished good hierarchy where you want to replace Packaging A with Packaging B. When smart issue is complete, you'll see that the entire trade specification hierarchy attached to Packaging A is issued and Packaging B is attached to the new version of the hierarchy.

Figure 22–5 Smart Issue packaging trade specification example

Use the Smart Issue tool to:

- Version a hierarchy only
- Replace one specification with another, without specifying a parent
- Replace one specification with another, while specifying a parent

The following specification types are supported:

Table 22–2 Affected specifications

Specification Type to Add or Remove	Parent Specification Type
Trade	Trade
Material	Trade
Material	Formulation Inputs and Alternate Inputs
Packaging/Printed Packaging	Formulation Inputs and Alternate Inputs
Packaging/Printed Packaging	Trade Packaging Materials and Alternate Packaging Materials
Packaging	Packaging Sub Components
Menu Item	Menu Item
Product	Menu Item

Warning: Because this tool enables such sweeping changes, typically only an administrator with the highest security level will have access to it. Three roles are associated with the Smart Issue tool:

[SMART_ISSUE_CREATOR]—Allows the user to create smart issue requests.

[SMART_ISSUE_EDITOR]—Allows the user to edit and run smart issue requests.

[SMART_ISSUE_READER]—Allows the ability to search and view smart issue requests.

Note: Additional security can be placed on the smart issue request itself by leveraging the Private and additional readers fields. This ability is explained further in this chapter.

Accessing the Smart Issue Tool

Access the Smart Issue tool as described in the procedure below.

To access the Smart Issue tool:

1. Click **GSM > Change Management > Smart Issue**. Agile PLM displays the Smart Issue search page.
2. Click the **Create New** action icon. The Smart Issue page displays, as shown in [Figure 22-6](#).

Figure 22–6 Smart Issue page

(0002162)
Smart Issue Request

Pending

Summary Details Audit

▼ Summary Information

Title:

Originator: Sally Jones

Owners: Sally Jones

Private: ☐

Status: Pending

Description:

Request #: 0002162

Create Date: 9/8/2011 8:09:48 AM

Last Edit: 9/8/2011 8:09:48 AM

> Extended Attributes

▼ Manage Custom Sections

Add Sections Remove Sections

> Attachments

> Related Documents

> Activities

The tabs on the Smart Issue page include:

- **Summary**—Defines the smart issue request and the users and groups able to view and edit it.
- **Detail**—Designates the specifications impacted by the smart issue request.
- **Results**—This tab appears when the smart issue request is completed or failed. This tab displays the new hierarchies created as a result of the smart issue.
- **Audit**—Details and a status for the smart issue request.

Defining the Smart Issue Request

Use the Summary tab to define the smart issue request.

To define the smart issue request:

1. Enter a **Title**. This field is required. The system automatically assigns the Originator, Status, Request #, Create Date, and Last Edit date.
2. Assign an owner of the smart issue request using the search icon (). The owner(s) of a request will be the only users allowed to edit and issue the request. Owners is a required field.
 - a. To designate the smart issue request as private, check the **Private** flag. By default all users with the [SMART_ISSUE_READER] role will be able to read

the smart issue request. If a request is marked as Private, only the users added to the Owner and Readers fields will be allowed to view the request.

- b. If the Private flag is selected, GSM displays the Readers field. Click the search icon (🔍) to open the user and group multi-select search, and select readers. Only users added to this field (and owners) will be able to view this smart issue request.
3. Enter a **Description** of the request.
4. Optionally, in the remaining sections on the page, add extended attributes, custom sections, and attachments.
5. Click **Save** to save the smart issue request.

You can attach smart issue requests to NPD activities and/or GSM activities. You can view all NPD activities associated to this request by clicking on the **NPD Activities** hyperlink in the Related Documents section.

You will see all GSM activities associated to the smart issue request in the Activities section.

Finding the Specifications to Version

Use the Details tab to specify which type of smart issue to perform. The options are:

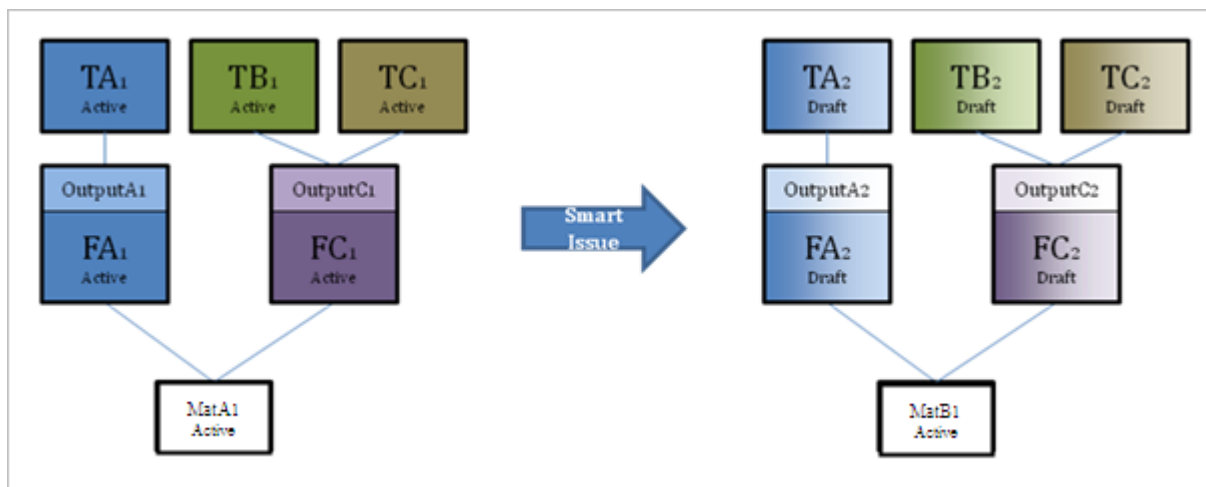
- **Replace Specification**
- **Replace Specification Given Parent**
- **Version Hierarchy Only**

Replace Specification

Use this option to replace a specification with another specification. This option is used to find all hierarchies that are attached to a given specification.

In the example below you would be replacing the material specification MatA v1 with material specification MatB v1. Notice after smart issue runs, all of the hierarchies attached to MatA1 are issued and the new issues of the hierarchy are now attached to MatB1.

Figure 22–7 Example of replacing a specification

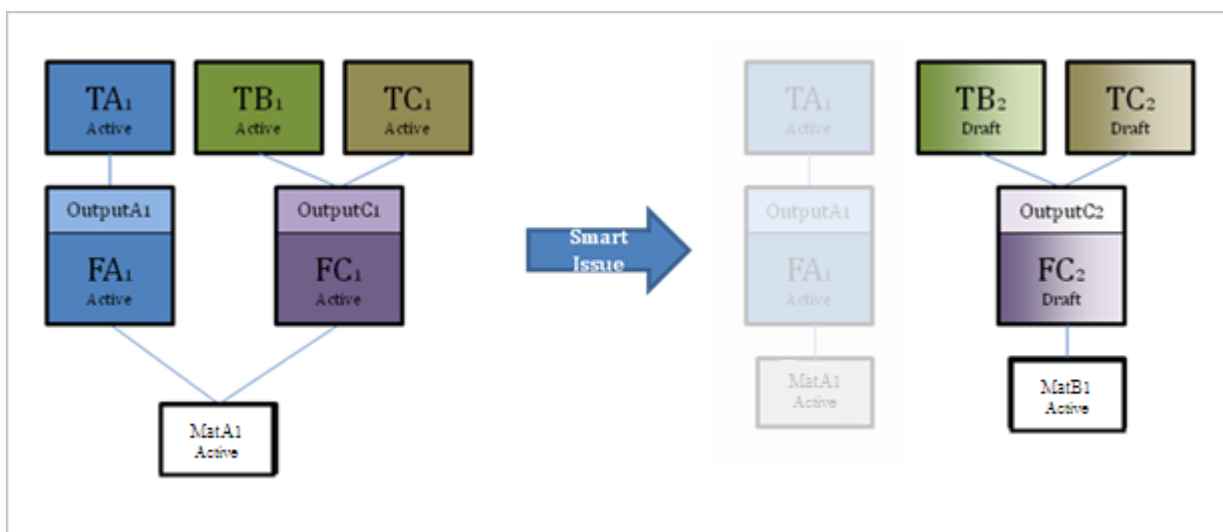


Replace Specification Given Parent

Use this option to replace a specification with another specification filtered by a parent specification. This option is used to find all hierarchies that are attached to a given parent and child pair of specifications.

In the example below you would be replacing the material specification MatA v1 with material specification MatB v1. However, you only want to replace MatA when it is used inside formulation specification FC. All other formulations that reference MatA you would like to keep untouched. This result could also be accomplished with the replace specification type if you know the top level specifications of the finished good hierarchies that reference formulation FC.

Figure 22–8 Example of replacing a specification with another specification filtered by a parent specification



Version Hierarchy Only

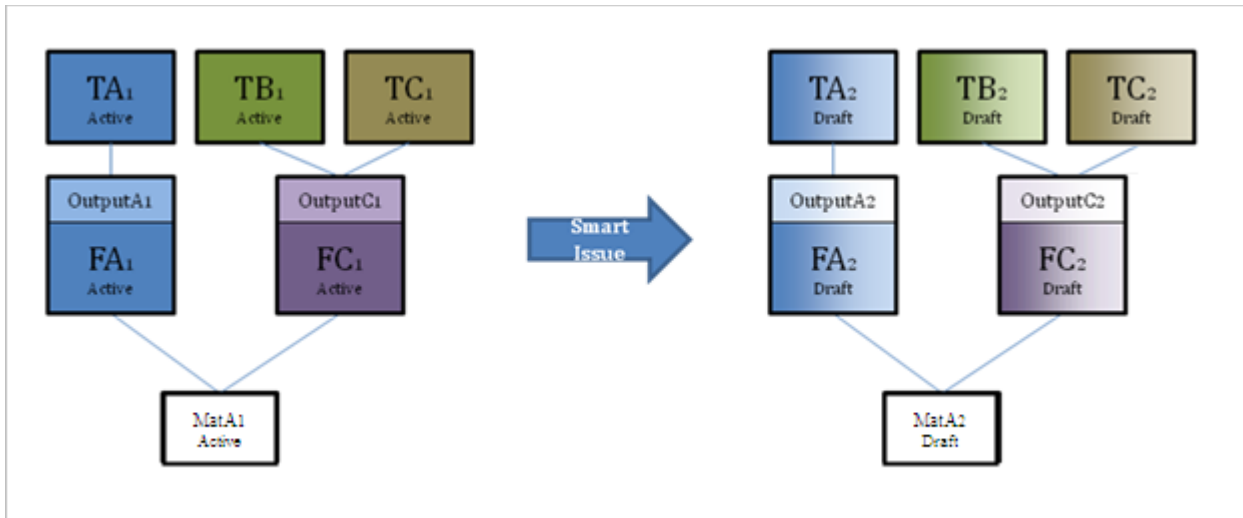
Use this option to issue the hierarchy only without replacing a specification. This option is used when you want to issue an entire hierarchy without replacing a specification. Smart issue will issue every specification in the hierarchy starting from the specification given as the “Starting From” specification.

In the example below, you would be versioning all hierarchies attached to material specification MatA v1. This action will also issue the material specification MatA v1 to MatA v2. You could achieve this same result if you were to manually create MatA v2 and use the replace specification type.

You may use only one option per smart issue request. The type selected will display different fields below the Type drop-down.

Note: The Get Latest Revision lock does not support this type of smart issue. The user will get all specifications versioned regardless of Get Latest Revision lock setting.

Figure 22–9 Example of issuing the hierarchy only without replacing a specification



To replace a specification:

1. From the **Type** drop-down list, select **Replace Specification**, as shown in [Figure 22–10](#).

Figure 22–10 Replace Specification option

2. For the **Specification to Remove** field, click the search icon (🔍) to display a search form in a dialog box.
3. Use the search form to select a material, menu item, packaging material, printed packaging, product, or trade specification. The search form closes.
4. For the **Specification to Add** field, click the search icon (🔍) to display a search form. This form contains specifications of the same type you selected to remove in step 3.

- Use the search form to select a specification to replace the specification being removed, and then click **Done**. Your selection appears in the Specification to Add field, as Figure 22–11 shows.

Figure 22–11 Specifications selected to remove and add

The screenshot shows the 'Smart Issue Request' interface with the status 'Pending'. The 'Search Criteria' section is expanded, showing 'Type' set to 'Replace Specification'. The 'Specification to Remove' field contains 'Bubbly Mango/Orange Drink (5087438-001)'. The 'Specification to Add' field contains 'Mango/Orange Drink (5082499-003)'. There is a 'See All Affected' button below the search criteria. The 'Smart Issue Action List' section is also visible but empty.

- Click **See All Affected**. The Affected Specs dialog box displays a listing of all of the specification hierarchies that are linked to the specification to remove, as Figure 22–12 shows:

Figure 22–12 Affected Specs dialog box

Affected Specs

Done




Cancel

▼ Affected Specs

Results Per Page 15

Export

Display Statuses: All

<input type="checkbox"/>		Spec #	Spec Name	Equivalent	Type	Status	Business Unit	Category	Issued
<input type="checkbox"/>		5088350-001	Trade Spec Mango 20080812		trd-CU	Approved	v521rc10 BU - Top, CPI Latin America, CPI North America	v521rc10 Trade Spec - Top » v521rc10 Trade Spec - Middle » v521rc10 Trade Spec - Bottom	Yes
<input type="checkbox"/>		5088350-002	New Issue Trade Spec Mango 20080812		trd-CU	Draft	v521rc10 BU - Top, CPI Latin America, CPI North America	v521rc10 Trade Spec - Top » v521rc10 Trade Spec - Middle » v521rc10 Trade Spec - Bottom	Yes
<input type="checkbox"/>		5103899-001	Trade Spec Mango Orange 2009041		trd-CU	Draft	CPI North America	v60030R9 Trade IE8 - Top » v60030R9 Trade IE8 - Middle » v60030R9 Trade IE8 - Bottom	Yes

1




All hierarchies are listed using the top level specification to represent the hierarchy. For any hierarchy listed, you can click on the hierarchy investigation icon () to display a popup window listing all specifications in the hierarchy that


will be issued. Take notice of the Issued column, which will state whether the specification will be issued or not based on the get latest revision setting on the specification. Click **Display Statuses** to filter the list.

7. Click the checkbox next to the hierarchies to issue, and then click **Done**. The dialog box closes, and selected specifications appear in the Smart Issue Action List. The Action List represents all of the hierarchies that will be issued when the smart issue request is performed.

You can now perform the smart issue, as described in ["Exporting the Affected Specifications"](#) on page 22-15.

To replace a specification based on a parent specification:


1. From the **Type** drop-down list, select **Replace Specification Given Parent**.
2. Click the **Parent** search icon () to display a search form in a dialog box.
3. Use the search form to select a formulation, menu item, or trade specification to designate as the parent specification. The search form closes.
4. Click the **Specification to Remove** search icon () to display the Spec to Remove dialog box. This dialog box will display all lower level specifications associated with the parent specification selected.
5. Select a specification to remove. The dialog box closes and the selected specification displays in the Specification to Remove field.
6. Click the **Specification to Add** search icon (). GSM displays a search page containing specifications of the same type you selected to remove in step 5.
7. Use the search page to select a specification to replace the specification being removed, and then click **Done**. Your selection appears in the Specification to Add field.
8. Click **See All Affected**. The Affected Specs dialog box displays a listing of all of the specification hierarchies that are linked to the specification to remove.

All hierarchies are listed using the top level specification to represent the hierarchy. For any hierarchy listed, you can click on the hierarchy investigation icon () to display a popup window listing all specifications in the hierarchy that will be issued. Take notice of the Issued column, which will state whether the specification will be issued or not based on the get latest revision setting on the specification.


9. Click the checkbox next to the hierarchies to issue, and then click **Done**. The dialog box closes, and selected specifications appear in the Smart Issue Action List. The Action List represents all of the hierarchies that will be issued when the smart issue request is performed.

You can now perform the smart issue, as described in ["Exporting the Affected Specifications"](#) on page 22-15.

To version a specification hierarchy:

1. From the **Type** drop-down list, select **Version Hierarchy Only**.
2. For the **Starting From** field, click the search icon () to display a search form in a dialog box.
3. Use the search form to select a material, menu item, packaging material, printed packaging, product, or trade specification. The search form closes. This specification serves as a bottom-level specification and displays in the Starting From field.

- Click **See All Affected**. The Affected Specs dialog box displays a listing of specifications available for smart issue.

All hierarchies are listed using the top level specification to represent the hierarchy. For any hierarchy listed, you can click on the hierarchy investigation icon () to display a popup window listing all specifications in the hierarchy that will be issued. Take notice of the Issued column, which will state whether the specification will be issued or not based on the get latest revision setting on the specification.

- Click the checkbox next to the hierarchies to issue, and then click **Done**. The dialog box closes, and selected specifications appear in the Smart Issue Action List. The Action List represents all of the hierarchies that will be issued when the Issue button is selected.

You can now perform the smart issue, as described below in ["Exporting the Affected Specifications"](#).

Exporting the Affected Specifications

You can export a listing of ALL specifications affected (top-level and the lower specifications related to each). The resulting spreadsheet includes the following columns: Top Level Spec, Level, Spec #, Spec Name, Equivalent, Type, Status, Business Unit, Category, Issued, and PKID. The Export button is available in Read and Edit mode. The export includes all affected hierarchies regardless of what checkboxes are selected.


Exporting the Action List

You can export a listing of ALL specifications in your Action List (top-level and the lower specifications related to each). The resulting spreadsheet includes the following columns: Top Level Spec, Level, Spec #, Spec Name, Equivalent, Type, Status, Business Unit, Category, Issued, and PKID.. The Export hyperlink is available in Read and Edit mode. The export will only include the hierarchies included in the Action List.

Performing the Smart Issue

Once hierarchies selected for the smart issue are displayed in the Smart Issue Action List, you are able to select the Issue button, as [Figure 22-13](#) shows.

Figure 22-13 Smart Issue Action List

Smart Issue Action List		Export						
		Spec #	Spec Name	Equivalent	Type	Status	Business Unit	Category
1		5088350-002	New Issue Trade Spec Mango 20080812		trd-CU	Draft	CPI Latin America, CPI North America	Trade Spec - Top » Trade Spec - Middle » Trade Spec - Bottom
Issue		<input type="checkbox"/> Version approved nutrient profiles						

Linked pages allow you to page through the results. You can also sort the data by clicking the column head.

To issue the smart issue request, the request must have a status of 'Pending' or 'Failed.'

To perform the smart issue:

- If desired, click the **Version approved nutrient profiles** checkbox. If selected, the approved nutrient profiles associated to any specification that is re-versioned will also be re-versioned. The new version of the nutrient profile will be attached to the

new revision of the specification and the old version will be removed. *Only Nutrient Profiles that are in a workflow step with a system tag of 'is Approved' will be versioned.* The new version of the nutrient profile that was marked as Active will become the active profile on the new specification.

2. Click **Issue** to perform the smart issue and the status is changed to "Executing." At this point the fields become read-only.


When the smart issue request reaches either a "Failed" or "Complete" status, an email is sent to the owner(s) and issuer of the request.

Once the smart issue request is in either a "Failed" or "Complete" state, the Results tab will be available.

Verifying the Smart Issue

Agile PLM for Process displays the Results tab upon completion of the smart issue request. This page shows two grids, one for the original hierarchies, and one displaying the newly issued hierarchies, as Figure 22–14 shows.

Figure 22–14 Results tab



Replace Trade with Trade (0000026)

Smart Issue Request

Completed

Summary

Details

Results


Audit

Smart Issue Results

Results Per Page: 20

Export

Original Specs

	Spec #	Spec Name	Equivalent	Type	Status	Business Unit	Category
<div>  <div> <div>5089549-001</div> <div> <div>v600rc7 - Smart Issue - Trade</div> <div>20090305</div> </div> </div> </div>		trd-TU	Draft	CPI North America	* No Category Available (Trade) » * No Category Available » * No Category Available		
1							

New Specs

	Spec #	Spec Name	Equivalent	Type	Status	Business Unit	Category
<div>  <div> <div>5089549-003</div> <div> <div>v600rc7 - Smart Issue - Trade</div> <div>20090305</div> </div> </div> </div>		trd-TU	Draft	CPI North America	* No Category Available (Trade) » * No Category Available » * No Category Available		
1							

You can sort results grids by column by clicking the column head. View specifications by clicking the hyperlinked Spec Name field.

Exporting the Results

You can export a listing of ALL specs (Top-level and the lower specifications related to each) from the original and the new hierarchies. The resulting spreadsheet will include the following columns: Top Level Spec, Original/New marker, Level, Spec #, Spec Name, Equivalent, Type, Status, Business Unit, Category, and specification PKID. The Export button is available in Read and Edit mode.

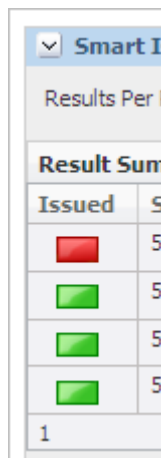
Failed Requests

If the request is in a status of "Failed," the Results tab displays the reason the smart issue request failed and a results summary. Generally a smart issue request fails because the link to the specification can no longer be found. Once the problem is corrected manually, you are able to restart the smart issue request and it will be begin re-issuing where it stopped.





The results summary grid lists all hierarchies that were attempted by smart issue. An Issued column includes status icons representing whether that hierarchy was completely issued or not.

This is intended to act as a quick summary view of the successful issues, so you will know what hierarchies still need to be addressed. If the top level shows as Completed, then that means the entire hierarchy was issued and no further action is needed. If the icon is red, that means either one or more specifications in that hierarchy were not issued.

Figure 22–15 Issued column with status icons




The screenshot shows a web interface for the Smart Issue tool. At the top, there is a dropdown menu labeled 'Smart I' and a section for 'Results Per Page'. Below this is a 'Result Summary' table. The table has two columns: 'Issued' and 'Status'. The 'Issued' column contains four rows of status icons: a red square, a green square, a green square, and a green square. The 'Status' column contains the number '5' for each of these four rows. At the bottom of the table, there is a row with the number '1'.

Issued	Status
	5
	5
	5
	5
1	

Exporting Failed Results






Click **Export** to receive a list of all specifications that were issued. The list includes the following columns: Top Level, Original/New, Level, Spec #, Spec Name, Equivalent, Type, Status, BU, Category, Pkid.

Workflowing Specifications

The Results grids include a briefcase icon () that you can use to workflow the new and original specifications. The briefcase serves as a navigation tool to help navigate to each specification.

Clicking the briefcase icon opens a frame to the left of the smart issue request. The frame contains two tree lists, Old Hierarchy and New Hierarchy. Old Hierarchy is a listing of all the specifications in the hierarchy before it was versioned. New Hierarchy is a listing of all specifications in the hierarchy after it was versioned.

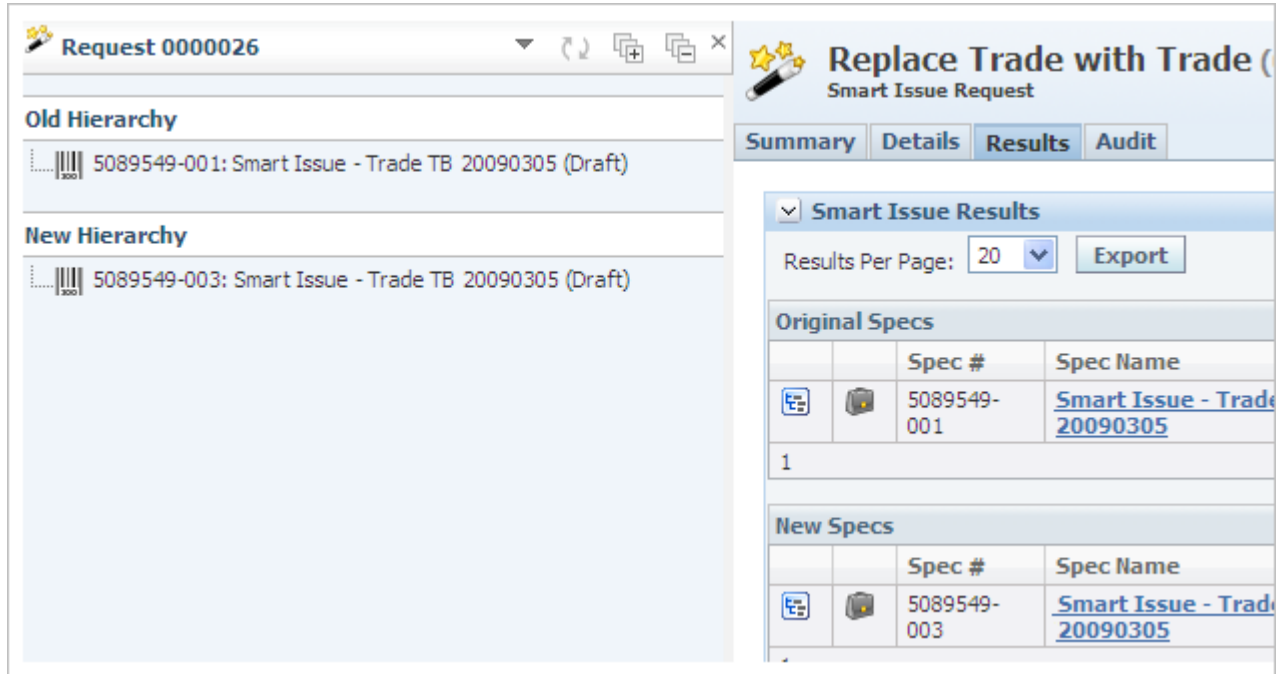
The frame contains a link and several action buttons, as defined below:

- **Request #**—Loads the smart issue request displayed below the briefcase frame.
- **Button submenu** ()—Select what content to display in the hierarchy tree.
- **Refresh** ()—Refresh the briefcase, updating the specification information displayed.
- **Expand** ()—Expands the selected hierarchy.
- **Collapse** ()—Collapses the selected hierarchy.
- **Close** ()—Closes the briefcase frame. The smart issue request remains.

To workflow specifications for approval:

1. Click the briefcase icon (). A frame displays to the left of the smart issue request, as [Figure 22–16](#) shows.

Figure 22–16 Briefcase frame



2. Click the specification in either grid to view the specification.
3. You can then edit the specification and workflow it to the appropriate status.

Checking the Status of the Smart Issue

Use the Audit tab to view the status of the smart issue request. The tab includes the user that initiated the smart issue request, the data/time the request was initiated, and the status.

Component Catalog

This chapter describes the capabilities and applied uses of the Component Catalog function. Topics in this chapter include:

- [Component Catalog](#)
- [Using Component Catalog Terms](#)

Component Catalog

If you have the necessary administrative privileges, in Component Catalog you can add terms to the database and manage certain properties about the terms. Once these terms have been created, you can use the library of predefined terms when creating percent breakdowns or when working on ingredient statements in LIO in GSM.

Integration with Other Applications

Component Catalog is integrated with GSM. Use Component Catalog terms when building percent breakdowns on material specifications or when working on ingredient statements in LIO.

Creating a New Component Catalog Term

Create and manage Component Catalog terms inside the component catalog. The Component Catalog is available as a submenu of GSM on the left navigation panel. You can create a new term by clicking **Create New**.

As shown in [Figure 23–1](#), the Catalog Term page contains several sections of data:

- [Catalog Term Section](#)
- [Aliases Section](#)
- [LIO Disclosure Section](#)
- [LIO Groupings](#)
- [Reconstitution/Equivalency Section](#)
- [Approved Usages Section](#)

Example 23–1 Component Catalog page

(1000586)
Component Catalog

▼ **Catalog Term**

Component Catalog:

Term #: 1000586

Term ID:

Special Notes:

Created By:

Formulation Tags:

▼ **Alias(es)**

Disclosure
No records found.

[Add New](#) [Change Order](#)

▼ **LIO Disclosure(s)**

Disclosure	Restrictions	Priority	Constraints
No records found.			

[Add New](#) [Change Order](#)

▼ **LIO Grouping(s)**

Grouping	Method	Restrictions	Priority	Constraints
No records found.				

[Add New](#) [Change Order](#)

▼ **Reconstitution/Equivalency**

Declare As	Target %/Factor	Comments
No records found.		

[Add New](#)

Catalog Term Section

The Catalog Term section defines the primary name of the term that you are defining and contains the following fields:

- **Component Catalog**—The name of the term being defined (required)
- **Term #**—A system defined number associated to this term
- **Special Notes**—User defined notes for the term
- **Created By**—The user who created the term
- **Formulation Tags**—These tags are used to help further define a component and its function. These tags will roll up when a formulation creates a breakdown. These tags will be critical when adjusting the moisture or solids of a formulation. For example, if a component is always a processing aid then it should be tagged here as a processing aid.

Once you have completed the term name, continue to the Aliases section.

Aliases Section

The Alias section defines the secondary name or names for the term that you are defining.

The Aliases section contains the following field:

Alias—Other names that you want to be treated similarly from a labeling perspective

Once you have entered all of the aliases for a given term, continue to the LIO Disclosure section.

LIO Disclosure Section

The LIO Disclosure section defines the terms that may be used (contextually) to describe the component catalog term that is being created during the LIO process. To add a new disclosure, click **Add New** under the Disclosures section. A dialog box opens for you to enter the details of the disclosure.

The LIO Disclosure section contains the following fields:

- **Disclosure**—The name of this item as it might appear on the ingredient statement if the restrictions and constraints are met.
- **Special Notes**—Your notes.
- **Restrictions**—A list of configurable tags that you can assign to the disclosure to prevent use in the LIO process. LIO will only use disclosures with the same restriction(s) or no restrictions applied.

Note: Specifying no restrictions means that the disclosure will be available for all ingredient statements in LIO.

- **Priority**—The order in which GSM presents the disclosures to you during the LIO process. If a you select a priority of "Req," that disclosure will be the only one that you see.
- **Constraints**—Additional criteria to limit when a particular disclosure can be used.

You can enter as many LIO disclosures as needed. Once you have entered all of the disclosure information for a given term, continue to the LIO Grouping section.

LIO Groupings

The LIO Groupings section defines the groups to which the component catalog term can be added during the LIO process. To add a new grouping, click **Add New** under the LIO Grouping section. A dialog box displays for you to enter details.

The LIO Grouping dialog box includes the following columns:

- **Grouping**—The name of the group that the term can be added to during the LIO process.
- **Special Notes**—Your notes.
- **Method**—The default declaration method for the group that is being added.
- **Restrictions**—A list of configurable tags that you can assign to the group to prevent use in the LIO process. LIO will only use groupings with the same restriction(s) or no restrictions applied.

Note: Specifying no restrictions means that the group will be available for all ingredient statements in LIO.

- **Priority**—The order in which GSM presents the groupings to you during the LIO process. If a you select a priority of "Req," that group will be the only one that you see.
- **Constraints**—Additional criteria to limit when a particular grouping can be used.

You can enter as many LIO groupings as needed. Once you have entered all of the group information for a given term, continue to the Reconstitution/Equivalency section.

Reconstitution/Equivalency Section

The Reconstitution/Equivalency section defines the reconstitution or equivalency rules that you can use during the LIO process. To add a new reconstitution/equivalency rule, click **Add New** under the Reconstitution/Equivalency section. A dialog box displays for you to enter details of the rule.

The Reconstitution/Equivalency table includes the following columns:

- **Declare As**—The name to use for the term after the reconstitution has been performed
- **Target %/Factor**—Factor or percent change to apply during the reconstitution process
- **Comments**—Your comments

Approved Usages Section

The Approved Usages section is for future use.

Using Component Catalog Terms

You can use Component Catalog terms in GSM when you are creating a percent breakdown on a material specification or when you are performing LIO. The terms can also be used in the percent breakdown on trade, product, and formulation specifications.

For more information on using LIO to create your ingredient statements, see [Chapter 18, "LIO Profiles"](#).

Key Search Fields

This appendix contains supplementary information about fields that are searchable within GSM. Topics include:

- [Searchable Fields](#)

Searchable Fields

Table A-1 describes search fields whose meaning or use may not be self-explanatory.

Table A-1 Key field names of note in the search criteria key field list, described

Key Field	Description
Associated Specification	Search against specifications containing associated specifications matching the search criteria entered. Search criteria include: Association, Equivalent, Name, and Number.
BD (Breakdown) Component	Searches against all breakdown component types (free text, material specification, Component Catalog, and Food Composition Library), declared within the percent breakdown
BD (Breakdown) Component COO	Search against Country of Origin (COO) column declared within the percent breakdown
BD (Breakdown) Component FCL	Search against Food Composition Library (FCL) terms that are declared within the percent breakdown
BD (Breakdown) Component Mat. Spec.	Search against Material Specifications that are declared within the percent breakdown
BD (Breakdown) Component Term	Search against Component Catalog terms that are declared within the percent breakdown
BD (Breakdown) Component Term or Alias	Search against Component Catalog term or alias that are declared within the percent breakdown
BD (Breakdown) Component Text	Search against the free text name of component or Food Composition Library (FCL) terms, material specifications, or Component Catalog terms, declared within the percent breakdown
Combined Statement	Search against the free-text combined statement used to declare materials in aggregation for labeling purposes
Concept (+Children)	Search against the concept, including concepts that exist as a child in the hierarchy
Concept (Exact Match)	Search against the exact match of the concept

Table A-1 Key field names of note in the search criteria key field list, described

Key Field	Description
Concept (Hierarchical)	Search against the hierarchy (both up and down) that the concept exists in
Equivalent	Search against the equivalent number designed to identify the material as it is referenced by other cross reference systems
GTIN/UPC/EAN	Search against the Global Trade Item Number (GTIN) or European Article Number (EAN) or Universal Product Code (UPC) barcode number
Material Specification	Search for a trade specification based on what material specifications are tied to it
Menu Item Build	Search against the Menu item specification or product specification listed in a menu item build
Supplier signed spec	Search against the flag on a sourcing approval that indicates the supplier has acknowledged a specification
System Equivalent	Search against the equivalent number designed to identify the material as it is referenced by other cross reference systems
Category	Search against the specification category of a specification. You can also browse for specifications using specification categories in the Category tab.
UDEX Classification	Search against taxonomies used by UDEX Electronic Exchange