

Splitting

15/04/2026 12:35 pm BST

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Tags: 9.5

Eyelit MES allows you to split lots to accurately record the location and status of material when lots are split during manufacture, post manufacture or when partial lots are moved, scrapped, consumed or dispatched.

Splits can be explicitly triggered manually by a user both in WIP and finished goods or they may be triggered implicitly as a result of another transaction such as the partial scrap or partial consumption of a lot. Examples:

- If 10 kg of a 100 kg lot needs to be moved from the warehouse to the shop floor location, the 100 kg lot must be split to support the move.
- A batch of 10,000 in WIP gets completed into pallets 100.
- Partial consumption.
- Partial scrap.

The system supports two triggers for splitting:

- **Explicit splitting** occurs when a batch is intentionally divided by an operator. During an explicit split, the serial number of the new item is assigned based on the product's serial number configuration (or a new serial number may be entered manually). For more information, see [Serial Numbers](#).

Operation Partial Completion splitting is an explicit split which occurs only when the **Partial Qty Mode** in the workflow **Operation** screen, is set to **New Item**. happens when you complete a partial quantity of a batch and pass it onto the next operation. For example, you are producing a batch of injection moulded parts that starts as a single batch of 10,000, but gets completed into 10 identifiable pallets of 1,000. As each quantity of 1000 is completed, the batch is split and the new child item is allocated a new serial number based on the product's serial number configuration. Note that this can happen in the middle or at the end of a workflow.

- **Implicit splitting** happens automatically when certain transactions are performed on a part of a batch. In this scenario, the serial number remains unchanged. The transactions that can trigger an implicit split are:
 - Pick
 - Dispatch
 - Use
 - Remove
 - Scrap

Split BOM Mode

The **Split BOM Mode**, which is configured for the workflow operation, defines how the immediate child components are split between the source and target quantity. The examples below describe each of the modes available in a workflow operation. For more information, see [Workflow Operation](#).

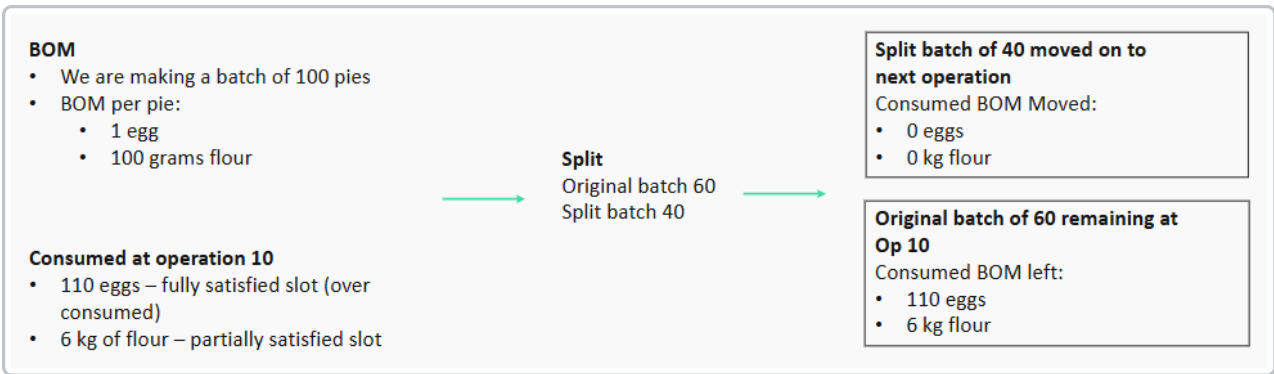
Note that the split of a parent will result in the split of all material below in the BOM hierarchy. The treatment of direct child material of the item being split is determined by the split modes defined below. Grandchildren and below are treated as implicit splits (and will always use **Ratio** mode).

The BOM modes are:

None

In this mode, none of the child material transfers with the spawned split item. It stays with the original parent item.

This mode is relevant for explicit splits.



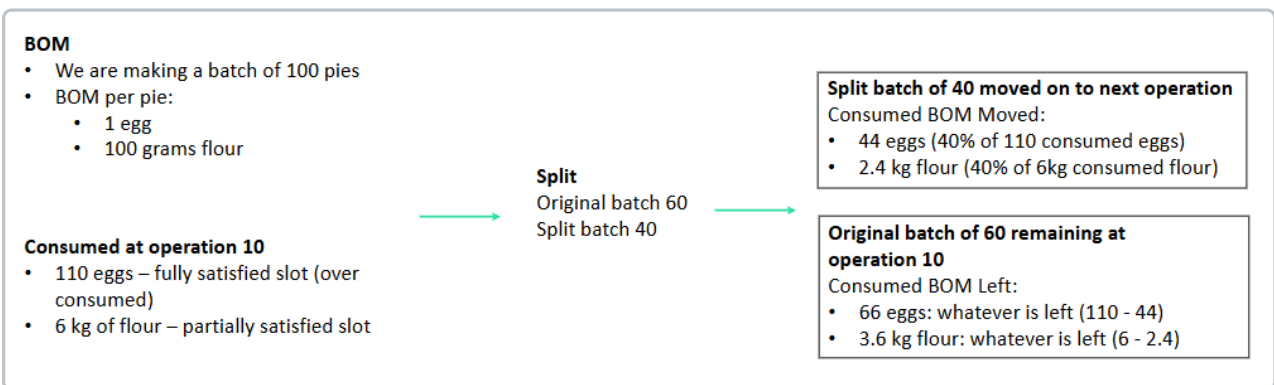
Ratio of BOM

This mode will split the child material in the same proportion as the parent item being split.

$$\text{Split Components} = (\text{Split Qty} \div \text{Batch Quantity}) \times \text{Consumed Components}$$

It would typically be used when a BOM slot of the item being split has been fully satisfied (i.e., the full required quantity components for that slot have already been consumed).

This mode is relevant for explicit splitting and implicit splitting (Pick, Dispatch Use, Remove, Scrap).

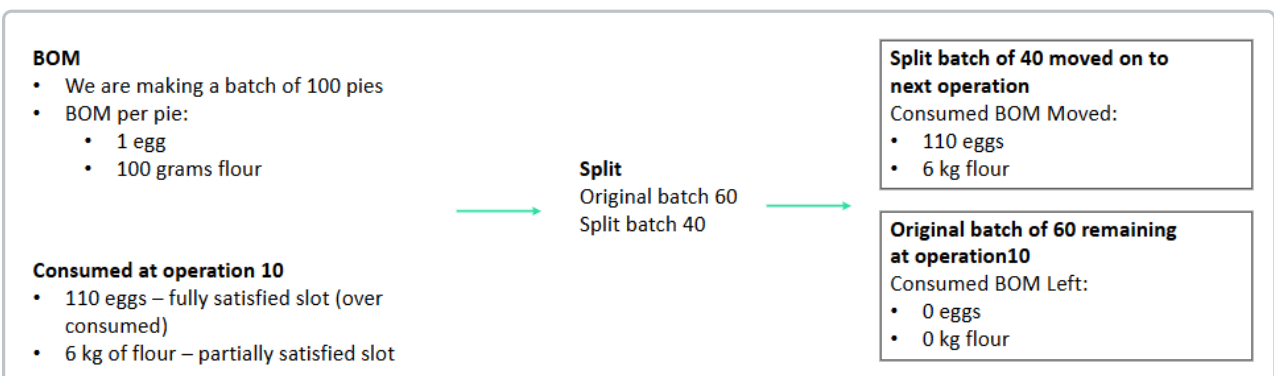


Entire BOM

This mode will transfer all the child material from the original parent item to the spawned split item.

This mode would typically be used when a lot has been partially built and you want to complete the part of the batch that has child material requirements satisfied leaving the remaining quantity with an empty BOM for subsequent material issue.

This mode is relevant for explicit splitting.



Required BOM

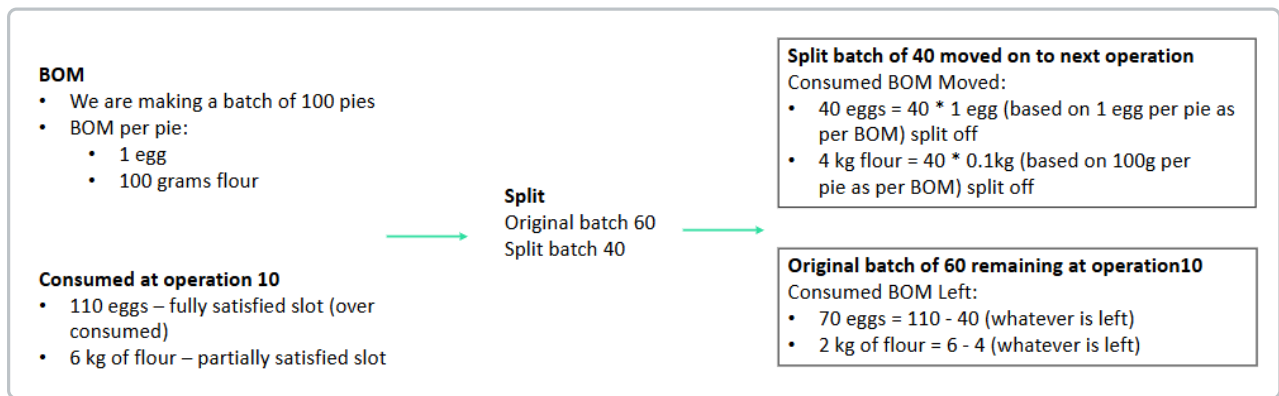
This mode will transfer only the child material required to satisfy the BOM requirements of the newly split off spawned item.

$$\text{Split Components} = \text{Split Quantity} \times \text{Required Quantity per slot}$$

This mode would typically be used when a lot has been partially built and you want to complete the part of the batch that has child material requirements satisfied and where you have consumed more child material than is required for the quantity being completed leaving the remaining child quantity against the original lot.

If you were assembling 100 tables, and had issued 60 table tops to the lot, but needed to complete 50 tables, you would only want 50 table tops to be allocated to the newly spawned split lot, leaving 10 of the consumed table tops against the original.

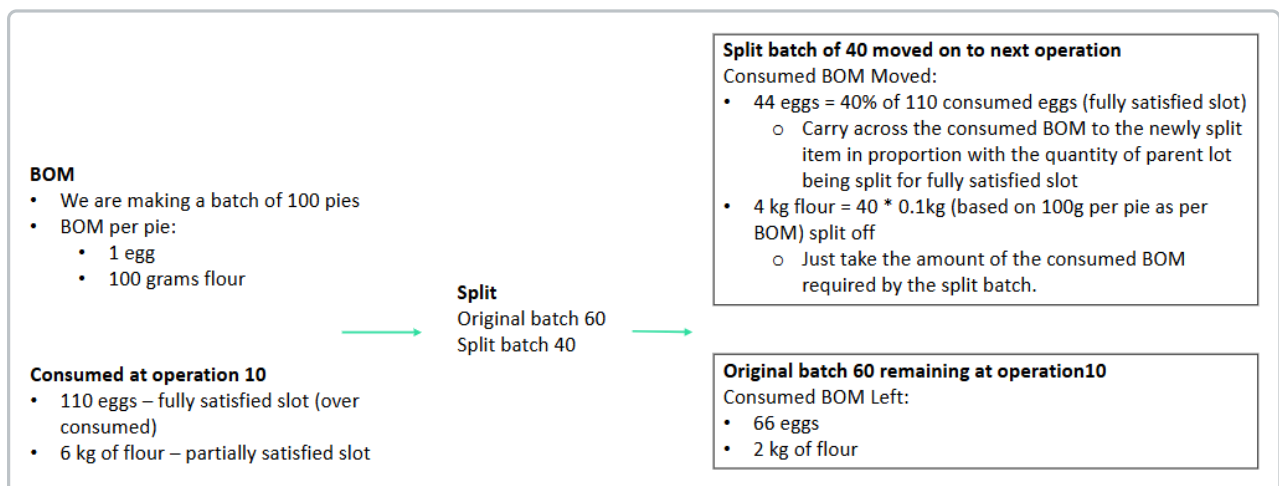
This mode is relevant for explicit splitting.



Slot Satisfaction Based

This mode is used where there are a combination of fulfilled and unfulfilled BOM slots. In this case fully satisfied slots use **Ratio of BOM** mode and partially satisfied slots use **Required BOM** mode. This hybrid approach ensures accurate adjustments while allowing operators to provide exact counts when needed.

This mode is relevant for explicit splitting. Note that this is the mode applied for [WIP Scrap for Partial Quantity](#).



Split BOM Modes applied

For explicit splits, by default, **Ratio of BOM** mode will apply.

For implicit splits, **Ratio of BOM** mode will always apply. (Note grandchild items and below in the BOM hierarchy are always considered implicit splits).

For splits on partial completion, the **Split BOM Mode** is configured in workflow.

Serial Numbers and Unique IDs

When a lot is split, the child lot will be given a new unique ID, but it may retain its visual serial number, or alternatively, it may be given a new serial number.

For implicit splitting, the visual serial number remains unchanged. For explicit splits, it uses the product's configuration. For more information, see [Serial Numbers](#).

Trigger a split

A split can be triggered in the following ways:

- Split with partial operation completion.
- Split via button profile.
- Split via Stock Items.

Split WIP on Partial Op Completion

To split a batch in WIP, the workflow operation must be configured to allow splitting and to define how the split-off item and any child materials will be managed.

In the **Add/Edit Operation** pop-up, the following fields need to be enabled and configured (see [Operation nodes](#) for detailed descriptions of each of the settings):

- **Partial Qty Mode**: Controls whether it is permitted to complete part of the quantity in WIP at the operation.
- **Partial Completion Default Qty**: Default quantity for partial completions.
- **Split BOM Mode**: Determines how you would manage the consumed BOM (child material) of a batch that is being split (see [Split BOM Modes](#) above).

Split via Button Profile

You can split a batch when you're logged onto a job. The **Split WIP Qty** button allows you to perform a split irrespective if the operation was configured to allow splitting or not.

Split via Stock Items

When you split an item/lot, you are given an option for how you want the serial number to be assigned. To split an item:

1. Navigate to **Stock Items**, select the item and click **Split** to display the **Split Item** pop-up.

Split Item screen

Blue fields in the form are required and are flagged with an asterisk () in this document.*

- **Barcode / Serial #**: Displays the serial number of the lot to be split.
- **Current Actual Qty**: Quantity and UOM of the lot to be split.
- **New Item Details**
 - **Barcode / Serial #**: Serial number that will be assigned to the split lot. Options:
 - Leave the field blank to have the serial number autogenerated based on the setup in **Product Configuration**.

- Input a serial number. You can copy in the same serial number of the original item. In this case, the visual serial number of the new spawned item will be the same as the original item, but the ID and unique ID (hidden columns in **Stock Items** screen) of the split-off item will be unique. Note that no validation is run against the serial number pattern you provide here.
- **Location***: Where the split-off item will be located.
- **Quantity*** : Quantity to be split off and the UOM.
- **Comments***: Leave a comment.

You can update the **Unique ID** and **Visual Serial Number** by selecting the stock item and clicking **Edit** .
