

For Smart Factory



Operating |  
User |

# MANUAL



# MES<sup>3D</sup>

ERP + MES + SCADA

Auto & S.I

# User Manual

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## I. Master Pre Manufacturing

### 생산 준비 마스터 작업 지시서 목록

MES KPI PMS QMS MMS Repair Scrap Process

Master Pre Manufacturing

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Name	Order Semi Product	Cutting Tree	Tree Number...	Work Start Date	Work End Date	Target Weight	Actual Weight	Target Qty	Actual Qty	Status
MPMO/00013	Semi-T4C3-(2.0-3.5)-17inch-18K...	Semi-HC-070(6.5)-18K-W-2.10gr...	18K-W-GoldTree	2 05/03/2024 13:46:50	05/03/2024 13:46:50	0.00	372.00	100	20.00	Done
MPMO/00012	Semi-MC-199(3.5X9)-18"-14k-3...		18K-W-GoldTree	1 05/03/2024 12:58:56	05/03/2024 12:58:56	0.00	0.00	100	0.00	Created PMO
MPMO/00011	Semi-T4C3-(2.0-3.5)-17inch-18K...	Semi-HC-070(6.5)-P-18K-W-2.1g...	18K-W-GoldTree	2 04/03/2024 15:29:08	04/03/2024 15:29:08	0.00	0.00	100	0.00	In Progress
MPMO/00010	Semi-T4C3-(2.0-3.5)-VN-17inch...		18K-W-GoldTree	1 04/03/2024 09:20:09	04/03/2024 09:20:09	5,000.00	100,000.00	100	50.00	Done
MPMO/00000	Semi-HC-070(6.5)-P-18K-W-2.1g...	Semi-T4C3-(2.0-3.5)-VN-17inch...	18K-W-GoldTree	1 01/03/2024 15:40:37	01/03/2024 15:40:37	0.00	292.00	100	15.00	Done
MPMO/00000	Semi-HC-070(6.5)-P-18K-W-2.1g...		18K-W-GoldTree	1 29/02/2024 13:52:47	29/02/2024 13:52:47	100.00	62.00	100	10.00	Done
MPMO/00007	S-HC-070(6.5)-18K-W-2.10gr-1.2...	S-HC-070(6.5)-18K-W-2.10gr-1.2...	Silver TREE CUTTING	6 28/02/2024 16:59:44	28/02/2024 16:59:44	0.00	60.00	100	6.00	Done
MPMO/00000			14K-W-GoldTree	4 28/02/2024 15:48:25	28/02/2024 15:48:25	0.00	0.00	100	0.00	Order
MPMO/00003	Semi-T4C3-(2.0-3.5)-VN-17inch...	Semi-HC-070(6.5)-P-18K-W-2.1g...	18K-W-GoldTree	3 28/02/2024 15:28:44	28/02/2024 15:28:44	0.00	442.00	100	20.00	Done
MPMO/00002	Semi-T4C3-(2.0-3.5)-VN-17inch...	Semi-HC-070(6.5)-P-18K-W-2.1g...	18K-W-GoldTree	2 28/02/2024 14:44:45	28/02/2024 14:44:45	0.00	0.00	100	0.00	In Progress
MPMO/00001	Semi-T4C3-(2.0-3.5)-VN-17inch...		18K TREE CUTTING	1 28/02/2024 09:37:52	28/02/2024 09:37:52	1000.00	0.00	100	0.00	In Progress

실행 순서 & 기능 :

1. 검색 기능.
2. 생산 준비 마스터 작업 지시서 목록 표시.
3. 엑셀로 다운로드 기능.
4. "Create" 버튼을 눌러 신규 작업 지시서 생성.



## I. Master Pre Manufacturing

### 신규 생산 준비 마스터 작업 지시서 생성

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number

Master Pre Manufacturing / New

Save Discard

Confirm Cancel

Draft Order Created PMO In Progress Done

MPMO #

Semi Cutting Tree

Target/Actual Weight  / 0.00

Tree Number:

Work Date  →

Target/Actual Qty  / 0

Created Date

Order PMO

Print Labels

Product	Number	MMO #	MMO Qty	Target Qty	UoM	Balance Qty	Remark

실행 순서 & 기능 :

1. 관련 정보 입력 :

\_ Tree Number 제작할 트리의 일일 일련번호 지정(미 입력 시 1부터 순차적으로 자동 입력)

\_ Semi Cutting Tree 제작할 트리 종류 지정

\_ Work Date 작업 일자

\_ Target/Actual Weight 목표/실제 중량

2. "Save" 버튼을 눌러 저장.

3. "Confirm" 버튼을 눌러 승인.



## I. Master Pre Manufacturing

### 트리에 작업될 제품의 수량 입력

The screenshot shows the 'Recast' window in the PMS. It includes a table of transfer records, a 'Confirm' button, and a 'Recast List' table. Numbered callouts indicate the following steps:

1. Order PMO button
2. Product table with columns: Product, Number, MMO #, MMO Qty, Target Qty, UoM, Balance Qty, Remark.
3. Recast List button
4. Confirm button (1 selected)
5. Complete button

Transfer	Created on	Product	Lot/Serial Number	From	To	Done	Status...
<input checked="" type="checkbox"/>	03/28/2024 16:55:05	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.1L	T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-PLI...	WH/REC	WH/Fac1/Metal Tree	25.50	Done

Product	Number	MMO #	MMO Qty	Target Qty	UoM	Balance Qty	Remark
SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12	0		0	10	pcs	0.00	

실행 순서 & 기능 :

1. "Order" 탭에서 생산될 트리에 작업될 각 제품의 정보 표시.
2. 관련 정보 입력 :  
 \_ Product 제품 코드(Semi)  
 \_ Number 트리 안의 작업 번호  
 \_ MMO# MMO 번호(있을 시)  
 \_ Target Qty 목표 수량
3. "Recast List" 버튼을 눌러 미별 제품 팝업 오픈.
4. 등록된 미별 제품을 선택하고 "Confirm" 버튼을 눌러 확정.
5. "Complete" 버튼을 눌러 제품 등록 완료.



## I. Master Pre Manufacturing

### PMO(생산 준비 공정 작업 지시서) 설정

실행 순서 & 기능 :

1. “PMO” 탭에서 진행, 생산 준비 공정 작업 지시서는 “Order” 탭 완료 후 설정된 Process에 따라 자동으로 발행됨. 각 작업 지시서는 1개의 공정에 대응하며, PMO 목록에 자동으로 등록됨.
2. 관련 정보 선택 :
  - \_ PQC Form PQC 양식 지정
  - \_ Item QC Item QC 필요 공정 선택
  - \_ PQC Check PQC 필요 공정 선택
  - \_ Disposal 잔량 금 자재 반납 필요 공정 선택
3. “add” 버튼을 눌러 해당 공정에 필요한 자재 입력창 오픈.
4. 필요 자재 입력 후 “Confirm” 버튼을 눌러 승인.
5. “Complete” 버튼을 눌러 완료.

Master Pre Manufacturing

PMO # PMO/00052  
Process Wax Tree

Material  
WaxResin  
Add a line

Confirm Close

1 Order PMO

Reference	Process	Source Location	Destination Location	PQC Form	Item QC	PQC Check	Disposal	Actual Weight	Actual Qty	Material	Status	
PMO/00052	Wax Tree	WH/Fac1/Wax Tree	WH/Fac1/Metal Tree	PQC Form				0.00	0	WaxResin	Draft	+ add
PMO/00053	Metal Tree	WH/Fac1/Metal Tree	WH/Fac1/Metal Tree Cutting	PQC Form				0.00	0	18K-W-GoldBar	Draft	+ add
PMO/00054	Metal Tree Cutting	WH/Fac1/Metal Tree Cutting	WH/Fac1/HM	PQC Form		✓	✓	0.00	0		Draft	+ add

2

3

4

5 Complete



## II. PMO (Pre Manufacturing Order)

### PMO(생산 준비 공정 작업 지시서) 수행

Order **PMO**

Reference	Process	Source Location	Destination Location	PQC Form	Item QC	PQC Check	Disposal	Actual Weight	Actual Qty	Material	Status
PMO/00034	Wax Tree	WH/Fac/Wax Tree	WH/Fac/Metal Tree	PQC Form	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	0.00	0.00	WaxResin	Draft
PMO/00035	Metal Tree	WH/Fac/Metal Tree	WH/Fac/Cutting	PQC Form	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	0.00	0.00	18K-W-GoldBar	Draft
PMO/00036	Metal Tree Cutting	WH/Fac/Cutting	WH/Fac/HM	PQC Form	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	0.00	0.00		Draft

Master Pre Manufacturing / MPMO/00014 / PMO/00034

1/1 < >

PMO # PMO/00034 Source Document MPMO/00014

PQC Form PQC Form | Process Wax Tree

Semi Cutting Tree 18K-W-GoldTree Work Date 06/03/2024 10:04:48 → 06/03/2024 10:04:48

Location WH/Fac/Wax Tree → WH/Fac/Metal Tree Target/Actual Qty 1.00 / 0.00 pcs

Target/Actual Weight 1.00 / 0.00 g

Order	Item	Standby	Operation			
MPMO #	Product	Number	MMO #	MMO Qty	Target Qty	UoM
MPMO/00014	Semi-T4C3-(20-3.5)-VN-17inch-18k-25.02g-w-12 pcs-5.12ct	5		0.00	500.00	pcs

실행 순서 & 기능 :

1. 목록에서 수행할 PMO 선택.

2. 관련 정보 입력 :

\_ PQC Form PQC 검사 양식

\_ Work Date 작업 시간

\_ Target/Actual Weight 목표/실제 중량

3. "Save" 버튼을 눌러 저장.

4. "Confirm" 버튼을 눌러 승인.



## II. PMO (Pre Manufacturing Order)

### 공정에 투입될 자재 입력

실행 순서 & 기능 :

1. "Item" 탭에서 진행.
2. 자재 정보 표시.
3. "Check" 버튼을 눌러 투입될 자재의 정보 입력창 오픈.
4. 관련 정보 입력 :  
\_ Lot No 로트 코드  
\_ Received Weight 입고 중량
5. "Confirm" 버튼을 눌러 승인.

**Receive Item** x

MPMO/PMO: MPMO/00014 / PMO/00034      Process: Wax Tree

Product: SEMI-18K-W-GoldTree-WAX-20240306111639      Target Weight: 1.00

Item	Lot No	From	Stock Qty	Received Weight	UoM	Confirmation Date
WaxResin	LOT WAXRESIN	WH/Fac1/Wax Tree	9,986.00	100	g	06/03/2024 13:29:17

**Confirm** Close

PQC Form: PQC Form      Process: Wax Tree

Semi Cutting Tree: 18K-W-GoldTree      Work Date: 06/03/2024 10:04:48 → 06/03/2024 10:04:48

Location: WH/Fac1/Wax Tree → WH/Fac1/Metal Tree      Target/Actual Qty: 100 / 0.00 pcs

Target/Actual Weight: 100 / 0.00 g

Order **Item** Standby Operation

Item	Lot No	From	Stock Qty	Received Weight	UoM	Confirmation Date	Status
WaxResin	LOT WAXRESIN	WH/Fac1/Wax Tree	9,986.00	100	g	06/03/2024 13:29:17	Done

**Check**



## II. PMO (Pre Manufacturing Order)

공정에 투입되는 직원, 기계, 몰드 정보 등록

실행 순서 & 기능 :

1. “Standby” 탭에서 진행.
2. 관련 정보 입력 :  
 \_ Step 세부 공정 명  
 \_ Name/Code 명칭/코드  
 \_ Start Date 작업 시작 일자  
 \_ End Date 작업 종료 일자
3. “Save” 버튼을 눌러 저장.

Master Pre Manufacturing / MPMO/00023 / PMO/00052

1/1 < >

Draft **In Progress** Done

PMO #	PMO/00052	Source Document	MPMO/00023
PQC Form	PQC Form	Process	Wax Tree
Semi Cutting Tree	18K-W-GoldTree	Work Date	04/04/2024 08:39:23 → 04/04/2024 08:39:23
Location	WH/Fac/Wax Tree → WH/Fac/Metal Tree	Target/Actual Qty	1 / 0 pcs
Target/Actual Weight	100 / 000 g		

Order Item **Standby** Operation

Step	Name/Code	Start Date	End Date	Before Weight	After Weight	Status
Wax tree - Man	Đào Thành Đặng X	04/04/2024 08:52:16			0.00	Not Yet
Add a line						

3

1

2



## II. PMO (Pre Manufacturing Order)

### 작업 전/후 실제 중량 입력

실행 순서 & 기능 :

1. "Before & After" 버튼을 눌러 작업 전/후 중량 입력창 오픈.
2. 전자 저울과 연동하여 중량 값 입력.
3. "Confirm" 버튼을 눌러 승인.

MPMO # MPMO/00010

PMO # PMO/00033

Operation & Level Wax Tree & Level 1

Product SEMI-18KWGOLDTREE-WAX

Before Uom pcs

After Uom pcs

Step Count 1

Level	Step	Staff	Before Weight	Record Date	After Weight	Record Date
1	Wax Tree	Nguyễn Hoàng Cần	0.00		0.00	

Confirm
Close

Target/Actual Weight  /0.00 g

Order Item **Standby** Operation

Step	Name/Code	Start Date	End Date	Before Weight	After Weight	Status
Wax tree - Man	Đào Thành Đình	04/04/2024 08:52:16			0.00	Not Yet

Add a line

2

3

Before & After

1



## II. PMO (Pre Manufacturing Order)

### 작업 후 실제 중량과 수량 입력

실행 순서 & 기능 :

1. "Operation" 탭에서 진행. 실제 중량과 수량 값은 자동으로 전 단계에서 입력한 값이 표시됨.
2. "Actual" 버튼을 눌러 수정 가능.
3. 실제 중량, 실제 수량, 양품 수량, 불량 수량 수정 가능.
4. "Confirm" 버튼을 눌러 승인.

Actual
✕

MPMO/PMO	MPMO/00023 / PMO/00052	Process	Wax Tree
Product	SEMI-18K-W-GoldTree-WAX-20240404085109	Target/Actual Weight	1.00 / 0.00 g

Actual
Item

Product	Actual Weight	UoM	Actual Qty	UoM	Confirm Date	Status
SEMI-18K-W-GoldTree-WAX-20240404085109	500.00	g	1	pcs		Waiting for Lot

Confirm
Close

Order
Item
Standby
Operation

Actual
Lot
Print labels

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
SEMI-18K-W-GoldTree-WAX-20240404085109	500.00	g	1	pcs			Waiting for Lot



## II. PMO (Pre Manufacturing Order)

### 공정 완료된 제품의 품질 검사

실행 순서 & 기능 :

1. "PQC" 버튼을 눌러 검사 실행.
2. 해당 항목 선택.
3. 검사 결과 입력.
4. "Submit" 버튼을 눌러 완료.

**Quality Checks Popup**

MMO #	MO #	Product	QC Form	Lot Qty	Not Yet
MPMO/00014	PMO/00034	SEMI-18K-W-GoldTree-WAX-2024030611639	PQC Form	1	1

No	Actual Qty	Create Date	Status
1	500	2024-03-06 06:29:17	Not Yet

Staff	OK g	NG g	OK pcs	NG pcs	Date	Judgement
my	495	5	1		06/03/24	OK

QC Type	QC Process	QC Code	Method	Frequency	Input	Judgement
Visual PQC	PQC	Missing Wax	By eyes	Check All	5	OK
Visual PQC	PQC	Unformed	By eyes	Check All	0	OK
Visual PQC	PQC	Unformed Bezel/Component	By eyes	Check All	0	OK
Visual PQC	PQC	Bubble/Crack/Deform	By eyes	Check All	0	OK
Visual PQC	PQC	Burr/ Water drop	By eyes	Check All	0	OK
Visual PQC	PQC	Poor Workmanship Soldering/Filing	By eyes	Check All	0	OK
Visual PQC	PQC	Over grinding	By eyes	Check All	0	OK
Visual PQC	PQC	Others	By eyes	Check All	0	OK

**SUBMIT**
**CLOSE**

Target/Actual Weight    100 / 000 g

Order   Item   Standby   **Operation**

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
SEMI-18K-W-GoldTree-WAX-2024030611639	500.00 g		100	pcs		06/03/2024 14:13:49	Waiting for QC

**QC**
Actual
Print labels



## II. PMO (Pre Manufacturing Order)

### 공정 완료된 제품의 Lot code 발행

실행 순서 & 기능 :

1. "Lot" 버튼을 눌러 발행.
2. "Create" 버튼을 눌러 로트 발행.
3. "Print labels"을 눌러 QR 인쇄.

MPMO/PMO
MPMO/00025 / PMO/00055
Process
Wax Tree

Product
SEMI-18K-W-GoldTree-WAX-20240404090426
Lot Qty
2

Create
Close

PMO #	PQC Form	Process	Wax Tree
Semi Cutting Tree	18K-W-GoldTree	Work Date	04/04/2024 09:03:51 → 04/04/2024 09:03:51
Location	WH/Fac/Wax Tree → WH/Fac/Metal Tree	Target/Actual Qty	1 / 0 pcs
Target/Actual Weight	1.00 / 0.00 g		

Order
Item
Standby
Operation

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
SEMI-18K-W-GoldTree-WAX-20240404090426	500.00 g		1 pcs			04/04/2024 09:04:56	Waiting for Lot

Actual
Lot
Print labels

2

1

3



## II. PMO (Pre Manufacturing Order)

### 불량 판정 제품의 수리 참고 이동

실행 순서 & 기능 :

1. "Return NG" 버튼을 눌러 진행.
2. "Confirm" 버튼을 눌러 수리 참고 이동 승인.

**Return NG** x

MPMO/PMO	MPMO/00025 / PMO/00055	Process	Wax Tree
Target/Actual Weight	1.00 / 500.00 g	Target/Actual Qty	1 / 1 pcs
Product	SEMI-18K-W-GoldTree-WAX-20240404090426		
		Create as 1 Return Order	<input type="checkbox"/>

Lot/Serial Number	Return Order	From	To	Actual Weight	UoM	Actual Qty	UoM
WAX-5.0g-Opcs-240404-001		WH/Fac1/Wax Tree		5.00 g		0 pcs	

**Confirm**
Close

Order Item Standby **Operation**

1 **Return NG**
**Print labels**

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
SEMI-18K-W-GoldTree-WAX-20240404090426	500.00 g		1 pcs		WAX-495.0g-1pcs-240404-001 WAX-5.0g-Opcs-240404-001	04/04/2024 09:04:56	<span style="background-color: #28a745; color: white; padding: 2px 5px;">Done</span>



## II. PMO (Pre Manufacturing Order)

### Disposal 진행(금 잔량 반납)

실행 순서 & 기능 :

1. "Disposal" 버튼을 눌러 진행.
2. 입고된 금 트리 중량 - 커팅된 제품 중량이 표시. "R" 버튼을 눌러 MES > MMS > Recasting List로 잔량 이동.
3. "Close" 버튼을 눌러 창 닫기.
4. "Complete" 버튼을 눌러 해당 MPMO 완료.

Disposal
✕

MPMO/PMO: MPMO/00132 / PMO/00456      Process: Metal Tree Cutting

Product: 18K-W-GoldTree      Target/Actual Weight: 1.00 / 15.00 g

Item	From	Lot Code	Received Weight	UoM	Used Qty	Remain Qty	Remark	
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612152527	WH/Fac1/Metal Tree Cutting	CAS_TRE-21.52g-240612-001	21.52 g		15.00	6.52	Input	F R

MES KPI

Master Pre Manuf

Save    Close

Save    Discard

Cancel    Complete

1/1 < >

Draft    In Progress    Done

PMO #	PMO/00456	Source Document	MPMO/00132
PQC Form	PQC Form	Process	Metal Tree Cutting
Semi Cutting Tree	18K-W-GoldTree	Work Date	06/12/2024 15:08:56 → 06/12/2024 15:08:56
Location	WH/Fac1/Metal Tree Cutting → WH/Fac1/HM	Target/Actual Qty	20 / 20 pcs
Target/Actual Weight	1.00 / 15.00 g		

Order    Item    Standby    **Operation**

1    Disposal    Return NG    Print labels

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	15.00 g		20 pcs		HC-070(6.5)-18K-W-2.10gr-1.20-...	06/12/2024 15:28:03	Done



## III. Alloy

### 합금 작업 지시서 목록

MMO#	MO#	FG Product	Product Code	Process	Scheduled Date	Origin Qty	Target Weight	Actual OK Weight	Status	Created by	Created on
	MQ/00172	18K-W-GoldBar		Alloy	06/03/2024 10:10:58	0.00	1,000.00	997.00	Done	Administrator	06/03/2024 10:11:26
	MQ/00151	Silver Alloy		Alloy	05/03/2024 13:03:46	0.00	0.00	0.00	In Process	Administrator	05/03/2024 13:03:51
	MQ/00145	18K-W-GoldBar		Alloy	04/03/2024 18:52:23	0.00	0.00	0.00	In Process	Administrator	04/03/2024 18:52:34
	MQ/00144	18K-W-GoldBar		Alloy	04/03/2024 18:48:07	0.00	0.00	0.00	In Process	Administrator	04/03/2024 18:48:16
	MQ/00143	18K-W-GoldBar		Alloy	04/03/2024 18:42:07	0.00	100.00	0.00	In Process	Administrator	04/03/2024 18:42:18
	MQ/00142	18K-W-GoldBar		Alloy	04/03/2024 18:00:43	0.00	250.20	325.00	Done	Administrator	04/03/2024 18:00:58
	MQ/00131	18K-W-GoldBar		Alloy	04/03/2024 14:40:04	0.00	100.00	98.00	Done	Administrator	04/03/2024 14:40:22
	MQ/00099	18K-Y-GoldBar		Alloy	01/03/2024 12:57:55	0.00	1,000.00	1,326.60	In Process	Administrator	01/03/2024 12:58:28
	MQ/00058	Silver Alloy		Alloy	29/02/2024 12:54:24	0.00	1,000.00	100.00	In Process	Administrator	29/02/2024 12:54:30
	MQ/00057	Silver Alloy		Alloy	29/02/2024 12:53:25	0.00	1,000.00	0.00	In Process	Administrator	29/02/2024 12:53:32
	MQ/00054	18K-W-GoldBar		Alloy	29/02/2024 12:41:07	0.00	100.00	99.00	Done	Administrator	29/02/2024 12:41:25
	MQ/00053	Silver Alloy		Alloy	29/02/2024 12:34:33	0.00	1,000.00	500.00	In Process	Administrator	29/02/2024 12:35:01
	MQ/00051	18K-W-GoldBar		Alloy	29/02/2024 12:34:04	0.00	100.00	99.00	Done	Administrator	29/02/2024 12:34:28
	MQ/00048	14K-W-GoldBar		Alloy	29/02/2024 09:44:08	0.00	1,000.00	100.00	Done	Administrator	29/02/2024 09:44:18
	MQ/00047	18K-W-GoldBar		Alloy	29/02/2024 09:21:48	0.00	100.00	99.00	Done	Administrator	29/02/2024 09:22:07
	MQ/00046	18K-W-GoldBar		Alloy	29/02/2024 09:10:35	0.00	1,000.00	998.00	Done	Administrator	29/02/2024 09:11:41
	MQ/00023	18K-W-GoldBar		Alloy	28/02/2024 14:21:57	0.00	1,000.00	1.00	Done	Administrator	28/02/2024 14:22:10
	MQ/00021	18K-W-GoldBar		Alloy	28/02/2024 14:03:41	0.00	1,000.00	996.00	Done	Administrator	28/02/2024 14:04:21
	MQ/00010	18K-W-GoldBar		Alloy	28/02/2024 10:53:02	0.00	1,000.00	999.00	Done	Administrator	28/02/2024 10:53:13

실행 순서 & 기능 :

1. 검색 기능.
2. 합금 작업 지시서 목록 표시.
3. 엑셀로 다운로드 기능.
4. "Create" 버튼을 눌러 신규 작업 지시서 생성.



## III. Alloy

### 합금 작업 지시서 생성

실행 순서 & 기능 :

1. 관련 정보 입력 :

\_ Product 합금 종류 지정

\_ BOM 해당 합금의 BOM version 지정

\_ Target / Actual Weight 목표/실제 중량

\_ Work Date 작업 일자

2. “Confirm” 버튼을 눌러 승인.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number

Alloy / New

Save Discard

Confirm 2 Draft In Progress Done

WO List

Product 18K-W-GoldBar Process & Level

BOM 18K-W-GoldBar - AU9999-LUX105 Created Date

Target / Actual Weight 1000 / 0.00 g Work Date 06/12/2024 08:00:00 → 06/12/2024 20:00:00

OK / NG Weight 0.00 / 0.00 g Line

Location →

Item Standby Operation

Item	Lot No	From	Stock Qty	Estimate	Received Weight	OK Weight	NG Weight	UoM	Confirmation Date
------	--------	------	-----------	----------	-----------------	-----------	-----------	-----	-------------------



## III. Alloy

### 투입 자재 입력

실행 순서 & 기능 :

1. "Item" 탭에서 진행.
  2. BOM에 등록되어 있는 자재 표시.
  3. "Check" 버튼을 눌러 입고 자재 정보창 오픈.
  4. 관련 정보 입력 :  
\_ Lot No 로트 코드  
\_ Received Weight 입고 중량  
\_ Received Qty 입고 수량
  5. "Confirm" 버튼을 눌러 승인.
- \*\* "Estimate" 칼럼은 Target 중량 대비 필요한 금과 알로이의 예상치를 표시.

Receive Item
✕

MMO#		Product	18K-W-GoldBar
MO#	MO/01175	Target Weight	1,000.00 g
Process & Level	Alloy & Level 0	Target Qty	1.00 pcs

Item	Lot No	From	Stock Qty	Received Weight	UoM	Confirmation Date
ALY-LUX105-18K/14K-W	ALY-LUX105-18...	WH/Fac1/Alloy	502.78	250.00 <span style="border: 1px solid red; padding: 2px;">Input</span>	g	
AU9999	aaaa	WH/Fac1/Alloy	2,250.00	750.00 <span style="border: 1px solid red; padding: 2px;">Input</span>	g	

MES
3

Alloy / MO/

Save
Confirm
Close

Cancel
Complete MO
Draft
In Progress
Done

Product
18K-W-GoldBar
Process & Level
Alloy & Level 0

BOM	18K-W-GoldBar - AU9999-LUX105	Created Date	06/12/2024 16:21:14
Target / Actual Weight	1,000.00 / 0.00 g	Work Date	06/12/2024 08:00:00 → 06/12/2024 20:00:00
OK / NG Weight	0.00 / 0.00 g	Line	

Location	WH/Fac1/Alloy → WH/Fac1/Metal Tree
----------	------------------------------------

Item
Standby
Operation
Setting
Check

Item	Lot No	From	Stock Qty	Estimate	Received Weight	OK Weight	NG Weight	UoM	Confirmation Date	Status
ALY-LUX105-18K/14K-W		WH/Fac1/Alloy	0.00	250.00	0.00	0.00	0.00 g			Waiting for Check Qty
AU9999		WH/Fac1/Alloy	0.00	750.00	0.00	0.00	0.00 g			Waiting for Check Qty



### III. Alloy

#### 공정 수행 직원 및 작업 전/후 실제 중량 입력

Before & After
✕

MMO#		Product	18K-W-GoldBar
MO#	MO/01175	Step Count	1
Process & Level	Alloy & Level 0		

Level	Step	Staff	Before Weight	Record Date	After Weight	Record Date	Gap
1	Alloy - Man	Huỳnh Văn Trĩa	1,000.00 <span style="color: red;">Input</span>	06/12/2024 16:35:12	999.00 <span style="color: red;">Input</span>		0.00

Save
Confirm
Close

Product: 18K-W-GoldBar

BOM: 18K-W-GoldBar - AU9999-LUX105

Target / Actual Weight:  / 0.00 g

OK / NG Weight: 0.00 / 0.00 g

Location: WH/Fac1/Alloy → WH/Fac1/Metal Tree

Process & Level: Alloy & Level 0

Created Date: 06/12/2024 16:21:14

Work Date:  →

Line:

Item 1 Standby
Operation
Setting

3 Before & After

Level	Step	Name/Code	Start Date	End Date	Before Weight	After Weight	Gap	Check Status
1	Alloy - Man	Huỳnh Văn Trĩa	06/12/2024 16:21:15		1,000.00	0.00	0.00	Not Yet

Add a line

실행 순서 & 기능 :

1. "Standby" 탭에서 진행.
2. 관련 정보 입력 :
  - \_ Step 세부 공정
  - \_ Name/Code 명칭/코드
  - \_ Start Date 시작 일자
  - \_ End Date 종료 일자
3. "Before & After" 버튼을 눌러 작업 전/후 중량 입력창 오픈.
4. 전자 저울과 연동하여 중량 값 입력.
5. "Confirm" 버튼을 눌러 승인.



### III. Alloy

#### 작업 후 실제 중량과 수량 입력

실행 순서 & 기능 :

1. "Operation" 탭에서 진행. 실제 중량과 수량 값은 자동으로 전 단계에서 입력한 값이 표시됨.
2. "Actual" 버튼을 눌러 수정 가능.
3. 실제 중량, 실제 수량, 양품 수량, 불량 수량 수정 가능.
4. "Confirm" 버튼을 눌러 승인.
5. "Detail" 버튼을 눌러 로트 발행.

**Actual**

MMO# | Process & Level | Alloy & Level O  
 MO# | Target / Actual Weight | 200.00 / 100.00 g  
 Product | Can Be Produced Weight | 18K-W-GoldBar | 266.666 g

No	Actual Weight	OK Weight	NG Weight	Created on	Status
1	100.00	100.00	0.00	04/04/2024 09:17:44	Waiting for Lot

Product: 18K-W-GoldBar

Target / Actual Weight: 200.00 / 100.00 g

OK / NG Weight: 100.00 / 0.00

Location: [Confirm] [Close]

Item Standby **Operation** Setting

No	Actual Weight	OK Weight	NG Weight	Created on	Status
1	105.00	100.00	5.00	04/04/2024 09:17:44	Waiting for Lot



## III. Alloy

### 제품의 Lot code 발행

실행 순서 & 기능 :

1. "OK" 탭에서 진행.
2. "Lot" 버튼을 눌러 팝업 오픈.
3. "Create" 버튼을 눌러 Lot 발행.

**Create Lot**

Alloy / MO/00192 / 2

Target / Actual Weight | 105.00 / 0.00 g

OK / NG Weight | 100.00 / 5.00 g

Product | 18K-W-GoldBar

BOM | 18K-W-GoldBar - AU9999-FLEXIA162

Work Date | 04/04/2024 09:17:44

Process & Level | Alloy & Level 0

Target / Actual Weight | 105.00 / 0.00 g

OK / NG Weight | 100.00 / 5.00 g

OK NG

Lot

To	Lot/Serial Number	Weight	Created on	State



## III. Alloy

### 합금 작업 지시서 완료

실행 순서 & 기능 :

1. “Complete MO” 버튼을 눌러 합금 작업 지시서 수행 완료.

Alloy / MO/00192 / 2 / MO/00192

Edit + Create Action 1/1 < >

Cancel Complete MO 1 Draft In Progress Done

Shipping 1 WO List

Product	18K-W-GoldBar	Process & Level	Alloy & Level O
BOM	18K-W-GoldBar - AU9999-FLEXIA162	Created Date	04/04/2024 09:17:42
Target / Actual Weight	200.00 / 105.00 g	Work Date	04/04/2024 08:00:00 → 04/04/2024 20:00:00
OK / NG Weight	100.00 / 5.00 g	Line	
Location	WH/Fac/Alloy → WH/Fac/Metal Tree		

Item Standby Operation Setting

Actual

No	Actual Weight	OK Weight	NG Weight	Created on	Status	
1	105.00	100.00	5.00	04/04/2024 09:17:44	Done	Detail



## IV. Rubber Mold

### 고무 몰드 작업 지시서 조회

실행 순서 & 기능 :

1. 기 발행된 고무 몰드 작업 지시서 현황 표시.
2. "Create" 버튼을 눌러 신규 작업 지시서 생성.

MMO#	MO# ▲	FG Product	Product Code	Process	Scheduled Date	Origin Qty	Target Weight	Actual OK Weight	Status	Created by	Created on
<input type="checkbox"/>	MO/00199	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/04/2024 11:18:35	0.00	200.00	0.00	Draft	my	04/04/2024 11:18:51
<input type="checkbox"/>	MO/00189	R-HC-070(6.5)-18K-W-210gr-120+1	R-HC-070(6.5)-18K-W-210gr-120+1	Rubber	04/04/2024 08:00:42	0.00	0.00	10.00	In Progress	KHC	04/04/2024 08:08:16
<input type="checkbox"/>	MO/00142	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/03/2024 10:07:33	0.00	0.00	0.00	In Progress	Administrator	04/03/2024 10:07:37
<input type="checkbox"/>	MO/00136	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/03/2024 08:53:34	0.00	0.00	15.00	Done	Administrator	04/03/2024 08:53:41
<input type="checkbox"/>	MO/00135	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/03/2024 08:50:59	0.00	0.00	30.00	Done	Administrator	04/03/2024 08:51:06
<input type="checkbox"/>	MO/00134	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/03/2024 08:47:24	0.00	0.00	0.00	In Progress	Administrator	04/03/2024 08:47:28
<input type="checkbox"/>	MO/00133	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/03/2024 08:44:15	0.00	0.00	0.00	In Progress	Administrator	04/03/2024 08:44:25
<input type="checkbox"/>	MO/00123	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/02/2024 16:38:06	0.00	0.00	10.00	Done	Administrator	04/02/2024 16:38:09
<input type="checkbox"/>	MO/00122	R-TN-1160-20+1	R-TN-1160-20+1	Rubber	04/02/2024 16:35:19	0.00	0.00	0.00	Cancelled	Administrator	04/02/2024 16:35:46
<input type="checkbox"/>	MO/00033	R-TB-FQ(LT)-082+1	R-TB-FQ(LT)-082+1	Rubber	03/29/2024 13:58:36	0.00	5.00	5.00	Done	Administrator	03/29/2024 13:59:06





## IV. Rubber Mold

### 공정에 사용되는 자재 및 은 원본 등록

실행 순서 & 기능 :

1. "Item" 탭에서 해당 공정에 사용되는 자재 및 은 원본 정보 등록.
2. "Check" 버튼을 눌러 해당 아이템의 Lot, 중량 및 수량 입력.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report KPI Dashboard TV

Rubber Mold / MO/00202

Save Discard 1/1 < >

Cancel Complete MO Draft In Progress Done

WO List

Product Mold Model: R-TN-1160-20  
 Product: R-TN-1160-20+1  
 Item QC / PQC Form: Item QC Form /  
 Target / Actual Weight: 100 / 0.00 g  
 OK / NG Weight: 0.00 / 0.00 g  
 Location: WH/Fac1/Mockup → WH/Mold

Process & Level: Rubber & Level 0  
 Target / Actual Qty: 100 / 0.00 pcs  
 OK / NG Qty: 0.00 / 0.00 pcs  
 Created Date: 04/04/2024 12:35:15  
 Work Date: 04/04/2024 08:00:00 → 04/04/2024 20:00:00  
 Line:

Item Standby Operation Setting

1

Item	Lot No	From	Stock Qty	Received Weight	OK Weight	NG Weight	UoM	Received Qty	OK Qty	NG Qty	UoM	Confirmation Date	Status	Only Check	
<input type="checkbox"/>	Rubber Resin	Rubber Resin Manual	WH/Fac1/Mockup	999,984.00	100	0.00	0.00 g	100	0.00	0.00	pcs	04/04/2024 12:35:16	Done	<input type="checkbox"/>	
<input type="checkbox"/>	S-T4C3-(20-3.5... S-T4C3-(20-3.5)-171...	WH/Fac1/Mockup	15.00	0.00	0.00			100	0.00	0.00	pcs		Waiting for Check Qty	<input checked="" type="checkbox"/>	

Add a line

2 Check



## IV. Rubber Mold

공정에 사용되는 자재 및 은 원본 정보 입력

실행 순서 & 기능 :

1. 고무 몰드 생산에 투입되는 자재 및 은 원본의 중량과 수량 입력.
2. “Confirm” 버튼을 눌러 승인.

**Receive Item**

MMO#  
MO# MO/00202  
Process & Level Rubber & Level 0

Product R-TN-1160-2.0+1  
Target Weight 1.00 g  
Target Qty 1.00 pcs

Item	Lot No	From	Stock Qty	Received Weight	Uo.	Received Qty	Uo.	Confirmation Date
Rubber Resin	Rubber Resin Manual	WH/Fac1/Mocku...	999,984.00	100 <b>input</b> g		100 pcs		04/04/2024 12:35:16
S-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12...	S-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12+2-C...	WH/Fac1/Mocku...	15.00	100 <b>input</b> g		100 pcs		

**Confirm** **Close**



## IV. Rubber Mold

### 공정에 투입되는 직원 정보 등록

실행 순서 & 기능 :

1. "Standby" 탭에서 진행.
2. 몰드 작업 담당자 지정.
3. "Complete" 버튼을 눌러 완료.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number

Rubber Mold / MO/01196

Save Discard 1/1

Cancel Complete MO Draft In Progress Done

Product Mold Model R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT Process & Level Rubber & Level U

Product R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT+1 Target / Actual Qty 2.00 / 2.00

Item QC / PQC Form Item QC Form / OK / NG Qty 0.00 / 0.00

Location WH/Fac1/Mockup → WH/Mold Created Date 06/13/2024 14:12:51

Work Date 06/13/2024 08:00:00 → 06/13/2024 20:00:00

Line

1 Standby Operation Setting 3 Complete

Level	Step	Name/Code	Start Date	End Date	Check Status
1	Rubber - Man	Phan Thành Thời	06/13/2024 14:12:52		Not Yet

Add a line 2



## IV. Rubber Mold

### 공정 완료된 제품의 실제 수량 등록

Actual
x

MMO#		Process & Level	Rubber & Level O
MO#	MO/01202	Target / Actual Qty	1.00 / 1.00
Product	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT+2		

Actual
Item

No	Actual Qty	OK Qty	NG Qty	Created on	Status
1	1.00	1.00	0.00	06/13/2024 17:06:07	Done

Cancel
Confirm
Close

Done

Location	WH/Fac1/Mockup → WH/Mold	Created Date	06/13/2024 17:06:06
		Work Date	06/13/2024 08:00:00 → 06/13/2024 20:00:00
		Line	

Item
Standby
Operation
Setting

No	Actual Qty	OK Qty	NG Qty	Created on	Status
1	1.00	1.00	0.00	06/13/2024 17:06:07	Done

실행 순서 & 기능 :

1. "Operation" 탭에서 진행.
2. "Actual" 버튼을 눌러 해당 아이템의 정보 입력창 오픈.
3. 고무 몰드 실제 생산 수량 입력.
4. "Confirm" 버튼을 눌러 승인.



## IV. Rubber Mold

### 공정 완료된 제품의 Lot code 발행

실행 순서 & 기능 :

1. "Detail" 버튼을 눌러 Lot code 발행 진행.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report KPI Dashboard TV

Rubber Mold / MO/00202

Edit Create Action 1/1 < >

Cancel Complete MO Draft In Progress Done

WO List

Product Mold Model	R-TN-1160-2.0	Process & Level	Rubber & Level 0
Product	R-TN-1160-2.0+1	Target / Actual Qty	1.00 / 1.00 pcs
Item QC / PQC Form	Item QC Form /	OK / NG Qty	0.00 / 0.00 pcs
Target / Actual Weight	1.00 / 30.00 g	Created Date	04/04/2024 12:35:15
OK / NG Weight	30.00 / 0.00 g	Work Date	04/04/2024 08:00:00 → 04/04/2024 20:00:00
Location	WH/Facil/Mockup → WH/Mold	Line	

Item Standby Operation Setting

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	30.00	30.00	0.00	1.00	1.00	0.00	04/04/2024 12:35:16	Waiting for Lot	Detail



### IV. Rubber Mold

#### 공정 완료된 제품의 Lot code 발행

#### Create Lot

Type Lot  OK  NG

Target / Actual Qty 2.00 / 0.00

OK / NG Qty 0.00 / 0.00

Actual Qty

실행 순서 & 기능 :

1. "OK" 탭에서 진행(고무 몰드는 불량 없음).
2. "Lot" 버튼을 눌러 팝업 오픈.
3. 생산된 고무 몰드의 숫자에 맞춰 발행할 로트의 숫자를 입력한다.
4. "Create" 버튼을 눌러 Lot 발행.

Rubber Mold / MO/01196 / 2

Draft Waiting for Lot Waiting for Tray Done

MMO#		Product	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-13CT+1
MO#	MO/01196	BOM	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-13CT+1 - 2024-06-13 14:12:51
Work Date	06/13/2024 14:12:52	Process & Level	Rubber & Level 0
		Target / Actual Qty	2.00 / 0.00
		OK / NG Qty	2.00 / 0.00

OK  NG

To	Lot/Serial Number	Qty	Created on	State
----	-------------------	-----	------------	-------



## IV. Rubber Mold

### 공정 완료된 제품의 Lot code 발행

실행 순서 & 기능 :

1. 발행된 로트 정보 표시.
2. QR 라벨 인쇄 기능.
3. "Back" 버튼을 눌러 메인 페이지로 이동.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number

Rubber Mold / MO/01196 / 2 / MO/01196 / 2 / MO/01196 / 2

Edit + Create

Action

1/1 < >

Back 3

Draft Waiting for Lot Waiting for Tray Done

<b>MMO#</b>		<b>Product</b>	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT+1
<b>MO#</b>	MO/01196	<b>BOM</b>	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT+1 - 2024-06-13 14:12:51
<b>Work Date</b>	06/13/2024 14:12:52	<b>Process &amp; Level</b>	Rubber & Level O
		<b>Target / Actual Qty</b>	2.00 / 2.00
		<b>OK / NG Qty</b>	2.00 / 0.00

OK NG

Lot 2 Print

To	Lot/Serial Number	Qty	Created on	State
WH/Mold	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT+1#1-240614 <span>1</span>	1.00	06/14/2024 08:15:30	Done
WH/Mold	R-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-1.3CT+1#2-240614	1.00	06/14/2024 08:15:30	Done



## IV. Rubber Mold

### 고무 몰드 작업 지시서 완료

실행 순서 & 기능 :

1. 생산 완료된 고무 몰드의 정보 표시.
2. "Complete MO" 버튼을 눌러 고무 몰드 작업 지시서의 완료 승인.

The screenshot displays the PMS interface for a Rubber Mold. At the top, there is a navigation bar with various menu items like MES, KPI, PMS, QMS, MMS, Repair, Scrap, Process, Closing Report, and Lot/Serial Number. Below this, the breadcrumb path is 'Rubber Mold / MO/O1196 / 2 / MO/O1196 / 2 / MO/O1196 / 2 / MO/O1196'. The main area contains a 'Complete MO' button (circled with a '2') and a 'WO List' button. The 'Complete MO' button is highlighted in red. Below the button, there is a table with columns: No, Actual Qty, OK Qty, NG Qty, Created on, Status, and a 'Detail' button. The table contains one row with the following data: No: 1, Actual Qty: 200, OK Qty: 200, NG Qty: 0.00, Created on: 06/13/2024 14:12:52, Status: Done (green circle), and a 'Detail' button (circled with a '1').

No	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	200	200	0.00	06/13/2024 14:12:52	Done	Detail



## V. Silver Mold

### 은 원본 작업 지시서 조회

실행 순서 & 기능 :

1. 검색 기능.
2. 기 발행된 은 원본 작업 지시서 현황 표시.
3. 엑셀로 다운로드 기능.
4. "Create" 버튼을 눌러 신규 작업 지시서 생성.

MES													
KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number													
Silver Mold													
Search...													
Filters Group By Favorites													
1-10 / 10													
	SMO	Process	Mold Model	Created on	Work Start Date	Work End Date	Target Weight...	Actual Weig...	Actual OK Weight	Target Qty	Actual Qty	Actual OK Qty	Status
<input type="checkbox"/>	SMO/00018	Silver MoL...	TEST123	05/21/2024 19:32:20	05/21/2024 19:32:16	05/21/2024 19:32:16	1.00	100.00	100.00	0.00	2	2	In Progress
<input type="checkbox"/>	SMO/00017	Silver MoL...	S-TB-350-(17-4.5)	05/21/2024 19:31:23	05/21/2024 19:31:19	05/21/2024 19:31:19	1.00	0.00	0.00	0.00	0	0	In Progress
<input type="checkbox"/>	SMO/00016	Silver MoL...	S-A01	05/21/2024 12:58:15	05/21/2024 12:58:12	05/21/2024 12:58:12	1.00	0.00	0.00	0.00	0	0	In Progress
<input type="checkbox"/>	SMO/00014	Silver MoL...	S-TB-350-(17-4.5)	05/21/2024 10:52:07	05/21/2024 10:52:00	05/21/2024 10:52:00	1.00	0.00	0.00	1.00	0	0	In Progress
<input type="checkbox"/>	SMO/00013	Silver MoL...	TEST123	05/21/2024 10:23:26	05/21/2024 10:22:17	05/21/2024 10:22:17	1.00	0.00	0.00	0.00	0	0	In Progress
<input type="checkbox"/>	SMO/00012	Silver MoL...	TEST123	05/08/2024 11:05:13	05/08/2024 11:03:57	05/08/2024 11:03:57	100.00	200.00	195.00	3.00	2	2	In Progress
<input type="checkbox"/>	SMO/00011	Silver MoL...	TEST123	05/08/2024 10:59:57	05/08/2024 10:59:49	05/08/2024 10:59:49	3.00	200.00	200.00	100.00	2	2	Done
<input type="checkbox"/>	SMO/0000...	Silver MoL...	TEST123	05/02/2024 13:58:30	05/02/2024 13:47:02	05/02/2024 13:47:02	100.00	100.00	95.00	3.00	2	2	Done
<input type="checkbox"/>	SMO/00007	Silver MoL...	S-SILVERMOLD-TEST	04/25/2024 16:11:38	04/25/2024 16:11:34	04/25/2024 16:11:34	1.00	60.00	60.00	0.00	2	2	Done
<input type="checkbox"/>	SMO/0000...	Silver MoL...	S-TN-1160-2.0	04/25/2024 13:09:29	04/25/2024 13:09:26	04/25/2024 13:09:26	1.00	1.00	1.00	0.00	1	1	Done



## V. Silver Mold

### 은 원본 작업 지시서 생성

Silver Mold / New

Save Discard

Confirm

Draft In Progress Done

1

2

Product Mold Model  Process

PQC Form PQC Form  Work Date

Location → Target/Actual Qty

Target/Actual Weight 100 / 0.00

05/02/2024 13:47:02 → 05/02/2024 13:47:02

0 / 0

Order Item Standby Operation

MPMO #	Product	Number	MMO #	MMO Qty	Target Qty	UoM	Remark

실행 순서 & 기능 :

1. 관련 정보 입력 :

\_ Product Mold Model Mold Model 정보

\_ PQC Form PQC 검사 양식

\_ Target / Actual Weight 목표/실제 중량

\_ Target / Actual Qty 목표/실제 수량

\_ Work Date 작업 일자

2. "Save" 버튼을 눌러 저장.



## V. Silver Mold

### 은 원본 작업 지시서 생성 승인

실행 순서 & 기능 :

1. "Confirm" 버튼을 눌러 승인.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number

Silver Mold / SMO/00019

Edit Create Print Action 11 / 11

Confirm 1 Draft In Progress Done

Product Mold Model	S-HC-070(6.5)-18K-W-2.10GR-120	Process	Silver Mold
PQC Form	PQC Form	Work Date	06/11/2024 15:12:32 → 06/11/2024 15:12:32
Location	WH/Fac1/Mockup → WH/Fac1/Mockup	Target/Actual Qty	2 / 0 pcs
Target/Actual Weight	1.00 / 0.00 g		

Item Standby Operation

Item	Lot No	From	Stock Qty	Received W...	UoM	Confirmation Date	Status
------	--------	------	-----------	---------------	-----	-------------------	--------



## V. Silver Mold

### 공정에 사용되는 자재 등록

Receive Item

SMO: SMO/00009

Process: Silver Mold

Product: TEST123

Target Weight: 100.00

Item	Lot No	From	Stock Qty	Received Weight	UoM	Confirmation Date
SEMI-TEST123	Lot Semi Test123 Manualy	WH/Facil/Mockup	900.00	200	g	

Confirm
Close

Silver Mold / SMO/00009

Edit Create

Cancel

Product Mold Model

PQC Form

Location

Target/Actual Weight

Item Standby Operation

Check

Item	Lot No	From	Stock Qty	Received Weight	UoM	Confirmation Date	Status
SEMI-TEST123	Lot Semi Test123 Manualy	WH/Facil/Mockup	900.00	0.00	g		Waiting for Check Qty

Add a line

실행 순서 & 기능 :

1. "Item" 탭에서 진행.
2. 은 원본 생산에 투입될 자재 목록 표시.
3. "Check" 버튼을 눌러 자재 정보창 오픈.
4. 관련 정보 입력 :  
\_ Lot No 로트 코드  
\_ Received Weight 입고 중량
5. "Confirm" 버튼을 눌러 승인.



## V. Silver Mold

### 공정에 투입되는 직원 정보 등록 및 중량 점검

실행 순서 & 기능 :

1. "Standby" 탭에서 진행.
2. 관련 정보 입력 :  
\_ Step 세부 공정  
\_ Name/Code 이름/코드  
\_ Start Date 시작 시간  
\_ End Date 종료 시간
3. "Save" 버튼을 눌러 저장.
4. "Before & After" 버튼을 눌러 작업 전/후의 중량 입력.
5. 전자 저울과 연동되어 측정된 중량이 입력됨.
6. "Confirm" 버튼을 눌러 승인.

**Before & After**

MMO#	MO/00204	Product	S-HC-070(6.5)-18K-W-2.10gr-120+1
MO#	MO/00204	Step Count	2
Process & Level	Silver Mold & Level 0		

Level	Step	Staff	Before Weight	Record Date	After Weight	Record Date	Gap
1	Small Cutting - Man	Nguyễn Hoàng Căn	30.00 <input type="text" value="Input"/>	04/04/2024 13:32:02	29.00 <input type="text" value="Input"/>		0.00
2	Hand made - Man	Đào Thành Đăng	<input type="text" value="29.00"/>		<input type="text" value="29.00"/>		0.00

OK / NG Weight: 0.00 / 0.00 g      Work Date: 04/04/2024 08:00:00 → 04/04/2024 20:00:00

Location: WH/Fac1/Mockup → WH/SilvS      Line:

Item **Standby** Operation Setting
**Before & After**

Level	Step	Name/Code	Start Date	End Date	Before Weight	After Weight	Gap	Check Status
1	Small Cutting - Man	Nguyễn Hoàng Căn	04/04/2024 13:28:30		30.00	0.00	0.00	Not Yet
2	Hand made - Man	Đào Thành Đăng	04/04/2024 13:28:30		0.00	0.00	0.00	Not Yet



## V. Silver Mold

### 공정 완료된 제품의 실제 중량과 수량 등록

실행 순서 & 기능 :

1. "Operation" 탭에서 진행. 실제 중량과 수량은 "Standby" 탭에서 측정된 값과 Target 수량이 자동으로 입력됨.
2. "Actual" 버튼을 눌러 자동 입력된 값 수정 가능.
3. 실제 중량, 수량, 양품 수량, 불량 수량이 표시됨.
4. "Confirm" 버튼을 눌러 승인.

The screenshot displays the 'Actual' dialog box for Silver Mold. The dialog contains the following information:

- SMO:** SMO/00009
- Process:** Silver Mold
- Product:** TEST123
- Target/Actual Weight:** 100.00 / 000 g

Below this information is a table with the following columns: Product, Actual Weight, UoM, Actual Qty, UoM, Confirm Date, and Status. The table contains two rows:

Product	Actual Weight	UoM	Actual Qty	UoM	Confirm Date	Status
S-TN-1160-20+1	100.00 <b>Input</b>	g	1	pcs		Waiting for Actual
S-TB-FC(LT)-079+1	100 <b>Input</b>	g	1	pcs		Waiting for Actual

At the bottom of the dialog, there are 'Confirm' and 'Close' buttons. The main interface below the dialog shows the 'Operation' tab selected, with 'Actual' and 'Print labels' buttons visible. The main data table below the dialog shows the following columns: Semi Product, Actual Weight, UoM, Actual Qty, UoM, Lot Code, Confirm Date, and Status. The table contains two rows:

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
S-TN-1160-20+1	0.00 g		1	pcs			Waiting for Actual
S-TB-FC(LT)-079+1	0.00 g		1	pcs			Waiting for Actual



## V. Silver Mold

### 공정 완료된 제품의 품질 검사

실행 순서 & 기능 :

1. "PQC" 버튼을 눌러 검사 실행.
2. 해당 항목 선택.
3. 검사 결과 입력.
4. "Submit" 버튼을 눌러 완료.

Quality Checks Popup

MMO #	MO #	Product	QC Form	Lot Qty	Not Yet
false	SMO/00009	TEST123	PQC Form	2	2

No	Actual Qty	Create Date	Status	Staff	OK g	NG g	INPUT	OK pcs	NG pcs	Date	Judgement
<input checked="" type="checkbox"/>	1	2024-05-02 07:01:28	Not Yet	Võ Thị Huyền Trang	45.00	5	INPUT	1		22/05/24	OK
<input checked="" type="checkbox"/>	1	2024-05-02 07:01:28	Not Yet								

QC Type	QC Process	QC Code	Method	Frequency	Input	Judgement
Visual PQC	PQC	Missing Wax	By eyes	Check All	0	OK
Visual PQC	PQC	Unformed	By eyes	Check All	0	OK
Visual PQC	PQC	Unformed Bezel/Component	By eyes	Check All	5	NG
Visual PQC	PQC	Bubble/Crack/Deform	By eyes	Check All	0	OK
Visual PQC	PQC	Burr/ Water drop	By eyes	Check All	0	OK
Visual PQC	PQC	Poor Workmanship Soldering/Filing	By eyes	Check All	0	OK
Visual PQC	PQC	Over grinding	By eyes	Check All	0	OK
Visual PQC	PQC	Others	By eyes	Check All	0	OK

Save Discard Cancel

Product Mold Model  
PQC Form  
Location  
Target/Actual Weight

SUBMIT CLOSE

Item	Standby	Operation	QC	Actual	Print labels		
Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
S-TN-1160-20+1	50.00 g		1 pcs			05/02/2024 14:24:25	Waiting for QC
S-TB-FC(LT)-079+1	5000 g		1 pcs			05/02/2024 14:24:25	Waiting for QC



## V. Silver Mold

### 공정 완료된 제품의 Lot code 발행

**Create Lot**

SMO	SMO/00009	Process	Silver Mold
Product	TEST123	Lot Qty	3

Save Discard

Cancel

**2** Create Close

Product Mold Model	TEST123	Process	Silver Mold
PQC Form	PQC Form	Work Date	05/02/2024 13:47:02 → 05/02/2024 13:47:02
Location	WH/Fac!/Mockup → WH/Fac!/Mockup	Target/Actual Qty	3 / 0 pcs
Target/Actual Weight	100.00 / 0.00 g		

Item Standby **Operation**

Actual **1** Lot Print labels

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
S-TN-1160-20+1	50.00 g		1 pcs			05/02/2024 14:24:25	Waiting for Lot
S-TB-FC(LT)-079+1	50.00 g		1 pcs			05/02/2024 14:24:25	Waiting for Lot

실행 순서 & 기능 :

1. "Lot" 버튼을 눌러 로트 발행창 오픈.
2. "Create" 버튼을 눌러 신규 로트 생성.



## V. Silver Mold

공정 완료 후 은 잔량을 주소실로 반납

실행 순서 & 기능 :

1. "Disposal" 버튼을 눌러 은 잔량 반납 절차 진행.
2. 은 사용 잔량이 없이 전량 소진하였을 경우 "F" 버튼을 눌러 처리, 잔량이 있을 경우 "R" 버튼을 눌러 반납 처리.
3. "Save" 버튼을 눌러 저장.

**Disposal**

MPMO/PMO / SMO/00012      Process Silver Mold

Product TEST123      Target/Actual Weight 100.00 / 200.00 g

Item	From	Lot Code	Received Weight	UoM	Used Qty	Remain Qty	Remark
SEMI-TEST123	WH/Fac1/Mockup	Lot Semi Test123 Manualy	300.00 g		200.00	100.00	Input

2
F
R

Silver Mold / SMO/00012

Product Mold Model

PQC Form      Work Date 05/08/2024 11:03:57 → 05/08/2024 11:03:57

Location WH/Fac1/Mockup → WH/Fac1/Mockup      Target/Actual Qty 3 / 2 pcs

Target/Actual Weight 100.00 / 200.00 g

Item Standby **Operation**

1

Semi Product	Actual Weight	UoM	Actual Qty	UoM	Lot Code	Confirm Date	Status
S-TN-1160-20+1	100.00 g	1 pcs			S-TN-1160-20+1-Silver-100.0g-L	05/08/2024 11:11:38	Done
S-TB-FC(LT)-079+1	100.00 g	1 pcs			S-TB-FC(LT)-079+1-Silver-95.0g- S-TB-FC(LT)-079+1-Silver-5.0g-L	05/08/2024 11:11:38	Done



## V. Silver Mold

### 불량품을 수리 센터로 이동

실행 순서 & 기능 :

1. "Print labels" 버튼을 눌러 QR 인쇄.
2. "Return NG" 버튼을 눌러 불량품 반납 절차 진행.
3. "Confirm" 버튼을 눌러 승인.
4. "Complete" 버튼을 눌러 은 원본 작업 지시서 수행 완료.

Silver Mold / SMO/00012

5 / 5 < >

Save Discard

Cancel Complete 4

Draft In Progress Done

Product Mold Model: TEST123 Process: Silver Mold

PQC Form: PQC Form Work Date: 05/08/2024 11:03:57 → 05/08/2024 11:03:57

Location: WH/Fac/Mockup → WH/Fac/Mockup Target/Actual Qty: 3 / 2 pcs

Target/Actual Weight: 100.00 / 200.00 g

Return NG

MPMO/PMO: / SMO/00012 Process: Silver Mold

Target/Actual Weight: 100.00 / 200.00 g Target/Actual Qty: 3 / 2 pcs

Product: TEST123 Create as 1 Return Order

Lot/Serial Number	Return Order	From	To	Actual Weight	UoM	Actual Qty	UoM
S-TB-FC(LT)-079+1-Silver-5.0g-1pcs-240508-001		WH/Fac/Mockup		5.00 g		1	pcs

Disposal Return NG Print labels 1

Confirm Date	Status
05/08/2024 11:11:38	Done
05/08/2024 11:11:38	Done

Confirm Close 3



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