

For Smart Factory



Operating
User |

MANUAL



MES^{3D}

ERP + MES + SCADA

Auto & S.I

User Manual

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I. Master Production

Production Work Order Master List

MESKPIPMSQMSMMSRepairScrapProcess

Master Production

Create

Search...

1

Filters

Group By

Favorites

1-7 / 7

	Name	Sale Order	Scheduled Date	Product	Target Weight	Actual Weight	NG	Status	Created by	Created on
☐	MMO/00012		02/29/2024 08:17:11	HC-070(6.5)-18K-W-210gr-120	2100	0.00	0.00	Confirmed	Administrator	02/29/2024 15:17:17
☐	MMO/00011		02/29/2024 07:27:23	HC-070(6.5)-18K-W-210gr-120	2100	3.00	0.00	Done	Administrator	02/29/2024 14:27:34
☐	MMO/00009		02/29/2024 07:00:19	HC-070(6.5)-18K-W-210gr-120	2100	0.00	0.00	In Progress	Administrator	02/29/2024 14:00:36
☐	MMO/00008		02/28/2024 09:53:20	HC-070(6.5)-18K-W-210gr-120	2100	0.00	0.00	In Progress	Administrator	02/28/2024 16:53:32
☐	MMO/00006		02/28/2024 09:44:29	HC-070(6.5)-18K-W-210gr-120	2100	0.00	0.00	In Progress	Administrator	02/28/2024 16:44:42
☐	MMO/00003		02/28/2024 06:23:02	T4C3-(2.0-3.5)-VN-17inch-18k-25.02g-w-121pcs-5.12ct	125.10	125.10	0.00	Done	Administrator	02/28/2024 13:23:19
☐	MMO/00002		02/28/2024 06:20:00	T4C3-(2.0-3.5)-VN-17inch-18k-25.02g-w-121pcs-5.12ct	125.10	0.00	0.00	In Progress	Administrator	02/28/2024 13:20:18

Step by step:

1. Search function.
2. Master list of production work orders.
3. Download function as Excel file.
4. Click the “Create” button to register a new production work order master.



I. Master Production

Production work order master registration

Master Production / New

✓ Save

✕ Discard

Confirm

Draft

Confirmed

In Progress

Done

1

2

3

Product

T4C3-(2.0-3.5)-VN-17inch-18k-25.02g-w-12pcs-5.12ct

Created Date

BOM

T4C3-(2.0-3.5)-VN-17inch-18k-25.02g-w-12pcs-5.12ct - MyBOM_2802

Work Date

Target / Actual Weight

75.06 / 0.00 g

Target / Actual Qty

3 / 0.00

Is Recast

Remark

Test

MO List

MO Setting

Reference	Level	Process	Product	BOM	Target Weig...	Actual Weig...	Actual Previ...	Status

- Step by step:
1. Enter relevant information:
_Product
_BOM
_Target / Actual Quantity
_Remark Remarks
 2. Save by pressing the “Save” button.
 3. Confirm by pressing the “Confirm” button.



I. Master Production

Production Work Order Master Sub-Process Work Order List

- Step by step:
1. Check the list of process work instructions for the product in the “MO List” tab. Each MO corresponds to one process. The displayed MO is automatically registered in the “MO” menu.
 2. Master production Displays a list of sub-process work orders (MO).

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Master Production / MMO/00235

SaveDiscard

2 / 80

Cancel

DraftConfirmedIn ProgressDone

ProductHC-070(6.5)-18K-W-210gr-120

BOMHC-070(6.5)-18K-W-210gr-120 - KHC - 01

Sale OrderS00061

Target / Actual Weight0.00 / 0.00 g

Is Recast

Created Date06/17/2024 09:18:12

Work Date06/17/2024 09:17:58 → 06/17/2024 09:17:58

Target / Actual Qty10.00 / 0.00

Remark

MO ListMO Setting

Reference	Level	Process	Product	BOM	Target Weight	Actual Weight	Actual Previous	Materials	Status	
MO/01213	1	Hand Made	SEMI-HC-070(6.5)-18K-W-210gr-120-HM	SEMI-HC-070(6.5)-18K-W-210gr-120-HM	0.00	0.00	0.00	18K Tem(Y) SEMI-HC-070(6.5)-18K-W-210gr...	Draft	
MO/01214	2	1st Polishing	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 1	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 1	0.00	0.00	0.00		Draft	
MO/01215	3	1st Finishing	SEMI-HC-070(6.5)-18K-W-210gr-120-FIN 1	SEMI-HC-070(6.5)-18K-W-210gr-120-FIN 1	0.00	0.00	0.00	18K W Cutting Plate T4C3	Draft	
MO/01216	4	2nd Polishing	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 2	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 2	0.00	0.00	0.00		Draft	
MO/01217	5	2nd Polishing	HC-070(6.5)-18K-W-210gr-120	HC-070(6.5)-18K-W-210gr-120 - KHC - 01	0.00	0.00	0.00		Draft	



I. Master Production

Set up process work orders

- Step by step:
1. You can change the setting value of each MO in the “MO Setting” tab.
 2. Select relevant settings:
 - _ Item QC Form Select Item QC inspection form
 - _ Item QC Select when implementing Item QC in the relevant process
 - _ PQC Select if PQC is implemented in the relevant process
 - _ Mapping tray Select if tray is used in the process
 3. Save by pressing the “Save” button.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Master Production / MMO/00235

SaveDiscard

2 / 80

Cancel

DraftConfirmedIn ProgressDone

Product

HC-070(6.5)-18K-W-210gr-120

Created Date

06/17/2024 09:18:12

BOM

HC-070(6.5)-18K-W-210gr-120 - KHC - 01

Work Date

06/17/2024 09:17:58 → 06/17/2024 09:17:58

Sale Order

S00061

Target / Actual Qty

10.00 / 0.00

Target / Actual Weight

0.00 / 0.00 g

Remark

Is Recast

MO ListMO Setting

Reference	Level	Process	Product	Item QC Form	Item QC	PQC	Status	Mapping Tray
MO/01213	1	Hand Made	SEMI-HC-070(6.5)-18K-W-210gr-120-HM	Item QC Form	☐	☒	Draft	☐
MO/01214	2	1st Polishing	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 1	Item QC Form	☐	☒	Draft	☐
MO/01215	3	1st Finishing	SEMI-HC-070(6.5)-18K-W-210gr-120-FIN 1	Item QC Form	☐	☒	Draft	☐
MO/01216	4	2nd Polishing	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 2	Item QC Form	☐	☒	Draft	☐
MO/01217	5	2nd Polishing	HC-070(6.5)-18K-W-210gr-120	Item QC Form	☐	☒	Draft	☐



II. MO (Manufacturing Order)

Process work in progress

MES

KPI

PMS

QMS

MMS

Repair

Scrap

Process

Closing Report

Lot/Serial Number

Master Production / MMO/00235

Save

Discard

2 / 80

Cancel

Draft

Confirmed

In Progress

Done

Product

HC-070(6.5)-18K-W-2.10gr-1.20

Created Date

06/17/2024 09:18:12

BOM

HC-070(6.5)-18K-W-2.10gr-1.20 - KHC - 01

Work Date

06/17/2024 09:17:58 → 06/17/2024 09:17:58

Sale Order

S00061

Target / Actual Qty

10.00 / 0.00

Target / Actual Weight

0.00 / 0.00 g

Remark

Is Recast

MO List

MO Setting

Reference...	Level	Process	Product	BOM	Target Weight...	Actual Weig...	Actual Previous	Materials	Status...	
1		1 Hand Made	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	0.00	0.00	0.00	18K Tem(Y) SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	Draft	
MO/O1214		2 1st Polishing	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	0.00	0.00	0.00		Draft	
MO/O1215		3 1st Finishing	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	0.00	0.00	0.00	18K W Cutting Plate T4C3	Draft	
MO/O1216		4 2nd Polishi...	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	0.00	0.00	0.00		Draft	
MO/O1217		5 2nd Polishi...	HC-070(6.5)-18K-W-2.10gr-1.20	HC-070(6.5)-18K-W-2.10gr-1.20 - K...	0.00	0.00	0.00		Draft	

Step by step:

1. In the “MO List” tab, select the MO you wish to work on from the list with the left arrow.



II. MO (Manufacturing Order)

Process work in progress

MES

KPI

PMS

QMS

MMS

Repair

Scrap

Process

Closing Report

Lot/Serial Number

1

5

Master Production / MMO/00235 / MO/01213

Edit

Create

Action

1 / 1

<

>

Confirm

Draft

In Progress

Done

6

WO List

Product

BOM

Item QC / PQC Form

Target / Actual Weight

OK / NG Weight

Location

SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM

SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM

Item QC Form / PQC Form

0.00 / 0.00 g

0.00 / 0.00 g

WH/Fac1/HM → WH/Fac1/PL1

Source Document

Process & Level

Target / Actual Qty

OK / NG Qty

Created Date

Work Date

Line

MMO/00235

Hand Made & Level 1

10.00 / 0.00 pcs

0.00 / 0.00 pcs

06/17/2024 09:18:12

06/17/2024 09:17:58 → 06/17/2024 09:17:58

1

3

4

5

2

Item

Standby

Operation

Item	Lot No	From	Stock Qty	Received Weig...	OK Weight	NG Weight	UoM	Received Qty	OK Qty	NG Qty	UoM	Confirmation ...
------	--------	------	-----------	------------------	-----------	-----------	-----	--------------	--------	--------	-----	------------------

Step by step:

1. Go to the selected MO page. Check the current process in Process & Level.
2. Item QC and PQC inspection formats can be changed.
3. Target quantity can be changed.
4. Work plan time can be changed.
5. Designate work line (if there are multiple lines in the process)
6. Confirm by pressing the “Confirm” button.



II. MO (Manufacturing Order)

Registration of materials and semi-finished products used in the process

Receive Item

MMO#

MMO/00235

Product

SEMI-HC-070(6.5)-18K-W-210gr-120-HM

MO#

MO/01213

Target Weight

0.00 g

Process & Level

Hand Made & Level 1

Target Qty

10.00 pcs

Item	Lot No	From	Stock Qty	Received Weight	UoM	Received Qty	UoM	Confirmation Date
18K Tem(Y)		WH/FacI/HM	0.00	0.00	g	100.00	pcs	
SEMI-HC-070(6.5)-18K-W-210gr-120		WH/FacI/HM	0.00	0.00	g	0.00	pcs	

MES

Master Prod

Edit

Cancel

Save

Confirm

Close

Product

SEMI-HC-070(6.5)-18K-W-210gr-120-HM

Source Document

MMO/00235

BOM

SEMI-HC-070(6.5)-18K-W-210gr-120-HM

Process & Level

Hand Made & Level 1

Item QC / PQC Form

Item QC Form / PQC Form

Target / Actual Qty

10.00 / 0.00 pcs

Target / Actual Weight

0.00 / 0.00 g

OK / NG Qty

0.00 / 0.00 pcs

Created Date

06/17/2024 09:18:12

Work Date

06/17/2024 09:17:58 → 06/17/2024 09:17:58

Location

WH/FacI/HM → WH/FacI/PL1

Line

HM3

Item

Standby

Operation

Item	Lot No	From	Stock Qty	Received Weight	OK Weight	NG Weight	UoM	Received Qty	OK Qty	NG Qty	UoM	Confirmation Date	Status
18K Tem(Y)		WH/FacI/HM	0.00	0.00	0.00	0.00	g	100.00	0.00	0.00	pcs		Waiting for Check Qty
SEMI-HC-070(6.5)-18K-W-21L		WH/FacI/HM	0.00	0.00	0.00	0.00	g	0.00	0.00	0.00	pcs		Waiting for Check Qty

Add a line

Step by step:

1. “Register information on materials and semi-finished products used in the process in the “Item” tab.
2. Displays material and semi-finished product information registered in the BOM.
3. Click the “Check” button to open the lot, weight, and quantity input window for the item.
4. Enter relevant information:

__ Lot No.

__ Received Weight

__ Received Qty

Quantity received
5. Confirm by pressing the “Confirm” button.

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Quality inspection of materials and semi-finished products used in the process

Step by step:

1. Click the “Item QC” button to proceed with the inspection.
2. Select the item to inspect from the list.
3. Enter the test results on the test sheet.
4. Confirm by clicking the “Submit” button.

Master Production / MMO/OC

Product

BOM

Item QC / PQC Form

Target / Actual Weight

OK / NG Weight

Location

Quality Checks PopUp

MMO #	MO #	Product	QC Form	Check QC	Lot Qty	Not Yet
MMO/00017	MO/00103	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM	Item QC Form	Sampling	2	2

Item	LOT	Status
☐ 18K Tem(Y)	18K Tem	Not Yet
☒ SEMI-T4C3-(2.0-3.5)-17	T4C3-(2.0-3.5)-17inch-18K	Not Yet

2

Staff	OK g	NG g	OK pcs	NG pcs	Date	Judgement
Đào Thành Đăng	74.98	25.02	3		02/04/24	OK

3

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/Co	By eyes	Check All	0	OK
Visual PQC	PQC	Bubble/Crack/Defo	By eyes	Check All	0	OK
Visual PQC	PQC	Burr/ Water drop	By eyes	Check All	0	OK
Visual PQC	PQC	Poor Workmanship	By eyes	Check All	0	OK

4

1

Item	Lot No	From	Stock Qty	Received Weight	OK Weight	NG Weight	Uo...	Received Qty	OK Qty	NG Qty	Uo...	Confirmatic
☐ 18K Tem(Y)	18K Tem	WH/FacI/HM	9,661.74	100.00	0.00	0.00 g		3.00	0.00	0.00	pcs	04/02/2024
☐ SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12	T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-CAS_CUT-400Og-10pcs-240328-0...	WH/FacI/HM	4,674.74	100.00	0.00	0.00 g		3.00	0.00	0.00	pcs	04/02/2024

Add a line



II. MO (Manufacturing Order)

Register information on employees, machines, and molds used in the process

Before & After

MMO#

MMO/00235

Product

SEMI-HC-070(6.5)-18K-W-210gr-120-HM

MO#

MO/01213

Step Count

3

Process & Level

Hand Made & Level 1

Level	Step	Staff	Before Weight	Record Date	After Weight	Record Date	Gap
1	Hand Made - Man		30.00	06/17/2024 10:48:09	0.00		0.00
2	Motor Cut - Man		0.00		0.00		0.00
3	Chemical Cleaning - Man		0.00		0.00		0.00

Save

Confirm

Close

Item

Standby

Operation

Level	Step	Name/Code	Start Date	End Date	Before Weight	After Weight	Gap	Part Qty	Check Status
1	Hand Made - Man		06/17/2024 09:47:16		30.00	0.00	0.00	0.00	Not Yet
2	Motor Cut - Man		06/17/2024 09:47:16		0.00	0.00	0.00	0.00	Not Yet
3	Chemical Cleaning - Man		06/17/2024 09:47:16		0.00	0.00	0.00	0.00	Not Yet

Add a line

- Step by step:
1. Proceed in the “Standby” tab.
 2. Enter relevant information:
 - _ Step detailed process
 - _ Name/Code Name/Code
 - _ Start Date Start time
 - _ End Date End time
 3. In the “Part Qty” column, enter the number of parts to be moved with the semi-finished product (optional).
 4. Press the “Before & After” button to enter the weight before/after work.
 5. The measured weight is entered in conjunction with an electronic scale.
 6. Confirm by pressing the “Confirm” button.



II. MO (Manufacturing Order)

Register the actual weight and quantity of the product for which the process has been completed

MES

Master Proc

Save

Cancel

Actual

Item

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status
1	14.00	0.00	0.00	10.00	0.00	0.00	06/24/2024 14:39:36	Waiting for PQC

Product

BOM

Item QC / f

Target / Ac

OK / NG W

Location

Item

Standby

Operation

Confirm

Close

WH/FacI/HM

→ WH/FacI/PL1

Work Date

Line

06/24/2024 08:00:00

→

06/24/2024 20:00:00

Actual

PQC

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status
1	14.00	0.00	0.00	10.00	0.00	0.00	06/24/2024 14:39:36	Waiting for PQC

- Step by step:
1. Proceed in the “Operation” tab. The actual weight and quantity are automatically entered as the measured value and semi-finished product quantity in the “Standby” tab.
 2. You can edit the automatically entered values by pressing the “Actual” button.
 3. Actual weight, quantity, good quantity, and defective quantity are displayed.
 4. Confirm by pressing the “Confirm” button.



II. MO (Manufacturing Order)

Quality inspection of finished products

Quality Checks Popup

MMO #	MO #	Product	QC Form	Lot Qty	Not Yet
MMO/00254	MO/01306	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM	PQC Form	1	1

No

Actual Qty

Create Date

Status

1

14

2024-06-24 07:39:36

Not Yet

Staff

Võ Thị Huyền Trang

Total Weight

14

OK g

14

NG g

INPUT 0

OK pcs

10

NG pcs

Date

24/06/24

Judgement

OK

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

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

OK / NG Weight

0.00 / 0.00 g

Created Date

06/24/2024 14:39:28

Location

WH/FacI/HM → WH/FacI/PL1

Work Date

06/24/2024 08:00:00 → 06/24/2024 20:00:00

Line

Item

Standby

Operation

Actual

PQC

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status
1	14.00	0.00	0.00	10.00	0.00	0.00	06/24/2024 14:39:36	Waiting for PQC

- Step by step:
1. Press the “PQC” button to run the inspection.
 2. Select the relevant item.
 3. Enter test results.
 4. Complete by clicking the “Submit” button.



II. MO (Manufacturing Order)

Issuance of lot code for products whose process has been completed

- Step by step:
1. Click the “Detail” button to proceed with lot code issuance.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Master Production / MMO/00227 / MO/01176

Edit+ Create

Action

1 / 1<>

CancelComplete MO

DraftIn ProgressDone

WO List

ProductSEMI-HC-070(6.5)-18K-W-210gr-120-HMSource DocumentMMO/00227

BOMSEMI-HC-070(6.5)-18K-W-210gr-120-HMProcess & LevelHand Made & Level 1

Item QC / PQC FormItem QC Form / PQC FormTarget / Actual Qty1.00 / 2.00 pcs

Target / Actual Weight0.00 / 2.00 gOK / NG Qty0.00 / 0.00 pcs

OK / NG Weight2.00 / 0.00 gCreated Date06/12/2024 16:27:45

LocationWH/Fac1/HM → WH/Fac1/PL1Work Date06/12/2024 08:00:00 → 06/12/2024 20:00:00

Line

ItemStandbyOperation

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	2.00	2.00	0.00	2.00	2.00	0.00	06/12/2024 16:27:51	Waiting for Lot	Detail1



II. MO (Manufacturing Order)

Issuance of lot codes for products judged to be good quality

Create Lot

Target / Actual Weight

14.00 / 0.00 g

OK / NG Weight

14.00 / 0.00 g

Type Lot

☒ OK ☐ NG

Target / Actual Qty

10.00 / 0.00 pcs

OK / NG Qty

0.00 / 0.00 pcs

Actual Qty

10.00

pcs

Part Qty

0

pcs

Create

Close

MMO#

MMO/00017

MO#

MO/00103

Work Date

04/02/2024 14:41:55

Target / Actual Weight

80.00 / 0.00 g

OK / NG Weight

53.00 / 27.00 g

Product

SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM

BOM

SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM

Process & Level

Hand Made & Level 1

Target / Actual Qty

3.00 / 0.00 pcs

OK / NG Qty

2.00 / 1.00 pcs

1

OK

NG

2

Lot

To	Lot/Serial Number	Weight	Qty	Created on	Tray Code	State

- Step by step:
1. Proceed from the “OK” tab.
 2. Click the “Lot” button to open a pop-up.
 3. The quantity determined to be good in PQC is automatically entered. Enter the number of each part included in the product (optional).
 4. Issue Lot by pressing the “Create” button.



II. MO (Manufacturing Order)

Issuance of lot codes for products judged to be defective

Master Production / MMS

Edit

Create

Back

MMO#

MO#

Work Date

Target / Actual Weight

OK / NG Weight

1

OK

NG

Create

4

Close

Target / Actual Weight

80.00 / 53.00 g

Target / Actual Qty

2.00 / 2.00 pcs

OK / NG Qty

2.00 / 0.00 pcs

Actual Qty

1.00

pcs

3

Return Order	To	Lot/Serial Number	Weight	Qty	Created on	Tray Code	State

- Step by step:
1. Proceed in the “NG” tab.
 2. Click the “Lot” button to open a pop-up.
 3. The quantity judged defective in PQC is automatically entered.
 4. Issue Lot by pressing the “Create” button



II. MO (Manufacturing Order)

Change a defective product to a good product or move it to a repair warehouse

Master Production / MMO#

Edit

Create

4

Back

MMO#

MO#

Work Date

Target / Actual Weight

OK / NG Weight

OK

NG

Return Order

MMO#
MO#
CWO#
Process & Level
Product

MMO/00017
MO/00103
1
Hand Made & Level 1
SEMI-T4C3--(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM

NG Weight
NG Qty
To
Return Order

27.00
1.00
WH/REC
0

3

Confirm

Close

2

Return NG

Print

Return Order	To	Lot/Serial Number	Weight	Qty	Created on	Tray Code	State
WH/MO/00080	WH/Fac1/HM	WH/REC	T4C3--(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-27g-lpcs-240402-001	27.00	1.00	04/02/2024 15:17:58	

1

Release

- Step by step:
1. Press the “Release” button to change defective product to good product.
 2. Press the “Return NG” button to open a pop-up to send the defective product to the repair warehouse.
 3. Move the defect by pressing the “Confirm” button.
 4. Click the “Back” button to go to the main page.



II. MO (Manufacturing Order)

MO Completed

- Step by step:
1. If there are multiple lines in the process, the lines must be specified.
 2. Click the “Complete MO” button to complete the MO.

MES

KPI

PMS

QMS

MMS

Repair

Scrap

Process

Closing Report

Lot/Serial Number

1

5

Master Production / MMO/00254 / MO/01306

Edit

Create

Action

1 / 1

Cancel

Complete MO

Draft

In Progress

Done

Product

SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM

Source Document

MMO/00254

BOM

SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM

Process & Level

Hand Made & Level 1

Item QC / PQC Form

Item QC Form / PQC Form

Target / Actual Qty

10.00 / 10.00 pcs

Target / Actual Weight

0.00 / 14.00 g

OK / NG Qty

10.00 / 0.00 pcs

Created Date

06/24/2024 14:39:28

OK / NG Weight

14.00 / 0.00 g

Work Date

06/24/2024 08:00:00 → 06/24/2024 20:00:00

Location

WH/FacI/HM → WH/FacI/PLI

Line

Item

Standby

Operation

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	14.00	14.00	0.00	10.00	10.00	0.00	06/24/2024 14:39:36	Done	Detail



II. MO (Manufacturing Order)

Deployed in MMO and then moved to MO

- Step by step:
1. Click the “Next MO” button to move to the next MO.
- ** Each MO has the same structure, and when the last MO is completed, the MMO is completed simultaneously, and the product moves to OQC.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Master Production / MMO/00254 / MO/01306

SaveDiscard

1 / 1<>

CancelNext MO

DraftIn ProgressDone

1

WO List

Product

SEMI-HC-070(6.5)-18K-W-210gr-120-HM

Source Document

MMO/00254

BOM

SEMI-HC-070(6.5)-18K-W-210gr-120-HM

Process & Level

Hand Made & Level 1

Item QC / PQC Form

Item QC Form / PQC Form

Target / Actual Qty

10.00 / 10.00 pcs

Target / Actual Weight

0.00 / 14.00 g

OK / NG Qty

10.00 / 0.00 pcs

OK / NG Weight

14.00 / 0.00 g

Created Date

06/24/2024 14:39:28

Location

WH/Fac1/HM → WH/Fac1/PL1

Work Date

06/24/2024 08:00:00 → 06/24/2024 20:00:00

Line

HM3

ItemStandbyOperation

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	14.00	14.00	0.00	10.00	10.00	0.00	06/24/2024 14:39:36	Done	Detail



III. Repair Work Order

Master Repair Order List

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Repair Work Order

+ Create3

2

Search...

1

Filters

Group By

Favorites

1-49 / 49

☐	Name	Sale Order	Product	Target Weight	Actual Weight	NG	Status	Created by	Created on
☐	RMO/00061		HC-070(6.5)-18K-W-2.10gr-1.20	2.10	2.10	0.00	Done	Administrator	06/25/2024 09:15:33
☐	RMO/00059		T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12	5.00	3.00	0.00	Done	Administrator	06/21/2024 13:33:14
☐	RMO/00057		T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12	3.00	0.00	0.00	In Progress	Administrator	06/21/2024 13:33:14
☐	RMO/00058		T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12	4.00	0.00	0.00	Confirmed	Administrator	06/21/2024 13:33:14
☐	RMO/00056		HC-070(6.5)-18K-W-2.10gr-1.20	2.10	2.09	0.00	Done	Administrator	06/17/2024 15:10:34
☐	RMO/00055		HC-070(6.5)-18K-W-2.10gr-1.20	2.10	0.00	0.00	In Progress	Administrator	06/17/2024 15:10:34
☐	RMO/00054		BP-T2C-3.5-18K-769GR-W-F-8-12CT	5.00	0.00	0.00	Confirmed	my2	05/31/2024 10:59:03
☐	RMO/00052		BP-T2C-3.5-18K-769GR-W-F-8-12CT	2.00	0.00	0.00	In Progress	my2	05/31/2024 10:59:03
☐	RMO/00053		BP-T2C-3.5-18K-769GR-W-F-8-12CT	3.00	0.00	0.00	Confirmed	my2	05/31/2024 10:59:03
☐	RMO/00049		BP-T2C-3.5-18K-769GR-W-F-8-12CT	2.00	2.00	0.00	Done	Administrator	05/31/2024 10:20:50
☐	RMO/00051		BP-T2C-3.5-18K-769GR-W-F-8-12CT	5.00	0.00	0.00	Confirmed	Administrator	05/31/2024 10:20:50
☐	RMO/00050		BP-T2C-3.5-18K-769GR-W-F-8-12CT	3.00	0.00	0.00	Confirmed	Administrator	05/31/2024 10:20:50
☐	RMO/00046		HC-070(6.5)-18K-W-2.10gr-1.20	2.00	1.90	0.00	Done	KHC	05/31/2024 09:40:05
☐	RMO/00044		BP-T2C-3.5-18K-769GR-W-F-8-12CT	2.00	0.00	0.00	Confirmed	my2	05/31/2024 08:06:29
☐	RMO/00043		BP-T2C-3.5-18K-769GR-W-F-8-12CT	2.00	0.00	0.00	In Progress	my2	05/31/2024 08:06:29
☐	RMO/00045		BP-T2C-3.5-18K-769GR-W-F-8-12CT	5.00	0.00	0.00	Confirmed	my2	05/31/2024 08:06:29
☐	RMO/00042		T4C3-2.0-B	0.50	0.00	0.00	In Progress	KHC	05/31/2024 08:05:21
☐	RMO/00041		HC-070(6.5)-18K-W-2.10gr-1.20	6.00	0.00	0.00	In Progress	KHC	05/22/2024 16:05:49

Step by step:

1. Search function.
2. Download function as Excel file.
3. Click the “Create” button to create a new master repair order.
4. Displays a list of generated master repair orders. RMOs created in MES > Repair > Repair Order appear in this list.

Master Manufacturing Orders



Add materials to master repair work order (optional)

1. Click the “add” button on the right side of the process that requires materials for repairs to open the Add Materials window.
2. Add required materials in the pop-up window.
3. Confirm by pressing the “Confirm” button.



III. Repair Work Order

Add materials to master repair work order (optional)

- Step by step:
1. The added material is displayed.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Repair Order / RO/00058 / RMO/00061

EditCreate

Action

1 / 1

Cancel

DraftConfirmedIn ProgressDone

MO ListMO Setting

Reference...	Level	Process	Product	BOM	Target Weight...	Actual Weig...	Actual Previous	Materials	Status...	
MO/01311	1	Hand Made	SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM	SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM	0.00	0.00	0.00	SEMI-HC-070(6.5)-18K-W-2.10gr... 18K Tem(Y)	Draft	+ add
MO/01312	2	1st Polishing	SEMI-HC-070(6.5)-18K-W-2.10GR-120-POL 1	SEMI-HC-070(6.5)-18K-W-2.10GR-120-POL 1	0.00	0.00	0.00		Draft	+ add
MO/01313	3	2nd Finishing	HC-070(6.5)-18K-W-2.10gr-120	HC-070(6.5)-18K-W-2.10gr-120 - 2024-06-25 09:15...	0.00	0.00	0.00		Draft	+ add

1



III. Repair Work Order

Proceed with repair work instructions for each process

- Step by step:
1. Proceed by pressing the arrow button to the left of the process to be repaired.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Repair Order / RO/00058 / RMO/00061

Cancel

1 / 1

DraftConfirmedIn ProgressDone

ProductHC-070(6.5)-18K-W-2.10gr-120Created Date06/25/2024 09:15:33

Target / Actual Weight2.10 / 0.00 gWork Date06/25/2024 02:15:33 → 06/25/2024 20:00:00

Is RecastIs RecastTarget / Actual Qty1.00 / 0.00

RepairRO/00058Remark

MO ListMO Setting

Reference...	Level	Process	Product	BOM	Target Weight...	Actual Weig...	Actual Previous	Materials	Status...	
MO/01311	1	Hand Made	SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM	SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM	0.00	0.00	0.00	SEMI-HC-070(6.5)-18K-W-2.10gr-120-HM 18K Tem(Y)	Draft	+ add
MO/01312	2	1st Polishing	SEMI-HC-070(6.5)-18K-W-2.10GR-120-POL 1	SEMI-HC-070(6.5)-18K-W-2.10GR-120-POL 1	0.00	0.00	0.00		Draft	+ add
MO/01313	3	2nd Finishing	HC-070(6.5)-18K-W-2.10gr-120	HC-070(6.5)-18K-W-2.10gr-120 - 2024-06-25 09:15...	0.00	0.00	0.00		Draft	+ add



III. Repair Work Order

Proceed with repair work instructions for each process

- Step by step:
1. Confirm movement to the relevant process.
 2. Confirm by pressing the “Confirm” button.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Repair Order / RO/00058 / RMO/00061 / MO/01311

EditCreate

Action

1/1<>

Confirm2

DraftIn ProgressDone

WO List

Product

BOM

Item QC / PQC Form

Target / Actual Weight

OK / NG Weight

Location

SEMI-HC-070(6.5)-18K-W-2.1OGR-120-HM

SEMI-HC-070(6.5)-18K-W-2.1OGR-120-HM

Item QC Form / PQC Form

0.00 / 0.00 g

0.00 / 0.00 g

WH/FacI/HM → WH/FacI/PLI

Source Document

Process & Level

Target / Actual Qty

OK / NG Qty

Created Date

Work Date

Line

1

RMO/00061

Hand Made & Level 1

1.00 / 0.00 pcs

0.00 / 0.00 pcs

06/25/2024 09:15:33

06/25/2024 08:00:00 → 06/25/2024 20:00:00

ItemStandbyOperation

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



III. Repair Work Order

Enter product information to be repaired

Receive Item

MMO#

RMO/00061

Product

SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM

MO#

MO/O1311

Target Weight

0.00 g

Process & Level

Hand Made & Level 1

Target Qty

1.00 pcs

Item	Lot No	From	Stock Qty	Received Weight	UoM	Received Qty	UoM	Confirmation Date
18K Tem(Y)	18K Tem	WH/Fac1/HM	2,594.54	1.00 Input	g	10.00	pcs	
SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	SEMI-HC-O...	WH/Fac1/HM	2.10	2.10 Input	g	1.00	pcs	

Save

Confirm

Close

Item QC / PQC Form

Item QC Form / PQC Form

Target / Actual Weight

0.00 / 0.00 g

OK / NG Weight

0.00 / 0.00 g

Location

WH/Fac1/HM → WH/Fac1/PL1

Target / Actual Qty

1.00 / 0.00 pcs

OK / NG Qty

0.00 / 0.00 pcs

Created Date

06/25/2024 09:15:33

Work Date

06/25/2024 08:00:00 → 06/25/2024 20:00:00

Line

Item

Standby

Operation

Item	Lot No	From	Stock Qty	Received Weight	OK Weight	NG Weight	UoM	Received Qty	OK Qty	NG Qty	UoM	Confirmation Date	Status
18K Tem(Y)		WH/Fac1/HM	0.00	0.00	0.00	0.00 g		1.00	0.00	0.00	pcs		Waiting for Check Qty
SEMI-HC-070(6.5)-18K-W-2.10gr-1.20		WH/Fac1/HM	0.00	0.00	0.00	0.00 g		0.00	0.00	0.00	pcs		Waiting for Check Qty

Add a line

- Step by step:
1. Proceed in the “Item” tab.
 2. Display product information to be repaired.
 3. Click the “Check” button to open the input window.
 4. Enter relevant information:
_ Lot No.
_ Received Weight
_ Received Qty
Quantity received
 5. Confirm by pressing the “Confirm” button.



III. Repair Work Order

Enter product information to be repaired

Before & After

MMO#

RMO/00061

Product

SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM

MO#

MO/01311

Step Count

2

Process & Level

Hand Made & Level 1

Level	Step	Staff	Before Weight	Record Date	After Weight	Record Date	Gap
1	Hand Made - Man	Võ Thị Huyền Trang	3.10	Input	06/25/2024 12:42:06	2.90	Input
2	Chemical Polishing - Man	Đào Thành Đặng	2.90	Input	06/25/2024 12:44:07	2.70	Input

Save

Confirm

Close

Item QC / PQC Form

Item QC Form / PQC Form

Target / Actual Weight

0.00 / 0.00 g

OK / NG Weight

0.00 / 0.00 g

Location

WH/FacI/HM → WH/FacI/PL1

Target / Actual Qty

1.00 / 0.00 pcs

OK / NG Qty

0.00 / 0.00 pcs

Created Date

06/25/2024 09:15:33

Work Date

06/25/2024 08:00:00 → 06/25/2024 20:00:00

Line

1

Standby

Operation

3

Before & After

Level	Step	Name/Code	Start Date	End Date	Before Weight	After Weight	Gap	Part Qty	Check Status
1	Hand Made - Man		06/25/2024 12:35:36		3.10	0.00	0.00	0.00	Not Yet
2	Chemical Polishing - Man		06/25/2024 12:35:36		0.00	0.00	0.00	0.00	Not Yet

Add a line

- Step by step:
1. Proceed in the “Standby” tab.
 2. Enter relevant information:
 - _ Step detailed process
 - _ Name/Code Name/Code
 - _ Start Date Task start date
 - _ End Date Task end date
 3. Click the “Before & After” button to open the input window.
 4. Enter the weight before and after work using a linked electronic scale.
 5. Save by pressing the “Confirm” button.



III. Repair Work Order

Enter actual weight and quantity

Actual

MMO#

RMO/00061

Process & Level

Hand Made & Level 1

MO#

MO/01311

Target / Actual Weight

0.00 / 2.70 g

PQC

Target / Actual Qty

1.00 / 1.00 pcs

Product

SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM

Actual

Item

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status
1	2.70	0.00	0.00	1.00	0.00	0.00	06/25/2024 12:35:36	Waiting for PQC

Confirm

Close

Location

WH/Fac1/HM

→ WH/Fac1/PL1

Work Date

06/25/2024 08:00:00 → 06/25/2024 20:00:00

Line

Item

Standby

Operation

Actual

PQC

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status
1	2.70	0.00	0.00	1.00	0.00	0.00	06/25/2024 12:35:36	Waiting for PQC

- Step by step:
1. Proceed in the “Operation” tab.
 2. Press the “Actual” button to open the input window – if modifications are needed.
 3. Actual weight, actual quantity correction.
 4. Confirm by pressing the “Confirm” button.



III. Repair Work Order

PQC progress

Quality Checks Popup

MMO #	MO #	Product	QC Form	Lot Qty	Not Yet
RMO/00061	MO/01311	SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	PQC Form	1	1

No

Actual Qty

Create Date

Status

☒

1

2.7

2024-06-25 05:35:36

Not Yet

Staff

Total Weight

OK g

NG g

OK pcs

NG pcs

Date

Judgement

Võ Thị Huyền Trang

2.7

2.7

INPUT

0

1

25/06/24

OK

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

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

Location

WH/Fac1/HM

→ WH/Fac1/PL1

Work Date

06/25/2024 08:00:00

→ 06/25/2024 20:00:00

Line

Item

Standby

Operation

Actual

PQC

No

Actual Weight

OK Weight

NG Weight

Actual Qty

OK Qty

NG Qty

Created on

Status

1

2.70

0.00

0.00

1.00

0.00

0.00

06/25/2024 12:35:36

Waiting for PQC

Step by step:

1. Press the “PQC” button to proceed with process inspection.
2. Select an item from a list.
3. Enter check results.
4. Approve by pressing the “Submit” button.



III. Repair Work Order

Lot issuance

- Step by step:
1. Press the “Detail” button to issue the lot.

MES

KPI

PMS

QMS

MMS

Repair

Scrap

Process

Closing Report

Lot/Serial Number

Repair Order / RO/00058 / RMO/00061 / MO/01311

Save

Discard

1 / 1

Cancel

Complete MO

Draft

In Progress

Done

WO List

Product

SEMI-HC-070(6.5)-18K-W-210GR-120-HM

Source Document

RMO/00061

BOM

SEMI-HC-070(6.5)-18K-W-210GR-120-HM

Process & Level

Hand Made & Level 1

Item QC / PQC Form

Item QC Form / PQC Form

Target / Actual Qty

1.00 / 1.00 pcs

Target / Actual Weight

0.00 / 2.70 g

OK / NG Qty

0.00 / 0.00 pcs

OK / NG Weight

2.70 / 0.00 g

Created Date

06/25/2024 09:15:33

Location

WH/FacI/HM → WH/FacI/PL1

Work Date

06/25/2024 08:00:00 → 06/25/2024 20:00:00

Line

Item

Standby

Operation

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	2.70	2.70	0.00	1.00	1.00	0.00	06/25/2024 12:35:36	Waiting for Lot	Detail1



III. Repair Work Order

Issuance of good quality lot

Create Lot

Target / Actual Weight

2.70 / 0.00 g

OK / NG Weight

2.70 / 0.00 g

Type Lot

OK

NG

Target / Actual Qty

1.00 / 0.00 pcs

OK / NG Qty

0.00 / 0.00 pcs

Actual Qty

1.00 pcs

Part Qty

0 pcs

Create

4

Close

MESKPIPMSQSMMSRepairScrapProcessClosing ReportLot/Serial Number

Repair Order / RO/00058 / RMO/00061 / MO/01311 / 1

Edit

Create

Action

1 / 1

<

>

Back

Draft

Waiting for Lot

Waiting for Tray

Done

MMO#

RMO/00061

MO#

MO/01311

Work Date

06/25/2024 12:35:36

Target / Actual Weight

2.70 / 0.00 g

OK / NG Weight

2.70 / 0.00 g

Product

SEMI-HC-070(6.5)-18K-W-210GR-120-HM

BOM

SEMI-HC-070(6.5)-18K-W-210GR-120-HM

Process & Level

Hand Made & Level 1

Target / Actual Qty

1.00 / 0.00 pcs

OK / NG Qty

1.00 / 0.00 pcs

1

OK

NG

2

Lot

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



III. Repair Work Order

Issue of defective lot

- Step by step:
1.

Proceed in the “NG” tab.
2.

Click the “Lot” button to open the input window.
3.

Enter actual quantity.
4.

Issue Lot by pressing the “Create” button.

Create Lot

Target / Actual Weight

10.00 / 0.00 g

OK / NG Weight

0.00 / 10.00 g

Type Lot

OK

NG

Target / Actual Qty

1.00 / 0.00 pcs

OK / NG Qty

0.00 / 0.00 pcs

Actual Qty

1.00

pcs

Edit

Create

Close

Back

MMO#

MO#

Work Date

Target / Actual Weight

OK / NG Weight

RMO/00011

MO/00118

04/02/2024 16:37:10

20.00 / 10.00 g

10.00 / 10.00 g

Product

BOM

Process & Level

Target / Actual Qty

OK / NG Qty

SEMI-SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM

SEMI-SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM

Hand Made & Level 1

100 / 1.00 pcs

100 / 0.00 pcs

OK

NG

Lot

Return NG

Print

Return Order	To	Lot/Serial Number	Weight	Qty	Created on	State



III. Repair Work Order

Change defective product to good product or move to Recasting List

Repair Work Order

Edit

+

Back

MMO#

MO#

CWO#

Process & Level

Product

RMO/00011

MO/00118

1

Hand Made & Level 1

SEMI-SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM

NG Weight

NG Qty

To

Return Order

10.00

1.00

WH/REC

0

MMO#

MO#

Work Date

Target / Actual Weight

OK / NG Weight

OK

NG

Confirm

Close

WO#	Return Order	From	To	Lot/Serial Number	Weight	Qty	Created on
WH/MO/00088	WH/Fac1/HM	WH/REC	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM-10g-1pcs-240402-002	10.00	100	04/02/2024 16:38:52	

Return NG

Print

Release

Return Order	To	Lot/Serial Number	Weight	Qty	Created on	State
WH/REC	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM-10g-1pcs-240402-002	10.00	100	04/02/2024 16:38:52	Done	

- Step by step:
1.

Press the “Release” button to change defective product to good product.
2.

Or press the “Return NG” button to go to MES > MMS > Recasting List.
3.

Confirm the move by pressing the “Confirm” button.
4.

Print QR by pressing the “Print” button.
5.

Click the “Back” button to go to the main page.



III. Repair Work Order

Complete repair work instructions for each process

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Repair Order / RO/00058 / RMO/00061 / MO/01311 / 1 / MO/01311 / MO/01312 / RMO/00061 / RO/00058 / RMO/00061 / MO/01312 / 2 / MO/01312

EditCreate

Action

1 / 1<>

CancelComplete MO

DraftIn ProgressDone

ProductSEMI-HC-070(6.5)-18K-W-210GR-120-POL 1

Source Document

RMO/00061

BOMSEMI-HC-070(6.5)-18K-W-210GR-120-POL 1

Qty

1st Polishing & Level 2

Item QC / PQC FormItem QC Form / PQC Form

1.00 / 1.00 pcs

Target / Actual Weight0.00 / 2.40 g

1.00 / 0.00 pcs

OK / NG Weight2.40 / 0.00 g

06/25/2024 09:15:33

LocationWH/Fac1/PL1 → WH/Fac1/FN2

06/25/2024 08:00:00 → 06/25/2024 20:00:00

ItemStandbyOperation

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	2.40	2.40	0.00	1.00	1.00	0.00	06/25/2024 13:13:48	Done	Detail

Step by step:

1. Click the “Complete MO” button to approve the completion of the process.

** Each MO has the same structure, and when the last MO is completed, RMO is completed simultaneously, and the product moves to OQC.



IV. Recasting List

Recast List Information

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Recasting List

3

Search...

1

▼ Filters

≡ Group By

★ Favorites

1-80 / 139

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	Return Type...	Created on	Process	Line	Step	Type	Product	Lot	Quantity	From	Before	After
☐	Disposal	06/20/2024 09:21:38	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-2024062...	CAS_TRE-25.0g-240620-001	10.00	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Stock	06/18/2024 15:36:28				18K	18K Tem(Y)	18K Tem - MO/00224 - 10 - 10.0 - 24/04/05 - ...	1.00	WH/Material/NG	0.00	0.00
☐	Disposal	06/17/2024 12:38:23	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240617L...	CAS_TRE-2970g-240617-001	37.00	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Disposal	06/17/2024 10:46:40	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240617...	CAS_TRE-296.0g-240617-001	26.00	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Disposal	06/13/2024 14:10:38	Silver Mold				SEMI-S-OV-(8.0X6.0)-CN-42CM-14K-2.06GR...	S-OV-(8.0X6.0)-CN-42CM-14K-2.06GR-W-1-L...	1.90	WH/Facil/Mockup	4.00	3.00
☐	Disposal	06/13/2024 13:56:01	Metal Tree Cutting				SEMI-SILVER TREE-CAS_TRE-20240613135013	CAS_TRE-9.7g-240613-001	5.70	WH/Facil/Mockup	0.00	0.00
☐	Disposal	06/12/2024 16:42:00	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240612L...	CAS_TRE-748.0g-240612-001	598.00	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Disposal	06/12/2024 15:44:21	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240612L...	CAS_TRE-132.5g-240612-001	82.50	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Disposal	06/12/2024 15:35:17	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240612L...	CAS_TRE-21.52g-240612-001	6.52	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Disposal	06/12/2024 14:02:47	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240612L...	CAS_TRE-96.0g-240612-001	71.00	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Stock	06/12/2024 12:43:21					S-BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT*2	S-BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT*2-Sil...	3.34	WH/SilvS/Sheff2	0.00	0.00
☐	Disposal	06/12/2024 10:17:16	Silver Mold				SEMI-S-BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	S-BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT-CAS...	5.00	WH/Facil/Mockup	15.00	10.00
☐	Disposal	06/12/2024 09:22:37	Metal Tree Cutting				SEMI-SILVER TREE-CAS_TRE-20240612091826	CAS_TRE-63.0g-240612-001	48.00	WH/Facil/Mockup	0.00	0.00
☐	Stock	06/11/2024 10:52:17				18K	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT-2g-1pc...	2.00	WH/FG	0.00	0.00
☐	Stock	06/11/2024 10:05:45				18K	SEMI-T4C3-2.0-B	T4C3-2.0-B-CAS_CUT-20.0g-2pcs-240422-...	20.00	WH/Facil/HM	0.00	0.00
☐	Stock	06/11/2024 09:16:53					ALY-FLEXIAI62-18K-W	ALY-FLEXIAI62-18K-W-240404-DCL-O13ZY-3...	10.00	WH/Material/Stock	0.00	0.00
☐	Stock	06/06/2024 15:17:57				18K	18K Tem(Y)	18K Tem - MO/00224 - 10 - 10.0 - 24/04/05 - ...	1.00	WH/Material/NG	0.00	0.00
☐	Disposal	06/04/2024 09:14:18	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-2024060...	CAS_TRE-343.0g-240604-001	33.00	WH/Facil/Metal Tree Cutting	0.00	0.00
☐	Scrap	05/29/2024 09:08:54	Hand Made		Hand Made	18K	18K-W-GoldTree	18K-W-GoldTree-HM-11110g-1pcs-240529-001	1,111.00	WH/Facil/HM	0.00	0.00

- Step by step:
1. Search function.
 2. Displays the remaining amount of gold to be returned to the mint and a list of defective products. This applies to PMO Disposal, defective semi-finished products and finished products that cannot be repaired in each process, Return to Casting in the Daily Closing Report, and gold materials determined to be returned from each WMS warehouse to the casting room.
 3. Excel conversion function.



IV. Recasting List

Recast List Information

✱

Recasting Action

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Return To

3

Alloy

Metal Tree

Alloy Product

4

18K-W-GoldTree

✕

Lot

Product	Lot	Quantity
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803	CAS_TRE-748.0g-240612-001	598.00 ✕
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612153809	CAS_TRE-132.5g-240612-001	82.50 ✕
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612152527	CAS_TRE-21.52g-240612-001	6.52 ✕

Add a line

Confirm 5

Cancel

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Recasting List

Search...

Create Recasting Order3 selected

ActionFiltersGroup ByFavorites1-80 / 139

	Return Type...	Created on	Process	Line	Step	Type	Product	Lot	Quantity	From	Before	After
☐	Disposal	06/13/2024 13:56:01	Metal Tree Cutting				SEMI-SILVER TREE-CAS_TRE-20240613135013	CAS_TRE-97g-240613-001	5.70	WH/FacI/Mockup	0.00	0.00
☒	Disposal	06/12/2024 16:42:00	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-202406121...	CAS_TRE-748.0g-240612-001	598.00	WH/FacI/Metal Tree Cutting	0.00	0.00
☒	Disposal	06/12/2024 15:44:21	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-202406121...	CAS_TRE-132.5g-240612-001	82.50	WH/FacI/Metal Tree Cutting	0.00	0.00
☒	Disposal	06/12/2024 15:35:17	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-202406121...	CAS_TRE-21.52g-240612-001	6.52	WH/FacI/Metal Tree Cutting	0.00	0.00
☒	Disposal	06/12/2024 14:02:47	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-202406121...	CAS_TRE-96.0g-240612-001	71.00	WH/FacI/Metal Tree Cutting	0.00	0.00
☐	Stock	06/12/2024 12:43:21					S-BP-T2C-3.5-18K-769GR-W-F-8-12CT+2	S-BP-T2C-3.5-18K-769GR-W-F-8-12CT+2-Sil...	3.34	WH/SilvS/Sheff2	0.00	0.00

- Step by step:
1.

Select the item you wish to return from the list. The location of the From column must be the same, the process of the Process column must be the same, and the gold purity (18K/14K) must be the same.
2.

Click the “Create Recasting Order” button to create a return order.
3.

Specify the location for return.
4.

Specifies the type of alloy to be returned and cast.
5.

Click the “Confirm” button to confirm.



V. Recasting Order

List of recast return instructions

Step by step:

1. Search function.
2. Download function as Excel.
3. Generate return order button.
4. Displays the list of return instructions generated by the “Recasting List” function. The most recently created return order is at the top of the list. Select the relevant instruction sheet and proceed with the return process.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Recasting Order

Search...

FiltersGroup ByFavorites

1-71 / 71

Create

Return Type	Reference	Created on	Product	Lot	From	To	Total Qty	Line	Process	Step	Status
☐	Disposal Return	WH/WARET/00086	06/25/2024 14:09:50	SEMI-18K-W-GOLDTREE-CAS_TR... SEMI-18K-W-GOLDTREE-CAS_TR... SEMI-18K-W-GOLDTREE-CAS_TR...	CAS_TRE-748.0g-240612-001 CAS_TRE-132.5g-240612-001 CAS_TRE-21.52g-240612-001	WH/Fac1/Metal Tree Cutting	WH/Fac1/Alloy	687.02	Metal Tree Cutting		Operation
☐	Repair Return	WH/WARET/00085	06/17/2024 14:40:14	SEMI-HC-070(6.5)-18K-W-2.10gr...	HC-070(6.5)-18K-W-2.10gr-1.20~...	WH/REC	WH/Fac1/Alloy	1.50	1st Polishing		Done
☐	Disposal Return	WH/WARET/00084	06/14/2024 15:11:52	SEMI-18K-W-GOLDTREE-CAS_TR...	CAS_TRE-64.0g-240613-001	WH/Fac1/Metal Tree Cutting	WH/Fac1/Alloy	29.00	Metal Tree Cutting		Operation
☐	Scrap Return	WH/WARET/00080	06/13/2024 15:20:04	18K-W-GoldTree	18K-W-GoldTree-HM-100.0g-1pc... 18K-W-GoldTree-HM-10.0g-1pcs...	WH/Fac1/HM	WH/Fac1/Alloy	110.00	Hand Made		Operation
☐	Repair Return	WH/WARET/00078	06/13/2024 15:19:28	SEMI-HC-070(6.5)-18K-W-2.10gr...	HC-070(6.5)-18K-W-2.10gr-1.20~... HC-070(6.5)-18K-W-2.10gr-1.20~...	WH/REC	WH/Fac1/Alloy	3.30			Operation
☐	Disposal Return	WH/WARET/00073	06/13/2024 15:08:14	SEMI-18K W Cutting Plate T4C3	18K W Cutting Plate T4C3-CAS_...	WH/Fac1/HM	WH/Fac1/Alloy	52.00	Hand Made		Operation
☐	Scrap Return	WH/WARET/00067	06/10/2024 14:32:56	18K-W-GoldTree	18K-W-GoldTree-HM-12.0g-1pcs...	WH/Fac1/HM	WH/Fac1/Alloy	12.00	Hand Made		Done
☐	Scrap Return	WH/WMTRET/000...	06/10/2024 14:31:02	18K-W-GoldTree	18K-W-GoldTree-HM-10.0g-1pcs...	WH/Fac1/HM	WH/Fac1/Metal Tree	10.00	Hand Made		Done
☐	Scrap Return	WH/WARET/00066	06/10/2024 14:28:33	18K-W-GoldTree	18K-W-GoldTree-CAS_CUT-10.0...	WH/Fac1/Metal Tree Cutting	WH/Fac1/Alloy	10.00	Metal Tree Cutting		Cancelled
☐	Scrap Return	WH/WARET/00065	05/29/2024 08:58:44	18K-W-GoldTree	18K-W-GoldTree-HM-1.0g-1pcs...	WH/Fac1/HM	WH/Fac1/Alloy	1.00	Hand Made		Cancelled
☐	Scrap Return	WH/WARET/00064	05/28/2024 13:13:46	18K-W-GoldTree	18K-W-GoldTree-CUT-10.0g-1pc...	WH/Fac1/Cutting	WH/Fac1/Alloy	10.00	Cutting		Operation
☐	Scrap Return	WH/WARET/00063	05/28/2024 08:47:42	18K-W-GoldTree	18K-W-GoldTree-CAS_TRE-1000...	WH/Fac1/Metal Tree	WH/Fac1/Alloy	10,000.00	Metal Tree		Operation
☐	Stock Return	WH/WARET/00062	05/23/2024 13:24:14	SEMI-18K-W-GOLDTREE-CAS_TR...	CAS_TRE-198.0g-240523-001	WH/Fac1/Metal Tree Cutting	WH/Fac1/Alloy	78.00			Operation
☐	Stock Return	WH/WARET/00061	05/23/2024 10:13:01	SEMI-T4C3-(2.0-3.5)-17inch-18...	T4C3-(2.0-3.5)-17inch-18K-W-2...	WH/Fac1/PL1	WH/Fac1/Alloy	9.00			Done
☐	Stock Return	WH/WARET/00060	05/22/2024 13:16:11	S-HC-070(6.5)-18K-W-2.10gr-1.2... S-TN-1160-2.0+1	S-HC-070(6.5)-18K-W-2.10gr-1.2... S-TN-1160-2.0+1-240402-001	WH/SilvS	WH/Fac1/Alloy	11.00	Silver Mold		Done
☐	Stock Return	WH/WARET/00059	05/22/2024 10:30:19	S-HC-070(6.5)-18K-W-2.10gr-1.2...	S-HC-070(6.5)-18K-W-2.10gr-1.2...	WH/SilvS	WH/Fac1/Alloy	45.00			Done



V. Recasting Order

Check the weight of gold material returned to the casting room

- Step by step:
1. Casting room personnel check incoming weight.
 2. Confirm by pressing the “Validate” button.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Recasting Order / WH/WARET/00086

EditCreate

PrintAction

1 / 71

Validate2Cancel

DraftOperationDone

☆ WH/WARET/00086

Return Type

Source Document

Product

From

To

Process

Disposal Return

Recasting Order

SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803

WH/FacI/Metal Tree Cutting

WH/FacI/Alloy

Metal Tree Cutting

Actual Qty

Total Qty

Gap Qty

Alloy Product

New Lot

1

0.00

687.02

0.00

18K-W-GoldTree

Input

ItemOrderScrap

Product	Lot No	Qty
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803	CAS_TRE-748.0g-240612-001	598.00
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612153809	CAS_TRE-132.5g-240612-001	82.50
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612152527	CAS_TRE-21.52g-240612-001	6.52



V. Recasting Order

New lots and storage locations for gold material returned to the mint.

Step by step:

1. Issuance of new lots of gold material returned to the mint.
2. Returned materials are stored in inventory at the relevant location.

MESKPIPMSQMSMMSRepairScrapProcessClosing ReportLot/Serial Number

Recasting Order / WH/WARET/00086

Edit+ CreatePrintAction1 / 71

DraftOperationDone

☆ WH/WARET/00086

Return Type

Source Document

Product

From

To

Process

Disposal Return

Recasting Order

SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803

WH/FacI/Metal Tree Cutting

WH/FacI/Alloy

Metal Tree Cutting

Actual Qty

Total Qty

Gap Qty

Alloy Product

New Lot

687.02

687.02

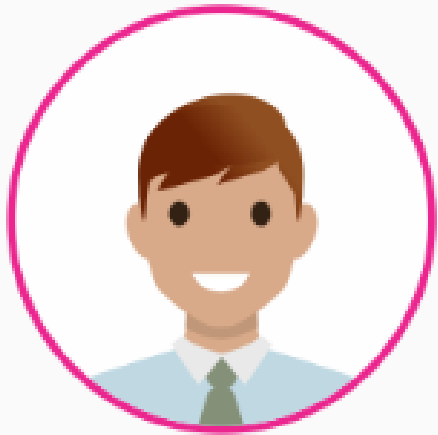
0.00

18K-W-GoldTree

18KWGOLDTREE-CAS_CUT-687.02-1-240625-001

ItemOrderScrap

Product	Lot No	Qty
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803	CAS_TRE-748.0g-240612-001	598.00
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612153809	CAS_TRE-132.5g-240612-001	82.50
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612152527	CAS_TRE-21.52g-240612-001	6.52



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