For Smart Factory



Operating User MANUAL



ERP + MES + SCADA



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User Manual

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생산 공정에서 발생한 불량 완제품 목록 조회

HES KPI PMS QMS N	иMS Repair	Scrap Proce	ess Closing Report	Lot/Serial Number							* 🐋	୍ତ
Repair Stock					■ Product ¥	Search	1					Q
± 3					▼ Filters ≡ G	Group By	★ Favorites				1-32 / 32	< >
Product	Location	Lot/Serial Number						Package	Available Quantity	On Hand Quantity	Unit of Me	asure
• SEMI-TBC-900-3.0-7.00inch-18K-W-9.59gr-	-F-40-4CT (8)								72.00	72.00		
• SEMI-SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25	5.02gr-5.12-HM-	-HM (1)							10.00	10.00		
▶ S-TB-FC(LT)-079+1(1)									5.00	5.00		
▶ S-HC-070(6.5)-18K-W-2.10gr-1.20+2 (2)									3.00	3.00		
▶ S-HC-070(6.5)-18K-W-2.10gr-1.20+1 (1)				2					15.00	15.00		
▶ 18K W Cutting Plate T4C3 (8)									32.20	32.20		
▼ HC-070(6.5)-18K-W-2.10gr-1.20 (8)									16.61	18.01		
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-12.0g-5.0g	-3.0pcs-240604-240409-	VN-001				0.00	1.40	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-44g-10pcs	-240402-VN-001-NG-001					4.40	4.40	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-15.3g-6pcs	-240419-VN-001-NG-001					4.00	4.00	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-6.300000	00000001g-3pcs-24041	5-VN-001-NG-00	01			1.00	1.00	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-2g-1pcs-24	40514-VN-ABD-001					2.00	2.00	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-1.4g-1pcs-2	240409-VN-001-NG-003					1.22	1.22	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-1.9g-1pcs-2	240531-VN-001					1.90	1.90	g	
HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-V	V-2.10gr-1.20-2.09g-1pcs	-240617-VN-001					2.09	2.09	g	



- 실행 순서 & 기능 :
- 1. 검색 기능.
- 생산 공정에서 발생한 불량 완제품 목록.
- 3. 엑셀로 다운로드 기능.

I. Stock

불량 완제품 선택 및 처리 기능 설명

MES KPI PMS QMS MMS Rep	ir Scrap Process Closing Report Lot/Serial Number		* 🔊 (¢
Repair Stock	E Product * Search_		٩
Repair Recasting Split Lot Me	rge Lots 1 selected → Print • Action ▼ Filters ≡ Group By ★ Favorites		1-32 / 32 < 🔪
Product Location	Lot/Serial Number	Package Available Quantity	On Hand Quantity Unit of Measure
SEMI-TBC-900-3.0-7.00inch-18K-W-9.59gr-F-40-4CT (8)	72.00	72.00
SEMI-SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-H	м-нм (1)	10.00	10.00
S-TB-FC(LT)-079+1(1)		5.00	5.00
S-HC-070(6.5)-18K-W-2.10gr-1.20+2 (2)		3.00	3.00
S-HC-070(6.5)-18K-W-2.10gr-1.20+1 (1)		15.00	15.00
18K W Cutting Plate T4C3 (8)		32.20	32.20
+ HC-070(6.5)-18K-W-2.10gr-1.20 (8)		16.61	18.01
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-12.0g-5.0g-3.0pcs-240604-240409-VN-001	0.00	1.40 g
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-44g-10pcs-240402-VN-001-NG-001	4.40	4.40 g
070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-15.3g-6pcs-240419-VN-001-NG-001	4.00	4.00 g
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-6.300000000000001g-3pcs-240415-VN-001-NG-001	1.00	1.00 g
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-2g-1pcs-240514-VN-ABD-001	2.00	2.00 g
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-1.4g-1pcs-240409-VN-001-NG-003	1.22	1.22 g
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-1.9g-1pcs-240531-VN-001	1.90	1.90 g
HC-070(6.5)-18K-W-2.10gr-1.20 WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-2.09g-1pcs-240617-VN-001	2.09	2.09 g



- 1. 목록에서 처리할 불량 완제품 선택.
- "Repair" 버튼을 눌러 수리 지시서 발행 가능.
- "Recasting" 버튼을 눌러 재주조를 위해 MES > MMS > Recasting List로 이동 가능(해당 기능은 MMS 매뉴얼 참조).
- 4. 해당 불량품의 분할 기능.
- 분할된 불량품의 병합 기능(분할된 불량품만 병합 가능).

수리 지시서 발행할 불량 완제품 선택

	🙀 Repair Center Actio	n					×
	Туре	Repair					
	Lot						
	Product		Lot/Serial Number	Available Quantity	Quantity	Unit of Measure	
	HC-070(6.5)-18K-W-2.10gr-1	1.20	HC-070(6.5)-18K-W-2.10gr-1.20-44g-10pcs-240402-VN-001-NG-001	4.40	4.40	g	
••• N							
Repa							٦
Re							
2							
SEMI-	Confirm 3 Cancel						
SEMI-							_
S-TB-F	FC(LT)-079+1 (1)				5.00	5.00	
S-HC-	070(6.5)-18K-W-2.10gr-1.20+2 (2)				3.00	3.00	
S-HC-	070(6.5)-18K-W-2.10gr-1.20+1 (1)				15.00	15.00	
18K W	Cutting Plate T4C3 (8)				32.20	32.20	
HC-07	70(6.5)-18K-W-2.10gr-1.20 (8)				16.61	18.01	
•	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-12.0g-5.0g-3.0pcs-240604-240409-VN-001		0.00	1.40 g	
	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-44g-10pcs-240402-VN-001-NG-001		4.40	4.40 g	
	070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-15.3g-6pcs-240419-VN-001-NG-001		4.00	4.00 g	
•	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-6.3000000000000001g-3pcs-240415-VN-001-NG-001		1.00	1.00 g	
ŀ	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-2g-1pcs-240514-VN-ABD-001		2.00	2.00 g	
- H	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-1.4g-1pcs-240409-VN-001-NG-003		1.22	1.22 g	
•	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-1.9g-1pcs-240531-VN-001		1.90	1.90 g	
•	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-210gr-1.20-2.09g-1pcs-240617-VN-001		2.09	2.09 g	

Explain

- 1. 목록에서 수리할 불량 완제품 선택.
- "Repair" 버튼을 눌러 해당 불량품의 수리 지시 팝업 오픈.
- 3. "Confirm" 버튼을 누르면 Repair Order 생성.

II. Repair Order

수리 지시서 목록 조회

	MMS Repair Scrap Proces	ss Closing Report Lot/Serial Number		* 🔍 C ⁵
Repair Order			þearch_ 1	۵
+ Create 3 ± 2			▼ Filters ≡ Group By ★ Favorites	1-52 / 52 < >
Name	Source	State	Created on	Created by
RO/00056	WH/REC	Draft 4	06/24/2024 16:47:15	Administrator
RO/00055	WH/REC	Confirmed	06/21/2024 13:32:00	Administrator
RO/00054	WH/REC	Done	06/17/2024 15:09:34	Administrator
RO/00053	WH/REC	Draft	06/04/2024 13:22:05	Administrator
RO/00052	WH/REC	Confirmed	05/31/2024 10:57:19	my2
RO/00051	WH/REC	Done	05/31/2024 10:15:23	Administrator
RO/00050	WH/REC	Done	05/31/2024 09:39:51	KHC
RO/00049	WH/REC	Confirmed	05/31/2024 08:05:40	my2
RO/00048	WH/REC	Confirmed	05/31/2024 08:04:59	KHC
RO/00047	WH/REC	Confirmed	05/22/2024 16:05:19	KHC
RO/00046	WH/REC	Done	05/22/2024 15:42:45	KHC
RO/00045	WH/REC	Confirmed	05/22/2024 10:13:23	KHC
RO/00044	WH/REC	Done	05/22/2024 10:13:12	KHC
RO/00043	WH/REC	Done	05/17/2024 13:48:14	KHC
RO/00042	WH/REC	Confirmed	05/16/2024 14:47:09	KHC
RO/00040	WH/REC	Draft	05/14/2024 15:18:50	Administrator
RO/00039	WH/REC	Done	05/14/2024 15:07:26	KHC
RO/00038	WH/REC	Done	05/14/2024 14:22:00	KHC
RO/00037	WH/REC	Done	05/06/2024 09:33:33	my



- 실행 순서 & 기능 :
- 1. 검색 기능.
- 2. 엑셀로 다운로드 기능.
- 3. 신규 수리 지시서 생성 버튼.
- Repair Stock에서 승인한 수리 지시서가 자동으로 목록에 표시됨. 해당 지시서를 선택해서 수리 진행.

II. Repair Order

수리 지시서 승인

	MMS Repair	Scrap Proces	s Closing Report	Lot/Serial Number							÷		ୈ
Repair Order / RO/00058													
✓ Save X Discard											1/5	52	>
Confirm Cancel										Draft	Confirme	ed	Done
RO/00058													
Source	WH/REC				Create Date			06/25/2024 09:11:48					
					Created by			Administrator					
Order Repair													
Product	Lot				Qty	Weight	Reason		Routing	Remark	Repair WO		
HC-070(6.5)-18K-W-2.10gr-1.20	HC-070(6.5)-18k	(-W-2.10gr-1.20-2.1g-1	pcs-240625-VN-001		1.00	2.10	Poor Work	manship Soldering/Filing	2	•			Û
Add a line									HM POL	FIN			
									FIN HM(CHE O) POL FIN			
									FIN HM(CHE X) POL FIN			
									FIN POL	FIN			
									HM(CHE	O) POL FIN			
									POL				
									TEST				
									Start ty	ping			



- 1. "Repair" 탭에서 진행.
- 2. Routing 칼럼의 드롭다운 항목에서

 해당 불량품을 수리 진행할 공정

 목록을 선택(공정 목록은 MES >

 Process > Repair Process에서

 만들어진 목록이 보여 짐).
- 3. "Confirm" 버튼을 눌러 승인.

II. Repair Order

불량품 별 수리 작업 지시서 확인

MES	KPI P	MS	QMS	MMS	Repair	Scrap	Process	Closing Report	rt Lot/Se	erial Number								÷.	2	ୈ
Repair Orde	er / RO/0	0058	3																	
🖋 Edit	+ Crea	ite								• Action								1/	52	>
Cancel																	Draft	Confirm	d	Done
																	2		ŧ	
RO/OC	0058																			
Source				WH/R	EC						Create Da	ate			06/25/2024 09:11:48					
											Created I	ру			Administrator					
Order	Repair																			
Product				Lot							Qty		Neight	Reason		Routing	Remark	Repair WC		
HC-070(6.5)-18K-W-2.1	Ogr-1.2	0	HC-07	70(6.5)-18K	-W-2.10gr-1	.20-2.1g-1pcs	-240625-VN-00	01		1.00		2.10	Poor Work	kmanship Soldering/Filing	HM POL FIN		RMO/000	51	Û
Add a line																		1		



- 1. 불량품 별 수리 작업 지시서가 Routing에 지정된 공정에 맞춰 생성됨.
- 해당 항목을 눌러 마스터 수리 작업 지시서로 이동.

III. Repair Work Order

마스터 수리 작업 지시서에서 자재 추가(선택 사항)

Â	Add material							×	
N	0#	MQ/01311							
P	ocess	Hand Made							
	Antoniol -								
	EMI-HC-070(6 5)-18K-W-210gr	-120					m		
1	BK Tem(Y)	2					C 🖻		
4	dd a line								
								_1	65
								~	Ŭ
e									
	Confirm 3 Close							1/1	< >
Ca	ncei					Uratt Commed	IN Pro	gress	Done
							мо	List	
		1					🔳 мо	List	
Proc	iuct	HC-070(6.5)-18K-W-210gr-120	Created Date		06/25/2024 09:15:33	- 05/25/2024 20:00:00	і мо	List	
Proc Targ	uct et / Actual Weight cast	HC-070(6.5)-18K-W-2.10gr-1.20 2.10 / 0.00 g	Created Date Work Date Target / Actual	Qty	06/25/2024 09:15:33 06/25/2024 02:15:33	→ 06/25/2024 20:00:00	ৗ МО	List	
Proc Targ Is Re Rep:	uet et / Actual Weight cast air	HC-070(6.5)-18K-W-210gr-1.20 210 / 0.00 g 3 R0/00058	Created Date Work Date Target / Actual Remark	Qty	06/25/2024 09:15:33 06/25/2024 02:15:33 100 / 0.00	→ 06/25/2024 20:00:00	мо	List	
Proc Targ Is Re Rep:	uot et / Actual Weight cast iir	HC-070(6.5)-18K-W-2.10gr-1.20 210 / 0.00 g 3 R0/00058	Created Date Work Date Target / Actual Remark	Qty	06/25/2024 09:15:33 06/25/2024 02:15:33 100 / 0.00	→ 06/25/2024 20:00:00	мо	List	
Proc Targ Is Re Rep M	uet et / Actual Weight cast hir DList MO Setting	HC-070(6.5)-18K-W-210gr-1.20 210 / 0.00 g 3 RO/00058	Created Date Work Date Target / Actual Remark	Qty	06/25/2024 09:15:33 06/25/2024 02:15:33 100 / 0.00	→ 06/25/2024 20:00:00	МО	List	
Proc Targ Is Re Rep M	uct et / Actual Weight cast sir D List MO Setting Reference Level Process	HC-070(6.5)-18K-W-2.10gr-1.20 210 / 000 g 3 RO/00058 Product	Created Date Work Date Target / Actual Remark	Qty Target Weight Actual V	06/25/2024 09:15:33 06/25/2024 02:15:33 100 / 0.00 Veig Actual Previous	→ 06/25/2024 20:00:00 Materials	MO	List	
Proc Targ Is Re Rep:	uot et / Actual Weight cast air D List MO Setting Reference Level Process MO/01311 1 Hand Ma	HC-070(6.5)-18K-W-2.10gr-1.20 210 / 0.00 g 3 RO/00058 Product 9 SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	Created Date Work Date Target / Actual Remark BOM SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	Qty Target Weight Actual V 0.00	06/25/2024 09:15:33 06/25/2024 02:15:33 100 / 0.00 Veig Actual Previous 0.00 0.00	→ 06/25/2024 20:00:00 Materials (SEMI-HC-070(6.5)-18K-W-2.10gr_)	Status Draft	List	
Proc Targ Is Re Rep. Mu	uct et / Actual Weight cast hir D List MO Setting Reference Level Process MO/01311 1 Hand Ma MO/01312 2 1st Polish	HC-070(6.5)-18K-W-210gr-1.20 2.10 / 0.00 g 3 RO/00058 Product be SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM mg SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-PL	Created Date Work Date Target / Actual Remark BOM SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM 1 SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-POL 1	Qty Target Weight Actual V 0.00 0.00	06/25/2024 09:15:33 06/25/2024 02:15:33 100 / 0.00 Veig Actual Previous 0.00 0.00	→ 06/25/2024 20:00:00 Materials (SEMI-HC-070(6.5)-18K-W-210gr_)	Status Draft Draft	List + add + add	



실행 순서 & 기능 :

- 1. 수리 시 자재가 필요한 공정 오른쪽의 "add" 버튼을 눌러 자재 추가 창 오픈.
- 2. 팝업 창에서 필요한 자재 추가.
- 3. "Confirm" 버튼을 눌러 승인.

III. Repair Work Order

마스터 수리 작업 지시서에서 자재 추가(선택 사항)

MES	KPI F	PMS	QMS M	IMS Repair	Scrap	Process	Closing Report	Lot/Serial Number								¥ 🐋	୍
Repair Ord	der / RO/C	0005	B / RMO/C	0061													
🖋 Edit	+ Crea	ate						Action								1/1	< >
Cancel													Draft	Confirmed	In Prog	gress	Done
															MO L	_ist	
Product				HC-070(65)-1	8K-W-210gr	-120			Created Date		06/2	5/2024 09:15:33					
T					2.08				West Date		00/0	5/0004 0015-00					
Target / Ac	tuai weight			2.10 / 0.00 g					work Date		06/2	5/2024 02:15:33 -	• 06/25/2024 20:0	00:00			
ls Recast				(*)					Target / Actual	Qty	1.00	/ 0.00					
Repair				RO/00058					Remark								
MO List	MO Settir	ng															
Refe	rence	Level	Process	Product			BOM			Target Weight	Actual Weig	Actual Previous	Materials	S	itatus		-
C MO/0	01311		1 Hand Made	SEMI-HC-07	O(6.5)-18K-\	N-2.10GR-1.20-1	HM SEMI-HC-07	'0(6.5)-18K-W-2.10GR-	1.20-HM	0.00	0.00	0.00	SEMI-HC-070(6.5)-18K-W-2.10gr)	Draft	+ add	Û
C MO/0	01312		2 1st Polishin	g SEMI-HC-07	0(6.5)-18K-\	N-2.10GR-1.20-I	POL 1 SEMI-HC-07	'0(6.5)-18K-W-2.10GR-	1.20-POL 1	0.00	0.00	0.00			Draft	+ add	Û
☑ MO/0	01313		3 2nd Finishi	ng HC-070(6.5)	-18K-W-2.10	gr-1.20	HC-070(6.5))-18K-W-2.10gr-1.20 - 2	2024-06-25 09:15:	0.00	0.00	0.00			Draft	+ add	Û



실행 순서 & 기능 :

1. 추가한 자재가 표시됨.

III. Repair Work Order

공정 별 수리 작업 지시서 진행

Zeitt + Create 0 Action 1/1 < 1 Cancel Oxforded in Progress in Progress One Cancel Cancel Oxforded in Progress One Freduct HC-070(65)-18K-W-210g-120 Created Date 06/25/2024 0215.33 Oxforded Oxforded Oxforded In Progress	MES	KPI F	PMS	QMS M	IMS Re	epair S	Scrap	Process	Closing Report	Lot/Ser	al Number									# 🔍	' ୯
Édit Cancel Control MO List MO List MO List Cancel Cancel Cancel Cancel Control Cancel Control Cancel Control Cancel Cancel Cancel Cancel Cancel Control Cancel Control Cancel Control Control Control Control Control Control Control Control Control	Repair Orde	er / RO/C	0005	<mark>8 /</mark> RMO/C	0061																
Cancel Drat Continued In Progres Dank Cancel Cancel Continued In Progres Dank Continued In Progres Dank Product HC-070(65)-18K-W-210gr-120 Created Date 06/25/2024 0915.33 06/25/2024 0200.00 In Progres MO List Product HC-070(65)-18K-W-210gr-120 Work Date 06/25/2024 0215.33 - 06/25/2024 0200.00 In Progres In P	🖋 Edit	+ Cre	ate								Action									1/1	< >
Mo List HC-070(6.5)-18K-W-2.10gr-1.20 Created Date 06/25/2024 0.915.33 Target / Actual Weight 2.10 / 0.00 g Work Date 06/25/2024 0.215.33 - 0.06/25/2024 20.00.00 Is Recast Image / Actual Oty 100 / 0.00 00/25/2024 0.215.33 0.06/25/2024 0.215.33 Repair R0/00058 Remark 100 / 0.00 Image / Actual Oty 100 / 0.00 Mo List Mo List Mo List Image / Actual Oty Image / Actual Ot	Cancel																Draft	Confirmed	In Pr	ogress	Done
Product HC-070(6.5)-18K-W-210gr-1.20 Created Date 06/25/2024 09:5.33 06/25/2024 00:0.00 Target / Actual Weight 20 / 0.00 g Work Date 06/25/2024 00:5.33 → 06/25/2024 20:00:00 Target / Actual Qty 00 / 0.00 00 / 0.00 Target / Actual Qty 00 / 0.00 00 / 0.00 Reference Level Proces Podutt BOM Target Weight Actual Previous Materials Status. I Polo181 1 Hundwiss StMI-HC-070(6.5)-18K-W-210GR-120-HU StMI-HC-070(6.5)-18K-W-210GR-120 -HU 0.00 O00 StMI-HC-070(6.5)-18K-W-210GR-120 -HU Ister Previous Materials Status. I V MO/01812 2 18 Hole-0.070(6.5)-18K-W-210GR-120 -HU Status-120 -HU 0.00 0.00 Status-120 - I Ister Previous Materials Status. I I Ister Previous Materials Status. I I Ister Previous Materials Status. I I I Ister Previous Materials Status. I I I I Ister Previous Materials Status. I I I																			мс) List	
Froduct FC-070(65)-18K-W-210gF-120 Created Date OS/25/2024 05:03 Target / Actual Weight 210 / 0.00 g Work Date 06/25/2024 02:05:33 → 06/25/2024 02:00:00 Is Recast Imaget / Actual Qty 06/25/2024 02:15:33 → 06/25/2024 02:00:00 000 / 0.00 Is Recast Imaget / Actual Qty 00/00058 Imaget / Actual Qty 00/000 / 0.00 Mollist MOlesting Molesting Imaget / Actual Weight Actual Weight Actual Weight Actual Weight Actual Weight Status Imaget / status <thimaget status<="" th=""> Imaget / st</thimaget>	Dreduct				110,070(0	5) 10K M	0.10 - 1	20				Created Data			00/25/20	24.00:15:22					
Target / Actual Weight 210 / 0.00 g Work Date 06/25/2024 02:05:33 → 06/25/2024 02:00:00 Is Recast O O Io	Product				HC-070(6	5.5J-18K-VV	-2.10gr-1.	.20				Created Date			06/25/20	724 09:15:55					
Is Recast Image: Actual Qty Image: Act	Target / Acto	ual Weight			2.10 / 0.0	00 g						Work Date			06/25/20	024 02:15:33 -	• 06/25/2024 20	00:00:00			
Repair R0/0058 Remark MO List MO Setting Reference_ Level Process Product BOM Target Weight Actual Weig. Actual Previous Materials Status I MO/DISI1 1 Hand Made SEMI-HC-070(65)-18K-W-210GR-120-HM BOM Target Weight Actual Weig. Actual Previous Materials Status I MO/DISI1 1 Hand Made SEMI-HC-070(65)-18K-W-210GR-120-HM 0.00 0.00 CEMI-HC-070(65)-18K-W-210Gr-120-HM I MO/DISI2 2 1st Polishing SEMI-HC-070(65)-18K-W-210GR-120-POL1 0.00 0.00 0.00 Defit I + add I MO/DISI2 2 1st Polishing SEMI-HC-070(65)-18K-W-210GR-120-POL1 0.00 0.00 0.00 Defit I + add I MO/DISI2 3 2 nd Finishing HC-070(65)-18K-W-210gr-120 HC-070(65)-18K-W-210gr-120 0.00 0.00 0.00 Defit I + add I	ls Recast				8							Target / Actual (Qty		1.00 / 0.	.00					
Reference Level Process Product BOM Target Weight Actual Weig Actual Previous Materials Status Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-HM SEMI-HC-070(6.5)-18K-W-210Gr-120-HM 0.00 0.00 SEMI-HC-070(6.5)-18K-W-210Gr-120-HM Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-HM 0.00 0.00 SEMI-HC-070(6.5)-18K-W-210Gr-120-HM Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-HM 0.00 0.00 0.00 SEMI-HC-070(6.5)-18K-W-210Gr-120-HM Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-HM 0.00 0.00 0.00 Contait # add Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-POL1 0.00 0.00 0.00 Defitie # add Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-POL1 0.00 0.00 0.00 Defitie # add Image: SEMI-HC-070(6.5)-18K-W-210Gr-120-POL1 0.00 <th< td=""><td>Repair</td><td></td><td></td><td></td><td>RO/00058</td><th>В</th><td></td><td></td><td></td><td></td><td></td><td>Remark</td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td><td></td></th<>	Repair				RO/00058	В						Remark									
Reference Level Process Product BOM Target Weight Actual Weig Actual Previous Materials Status I MO(01311 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 SEMI-HC-070(6.5)-18K-W-210GR-120-HM 0.00 SEMI-HC-070(6.5)-18K-W-210GR-120-HM 0.00 SEMI-HC-070(6.5)-18K-W-210GR-120-HM 0.00 SEMI-HC-070(6.5)-18K-W-210GR-120-HM 0.00 0.00 SEMI-HC-070(6.5)-18K-W-210GR-120-HM SEMI-HC-070(6.5)-18K-W-210GR-120-HM SEMI-HC-070(6.5)-18K-W-210GR-120-HM SEMI-HC-070(6.5)-18K-W-210GR-120-HM SEMI-HC-070(6.5)-18K-W-210GR-120-HM SEMI-HC-070(6.5)-18K-W-210GR-120-HM	MO List	MO Settir	ng																		
C NO/01311 1 Hand Made SEMI-HC-070(6.5)-18K-W-210GR-120-HM 0.00 0.00 SEMI-HC-070(6.5)-18K-W-210gr. Draft + add 1 1 1 1 Hand Made SEMI-HC-070(6.5)-18K-W-210GR-120-HM 0.00 0.00 SEMI-HC-070(6.5)-18K-W-210gr. Draft + add 1 1 1 1 Hand Made SEMI-HC-070(6.5)-18K-W-210GR-120-POL 1 0.00 0.00 Optimit + add 1 1 1 1 1 0.00 0.00 0.00 0.00 0.00 Draft + add 1 1 1 1 0.00 0.00 0.00 0.00 0.00 Draft + add 1 1 1 1 0.00 0.00 0.00 0.00 0.00 Draft + add 1 1 1 1 1 0.00 0.00 0.00 0.00 Draft + add 1 1 1 1 1 0.00 0.00 0.00 0.00 Draft + add 1	Refere	ence	Level	Process	Produc	t			BOM				Target Weight	Actual W	eig Ac	tual Previous	Materials		Status		÷
C MO/01312 2 1st Polishing SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-POL 1 SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-POL 1 0.00 0.00 0.00 Draft + add 1 C MO/01312 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	C MO/01	311		1 Hand Made	SEMI-H	C-070(6.5	i)-18K-W-	-2.10GR-1.20-	HM SEMI-HC-(070(6.5)-18	-W-2.10GR-	1.20-HM	0.0	00	0.00	0.00	SEMI-HC-070(6 (18K Tem(Y))	.5)-18K-W-2.10gr)	Draft	+ add	÷
[2] 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 th	☑ MO/01	312		2 1st Polishin	g SEMI-H	C-070(6.5)-18K-W-	-2.10GR-1.20-	POL 1 SEMI-HC-(070(6.5)-18	-W-2.10GR-	1.20-POL 1	0.0	00	0.00	0.00			Draft	+ add	Û
	☑ MO/01	313		3 2nd Finishi	ng HC-070	0(6.5)-18K-	-W-2.10gr	-1.20	HC-070(6	.5)-18K-W-2	10gr-1.20 - 2	024-06-25 09:15:	0.0	00	0.00	0.00			Draft	+ add	Û



실행 순서 & 기능 :

 수리를 진행할 공정의 왼쪽 화살표 버튼을 눌러 진행.

III. Repair Work Order

공정 별 수리 작업 지시서 진행

E MES KPI PMS QMS I	MMS Repair Scrap Process Closing Report Lo	ot/Serial Number		* 剩 🖑
Repair Order / RO/00058 / RMO/0	DOO61 / MO/01311			
✓ Edit + Create		◆ Action		1/1 < >
Confirm 2			Draft	In Progress Done
				WO List
Product	SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	Source Document	RMO/00061	
вом	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	100 / 0.00 pcs	
Target / Actual Weight	0.00 / 0.00 g	OK / NG Qty	0.00 / 0.00 pcs	
OK / NG Weight	0.00 / 0.00 g	Created Date	06/25/2024 09:15:33	
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				
Item Lot No	From Stock Qty Received Weight	OK Weight NG Weight UoM Recei	ved Qty OK Qty NG Qty UoM Ca	onfirmation Date



- 1. 해당 공정으로 이동 확인.
- 2. "Confirm" 버튼을 눌러 승인.

III. Repair Work Order 수리할 제품 정보 입력

* Receive Item														×
MMO#	RMO/	00061				Prod	luct				SEMI-HC	-070(6.5)	-18K-W-2.10GR-1.20-HM	
MO#	MO/0	1311				Targ	et Weight				0.00 g			
Process & Level	Hand	Made & Leve	el 1			Targ	et Qty				1.00 pcs			
ltem			Lot No	From		Stock Qty	Rec	eived Weight	UoM	Rece	ived 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-2.10g	r-1.20		SEMI-HC-O	WH/Fac1/HM		2.10	4	2.10 Input	g		1.00) pcs		
Save Confirm 5	Clos	e												
Item QC / PQC Form	Item QC	Form / PQC Fo	irm			Target	/ Actual Qty		1.00	/ 0.00 pcs				
Target / Actual Weight	0.00 /	0.00 g				OK / N	G Qty		0.00	/ 0.00 pcs				
OK / NG Weight	0.00 /	0.00 g				Create	d Date		06/2	5/2024 09:15:33				
Location	WH/Fac	1/HM → WH/F	ac1/PL1			Work D	ate		06/2	5/2024 08:00:0	0 → 06/25/	2024 20:00:	00	
						Line								
teem Standby Operation													3	_
Item	Lot No	From	Stock Qty	Received Weight	OK Weight	NG Weight	UoM Rec	eived Qty	OK Qty	NG Qty	UoM Confir	rmation Date	e 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	Û
SEMI-HC-070(6.5)-18K-W-2.10gr-1.20		WH/Fac1/HM	0.00	0.00	0.00	0.00	ء 2	0.00	0.00	0.00	pcs		Waiting for Check Qty	Û
Add a line														

Explain

- 실행 순서 & 기능 :
- 1. "Item" 탭에서 진행.
- 2. 수리할 제품 정보 표시.
- 3. "Check" 버튼을 눌러 입력창 오픈.
- 4. 관련 정보 입력 :
- _ Lot No

5)

>

- _ Received Weight 입고 중량
- _ Received Qty 입고 수량
- 5. "Confirm" 버튼을 눌러 승인.

III. Repair Work Order

수리할 제품 정보 입력

<u>ب</u> ا	Before & After									^		
ммо	#	RMO/00061			Product	SEMI-HC-070(SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM					
мо#		MO/01311			Step Count	2						
Proce	ess & Level	Hand Made & Lev	el 1									
Leve	l Step	Staff		Before Weight	Record Date	After Weight	Record Date			Gap		
1	Hand Made - Man	(Võ Th	ị Huyên Trang	3.10 Input	06/25/2024 12:42:06	2.90 Input	06/25/2024 12:44:	07		0.20		
2	Chemical Polishing - Ma	an (Đào T	hành Đặng	2.90 Input	06/25/2024 12:44:07	2.70 Input	06/25/2024 12:44:	07		0.20		
S em QC irget / < / NG	ave Confirm 5 : / PQC Form Actual Weight Weight	Close Item QC Form / PQC 0.00 / 0.00 g 0.00 / 0.00 g	Form		Target / Actual Qty OK / NG Qty Created Date	100 / 0.00 pcs 0.00 / 0.00 pc 06/25/2024 09:1	s 5:33					
S em QC arget / K / NG ocation	ave Confirm 5 ; / PQC Form Actual Weight weight n Standby Operation	Close Item QC Form / PQC 000 / 000 g 000 / 000 g WH/Fact/HM → WH	Form /Fac1/PL1		Target / Actual Qty OK / NG Qty Created Date Work Date Line	100 / 0.00 pcs 0.00 / 0.00 pc 06/25/2024 09:1 06/25/2024 08:0	s 5:5:33 00:00 → 06/25/2024 2	0.00.00				
S em QC arget / K / NG occation	ave Confirm 5 ; / PQC Form Actual Weight Weight n Standby Operation	Close Item QC Form / PQC 0.00 / 0.00 g 0.00 / 0.00 g WH/Fact/HM → WH	Form /Fac1/PL1 Start Date	End Date	Target / Actual Qty OK / NG Qty Created Date Work Date Line	100 / 000 pcs 000 / 000 pc 06/25/2024 09:0 06/25/2024 08:0	s 5:33 00:00 → 06/25/2024 2 Gap	0:00:00	3 Before & Aft	ter		
S eem QC arget / K / NG bocation	ave Confirm 5 ; / PQC Form Actual Weight Weight Standby Operation Step Hand Made - Man	Close Item QC Form / PQC 0.00 / 0.00 g 0.00 / 0.00 g WH/Fact/HM → WH Name/Code	Form /Fac1/PL1 Start Date 06/25/2024 12:35:36	End Date	Target / Actual Qty OK / NG Qty Created Date Work Date Line Before Weight	100 / 0.00 pcs 0.00 / 0.00 pc 06/25/2024 09:1 06/25/2024 08:0 After Weight 0.00	s s 55:33 00:00 → 06/25/2024 2 Gap 0.00	0.00.00 Part Qty C 0.00	Before & Aft Check Status Not Yet	ter		



실형	뱅 순서 & 기능 :
1.	"Standby" 탭에서 진행.
2.	관련 정보 입력 :
_ S	tep 세부 공정
_ N	ame/Code 명칭/코드
S	tart Date 작업 시작 일자
_ E	nd Date 작업 종료 일자
3.	"Before & After" 버튼을 눌러 입력 창
	오픈.
4.	작업 전/후 중량을 연동된 전자
	저울을 사용하여 입력.

5. "Confirm" 버튼을 눌러 저장.

III. Repair Work Order

실제 중량 및 수량 입력

۴ 🖈	ctual								×		
MMO	#	RMO/00061		Proc	ess & Level	Hand	d Made & Level 1				
MO#		MO/01311		Targ	et / Actual Weight	0.00	0.00 / 2.70 g				
PQC		•		Targ	et / Actual Qty	1.00	1.00 / 1.00 pcs				
Produ	ct	SEMI-HC-070(6.5)-18K-W	/-2.10GR-1.20-HM								
Act	ual Item								2		
No	Actual Weigh	ot OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status			
1	2	2.70 0.00	0.00	3 1.00	0.00	0.0	0 06/25/2024 12:35:36	Waiting for PQC	>		
									1e		
С	onfirm 4 Close										
Location		WH/Encl/HM	→ WH/Eac1/DL1	Work	Date	00	1012024 00:00:00	00/05/0004 20:00:00			
Location		WH/Paci/HM	→ WII/Faci/FLI	Line	Date	06,	→	06/26/2024 20:00:00	× ×		
ltem	Standby Jperation										
								2 Actual PC	5C		
No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty Cre	ated on	Status	i		
1	2.7	0.00	0.00	1.00	0.00	0.00 06/	25/2024 12:35:36	Waiting for PQC			

Explain

실행 순서 & 기능 :

- 1. "Operation" 탭에서 진행.
- "Actual" 버튼을 눌러 입력 창 오픈 수정 필요 시.
- 3. 실제 중량, 실제 수량 수정.

4. "Confirm" 버튼을 눌러 승인.

III. Repair Work Order

PQC 진행

🐞 Quality Checks Popup

MMO #	MO #	Product				QC Form			Lot Qty	Not Yet		
RMO/00061	MO/01311	SEMI-HC-070(6.5)-18K-V	V-2.10GR-1.20-⊢	IM			PQC Form			1	1	
No	Actual Qty	Create Date	Status	Staff	Staff Total Weigh		NG g	OK pcs	NG pcs	Date	Judgemen	
	2.7	2024-06-25 05:35:36	Not Yet	Võ Thị Huyền Trang	gr 2.7	2.7 INP	ит 0 3	1		25/06/24	бК	
2				QC Туре	QC Process	QC Code		Method	Frequency	Input	Judgement	
				Visual PQC	PQC	Missing Wax		By eyes	Check All	0	ок	
R				Visual PQC	PQC	Unformed		By eyes	Check All	0	ок	
1				Visual PQC	PQC	Unformed Bezel/C	omponent	By eyes	Check All	0	ок	
				Visual PQC	PQC	Bubble/Crack/Defo	orm	By eyes	Check All	0	ок	
				Visual PQC	PQC Burr/ Water drop			By eyes	Check All	0	ок	
				Visual PQC	PQC	Poor Workmanship	Workmanship Soldering/Filing		Check All	0	ок	
				Visual PQC	PQC	Over grinding		By eyes	Check All	0	ок	
				Visual PQC	PQC	Others		By eyes	Check All	0	ок	
SUBMIT	4 CLOSE											
Location		WH/Fac1/HM		WH/Fac1/PL1	Work	Date	06/25/2024 08:00:00			→ 06/25/2024 20:00:00		
					Line						Ŧ	
ltem Standb	by Operation											
										Actual	1 PQC	
No	Actual We	ight OK Weig	ht	NG Weight	Actual Qty	OK Qty	OK Qty NG Qty Crea		State	ıs	i	
1		2.70	0.00	0.00	1.00	0.00	0.00 06/25	0.00 06/25/2024 12:35:36				



- 1. "PQC" 버튼을 눌러 공정 검사 진행.
- 2. 목록에서 항목 선택.
- 3. 검사 결과 입력.
- 4. "Submit" 버튼을 눌러 승인.

III. Repair Work Order

Lot 발행

MES KPI PMS QMS	MMS Repair Scrap Pro	ocess Closing Report	Lot/Serial Number			¥ 📌 🤄
Repair Order / RO/00058 / RMO/	00061 / MO/01311					
✓ Save X Discard						1/1 <
Cancel Complete MO						Draft In Progress Dom
						WO List
Product	SEMI-HC-070(6.5)-18K-W-2.10GR	R-1.20-HM		Source Documer	nt	RMO/00061
вом	SEMI-HC-070(6.5)-18K-W-2.10GR	R=1.20-HM		Process & Level		Hand Made & Level 1
Item QC / PQC Form	Item QC Form / PQC Form			Target / Actual Q	ty	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/Fac1/HM	→ WH/Fac1/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 Detail 1



- 실행 순서 & 기능 :
- 1. "Detail" 버튼을 눌러 Lot 발행.

III. Repair Work Order

양품 Lot 발행

Create Lot				×
Target / Actual Weight	270 / 0.00 g	Target / Actual Otv	100 / 000 pcs	
	270 / 0.00 -			
	2.70 7 0.00 g	OK / NG Qty	0.00 7 0.00 pcs	
Type Lot	UK ONG	Actual Qty	3 1.00 pcs	
		Part Qty	0 pcs	
Create / Close				
MES KPI PMS QMS	MMS Repair Scrap Process Closing Report L	.ot/Serial Number		•ي ايھ ≆
Repair Order / RO/00058 / RMO/	/00061/M0/01311/1			
<pre> Edit + Create</pre>		• Action		1/1 < >
Back				
Juck			Draft Waiting for Lot	Waiting for Tray Done
			Draft Waiting for Lot	Waiting for Tray Done
MMO#	RMO/00061	Product	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	Waiting for Tray Done
ммо# мо#	RMO/00061 MO/01311	Product BOM	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	Waiting for Tray Done
MMO# MO# Work Date	RMO/00061 MO/01311 06/25/2024 12:35:36	Product BOM Process & Level	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM Hand Made & Level 1 Hand Made & Level 1	Waiting for Tray Done
MMO# MO# Work Date Target / Actual Weight	RMO/00061 MO/01311 06/25/2024 12:35:36 2.70 / 0.00 g	Product BOM Process & Level Target / Actual Qty	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM Hand Made & Level 1 100 / 0.00 pcs	Waiting for Tray Done
MMO# MO# Work Date Target / Actual Weight OK / NG Weight	RMO/00061 MO/01311 06/25/2024 12:35:36 2.70 / 000 g 2.70 / 000 g	Product BOM Process & Level Target / Actual Qty OK / NG Qty	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM Hand Made & Level 1 100 / 0.00 pcs 100 / 0.00 pcs	Waiting for Tray Done
MMO# MO# Work Date Target / Actual Weight OK / NG Weight	RMO/00061 MO/01311 06/25/2024 12:35:36 2.70 / 0.00 g 2.70 / 0.00 g	Product BOM Process & Level Target / Actual Qty OK / NG Qty	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM Hand Made & Level 1 100 / 0.00 pcs 100 / 0.00 pcs	Waiting for Tray Done
MMO# MO# Work Date Target / Actual Weight OK / NG Weight NG	RMO/00061 MO/01311 06/25/2024 12:35:36 2.70 / 000 g 2.70 / 000 g	Product BOM Process & Level Target / Actual Qty OK / NG Qty	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM Hand Made & Level 1 100 / 0.00 pcs 100 / 0.00 pcs	Waiting for Tray Done
MMO# MO# Work Date Target / Actual Weight OK / NG Weight NG	RMO/00061 MO/01311 06/25/2024 12:35:36 2.70 / 0.00 g 2.70 / 0.00 g	Product BOM Process & Level Target / Actual Qty OK / NG Qty	Draft Waiting for Lot SEMI-HC-070(6.5)-18K-W-210GR-120-HM SEMI-HC-070(6.5)-18K-W-210GR-120-HM Hand Made & Level 1 100 / 0.00 pcs 100 / 0.00 pcs	Waiting for Tray Done



- 실행 순서 & 기능 :
- 1. "OK" 탭에서 진행.

- 2. "Lot" 버튼을 눌러 입력창 오픈.
- 3. 실제 수량 및 부속품 수량(선택 사항) 입력.
 - 4. "Create" 버튼을 눌러 Lot 발행.

III. Repair Work Order

불량 Lot 발행

	🐞 Cre	eate Lot									×	
	Target /	Actual Weight	10.00 / 0.00 g		Tar	get / Actual Q	ty	1.00 / 0.00 pcs				
	OK / NG	Weight	0.00 / 10.00 g		3 ОК	/ NG Qty		0.00 / 0.00 pcs	005			
	Type Lo	t	O OK O NG	OK ONG				1.00	pcs			
Repair Work Order / RM					1	•••••						
✓ Edit + Create	4	Close										
Back	Cier	Close										
MMO#		RMO/00011			Product		SEMI-SEMI-T4C3	-(2.0-3.5)-17inch-18K-	W-25.02gr-5.12-HM-HM			
MO#		MO/00118			BOM		SEMI-SEMI-T4C3	EMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM				
Work Date		04/02/2024 16:37:10			Process & Level	Hand Made & Level			& Level 1			
Target / Actual Weight		20.00 / 10.00 g			Target / Actual Qty	arget / Actual Qty 1.00 / 1.00) / 1.00 pcs			
OK / NG Weight		10.00 / 10.00 g			OK / NG Qty		1.00 / 0.00 pcs	/ pcs				
OK NG									2			
									Lot	Return NG	Print	
Return Order			То	Lot/Serial Number	Weigh	ht Qty	Created on	State			i	



- 1. "NG" 탭에서 진행.
- 2. "Lot" 버튼을 눌러 입력 창 오픈.
- 3. 실제 수량 입력.
- 4. "Create" 버튼을 눌러 Lot 발행.

III. Repair Work Order

불량을 양품으로 변경하거나 Recasting List로 이동

	🐞 Return	n Order										×		
Papair Work Ordon	MMO#		RMO/00011				NG Weight	10.00						
	MO#		MO/00118				NG Qty	1.00						
✓ Edit + Cre	CWO#		1				То	WH/REC						
Back	Process & L	evel	Hand Made & Lev	vel 1			Return Order	0	0					
······	Product		SEMI-SEMI-T4C3-	-(2.0-3.5)-1	7inch-18K-W-25.02gr-	5.12-HM-HM								
	WO#	Return Order	From	То	Lot/Serial Number				Weight	Qty	Created on	:		
MMO#	WH/MO/00	088	WH/Fac1/HM	WH/REC	SEMI-T4C3-(2.0-3.5)-	-17inch-18K-W-25.	02gr-5.12-HM-HM-10g-1pcs-24	10402-002	10.00	1.00	04/02/2024 16:3	8:52		
MO#														
Work Date														
Target / Actual Weigh												_		
OK / NG Weight														
on / no noight	3 Confirm	Close												
OK NG														
										2		4		
										Ret	urn NG Print			
Return Order	То	Lot/Serial Number					Weight	Qty	Created on	Stat	e	I		
	WH/REC	SEMI-T4C3-(2.0-3.5)-1	7inch-18K-W-25.02gr-5.12	2-HM-HM-10g	-1pcs-240402-002		10.00	1.00	04/02/2024 16:38:52	Done	a 1 Relea	se		
												_ []		



- "Release" 버튼을 눌러 불량을 양품으로 변경.
- 2. 혹은 "Return NG" 버튼을 눌러 MES > MMS > Recasting List로 이동.
- 3. "Confirm" 버튼을 눌러 이동 승인.
- 4. "Print' 버튼을 눌러 QR 인쇄.
- "Back" 버튼을 눌러 메인 페이지로 이동.

III. Repair Work Order

공정 별 수리 작업 지시서 완료

MES	KPI	PMS	QMS	MMS	Repair	Scrap	Process	Closing Report	Lot/Seria	al Number								:	û: 🍕	୍ଦ
Repair Ord / RO/0005	ler / RO/ 58 / RMC	00058 0/0006	3 / RMO, 61 / MO/	/0006 ⁻ /01312 /	1 / MO/0 / 2 / MO/	1 311 / 1 / 1 /01312	MO/01311 /	MO/01312 / RN	10/0006	51										
🖋 Edit	+ Cre	eate								Action									1/1	< >
Cancel	Com	plete MC	1														Draft	In Prog	ress	Done
																		wo i	ist	
Product				SEMI-	HC-070(6	5)-18K-W-:	10GR-120-F	OL 1		So	urce Docur	nent		RMO/	/00061					
BOM				SEMI-	HC-070(6.	5)-18K-W-2	2.10GR-1.20-F	OL 1		Mrp Pro Ok		эl		1st Po	blishing & Level 2					
ltem QC / P	QC Form			Item (QC Form /	PQC Form				 Field: mrp_pro_ Object: mrp_cw 	_ok_ids	Qty		1.00	/ 1.00 pcs					
Target / Act OK / NG We	tual Weigh	t		0.00	/ 2.40 g					 Type: one2man Context: {} Domain: [["is n 	y o"."=".falsell			1.00	/ 0.00 pcs 5/2024 09:15:33					
Location				WH/F	ac1/PL1 →	WH/Fac1/I	N2			 Modifiers: {"real On change: 1 Relation: mrp.p 	idonly":true}			06/25	5/2024 08:00:00 → 0	06/25/2024 20:00:0	00			
										~										
ltem S	Standby	Operati	on																	
																			Actual	
No		Act	ual Weigh	it		OK Weight		NG Weight		Actual Qty		OK Qty	NG Qt	y C	Created on	\$	Status			-
1			2	.40		2.4	ю	0.00		1.00		1.00	с	0.00 0	06/25/2024 13:13:48	(Done	Det	ail	



- "Complete MO" 버튼을 눌러 해당 공정 완료 승인.
- ** 각 MO는 동일한 구조로 되어있고,
 마지막 MO 완료 시 RMO가 동시에
 완료되며, 해당 제품은 OQC로
 이동함.



ERP + MES + SCADA