

For Smart Factory



Operating |
User |

MANUAL



MES^{3D}

ERP + MES + SCADA

Auto & S.I

User Manual

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Repair

Repair Information



Explain

I. Stock

생산 공정에서 발생한 불량 완제품 목록 조회

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-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)				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	
<input type="checkbox"/> 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
<input type="checkbox"/> 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
<input type="checkbox"/> HC-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
<input type="checkbox"/> 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
<input type="checkbox"/> 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
<input type="checkbox"/> 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
<input type="checkbox"/> HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-19g-1pcs-240531-VN-001		1.90	1.90	g
<input type="checkbox"/> 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

실행 순서 & 기능 :

1. 검색 기능.
2. 생산 공정에서 발생한 불량 완제품 목록.
3. 엑셀로 다운로드 기능.

Repair

Repair Information



Explain

I. Stock

불량 완제품 선택 및 처리 기능 설명

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

Repair Stock

Product Search...

Repair Recasting Split Lot Merge 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-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)						
				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)						
<input type="checkbox"/>	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
<input checked="" type="checkbox"/>	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
<input type="checkbox"/>	HC-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
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-1.20	WH/REC	HC-070(6.5)-18K-W-2.10gr-1.20-6.30000000000000000000g-3pcs-240415-VN-001-NG-001	1.00	1.00	g
<input type="checkbox"/>	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
<input type="checkbox"/>	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
<input type="checkbox"/>	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
<input type="checkbox"/>	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

실행 순서 & 기능 :

1. 목록에서 처리할 불량 완제품 선택.
2. “Repair” 버튼을 눌러 수리 지시서 발행 가능.
3. “Recasting” 버튼을 눌러 재주소를 위해 MES > MMS > Recasting List로 이동 가능(해당 기능은 MMS 매뉴얼 참조).
4. 해당 불량품의 분할 기능.
5. 분할된 불량품의 병합 기능(분할된 불량품만 병합 가능).

Repair

Repair Information



Explain

I. Stock

수리 지시서 발행할 불량 완제품 선택

실행 순서 & 기능 :

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

Repair Center Action ✕

Type: Repair

Lot

Product	Lot/Serial Number	Available Quantity	Quantity	Unit of Measure
HC-070(6.5)-18K-W-2.10gr-120	HC-070(6.5)-18K-W-2.10gr-120-44g-10pcs-240402-VN-001-NG-001	4.40	4.40	g

SEMI-

SEMI-

Confirm 3

Cancel

▶ 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-120 (8)				16.61	18.01
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-12.0g-5.0g-3.0pcs-240604-240409-VN-001	0.00	140 g
<input checked="" type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-44g-10pcs-240402-VN-001-NG-001	4.40	4.40 g
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-15.3g-6pcs-240419-VN-001-NG-001	4.00	4.00 g
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-6.30000000000000000000001g-3pcs-240415-VN-001-NG-001	1.00	100 g
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-2g-1pcs-240514-VN-ABD-001	2.00	2.00 g
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-1.4g-1pcs-240409-VN-001-NG-003	1.22	122 g
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-1.9g-1pcs-240531-VN-001	1.90	190 g
<input type="checkbox"/>	HC-070(6.5)-18K-W-2.10gr-120	WH/REC	HC-070(6.5)-18K-W-2.10gr-120-2.09g-1pcs-240617-VN-001	2.09	2.09 g

Repair

Repair Information



Explain

II. Repair Order

수리 지시서 목록 조회

Name	Source	State	Created on	Created by
<input type="checkbox"/> RO/00056	WH/REC	Draft	06/24/2024 16:47:15	Administrator
<input type="checkbox"/> RO/00055	WH/REC	Confirmed	06/21/2024 13:32:00	Administrator
<input type="checkbox"/> RO/00054	WH/REC	Done	06/17/2024 15:09:34	Administrator
<input type="checkbox"/> RO/00053	WH/REC	Draft	06/04/2024 13:22:05	Administrator
<input type="checkbox"/> RO/00052	WH/REC	Confirmed	05/31/2024 10:57:19	my2
<input type="checkbox"/> RO/00051	WH/REC	Done	05/31/2024 10:15:23	Administrator
<input type="checkbox"/> RO/00050	WH/REC	Done	05/31/2024 09:39:51	KHC
<input type="checkbox"/> RO/00049	WH/REC	Confirmed	05/31/2024 08:05:40	my2
<input type="checkbox"/> RO/00048	WH/REC	Confirmed	05/31/2024 08:04:59	KHC
<input type="checkbox"/> RO/00047	WH/REC	Confirmed	05/22/2024 16:05:19	KHC
<input type="checkbox"/> RO/00046	WH/REC	Done	05/22/2024 15:42:45	KHC
<input type="checkbox"/> RO/00045	WH/REC	Confirmed	05/22/2024 10:13:23	KHC
<input type="checkbox"/> RO/00044	WH/REC	Done	05/22/2024 10:13:12	KHC
<input type="checkbox"/> RO/00043	WH/REC	Done	05/17/2024 13:48:14	KHC
<input type="checkbox"/> RO/00042	WH/REC	Confirmed	05/16/2024 14:47:09	KHC
<input type="checkbox"/> RO/00040	WH/REC	Draft	05/14/2024 15:18:50	Administrator
<input type="checkbox"/> RO/00039	WH/REC	Done	05/14/2024 15:07:26	KHC
<input type="checkbox"/> RO/00038	WH/REC	Done	05/14/2024 14:22:00	KHC
<input type="checkbox"/> 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.
4. Repair Stock에서 승인한 수리 지시서가 자동으로 목록에 표시됨. 해당 지시서를 선택해서 수리 진행.

Repair

Repair Information



Explain

II. Repair Order

수리 지시서 승인

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

Repair Order / RO/00058

Save Discard 1 / 52

Confirm 3 Cancel Draft Confirmed 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-210gr-120	HC-070(6.5)-18K-W-210gr-120-21g-1pcs-240625-VN-001	100	210	Poor Workmanship Soldering/Filing	2		

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 typing...

실행 순서 & 기능 :

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.

Repair

Repair Information



Explain

II. Repair Order

불량품 별 수리 작업 지시서 확인

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

Repair Order / RO/00058

Edit + Create Action 1/52

Cancel Draft Confirmed Done

2 MRMO#

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-lpcs-240625-VN-001	1.00	2.10	Poor Workmanship Soldering/Filing	HM POL FIN		RMO/00061

Add a line 1

실행 순서 & 기능 :

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

Repair

Repair Information



Explain

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)

Add material

MO# MO/01311
Process Hand Made

Material
SEMI-HC-070(6.5)-18K-W-210gr-120
18K Tem(Y) **2**

Add a line

Confirm **3** Close

Cancel Draft Confirmed in progress Done

Product HC-070(6.5)-18K-W-210gr-120
Target / Actual Weight 210 / 0.00 g
Is Recast
Repair RO/00058

Created Date 06/25/2024 09:15:33
Work Date 06/25/2024 02:15:33 → 06/25/2024 20:00:00
Target / Actual Qty 100 / 0.00
Remark

MO List MO 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-210GR-120-HM	SEMI-HC-070(6.5)-18K-W-210GR-120-HM	0.00	0.00	0.00	SEMI-HC-070(6.5)-18K-W-210gr...	Draft	+add 1
MO/01312	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	+ad
MO/01313	3	2nd Finishing	HC-070(6.5)-18K-W-210gr-120	HC-070(6.5)-18K-W-210gr-120 - 2024-06-25 09:15...	0.00	0.00	0.00		Draft	+add

Repair

Repair Information



Explain

실행 순서 & 기능 :

1. 추가한 자재가 표시됨.

III. Repair Work Order

마스터 수리 작업 지시서에서 자재 추가(선택 사항)

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

Repair Order / RO/00058 / RMO/00061

Edit + Create Action 1/1 < >

Cancel Draft Confirmed In Progress Done

MO List

Product: HC-070(6.5)-18K-W-2.10gr-1.20
Created Date: 06/25/2024 09:15:33
Target / Actual Weight: 2.10 / 0.00 g
Work Date: 06/25/2024 02:15:33 → 06/25/2024 20:00:00
Is Recast:
Target / Actual Qty: 1.00 / 0.00
Repair: RO/00058
Remark:

MO List MO 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-1.20-HM	SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM	0.00	0.00	0.00	SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-18K Tem(Y)	Draft	+ add
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
MO/01313	3	2nd Finishing	HC-070(6.5)-18K-W-2.10gr-1.20	HC-070(6.5)-18K-W-2.10gr-1.20 - 2024-06-25 09:15...	0.00	0.00	0.00		Draft	+ add

Repair

Repair Information



Explain

실행 순서 & 기능 :

1. 수리를 진행할 공정의 왼쪽 화살표 버튼을 눌러 진행.

III. Repair Work Order

공정 별 수리 작업 지시서 진행

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

Repair Order / RO/00058 / RMO/00061

Edit + Create Action 1/1 < >

Cancel Draft Confirmed In Progress Done

MO List

Product HC-070(6.5)-18K-W-2.10gr-1.20 Created Date 06/25/2024 09:15:33

Target / Actual Weight 2.10 / 0.00 g Work Date 06/25/2024 02:15:33 → 06/25/2024 20:00:00

Is Recast Is Recast Target / Actual Qty 1.00 / 0.00

Repair RO/00058 Remark

MO List MO 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-1.20-HM	SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-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-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
MO/01313	3	2nd Finishing	HC-070(6.5)-18K-W-2.10gr-1.20	HC-070(6.5)-18K-W-2.10gr-1.20 - 2024-06-25 09:15...	0.00	0.00	0.00		Draft	+ add

Repair

Repair Information



Explain

III. Repair Work Order

공정 별 수리 작업 지시서 진행

실행 순서 & 기능 :

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

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

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

Edit + Create Action 1/1 < >

Confirm 2 Draft In Progress Done

WO List

Product	SEMI-HC-070(6.5)-18K-W-2.1OGR-120-HM	Source Document	RMO/00061
BOM	SEMI-HC-070(6.5)-18K-W-2.1OGR-120-HM	Process & Level	Hand Made & Level 1
Item QC / PQC Form	Item QC Form / PQC Form	Target / Actual Qty	1.00 / 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/FacI/HM → WH/FacI/PLI	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...
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Repair

Repair Information



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

_ Received Weight 입고 중량

_ Received Qty 입고 수량

5. "Confirm" 버튼을 눌러 승인.

III. Repair Work Order

수리할 제품 정보 입력

Receive Item

MMO# RMO/00061 Product SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-HM
 MO# MO/01311 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 type="button" value="Input"/>	g	10.00	pcs	
SEMI-HC-070(6.5)-18K-W-2.10gr-1.20	SEMI-HC-0...	WH/Fac1/HM	2.10	2.10 <input type="button" value="Input"/>	g	1.00	pcs	

Save Confirm Close

Item QC / PQC Form Item QC Form / PQC Form Target / Actual Qty 1.00 / 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

Check

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

Repair

Repair Information



Explain

III. Repair Work Order

수리할 제품 정보 입력

Before & After
✕

MMO# RMO/00061

MO# MO/01311

Process & Level Hand Made & Level 1

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

Step Count 2

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	06/25/2024 12:44:07	0.20
2	Chemical Polishing - Man	Đào Thành Đặng	2.90 Input	06/25/2024 12:44:07	2.70 Input	06/25/2024 12:44:07	0.20

Save

Confirm Close

Item QC / PQC Form

Target / Actual Weight 0.00 / 0.00 g

OK / NG Weight 0.00 / 0.00 g

Location WH/FacI/HM → WH/FacI/PLI

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

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

실행 순서 & 기능 :

1. "Standby" 탭에서 진행.
2. 관련 정보 입력 :
 - _ Step 세부 공정
 - _ Name/Code 명칭/코드
 - _ Start Date 작업 시작 일자
 - _ End 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.

Repair

Repair Information



Explain

III. Repair Work Order

실제 중량 및 수량 입력

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	3	1.00	0.00	0.00 06/25/2024 12:35:36	Waiting for PQC

Confirm **4** 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 **1** Operation

2 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

실행 순서 & 기능 :

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

Repair

Repair Information



Explain

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-W-2.10GR-1.20-HM	PQC Form	1	1

No	Actual Qty	Create Date	Status	Staff	Total Weight	OK g	INPUT	NG g	OK pcs	NG pcs	Date	Judgement
1	2.7	2024-06-25 05:35:36	Not Yet	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

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

실행 순서 & 기능 :

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

Repair

Repair Information



Explain

III. Repair Work Order

Lot 발행

실행 순서 & 기능 :

1. "Detail" 버튼을 눌러 Lot 발행.

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-2.10GR-1.20-HM	Source Document	RMO/00061
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	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

Detail 1

Repair

Repair Information



Explain

III. Repair Work Order

양품 Lot 발행

Create Lot ✕

Target / Actual Weight	2.70 / 0.00 g	Target / Actual Qty	1.00 / 0.00 pcs
OK / NG Weight	2.70 / 0.00 g	OK / NG Qty	0.00 / 0.00 pcs
Type Lot	<input checked="" type="radio"/> OK <input type="radio"/> NG	Actual Qty	<input type="text" value="1.00"/> pcs
		Part Qty	<input type="text" value="0"/> pcs

Create **4** **Close**

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.

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number ☰ 🗨️ 1 🔄 5

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	Product	SEMI-HC-070(6.5)-18K-W-210GR-120-HM
MO#	MO/01311	BOM	SEMI-HC-070(6.5)-18K-W-210GR-120-HM
Work Date	06/25/2024 12:35:36	Process & Level	Hand Made & Level 1
Target / Actual Weight	2.70 / 0.00 g	Target / Actual Qty	1.00 / 0.00 pcs
OK / NG Weight	2.70 / 0.00 g	OK / NG Qty	1.00 / 0.00 pcs

1 **OK** **NG** **2** **Lot**

To	Lot/Serial Number	Weight	Qty	Created on	State
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Repair

Repair Information



Explain

III. Repair Work Order

불량 Lot 발행

실행 순서 & 기능 :

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

✖ 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: 100 / 0.00 pcs

OK / NG Qty: 0.00 / 0.00 pcs

Actual Qty: pcs

Repair Work Order / RM

Edit
+ Create

Back
Create
Close

MMO# RMO/00011

MO# MO/00118

Work Date 04/02/2024 16:37:10

Target / Actual Weight 20.00 / 10.00 g

OK / NG Weight 10.00 / 10.00 g

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

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

Process & Level Hand Made & Level 1

Target / Actual Qty 100 / 1.00 pcs

OK / NG Qty 100 / 0.00 pcs

1 OK NG

2

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

Repair

Repair Information



Explain

III. Repair Work Order

불량을 양품으로 변경하거나 Recasting List로 이동

실행 순서 & 기능 :

1. "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.
5. "Back" 버튼을 눌러 메인 페이지로 이동.

The screenshot shows the 'Return Order' window with the following details:

- MMO#: RMO/00011, NG Weight: 10.00
- MO#: MO/00118, NG Qty: 1.00
- CWO#: 1, To: WH/REC
- Process & Level: Hand Made & Level 1, Return Order: 0
- Product: SEMI-SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM-HM

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	1.00	04/02/2024 16:38:52

Buttons and Callouts:

- 5: Back button
- 3: Confirm button
- 2: Return NG button
- 4: Print button
- 1: Release button

Repair

Repair Information



Explain

III. Repair Work Order

공정 별 수리 작업 지시서 완료

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

1 / 1 < >

Cancel Complete MO 1 Action Draft In Progress Done

WO List

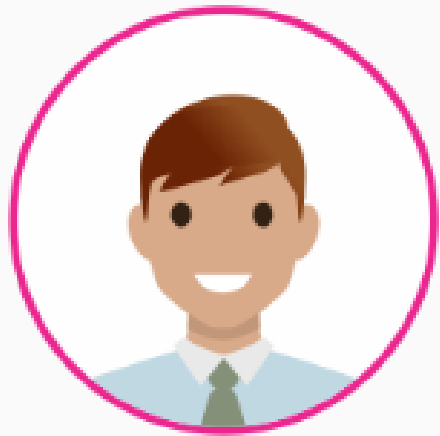
Product	SEMI-HC-070(6.5)-18K-W-210GR-120-POL 1	Source Document	RMO/00061
BOM	SEMI-HC-070(6.5)-18K-W-210GR-120-POL 1	Mrp Pro Ok	1st Polishing & Level 2
Item QC / PQC Form	Item QC Form / PQC Form	Qty	1.00 / 1.00 pcs
Target / Actual Weight	0.00 / 2.40 g		1.00 / 0.00 pcs
OK / NG Weight	2.40 / 0.00 g		06/25/2024 09:15:33
Location	WH/Fac1/PL1 → WH/Fac1/FN2		06/25/2024 08:00:00 → 06/25/2024 20:00:00

Item Standby Operation 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

실행 순서 & 기능 :

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



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