

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

View a list of defective finished products that occurred during production

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

Repair Stock

Product Search... 1

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)				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

Step by steps:

1. Search function.
2. A list of defective finished products that occurred during the production process.
3. Download function as Excel.

Repair

Repair Information



Explain

I. Stock

Description of defective finished product selection and processing functions

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)						
				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 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-1.20-6.3000000000000000g-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

Step by steps:

1. Select defective finished products to be processed from the list.
2. You can issue a repair order by pressing the “Repair” button.
3. You can press the “Recasting” button to go to MES > MMS > Recasting List for recasting (refer to the MMS manual for this function).
4. Splitting function of the defective product.
5. Merge function for split defective products (only split defective products can be merged).

Repair

Repair Information



Explain

I. Stock

Select defective finished products for which repair orders will be issued

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

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-120-6.3000000000000001g-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	1.22 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	1.90 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

Step by steps:

1. Select the defective finished product to be repaired from the list.
2. Click the “Repair” button to open a pop-up with repair instructions for the defective product.
3. Click the “Confirm” button to create a Repair Order.

Repair

Repair Information



Explain

II. Repair Order

Search repair order list

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

Step by steps:

1. Search function.
2. Download function as Excel.
3. Button to create new repair order.
4. Approved repair orders from Repair Stock are automatically listed. Select the relevant instruction and proceed with the repair.

Repair

Repair Information



Explain

II. Repair Order

Approval of repair order

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 **1** 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...

Step by steps:

1. Proceed in the “Repair” tab.
2. Select the process list for repairing the defective product from the drop-down item in the Routing column (the process list is displayed at MES > Process > Repair Process).
3. Confirm by pressing the “Confirm” button.

Repair

Repair Information



Explain

II. Repair Order

Check repair work instructions for each defective product

Step by steps:

1. Repair work instructions for each defective product are created according to the process specified in Routing.
2. Go to the master repair work order by clicking on the item.

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 1 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

Repair

Repair Information



Explain

Step by steps:

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)

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 **Confirm** in progress Done

MO List

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

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

III. Repair Work Order

Add materials to master repair work order (optional)

Step by steps:

1. The added material is displayed.

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-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

III. Repair Work Order

Proceed with repair work instructions for each process

Step by steps:

1. Proceed by pressing the arrow button to the left of the process to be repaired.

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-... 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

Proceed with repair work instructions for each process

Step by steps:

1. Confirm movement to the relevant process.
2. Click the “Confirm” button to confirm.

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-1.20-HM	Source Document	RMO/00061
BOM	SEMI-HC-070(6.5)-18K-W-2.1OGR-1.20-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...
------	--------	------	-----------	-----------------	-----------	-----------	-----	--------------	--------	--------	-----	----------------------

Repair

Repair Information



Explain

Step by steps:

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

Receive Item [Close]

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 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

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	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

5

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	

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 steps:

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.

Repair

Repair Information



Explain

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	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

Step by steps:

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.

Repair

Repair Information



Explain

III. Repair Work Order

Check PQC

🔍 **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	NG g	OK pcs	NG pcs	Date	Judgement
<input checked="" type="checkbox"/> 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
Line

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 steps:

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

Repair

Repair Information



Explain

III. Repair Work Order

Create Lot

Step by steps:

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-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

Create Lot OK

Step by steps:

1. Proceed from the “OK” tab.
2. Click the “Lot” button to open the input window.
3. Enter actual quantity and accessory quantity (optional).
4. Issue Lot by pressing the “Create” button.

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

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

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

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

OK NG

To	Lot/Serial Number	Weight	Qty	Created on	State
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Repair

Repair Information



Explain

III. Repair Work Order

Create Lot NG

Step by steps:

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: 100 / 0.00 pcs

OK / NG Qty: 0.00 / 0.00 pcs

Actual Qty: pcs

Repair Work Order / RM:

MMO# RMO/00011 Product SEMI-SEMI-T4C3-(2.0-3.5)-17mch-18K-W-25.02gr-5.12-HM-HM

MO# MO/00118 BOM SEMI-SEMI-T4C3-(2.0-3.5)-17mch-18K-W-25.02gr-5.12-HM-HM

Work Date 04/02/2024 16:37:10 Process & Level Hand Made & Level 1

Target / Actual Weight 20.00 / 10.00 g Target / Actual Qty 100 / 1.00 pcs

OK / NG Weight 10.00 / 10.00 g OK / NG Qty 100 / 0.00 pcs

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

Repair

Repair Information



Explain

III. Repair Work Order

Change defective product to good product or move to Recasting List

Step by steps:

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.

Return Order

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

MMO#
MO#
Work Date
Target / Actual Weight
OK / NG Weight

OK NG

Buttons: Confirm, Close, Return NG, Print, Release, Back, Edit, + Create

Repair

Repair Information



Explain

III. Repair Work Order

Complete repair work instructions for each process

Step by steps:

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.

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

Cancel **Complete MO** 1

Product SEMI-HC-070(6.5)-18K-W-210GR-120-POL 1
BOM SEMI-HC-070(6.5)-18K-W-210GR-120-POL 1
Item QC / PQC Form Item QC Form / PQC Form
Target / Actual Weight 0.00 / 2.40 g
OK / NG Weight 2.40 / 0.00 g
Location WH/Fac1/PL1 → WH/Fac1/FN2

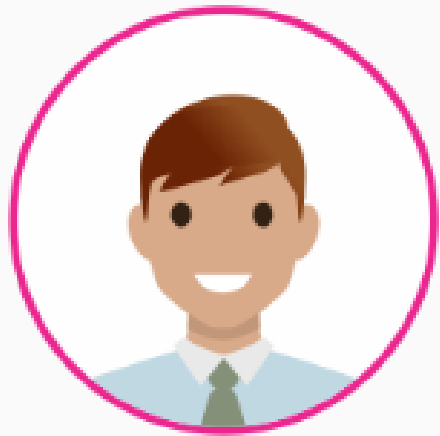
Source Document
Mrp Pro Ok
Qty
Field: mrp_pro_ok_ids
Object: mrp.cwo
Type: one2many
Context: {}
Domain: [{"is_ng": "=,false"}]
Modifiers: [{"readonly": true}]
On change: 1
Relation: mrp.production

RMO/00061
1st Polishing & Level 2
1.00 / 1.00 pcs
1.00 / 0.00 pcs
06/25/2024 09:15:33
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



Thank you for using
For Smart Factory

MES 3D

ERP + MES + SCADA