

For Smart Factory



Operating |  
User |

# MANUAL



# MES<sup>3D</sup>

ERP + MES + SCADA

Auto & S.I

# User Manual

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# MMS

## Master Manufacturing Orders



Explain

### I. Master Production

#### 생산 작업 지시 마스터 목록

실행 순서 & 기능 :

1. 검색 기능.
2. 생산 작업 지시 마스터 목록.
3. 엑셀 파일로 다운로드 기능.
4. “Create” 버튼을 눌러 신규 생산 작업 지시 마스터 등록.

The screenshot shows the MMS Master Production interface. At the top, there is a navigation bar with 'MES', 'KPI', 'PMS', 'QMS', 'MMS', 'Repair', 'Scrap', and 'Process'. Below this is a 'Master Production' header with a search bar (1), a '+ Create' button (4), and a download icon (3). The main area is a table with columns: Name, Sale Order, Scheduled Date, Product, Target Weight, Actual Weight, NG, Status, Created by, and Created on. The table contains 8 rows of data. Callout 2 points to the 'Product' column.

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

# MMS

## Master Manufacturing Orders



Explain

### I. Master Production

#### 생산 작업 지시 마스터 등록

Master Production / New

Save Discard

Confirm


Draft Confirmed In Progress Done

MO List

1


2

3

Product T4C3-(2.0-3.5)-VN-17inch-18k-25.02g-w-121pcs-5.12ct  Created Date

BOM T4C3-(2.0-3.5)-VN-17inch-18k-25.02g-w-121pcs-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

실행 순서 & 기능 :

1. 관련 정보 입력 :

\_ Product 제품

\_ BOM

\_ Target / Actual Qty 목표/실제 수량

\_ Remark 비고

2. “Save” 버튼을 눌러 저장.

3. “Confirm” 버튼을 눌러 승인.



## I. Master Production

### 생산 작업 지시 마스터 하위 공정 작업 지시서 목록

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

MO List

Product: HC-070(6.5)-18K-W-2.10gr-120  
 BOM: HC-070(6.5)-18K-W-2.10gr-120 - KHC - 01  
 Sale Order: S00061  
 Target / Actual Weight: 0.00 / 0.00 g  
 Is Recast:

Created Date: 06/17/2024 09:18:12  
 Work Date: 06/17/2024 09:17:58 → 06/17/2024 09:17:58  
 Target / Actual Qty: 10.00 / 0.00  
 Remark:

1 MO List MO Setting

Reference	Level	Process	Product	BOM	Target Weight	Actual Weight	Actual Previous	Materials	Status	i
MO/01213	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	18K Tem(Y) SEMI-HC-070(6.5)-18K-W-2.10gr...	Draft	
MO/01214	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	
MO/01215	3	1st Finishing	SEMI-HC-070(6.5)-18K-W-2.10gr-120-FIN 1	SEMI-HC-070(6.5)-18K-W-2.10gr-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-2.10gr-120-POL 2	SEMI-HC-070(6.5)-18K-W-2.10gr-120-POL 2	0.00	0.00	0.00		Draft	
MO/01217	5	2nd Polishing	HC-070(6.5)-18K-W-2.10gr-120	HC-070(6.5)-18K-W-2.10gr-120 - KHC - 01	0.00	0.00	0.00		Draft	

실행 순서 & 기능 :

1. “MO List” 탭에서 해당 제품의 공정 작업 지시서 목록을 확인. 각 MO는 1개의 공정에 대응. 표시된 MO는 자동으로 “MO” 메뉴에 등록됨.
2. 생산 작업 지시 마스터(Master production) 하위 공정 작업 지시서(MO) 목록 표시.



## I. Master Production

### 공정 작업 지시서 설정

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-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 List MO 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	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Draft	<input type="checkbox"/>
MO/01214	2	1st Polishing	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 1	Item QC Form	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Draft	<input type="checkbox"/>
MO/01215	3	1st Finishing	SEMI-HC-070(6.5)-18K-W-210gr-120-FIN 1	Item QC Form	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Draft	<input type="checkbox"/>
MO/01216	4	2nd Polishing	SEMI-HC-070(6.5)-18K-W-210gr-120-POL 2	Item QC Form	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Draft	<input type="checkbox"/>
MO/01217	5	2nd Polishing	HC-070(6.5)-18K-W-210gr-120	Item QC Form	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Draft	<input type="checkbox"/>

실행 순서 & 기능 :

1. “MO Setting” 탭에서 각 MO의 설정 값 변경 가능.
2. 관련 설정 선택 :
  - \_ Item QC Form Item QC 검사 양식 선택
  - \_ Item QC 해당 공정에서 Item QC를 시행할 경우 선택
  - \_ PQC 해당 공정에서 PQC를 시행할 경우 선택
  - \_ Mapping tray 해당 공정에서 Tray를 사용할 경우 선택
3. “Save” 버튼을 눌러 저장.



## II. MO (Manufacturing Order)

### 공정 작업 진행

실행 순서 & 기능 :

1. "MO List" 탭의 목록에서 작업을 진행할 MO의 왼쪽 화살표 선택.

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

<b>Product</b>	HC-070(6.5)-18K-W-2.10gr-1.20	<b>Created Date</b>	06/17/2024 09:18:12
<b>BOM</b>	HC-070(6.5)-18K-W-2.10gr-1.20 - KHC - 01	<b>Work Date</b>	06/17/2024 09:17:58 → 06/17/2024 09:17:58
<b>Sale Order</b>	S00061	<b>Target / Actual Qty</b>	10.00 / 0.00
<b>Target / Actual Weight</b>	0.00 / 0.00 g	<b>Remark</b>	
<b>Is Recast</b>	<input type="checkbox"/>		

MO List
MO Setting

Reference...	Level	Process	Product	BOM	Target Weight...	Actual Weig...	Actual Previous	Materials	Status...
MO/01213	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...	Draft
MO/01214	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/01215	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/01216	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/01217	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



## II. MO (Manufacturing Order)

### 공정 작업 진행

실행 순서 & 기능 :

1. 선택한 MO 페이지로 이동. Process & Level에서 현재 공정 확인.
2. Item QC와 PQC 검사 양식 변경 가능.
3. 목표 수량 변경 가능.
4. 작업 계획 시간 변경 가능.
5. 작업 라인 지정(해당 공정에 여러 개의 라인이 있을 시)
6. "Confirm" 버튼을 눌러 승인.

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

Master Production / MMO/00235 / MO/01213

Edit Create Action

1 / 1 < >

Confirm 6 Draft In Progress Done

Product SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM Source Document MMO/00235

BOM SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM Process & Level Hand Made & Level 1 1

Item QC / PQC Form Item QC Form / PQC Form 2 Target / Actual Qty 10.00 / 0.00 pcs 3

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 06/17/2024 09:18:12

Location WH/Fac1/HM → WH/Fac1/PL1 Work Date 06/17/2024 09:17:58 → 06/17/2024 09:17:58 4

Line 5

Item Standby Operation

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





## II. MO (Manufacturing Order)

### 공정에 사용되는 자재 및 반제품 등록

실행 순서 & 기능 :

1. "Item" 탭에서 해당 공정에 사용되는 자재 및 반제품 정보 등록.
2. BOM에 등록된 자재 및 반제품 정보 표시.
3. "Check" 버튼을 눌러 해당 아이템의 Lot, 중량 및 수량 입력 창 오픈.
4. 관련 정보 입력 :  
 \_ Lot No  
 \_ Received Weight 입고 중량  
 \_ Received Qty 입고 수량
5. "Confirm" 버튼을 눌러 확정.

#### 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/Fac1/HM	0.00	0.00	g	100.00	pcs	
SEMI-HC-070(6.5)-18K-W-210gr-120		WH/Fac1/HM	0.00	0.00	g	0.00	pcs	

4

MES

Master Prod

Edit

1/1 < >

Cancel Save Confirm Close

5

WO List

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  
 OK / NG Weight : 0.00 / 0.00 g      Created Date : 06/17/2024 09:18:12  
 Location : WH/Fac1/HM → WH/Fac1/PL1      Work Date : 06/17/2024 09:17:58 → 06/17/2024 09:17:58  
 Line : HM3

1

Item Standby Operation

3

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	100.00	0.00	0.00	pcs		Waiting for Check Qty
SEMI-HC-070(6.5)-18K-W-210gr-120		WH/Fac1/HM	0.00	0.00	0.00	0.00	g	0.00	0.00	0.00	pcs		Waiting for Check Qty

2

Add a line



## II. MO (Manufacturing Order)

### 공정에 사용되는 자재 및 반제품의 품질 검사

실행 순서 & 기능 :

1. "Item QC" 버튼을 눌러 검사 진행.
2. 목록에서 검사할 아이템 선택.
3. 검사지에 검사 결과 입력.
4. "Submit" 버튼을 눌러 확정.

**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	Staff	OK g	NG g	INPUT	OK pcs	NG pcs	Date	Judgement
<input type="checkbox"/> 18K Tem(Y)	18K Tem	Not Yet	Đào Thành Đăng	74.98	25.02	INPUT	3		02/04/24	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/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

**1** Check **Item QC**

**2**  SEMI-T4C3-(2.0-3.5)-17 T4C3-(2.0-3.5)-17inch-18K Not Yet

**3** INPUT

**4** SUBMIT CLOSE

Master Production / MMO/OC

Edit + Create

Cancel Complete MO

Product

BOM

Item QC / PQC Form

Target / Actual Weight

OK / NG Weight

Location

Item Standby Operation

Item	Lot No	From	Stock Qty	Received Weight	OK Weight	NG Weight	Uo...	Received Qty	OK Qty	NG Qty	Uo...	Confirmatic
<input type="checkbox"/> 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
<input type="checkbox"/> 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-400.0g-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

# MMS

## Master Manufacturing Orders



Explain

## II. MO (Manufacturing Order)

공정에 투입되는 직원, 기계, 몰드 정보 등록

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

실행 순서 & 기능 :

1. "Standby" 탭에서 진행.
2. 관련 정보 입력 :  
\_ Step 세부 공정  
\_ Name/Code 이름/코드  
\_ Start Date 시작 시간  
\_ End Date 종료 시간
3. "Part Qty" 칼럼에 해당 반제품과 같이 이동되는 부품의 개수를 입력(선택 사항).
4. "Before & After" 버튼을 눌러 작업 전/후의 중량 입력.
5. 전자 저울과 연동되어 측정된 중량이 입력됨.
6. "Confirm" 버튼을 눌러 승인.

Save Confirm Close

Item QC / PQC Form	Item QC Form / PQC Form	Target / Actual Qty	1000 / 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	06/17/2024 09:18:12
Location	WH/FacI/HM → WH/FacI/PL1	Work Date	06/17/2024 09:17:58 → 06/17/2024 09:17:58
		Line	HM3

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



## II. MO (Manufacturing Order)

### 공정 완료된 제품의 실제 중량과 수량 등록

Actual
×

MMO# : MMO/00254

MO# : MO/01306

PQC : ■

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

Process & Level : Hand Made & Level 1

Target / Actual Weight : 0.00 / 14.00 g

Target / Actual Qty : 10.00 / 10.00 pcs

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

Save
Cancel

Product

Confirm
Close

Item QC / f

Target / Actual Weight : 0.00 / 14.00 g

OK / NG Weight : 0.00 / 0.00 g

Location : WH/Fac/HM → WH/Fac/PL1

OK / NG Qty : 0.00 / 0.00 pcs

Created Date : 06/24/2024 14:39:28

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

실행 순서 & 기능 :

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



## II. MO (Manufacturing Order)

### 공정 완료된 제품의 품질 검사

실행 순서 & 기능 :

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

Quality Checks Popup

MMO #	MO #	Product	QC Form	Lot Qty	Not Yet
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	Staff	Total Weight	OK g	NG g	OK pcs	NG pcs	Date	Judgement			
<input checked="" type="checkbox"/>	1	14	2024-06-24 07:39:36	Not Yet	Võ Thị Huyền Trang	14	14	<input type="text" value="INPUT"/>	0	3	10	<input type="text"/>	24/06/24	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

---

OK / NG Weight: 0.00 / 0.00 g

Location: WH/Fac/HM → WH/Fac/PL1

Created Date: 06/24/2024 14:39:28

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

Line: -

Item Standby Operation

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

# MMS

## Master Manufacturing Orders



Explain

## II. MO (Manufacturing Order)

### 공정 완료된 제품의 Lot code 발행

실행 순서 & 기능 :

1. "Detail" 버튼을 눌러 Lot code 발행 진행.

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

Master Production / MMO/00227 / MO/01176

Edit Create Action 1/1 < >

Cancel Complete MO Draft In Progress Done

WO List

Product	SEMI-HC-070(6.5)-18K-W-210gr-120-HM	Source Document	MMO/00227
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 / 2.00 pcs
Target / Actual Weight	0.00 / 2.00 g	OK / NG Qty	0.00 / 0.00 pcs
OK / NG Weight	2.00 / 0.00 g	Created Date	06/12/2024 16:27:45
Location	WH/Fac1/HM → WH/Fac1/PL1	Work Date	06/12/2024 08:00:00 → 06/12/2024 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	2.00	2.00	0.00	2.00	2.00	0.00	06/12/2024 16:27:51	Waiting for Lot	Detail 1



## II. MO (Manufacturing Order)

### 양품 판정된 제품의 Lot code 발행

실행 순서 & 기능 :

1. "OK" 탭에서 진행.
2. "Lot" 버튼을 눌러 팝업 오픈.
3. PQC에서 양품 판정된 수량이 자동으로 입력됨. 해당 제품에 포함되는 각 부품의 개수를 입력(선택 사항).
4. "Create" 버튼을 눌러 Lot 발행.

✖ 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**  pcs

**Part Qty**  pcs

Create **4** 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-512-HM

**BOM** SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-512-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

# MMS

## Master Manufacturing Orders



Explain

## II. MO (Manufacturing Order)

### 불량 판정된 제품의 Lot code 발행

**Create Lot**

Target / Actual Weight: 80.00 / 53.00 g

OK / NG Weight: 53.00 / 27.00 g

Type Lot:  OK  NG

Target / Actual Qty: 2.00 / 2.00 pcs

OK / NG Qty: 2.00 / 0.00 pcs

Actual Qty:  pcs

**Create**

MMO#			
MO#	MO/00103	BOM	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM
Work Date	04/02/2024 14:41:55	Process & Level	Hand Made & Level1
Target / Actual Weight	80.00 / 53.00 g	Target / Actual Qty	2.00 / 2.00 pcs
OK / NG Weight	53.00 / 27.00 g	OK / NG Qty	2.00 / 1.00 pcs

1  
OK NG

2  
**Lot** Return NG Print

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

실행 순서 & 기능 :

1. “NG” 탭에서 진행.
2. “Lot” 버튼을 눌러 팝업 오픈.
3. PQC에서 불량 판정된 수량이 자동으로 입력됨.
4. “Create” 버튼을 눌러 Lot 발행.





## II. MO (Manufacturing Order)

불량 판정된 제품을 양품으로 변경하거나, 수리 창고로 이동

실행 순서 & 기능 :

1. "Release" 버튼을 눌러 불량을 양품으로 변경.
2. "Return NG" 버튼을 눌러 불량을 수리 창고로 보내는 팝업 오픈.
3. "Confirm" 버튼을 눌러 불량 이동.
4. "Back" 버튼을 눌러 메인 페이지로 이동.

Master Production / MMO/
Return Order

MMO#	MMO/00017	NG Weight	27.00
MO#	MO/00103	NG Qty	1.00
CWO#	1	To	WH/REC
Process & Level	Hand Made & Level 1	Return Order	0
Product	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM		

WO#	Return Order	From	To	Lot/Serial Number	Weight	Qty	Created on
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

MMO#
MO#
Work Date
Target / Actual Weight

OK / NG Weight
53.00 / 27.00 g
OK / NG Qty
2.00 / 100 pcs

OK
NG

Confirm
Close

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

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	TY-A-002	Done
--------	--	---	-------	------	---------------------	----------	------

Return NG
Print

4

3

2

1

# MMS

## Master Manufacturing Orders



Explain

## II. MO (Manufacturing Order)

### MO 완료

실행 순서 & 기능 :

1. 해당 공정에 여러 개의 라인이 있을 경우 라인을 지정해야 함.
2. "Complete MO" 버튼을 눌러 해당 MO 완료.

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

Master Production / MMO/00254 / MO/01306

Edit + Create Action 1/1 < >

Cancel Complete MO 2 Draft In Progress Done

WO List

Product SEMI-HC-070(6.5)-18K-W-2.10gr-120-HM Source Document MMO/00254

BOM SEMI-HC-070(6.5)-18K-W-2.10gr-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/FacI/HM → WH/FacI/PLI Work Date 06/24/2024 08:00:00 → 06/24/2024 20:00:00

Line 1

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

# MMS

## Master Manufacturing Orders



Explain

## II. MO (Manufacturing Order)

### MMO에 전개된 다음 MO로 이동

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

Master Production / MMO/00254 / MO/01306

Save Discard 1/1 < >

Cancel **Next MO** 1 Draft In Progress Done

WO List

Product	SEMI-HC-070(6.5)-18K-W-2.10gr-120-HM	Source Document	MMO/00254
BOM	SEMI-HC-070(6.5)-18K-W-2.10gr-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/PLI	Work Date	06/24/2024 08:00:00 → 06/24/2024 20:00:00
		Line	HM3

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

실행 순서 & 기능 :

1. "Next MO" 버튼을 눌러 다음 MO로 이동.

\*\* 각 MO는 동일한 구조로 되어있고, 마지막 MO 완료 시 MMO가 동시에 완료되며, 해당 제품은 OQC로 이동함.



## III. Repair Work Order

### 마스터 수리 지시서 목록

MES KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number									
Repair Work Order									
Search...									
+ Create 3 2									
Filters Group By Favorites 1-49 / 49									
Name	Sale Order	Product	Target Weight	Actual Weight	NG	Status	Created by	Created on	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	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	
<input type="checkbox"/>	RMO/00042	T4C3-2.0-B	0.50	0.00	0.00	In Progress	KHC	05/31/2024 08:05:21	
<input type="checkbox"/>	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	

실행 순서 & 기능 :

1. 검색 기능.
2. 엑셀 파일로 다운로드 기능.
3. "Create" 버튼을 눌러 마스터 신규 수리 지시서 생성.
4. 생성된 마스터 수리 지시서 목록 표시. MES > Repair > Repair Order에서 생성된 RMO가 이 목록에 표시됨.



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

Cancel
Confirm 3
Close

1/1
◀ ▶

Draft
Confirmed
In progress
Done

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

**Target / Actual Weight** | 210 / 0.00 g

**Is Recast** | C

**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 <span style="border: 1px solid #000; border-radius: 50%; padding: 2px 5px; margin-left: 5px;">1</span>
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

# MMS

## Master Manufacturing Orders



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 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



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	<span style="background-color: #ccc; border-radius: 50%; padding: 2px;">X</span>	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...		
<span style="background-color: #1a3d4d; color: white; border-radius: 50%; padding: 2px 5px;">1</span> 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	<span style="background-color: #1a3d4d; color: white; padding: 2px 5px;">+ add</span>	<span style="background-color: #ccc; border-radius: 50%; padding: 2px;">X</span>
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	<span style="background-color: #1a3d4d; color: white; padding: 2px 5px;">+ add</span>	<span style="background-color: #ccc; border-radius: 50%; padding: 2px;">X</span>
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	<span style="background-color: #1a3d4d; color: white; padding: 2px 5px;">+ add</span>	<span style="background-color: #ccc; border-radius: 50%; padding: 2px;">X</span>



실행 순서 & 기능 :

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

### 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 / 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...
------	--------	------	-----------	-----------------	-----------	-----------	-----	--------------	--------	--------	-----	----------------------





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	

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

# MMS

## Master Manufacturing Orders



Explain

### III. Repair Work Order

#### 수리할 제품 정보 입력

**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 <b>Input</b>	06/25/2024 12:42:06	2.90 <b>Input</b>	06/25/2024 12:44:07	0.20
2	Chemical Polishing - Man	Đào Thành Đặng	2.90 <b>Input</b>	06/25/2024 12:44:07	2.70 <b>Input</b>	06/25/2024 12:44:07	0.20

**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/FacI/HM → WH/FacI/PLI	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.

# MMS

## Master Manufacturing Orders



Explain

### III. Repair Work Order

#### 실제 중량 및 수량 입력

**Actual** [Close]

MMO# RMO/00061 Process & Level Hand Made & Level 1  
MO# MO/01311 Target / Actual Weight 0.00 / 2.70 g  
PQC [Red Dot] 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	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.



## 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	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** 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 **Operation**
**Actual** 1 **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.

# MMS

## Master Manufacturing Orders



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



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

### 양품 Lot 발행

🔍 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**                     pcs

**Part Qty**                         pcs

**Create** 4 Close

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

<b>MMO#</b>	RMO/00061	<b>Product</b>	SEMI-HC-070(6.5)-18K-W-210GR-120-HM
<b>MO#</b>	MO/01311	<b>BOM</b>	SEMI-HC-070(6.5)-18K-W-210GR-120-HM
<b>Work Date</b>	06/25/2024 12:35:36	<b>Process &amp; Level</b>	Hand Made & Level 1
<b>Target / Actual Weight</b>	2.70 / 0.00 g	<b>Target / Actual Qty</b>	1.00 / 0.00 pcs
<b>OK / NG Weight</b>	2.70 / 0.00 g	<b>OK / NG Qty</b>	1.00 / 0.00 pcs

1 OK NG
2 Lot

To	Lot/Serial Number	Weight	Qty	Created on	State



## 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

Buttons: Edit, + Create, Create, Close, Back

Repair Work Order / RMO

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

Buttons: OK, NG, Lot, Return NG, Print

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



### 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.

Repair Work Order
Return Order

MMO# RMO/00011

MO# MO/00118

CWO# 1

Process & Level Hand Made & Level 1

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

NG Weight 10.00

NG Qty 1.00

To WH/REC

Return Order 0

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

3 Confirm
Close

2 Return NG
4 Print

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	1.00	04/02/2024 16:38:52	Done

1 Release



# MMS

## Master Manufacturing Orders



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  
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

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.



## IV. Recasting List

### 재주조 목록 정보

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/ShefI2	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-013ZY-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

실행 순서 & 기능 :

1. 검색 기능.
2. 주소실로 반납할 금 잔량과 불량 제품 목록 표시. PMO의 Disposal, 각 공정의 불량 반제품과 수선 불가 완제품, Daily Closing Report의 Return to Casting, WMS 각 창고에서 주소실로 반납 결정된 금 자재 등이 해당됨.
3. Excel 변환 기능.



## IV. Recasting List

### 재주조 목록 정보

✖ Recasting Action
✕

**Return To** 3

Alloy
Metal Tree

**Alloy Product** 4 18K-W-GoldTree ↗

**Lot**
Add a line

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-2152g-240612-001	6.52	✖

5 Confirm
Cancel

실행 순서 & 기능 :

1. 목록에서 반납할 품목 선택, From 칼럼의 location이 동일해야 하며, Process 칼럼의 공정이 동일해야 하며, 금 순도(18K/14K)가 동일해야 한다.
2. “Create Recasting Order” 버튼을 눌러 반납 지시서 생성.
3. 반납할 장소를 지정한다.
4. 반납되어 주조될 합금의 종류를 지정한다.
5. “Confirm” 버튼을 눌러 승인한다.

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

Recasting List Search...

2 Create Recasting Order
3 selected

⬇ Action
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★ Favorites

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	Return Type...	Created on	Process	Line	Step	Type	Product	Lot	Quantity	From	Before	After
<input type="checkbox"/>	Disposal	06/13/2024 13:56:01	Metal Tree Cutting				SEMI-SILVER TREE-CAS_TRE-20240613135013	CAS_TRE-97g-240613-001	5.70	WH/Fac1/Mockup	0.00	0.00
<input checked="" type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input checked="" type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input checked="" type="checkbox"/>	Disposal	06/12/2024 15:35:17	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-202406121...	CAS_TRE-2152g-240612-001	6.52	WH/Fac1/Metal Tree Cutting	0.00	0.00
<input checked="" type="checkbox"/>	Disposal	06/12/2024 14:02:47	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-202406121...	CAS_TRE-960g-240612-001	71.00	WH/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	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/Shefl2	0.00	0.00



## V. Recasting Order

### 재주조 반납 지시서 목록

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-120-...	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-1pcs... 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-120-... HC-070(6.5)-18K-W-2.10gr-120-...	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

실행 순서 & 기능 :

1. 검색 기능.
2. 엑셀로 다운로드 기능.
3. 반납 지시서 생성 버튼.
4. “Recasting List” 기능에서 생성된 반납 지시서 목록 표시. 가장 최근에 생성된 반납 지시서가 목록의 최상단에 위치. 해당 지시서를 선택해서 반납 절차 진행.



## V. Recasting Order

### 주조실로 반납된 금 자재의 중량 확인

실행 순서 & 기능 :

1. 주조실 담당자 입고 중량 점검.
2. "Validate" 버튼을 눌러 확정.

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

Recasting Order / WH/WARET/00086

Edit Create Print Action 1/71 < >

Validate 2 Cancel Draft Operation Done

### ☆ WH/WARET/00086

Return Type	Disposal Return	Actual Qty	1 0.00	Input
Source Document	Recasting Order	Total Qty	687.02	
Product	SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803	Gap Qty	0.00	
From	WH/Fac1/Metal Tree Cutting	Alloy Product	18K-W-GoldTree	
To	WH/Fac1/Alloy	New Lot		
Process	Metal Tree Cutting			

Item Order Scrap

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

### 주조실로 반납된 금 자재의 신규 로트 및 저장 장소

실행 순서 & 기능 :

1. 주조실로 반납된 금 자재의 신규 로트 발행.
2. 반납된 자재는 해당 location에 재고로 보관됨.

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

Recasting Order / WH/WARET/00086

Edit + Create Print Action 1 / 71 ◀ ▶

Draft Operation Done

### ☆ WH/WARET/00086

Return Type	Disposal Return	Actual Qty	687.02
Source Document	Recasting Order	Total Qty	687.02
Product	SEMI-18K-W-GOLDTREE-CAS_TRE-20240612163803	Gap Qty	0.00
From	WH/Fac1/Metal Tree Cutting	Alloy Product	18K-W-GoldTree
To	2 WH/Fac1/Alloy	New Lot	1 18KWGOLDTREE-CAS_CUT-687.02-1-240625-001
Process	Metal Tree Cutting		

Item
Order
Scrap

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-20240612163809	CAS_TRE-132.5g-240612-001	82.50
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612162527	CAS_TRE-21.52g-240612-001	6.52



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