

For Smart Factory



Operating |
User |

MANUAL



MES^{3D}

ERP + MES + SCADA

Auto & S.I

User Manual

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MMS

Master Manufacturing Orders



Explain

I. Master Production

Production Work Order Master List

Step by step:

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

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

Production work order master registration

Master Production / New

Draft Confirmed In Progress Done

MO List

1

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

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

Created Date

Work Date

Target / Actual Weight 75.06 / 0.00 g

Target / Actual Qty 3 / 0.00

Is Recast

Remark Test

MO List MO Setting

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

Step by step:

1. Enter relevant information:

_ Product

_ BOM

_ Target / Actual Quantity

_ Remark Remarks

2. Save by pressing the “Save” button.

3. Confirm by pressing the “Confirm” button.

MMS

Master Manufacturing Orders



Explain

I. Master Production

Production Work Order Master Sub-Process Work Order List

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

Master Production / MMO/OO235

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
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:

In Recast

MO List MO Setting

Reference	Level	Process	Product	BOM	Target Weight	Actual Weight	Actual Previous	Materials	Status	
MO/01213	1	Hand Made	SEMI-HC-070(6.5)-18K-W-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	

Step by step:

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

MMS

Master Manufacturing Orders



Explain

I. Master Production

Set up process work orders

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

Master Production / MMO/OO235

Save Discard 2 / 80

Cancel Draft Confirmed In Progress Done

Product: HC-070(6.5)-18K-W-2.10gr-1.20
BOM: HC-070(6.5)-18K-W-2.10gr-1.20 - KHC - 01
Sale Order: S00061
Target / Actual Weight: 0.00 / 0.00 g
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:

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-2.10gr-1.20-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-2.10gr-1.20-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-2.10gr-1.20-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-2.10gr-1.20-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-2.10gr-1.20	Item QC Form	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Draft	<input type="checkbox"/>

Step by step:

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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Process work in progress

Step by step:

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

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

Master Production / MMO/00235

Save Discard 2 / 80

Cancel Draft Confirmed In Progress Done

Product HC-070(6.5)-18K-W-2.10gr-1.20 Created Date 06/17/2024 09:18:12

BOM HC-070(6.5)-18K-W-2.10gr-1.20 - KHC - 01 Work Date 06/17/2024 09:17:58 → 06/17/2024 09:17:58

Sale Order S00061 Target / Actual Qty 10.00 / 0.00

Target / Actual Weight 0.00 / 0.00 g Remark

Is Recast

MO List MO Setting

Reference...	Level	Process	Product	BOM	Target Weight...	Actual Weig...	Actual Previous	Materials	Status...	
MO/01213	1	Hand Made	SEMI-HC-070(6.5)-18K-W-2.10gr-1...	SEMI-HC-070(6.5)-18K-W-2.10gr-1...	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...	SEMI-HC-070(6.5)-18K-W-2.10gr-1...	0.00	0.00	0.00		Draft	
MO/01215	3	1st Finishing	SEMI-HC-070(6.5)-18K-W-2.10gr-1...	SEMI-HC-070(6.5)-18K-W-2.10gr-1...	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...	SEMI-HC-070(6.5)-18K-W-2.10gr-1...	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	

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Process work in progress

Step by step:

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

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

WO List

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 ...
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MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

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

Receive Item

MMO# MMO/00235 Product SEMI-HC-070(6.5)-18K-W-210gr-120-HM
MO# MO/01213 Target Weight 0.00 g
Process & Level Hand Made & Level 1 Target Qty 10.00 pcs

Item	Lot No	From	Stock Qty	Received Weight	UoM	Received Qty	UoM	Confirmation Date
18K Tem(Y)		WH/FacI/HM	0.00	0.00 <input type="text" value="Input"/>	g	100.00	pcs	
SEMI-HC-070(6.5)-18K-W-210gr-120		WH/FacI/HM	0.00	0.00 <input type="text" value="Input"/>	g	0.00	pcs	

MES Master Prod Edit Cancel Save Confirm Close

Product SEMI-HC-070(6.5)-18K-W-210gr-120-HM Source Document MMO/00235
BOM SEMI-HC-070(6.5)-18K-W-210gr-120-HM Process & Level Hand Made & Level 1
Item QC / PQC Form Item QC Form / PQC Form Target / Actual Qty 10.00 / 0.00 pcs
Target / Actual Weight 0.00 / 0.00 g OK / NG Qty 0.00 / 0.00 pcs
OK / NG Weight 0.00 / 0.00 g Created Date 06/17/2024 09:18:12
Location WH/FacI/HM → WH/FacI/PLI Work Date 06/17/2024 09:17:58 → 06/17/2024 09:17:58
Line HM3

1 Item Standby Operation

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

2 3 Check

Step by step:

1. “Register information on materials and semi-finished products used in the process in the “Item” tab.
2. Displays material and semi-finished product information registered in the BOM.
3. Click the “Check” button to open the lot, weight, and quantity input window for the item.
4. Enter relevant information:
_ Lot No.
_ Received Weight
_ Received Qty Quantity received
5. Confirm by pressing the “Confirm” button.

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

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

Step by step:

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

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
<input type="checkbox"/> 18K Tem(Y)	18K Tem	Not Yet
<input checked="" type="checkbox"/> SEMI-T4C3-(2.0-3.5)-17	T4C3-(2.0-3.5)-17inch-18K	Not Yet

Staff	OK g	NG g	OK pcs	NG pcs	Date	Judgement
Đào Thành Đăng	74.98	25.02	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/Defoi	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

SUBMIT **CLOSE**

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/Fac1/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-400Og-10pcs-240328-0...	WH/Fac1/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)

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

Before & After

MMO# MMO/00235 Product SEMI-HC-070(6.5)-18K-W-210gr-1.20-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 <input type="text" value="Input"/>	06/17/2024 10:48:09	0.00 <input type="text" value="Input"/>		0.00
2	Motor Cut - Man		0.00 <input type="text" value="Input"/>		0.00 <input type="text" value="Input"/>		0.00
3	Chemical Cleaning - Man		0.00 <input type="text" value="Input"/>		0.00 <input type="text" value="Input"/>		0.00

Step by step:

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

Save Confirm Close

Item Standby Operation

Before & After

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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

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

Step by step:

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

Actual

MMO# : MMO/00254 Process & Level : Hand Made & Level 1
MO# : MO/01306 Target / Actual Weight : 0.00 / 14.00 g
PQC : Target / Actual Qty : 10.00 / 10.00 pcs
Product : SEMI-HC-070(6.5)-18K-W-2.10gr-1.20-HM

MES Actual Item

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

Product :
BOM :
Item QC / f :
Target / Ac : **Confirm** **4** Close
OK / NG W :
Location : WH/Faci/HM → WH/Faci/PLI Work Date : 06/24/2024 08:00:00 → 06/24/2024 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	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)

Quality inspection of finished products

Quality Checks Popup

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

No	Actual Qty	Create Date	Status	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	0	10	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

SUBMIT **CLOSE**

OK / NG Weight: 0.00 / 0.00 g
Location: WH/Fac/HM → WH/Fac/PLI
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

Step by step:

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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Issuance of lot code for products whose process has been completed

Step by step:

1. Click the "Detail" button to proceed with lot code issuance.

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-2.10gr-1.20-HM	Source Document	MMO/00227
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 / 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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Issuance of lot codes for products judged to be good quality

Create Lot

Target / Actual Weight	14.00 / 0.00 g	Target / Actual Qty	10.00 / 0.00 pcs
OK / NG Weight	14.00 / 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="10.00"/> pcs
		Part Qty	<input type="text" value="0"/> pcs

Create 4 **Close**

MMO#	MMO/00017	Product	SEMI-T4C3-(2.0-3.5)-17inch-18K-W-25.02gr-5.12-HM
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 & Level 1
Target / Actual Weight	80.00 / 0.00 g	Target / Actual Qty	3.00 / 0.00 pcs
OK / NG Weight	53.00 / 27.00 g	OK / NG Qty	2.00 / 1.00 pcs

OK NG

Lot

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

Step by step:

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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Issuance of lot codes for products judged to be defective

Step by step:

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

Master Production / MMS

Edit + Create

Back

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 & Level 1

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

Type Lot OK NG

Actual Qty 100 pcs

Create Close

OK NG

Lot Return NG Print

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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

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

Step by step:

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

The screenshot shows the 'Return Order' window in the MMS system. It contains the following information:

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

Below this information is a table with the following data:

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-1pcs-240402-001	27.00	1.00	04/02/2024 15:17:58

At the bottom of the window, there are two buttons: 'Return NG' (highlighted with callout 2) and 'Print'. Below these is another table with the following data:

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-1pcs-240402-001	27.00	1.00	04/02/2024 15:17:58	TY-A-002	Done

Callouts in the image indicate the following actions:

- 1:** Release button (bottom right)
- 2:** Return NG button (bottom right)
- 3:** Confirm button (bottom left)
- 4:** Back button (left sidebar)

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

MO Completed

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/Fac1/HM → WH/Fac1/PL1	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

Step by step:

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

MMS

Master Manufacturing Orders



Explain

II. MO (Manufacturing Order)

Deployed in MMO and then moved to MO

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-210gr-120-HM	Source Document	MMO/00254
BOM	SEMI-HC-070(6.5)-18K-W-210gr-120-HM	Process & Level	Hand Made & Level 1
Item QC / PQC Form	Item QC Form / PQC Form	Target / Actual Qty	10.00 / 10.00 pcs
Target / Actual Weight	0.00 / 14.00 g	OK / NG Qty	10.00 / 0.00 pcs
OK / NG Weight	14.00 / 0.00 g	Created Date	06/24/2024 14:39:28
Location	WH/Fac1/HM → WH/Fac1/PL1	Work Date	06/24/2024 08:00:00 → 06/24/2024 20:00:00
		Line	HM3

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

Step by step:

1. Click the “Next MO” button to move to the next MO.

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

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Master Repair Order List

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

Repair Work Order

Search... 1

+ Create 3 Download 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-7.69GR-W-F-8-1.2CT	5.00	0.00	0.00	Confirmed	my2	05/31/2024 10:59:03
<input type="checkbox"/>	RMO/00052	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	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-7.69GR-W-F-8-1.2CT	3.00	0.00	0.00	Confirmed	my2	05/31/2024 10:59:03
<input type="checkbox"/>	RMO/00049	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	2.00	2.00	0.00	Done	Administrator	05/31/2024 10:20:50
<input type="checkbox"/>	RMO/00051	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	5.00	0.00	0.00	Confirmed	Administrator	05/31/2024 10:20:50
<input type="checkbox"/>	RMO/00050	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	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-7.69GR-W-F-8-1.2CT	2.00	0.00	0.00	Confirmed	my2	05/31/2024 08:06:29
<input type="checkbox"/>	RMO/00043	BP-T2C-3.5-18K-7.69GR-W-F-8-1.2CT	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-7.69GR-W-F-8-1.2CT	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

Step by step:

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

MMS

Master Manufacturing Orders



Explain

Step by step:

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)

The screenshot displays the 'Add material' dialog box in the MMS system. The dialog is titled 'Add material' and shows the following information:

- MO#**: MO/01311
- Process**: Hand Made
- Material**: SEMI-HC-070(6.5)-18K-W-2.10gr-1.20
- Material Selection**: 18K Tem(Y) (highlighted with a red circle '2')

At the bottom of the dialog, there are buttons for 'Confirm' (highlighted with a red circle '3') and 'Close'. The 'Confirm' button is also highlighted with a red circle '3' in the main interface below.

Below the dialog, the 'MO List' table is visible, showing the following data:

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...	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 +ad 1
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

MMS

Master Manufacturing Orders



Explain

Step by step:

1. The added material is displayed.

III. Repair Work Order

Add materials to master repair work order (optional)

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

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 100 / 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

MMS

Master Manufacturing Orders



Explain

Step by step:

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

III. Repair Work Order

Proceed with repair work instructions for each process

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

Product HC-070(6.5)-18K-W-2.10gr-120 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 100 / 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-120-HM	SEMI-HC-070(6.5)-18K-W-2.10GR-120-HM	0.00	0.00	0.00	SEMI-HC-070(6.5)-18K-W-2.10gr... 18K Tem(Y)	Draft	+ add
MO/01312	2	1st Polishing	SEMI-HC-070(6.5)-18K-W-2.10GR-120-POL 1	SEMI-HC-070(6.5)-18K-W-2.10GR-120-POL 1	0.00	0.00	0.00		Draft	+ add
MO/01313	3	2nd Finishing	HC-070(6.5)-18K-W-2.10gr-120	HC-070(6.5)-18K-W-2.10gr-120 - 2024-06-25 09:15...	0.00	0.00	0.00		Draft	+ add

MMS

Master Manufacturing Orders



Explain

Step by step:

1. Confirm movement to the relevant process.
2. Confirm by pressing the “Confirm” button.

III. Repair Work Order

Proceed with repair work instructions for each process

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-2.10GR-120-HM	Source Document	RMO/00061
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	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

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

MMS

Master Manufacturing Orders



Explain

Step by step:

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

III. Repair Work Order

Enter product information to be repaired

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="text" 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="text" value="Input"/>	g	1.00	pcs	

Item QC / PQC Form Item QC Form / PQC Form Target / Actual Qty 100 / 0.00 pcs
Target / Actual Weight 0.00 / 0.00 g OK / NG Qty 0.00 / 0.00 pcs
OK / NG Weight 0.00 / 0.00 g Created Date 06/25/2024 09:15:33
Location WH/Fac1/HM → WH/Fac1/PL1 Work Date 06/25/2024 08:00:00 → 06/25/2024 20:00:00
Line

Item	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

Enter product information to be repaired

Step by step:

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

Before & After [Close]

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**

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

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

3 Before & After

2

1

4

5

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Enter actual weight and quantity

Step by step:

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

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

Confirm [Close]

Location WH/Fac1/HM → WH/Fac1/PL1 Work Date 06/25/2024 08:00:00 → 06/25/2024 20:00:00
Line

Item Standby **Operation**

Actual **PQC**

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

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

PQC progress

Step by step:

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

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/PLI Work Date: 06/25/2024 08:00:00 → 06/25/2024 20:00:00

Line: _____

Item Standby **Operation**

Actual **PQC**

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

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Lot issuance

Step by step:

1. Press the “Detail” button to issue the lot.

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

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

Save Discard 1/1 < >

Cancel Complete MO Draft In Progress Done

WO List

Product	SEMI-HC-070(6.5)-18K-W-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	100 / 100 pcs
Target / Actual Weight	0.00 / 2.70 g	OK / NG Qty	0.00 / 0.00 pcs
OK / NG Weight	2.70 / 0.00 g	Created Date	06/25/2024 09:15:33
Location	WH/Fac1/HM → WH/Fac1/PL1	Work Date	06/25/2024 08:00:00 → 06/25/2024 20:00:00
		Line	

Item Standby Operation

Actual

No	Actual Weight	OK Weight	NG Weight	Actual Qty	OK Qty	NG Qty	Created on	Status	
1	2.70	2.70	0.00	100	100	0.00	06/25/2024 12:35:36	Waiting for Lot	Detail 1

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Issuance of good quality lot

Step by step:

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

Create **4** Close

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

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

Edit **Create** **Action** 1/1 < >

Back Draft **Waiting for Lot** Waiting for Tray Done

MMO#	RMO/00061	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
----	-------------------	--------	-----	------------	-------

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Issue of defective lot

Step by step:

1. Proceed in the “NG” tab.
2. Click the “Lot” button to open the input window.
3. Enter actual quantity.
4. Issue Lot by pressing the “Create” button.

Repair Work Order / RM

Edit + Create Back

Create Close

Target / Actual Weight 10.00 / 0.00 g

OK / NG Weight 0.00 / 10.00 g

Type Lot OK NG

Target / Actual Qty 1.00 / 0.00 pcs

OK / NG Qty 0.00 / 0.00 pcs

Actual Qty 1.00 pcs

MMO# RMO/00011

MO# MQ/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)-17inch-18K-W-25.02gr-5.12-HM-HM

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

Process & Level Hand Made & Level 1

Target / Actual Qty 1.00 / 1.00 pcs

OK / NG Qty 1.00 / 0.00 pcs

OK NG

Lot Return NG Print

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

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Change defective product to good product or move to Recasting List

Step by step:

1. Press the “Release” button to change defective product to good product.
2. Or press the “Return NG” button to go to MES > MMS > Recasting List.
3. Confirm the move by pressing the “Confirm” button.
4. Print QR by pressing the “Print” button.
5. Click the “Back” button to go to the main page.

The screenshot shows the 'Return Order' window in the MMS system. The window contains the following fields:

- 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

Below the fields is a table with the following data:

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

At the bottom of the window, there are buttons for 'OK', 'NG', 'Confirm', and 'Close'. The 'Confirm' button is highlighted with a red dashed box and a purple circle containing the number 3. The 'Release' button is highlighted with a red dashed box and a purple circle containing the number 1. The 'Return NG' button is highlighted with a red dashed box and a purple circle containing the number 2. The 'Print' button is highlighted with a red dashed box and a purple circle containing the number 4. The 'Back' button is highlighted with a red dashed box and a purple circle containing the number 5.

MMS

Master Manufacturing Orders



Explain

III. Repair Work Order

Complete repair work instructions for each process

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

Cancel **Complete MO** 1 Action

Draft **In Progress** Done

WO List

Product	SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-POL 1	Source Document	RMO/00061
BOM	SEMI-HC-070(6.5)-18K-W-2.10GR-1.20-POL 1		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	Mrp Pro Ok	06/25/2024 09:15:33
Location	WH/Fac1/PL1 → WH/Fac1/FN2	<ul style="list-style-type: none">Field: mrp_pro_ok_idsObject: mrp.cwoType: one2manyContext: {}Domain: [{"is_ng": "=, false}]Modifiers: [{"readonly": true}]On change: 1Relation: mrp.production	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

Step by step:

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

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



IV. Recasting List

Recast List Information

Return Type...	Created on	Process	Line	Step	Type	Product	Lot	Quantity	From	Before	After
<input type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	06/18/2024 15:36:28				18K	18K Tem(Y)	18K Tem - MO/00224 - 1.0 - 10.0 - 24/04/05 - ...	1.00	WH/Material/NG	0.00	0.00
<input type="checkbox"/>	06/17/2024 12:38:23	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240617L...	CAS_TRE-297.0g-240617-001	37.00	WH/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	06/17/2024 10:46:40	Metal Tree Cutting				SEMI-18K-W-GOLDTREE-CAS_TRE-20240617L...	CAS_TRE-296.0g-240617-001	26.00	WH/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	06/13/2024 14:10:38	Silver Mold				SEMI-S-OV-(8.OX6.0)-CN-42CM-14K-2.06GR...	S-OV-(8.OX6.0)-CN-42CM-14K-2.06GR-W-1-L...	1.90	WH/Fac1/Mockup	4.00	3.00
<input type="checkbox"/>	06/13/2024 13:56:01	Metal Tree Cutting				SEMI-SILVER TREE-CAS_TRE-20240613I35013	CAS_TRE-9.7g-240613-001	5.70	WH/Fac1/Mockup	0.00	0.00
<input type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	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/Silv/Shefl2	0.00	0.00
<input type="checkbox"/>	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/Fac1/Mockup	15.00	10.00
<input type="checkbox"/>	06/12/2024 09:22:37	Metal Tree Cutting				SEMI-SILVER TREE-CAS_TRE-20240612O91826	CAS_TRE-63.0g-240612-001	48.00	WH/Fac1/Mockup	0.00	0.00
<input type="checkbox"/>	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-lpc...	2.00	WH/FG	0.00	0.00
<input type="checkbox"/>	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/Fac1/HM	0.00	0.00
<input type="checkbox"/>	06/11/2024 09:16:53					ALY-FLEXIA162-18K-W	ALY-FLEXIA162-18K-W-240404-DCL-013ZY-3...	10.00	WH/Material/Stock	0.00	0.00
<input type="checkbox"/>	06/06/2024 15:17:57				18K	18K Tem(Y)	18K Tem - MO/00224 - 1.0 - 10.0 - 24/04/05 - ...	1.00	WH/Material/NG	0.00	0.00
<input type="checkbox"/>	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/Fac1/Metal Tree Cutting	0.00	0.00
<input type="checkbox"/>	05/29/2024 09:08:54	Hand Made		Hand Made	18K	18K-W-GoldTree	18K-W-GoldTree-HM-1111.0g-lpcs-240529-001	1,111.00	WH/Fac1/HM	0.00	0.00

Step by step:

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



IV. Recasting List

Recast List Information

Recasting Action x

Return To 3 v

Alloy

Metal Tree

Alloy Product 4 18K-W-GoldTree v 🔗

Lot

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

Add a line

Confirm 5

Cancel

Step by step:

1. Select the item you wish to return from the list. The location of the From column must be the same, the process of the Process column must be the same, and the gold purity (18K/14K) must be the same.
2. Click the “Create Recasting Order” button to create a return order.
3. Specify the location for return.
4. Specifies the type of alloy to be returned and cast.
5. Click the “Confirm” button to confirm.

MES												
KPI PMS QMS MMS Repair Scrap Process Closing Report Lot/Serial Number												
Recasting List												Search...
<div style="display: flex; justify-content: space-between; align-items: center;"> Create Recasting Order 3 selected </div> <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 5px;"> ✕ Action ⌵ Filters ≡ Group By ★ Favorites </div>												1-80 / 139
<input type="checkbox"/>	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-9.7g-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-21.52g-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-96.0g-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-7.69GR-W-F-8-12CT+2	S-BP-T2C-3.5-18K-7.69GR-W-F-8-12CT+2-SIL...	3.34	WH/Silv/Sheff2	0.00	0.00

MMS

Master Manufacturing Orders



Explain

V. Recasting Order

List of recast return instructions

Return Type	Reference	Created on	Product	Lot	From	To	Total Qty	Line	Process	Step	Status
<input type="checkbox"/>	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	687.02		Metal Tree Cutting		Operation
<input type="checkbox"/>	Repair Return	WH/WARET/00085	06/17/2024 14:40:14	SEMI-HC-070(6.5)-18K-W-2.10gr...	HC-070(6.5)-18K-W-2.10gr-1.20-...	WH/REC	1.50		1st Polishing		Done
<input type="checkbox"/>	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	29.00		Metal Tree Cutting		Operation
<input type="checkbox"/>	Scrap Return	WH/WARET/00080	06/13/2024 15:20:04	18K-W-GoldTree	18K-W-GoldTree-HM-10.0g-lpcs... 18K-W-GoldTree-HM-10.0g-lpcs...	WH/Fac1/HM	110.00		Hand Made		Operation
<input type="checkbox"/>	Repair Return	WH/WARET/00078	06/13/2024 15:19:28	SEMI-HC-070(6.5)-18K-W-2.10gr...	HC-070(6.5)-18K-W-2.10gr-1.20-... HC-070(6.5)-18K-W-2.10gr-1.20-...	WH/REC	3.30				Operation
<input type="checkbox"/>	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	52.00		Hand Made		Operation
<input type="checkbox"/>	Scrap Return	WH/WARET/00067	06/10/2024 14:32:56	18K-W-GoldTree	18K-W-GoldTree-HM-12.0g-lpcs...	WH/Fac1/HM	12.00		Hand Made		Done
<input type="checkbox"/>	Scrap Return	WH/WMTRET/000...	06/10/2024 14:31:02	18K-W-GoldTree	18K-W-GoldTree-HM-10.0g-lpcs...	WH/Fac1/HM	10.00		Hand Made		Done
<input type="checkbox"/>	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	10.00		Metal Tree Cutting		Cancelled
<input type="checkbox"/>	Scrap Return	WH/WARET/00065	05/29/2024 08:58:44	18K-W-GoldTree	18K-W-GoldTree-HM-1.0g-lpcs...	WH/Fac1/HM	1.00		Hand Made		Cancelled
<input type="checkbox"/>	Scrap Return	WH/WARET/00064	05/28/2024 13:13:46	18K-W-GoldTree	18K-W-GoldTree-CUT-10.0g-lpc...	WH/Fac1/Cutting	10.00		Cutting		Operation
<input type="checkbox"/>	Scrap Return	WH/WARET/00063	05/28/2024 08:47:42	18K-W-GoldTree	18K-W-GoldTree-CAS_TRE-1000...	WH/Fac1/Metal Tree	10,000.00		Metal Tree		Operation
<input type="checkbox"/>	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	78.00				Operation
<input type="checkbox"/>	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	9.00				Done
<input type="checkbox"/>	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	11.00		Silver Mold		Done
<input type="checkbox"/>	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	45.00				Done

Step by step:

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

MMS

Master Manufacturing Orders



Explain

V. Recasting Order

Check the weight of gold material returned to the casting room

Step by step:

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

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	0.00 <input type="text" value="0.00"/>
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

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

Step by step:

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

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

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-20240612153809	CAS_TRE-132.5g-240612-001	82.50
SEMI-18K-W-GOLDTREE-CAS_TRE-20240612152527	CAS_TRE-21.52g-240612-001	6.52



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