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Name: Bertie Harte			Abteilung/Dept.: ▮▮▮▮		**Index Log:** **00001**
Firma, Ort/Company, Location: ▮▮▮▮					Datum/Date: 16/08/21

Betreff, Teilnehmer/Reference, Participants:
Bertie Harte ▮▮

Report – Automatic Re-order from ASM Equipment.

1.0 Scope:

This report outlines the basic operation of automatic material reorder from ASM equipment in KOI Mallow.
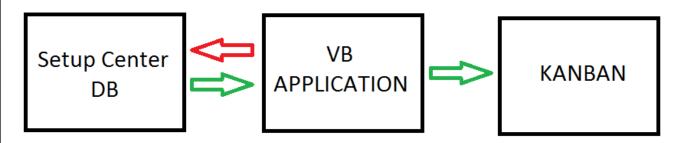
2.0 Status:

Currently the system is in Testing across a number of X-Series SMT Lines.
Background Testing is also underway on the S-Series equipment.

3.0 Details:

There are 4 main components to the system.
- The Siplace Setup Centre DB [Database] on server IEMAPLK004.
- A "Test" DB on server IEMAPLK004.
- A VB [Visual Basic] application – on a networked PC.
- The existing SAP / ERP Kanban system.

Technical Solution:

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- The "**Automatic Material Reorder**" function is enabled on Siplace Setup Centre Application.
- When the Component level (quantity) drops below the threshold value of 35 minutes an entry is automatically created in the "**Reorder**" Table in the Siplace Setup Centre DB.

- The VB Application calls a query on the Setup Centre DB for the most recent "**Reorde**r" information.
- The Query examines the "**Reorder**" table in the DB and matches the returned "**Siplace Pro Component**" and the location to the SAP "**Control cycle number**" in the "**Test**" DB.
- The "**Point Of Time**" [timestamp] and the "**Control cycle number**" are returned to the VB Application.
- There are no changes made to any of the data on any Table in any DB – it is essentially read only.

- The VB Application then logs onto the SAP ERP System and orders the material using the "**Control cycle number**", and then logs off, this directly reflects the existing manual system.
- The application then updates its log-file with the last "**Point Of Time**" transacted.

- 3 minutes later the above sequence is repeated. (this frequency is configurable)

- If no new data exist from the query to the DB no further action occurs.

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- If new order(s) exist then the sequence to log onto and order in KANBAN repeats, and the time stamp is updated.

- All SAP ERP requires from the system is "Control cycle number" to complete the order.

	PointOfTime	Control cycle number
1	2018-03-06 09:17:25.320	3CC16749
2	2018-03-06 09:15:25.257	3CC15936

- After each completed SAP Reorder a Log file is updated showing the order history.
- Load Carriers (multiple issues reels for fast runners) are excluded from the Automatic process.

4.0 Further development and requirements:

- Currently the system is working in beta testing phase.
- Specification document for SAP ERP development to be completed once testing has been completed and all use cases are known. [**Action: Team**]
- Technical details and documentation required for ongoing maintenance of the "Test" DB in the event of Line moves or re-optimisation, this is due to changes in the "Control Cycle" on SAP. [**Action: B.Harte**]
- Alternatively, the location for the Control Cycle master document can be mapped so that live updates occur without impacting the SQL functions. [**Action: Team**]
- Low QTY reels are a problem as the "Time" between reorders is not enough to clear an order. Currently we exclude these from the reorder.
- There is an option to allow the ops to "reorder" these reels automatically when they splice on a reel, however this might promote poor performance as the ops would be free to order any reel at any time.
- Currently testing a function that will only accept an ASM scanner order from a limited list of components.
- Agree a defined time for material supply after reorder, currently this is set to 35mins, during testing it was found that 30 -50[min] was a more robust interval, depending on the Bay/Products, however the Line operators were complaining that the component level indicator alarms on the machines were masking other errors. This setting will be monitored and adjusted based on feedback.

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