

NHÀ MÁY THUỐC BVTV CHÂU THÀNH XUỐNG SẢN XUẤT



HƯỚNG DẪN VẬN HÀNH HỆ THỐNG KIỂM TRA QR CODE CHAI KT01

Số hiệu: HD-KT01

Phiên bản: 01

Ngày ban hành: 01/04/2022

Trách nhiệm	Chức danh	Họ và tên	Ngày tháng	Chữ ký
Biên soạn	NV KCS	Trương Thị Thanh Tuyền/...../.....	
Đồng thuận	NV Vận hành	Bùi Phan Xuân Chiên/...../.....	
	NV Vận hành	Nguyễn Phuoc Nhuận/...../.....	
	NV Vận hành	Nguyễn Thị Ngọc Diệu/...../.....	
	NV Vận hành	Nguyễn Văn Bào/...../.....	
	NV Bảo trì	Phan Hữu Vũ/...../.....	
Xem xét	PT Bảo trì chuyền	Nguyễn Phú Nam/...../.....	
Duyệt	PQĐ Xưởng SX	Nguyễn Phuoc Sĩ/...../.....	

Lưu ý: Tài liệu lưu hành nội bộ, là tài sản của Tập đoàn Lộc Trời. Nghiêm cấm sao chép dưới mọi hình thức khi chưa có ý kiến phê duyệt chấp thuận bằng văn bản của Cấp có thẩm quyền theo Khung phân quyền hiện hành.

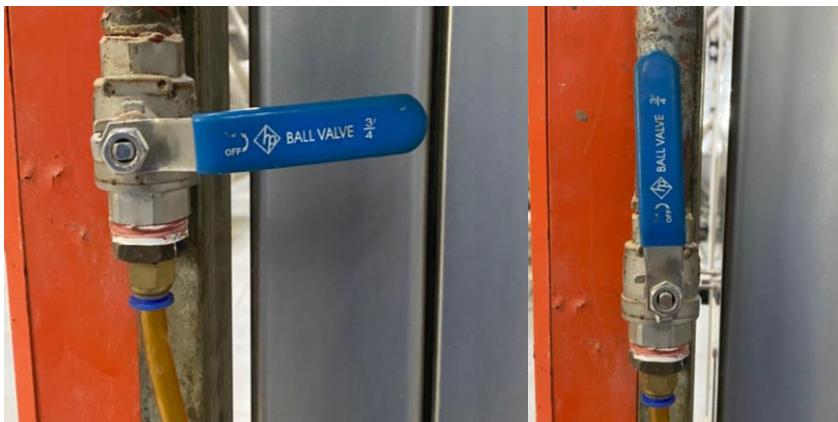
I. KIỂM TRA TRƯỚC KHI VẬN HÀNH

➤ Kiểm tra an toàn trước khi hoạt động.



◀ Kiểm tra băng tải, bộ phận tách chai, bộ phận xoay chai

▼ Mở van cung cấp khí nén



▲ Xoay công tắc NGUỒN đến vị trí OPEN để cấp điện

▲ Án vào nút XANH để cấp điện nguồn cho bộ UPS của máy vi tính

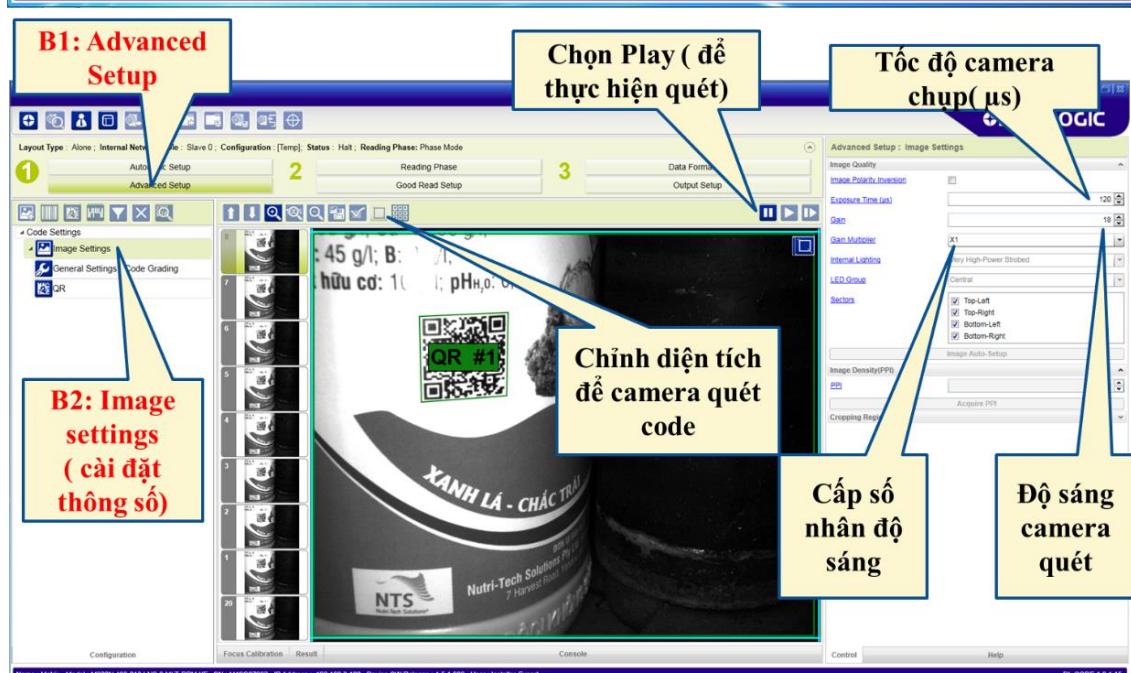
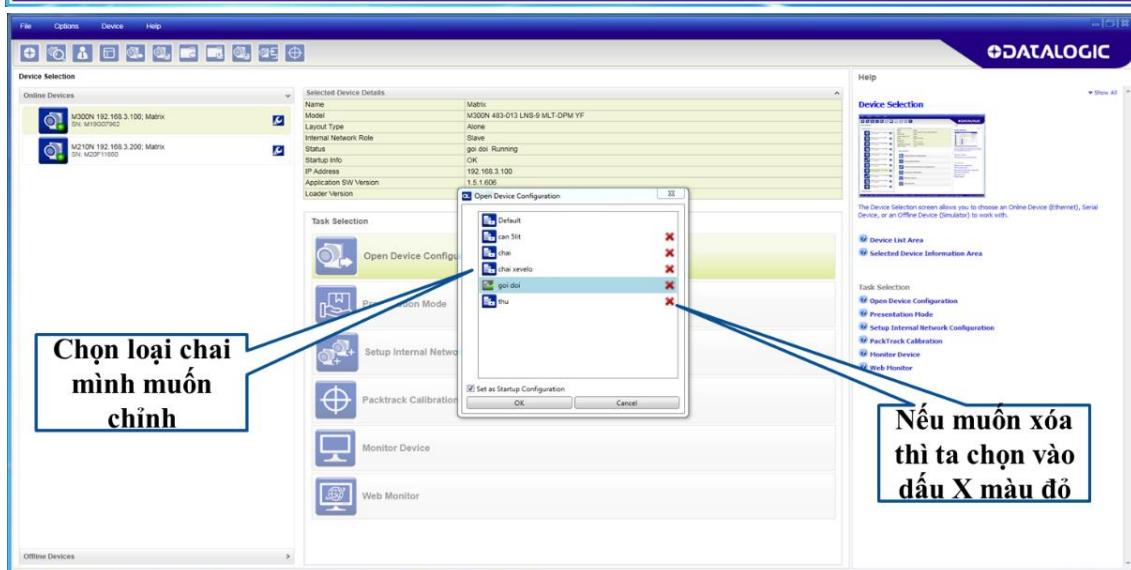
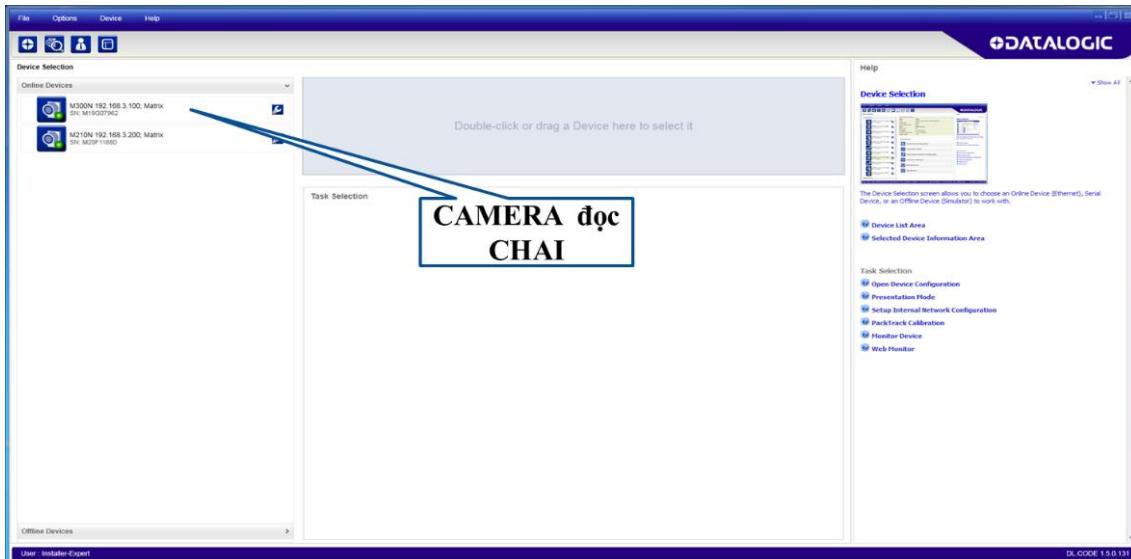
II. VẬN HÀNH

1. Điều chỉnh camera

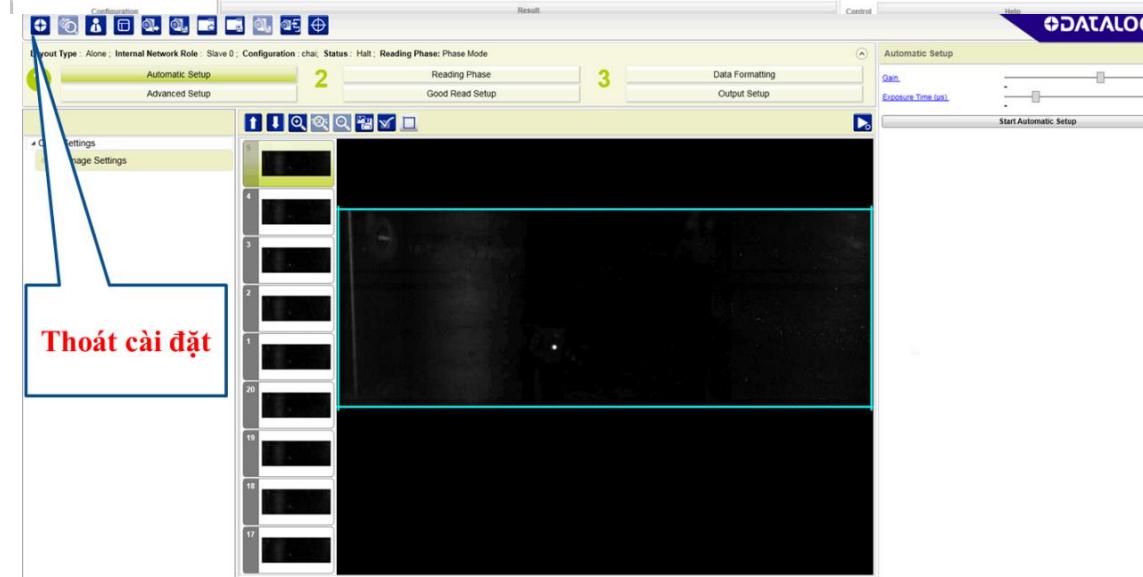
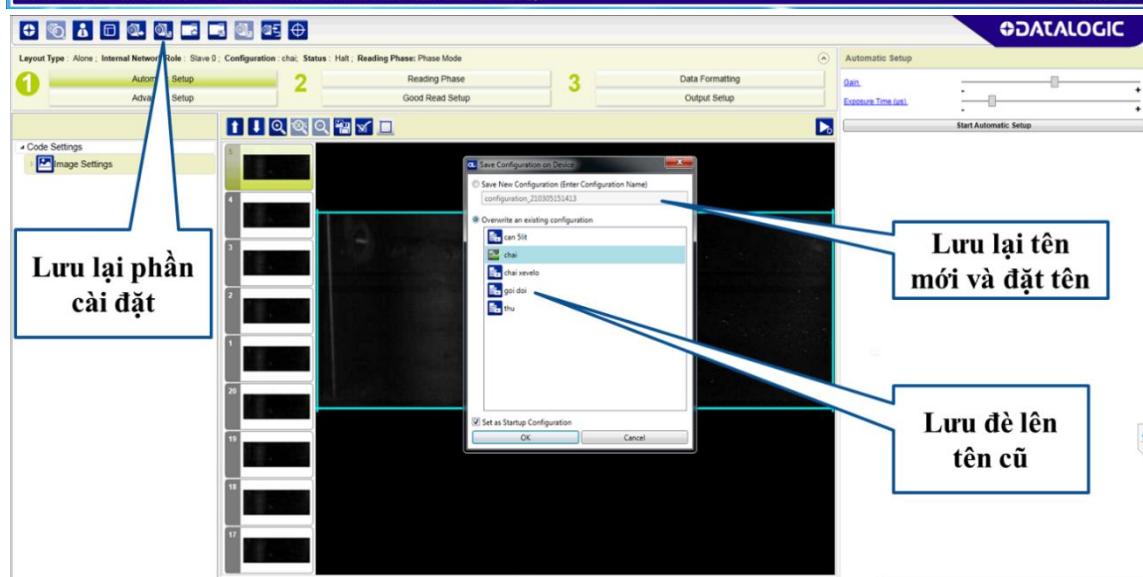
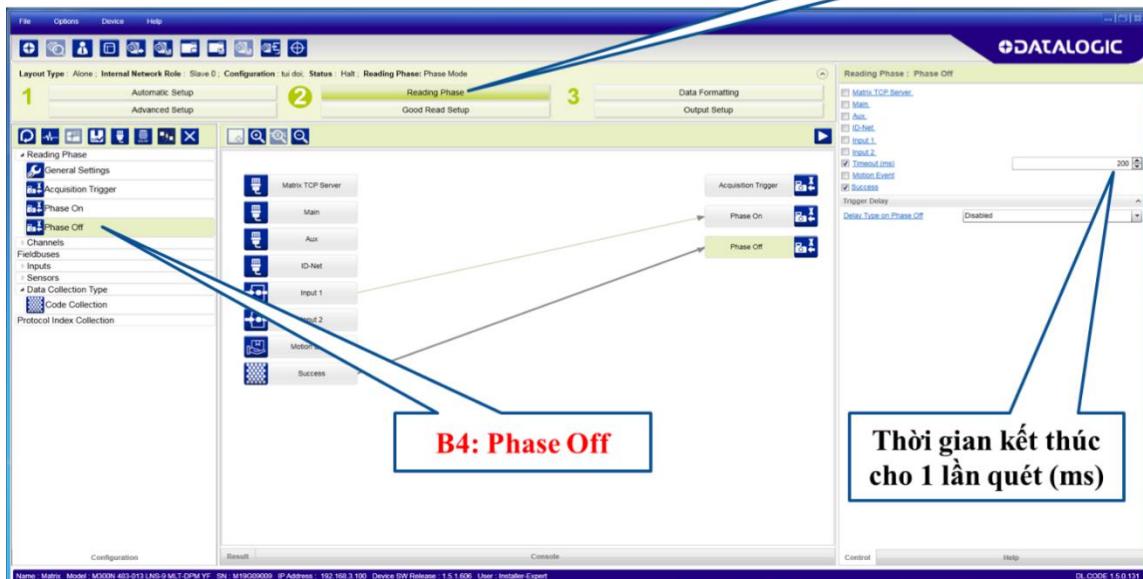


◀ Sau khi máy tính mở lên, ta chọn ứng dụng hiệu chỉnh camera
DL.CODE 1.50

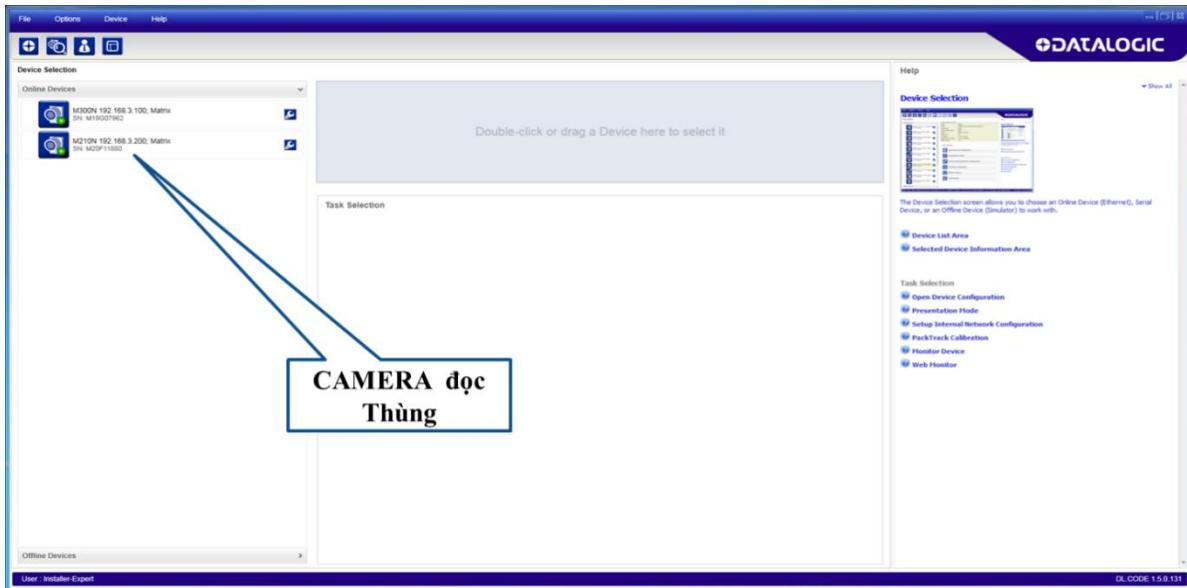
➤ Chọn camera đọc code chai, địa chỉ **192.168.3.100** để điều chỉnh cho hợp lý



B3: Reading Phase

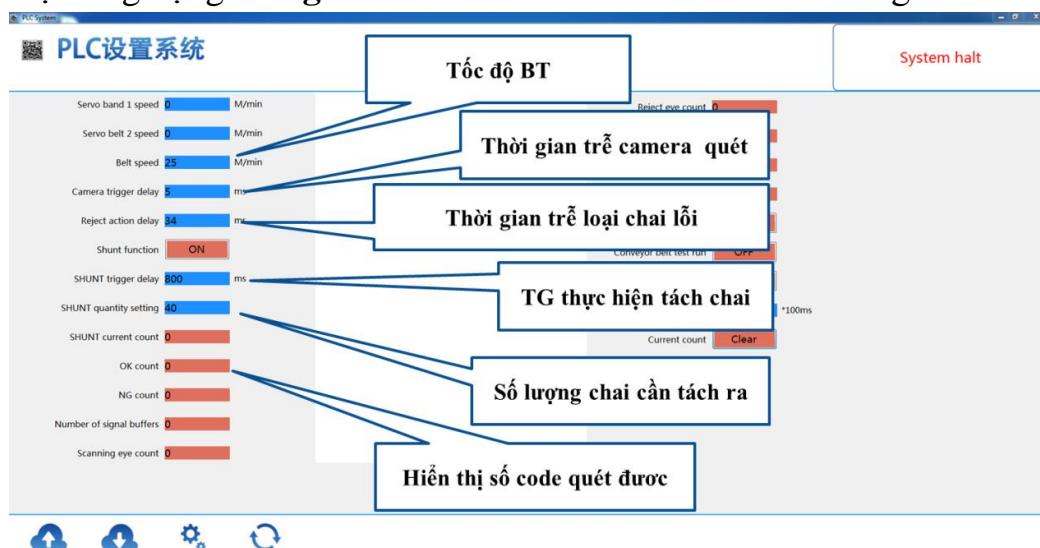


- Chọn camera đọc **code thùng**, địa chỉ **192.168.3.200** để điều chỉnh cho hợp lý

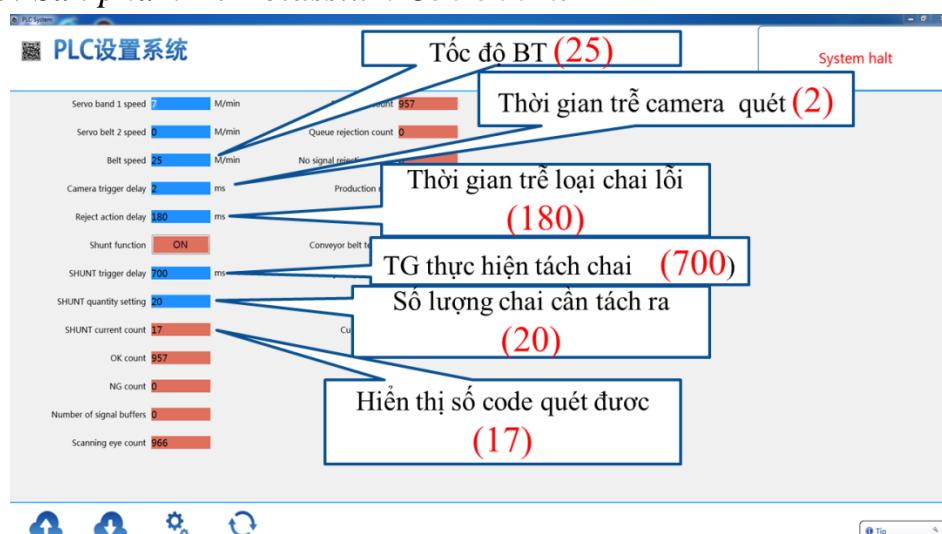


2. Cài đặt thông số PLC

- Chọn ứng dụng Wing WDT Module – PLC để cài đặt thông số



Tham khảo: Sản phẩm Hi-Potassium C30 500ml

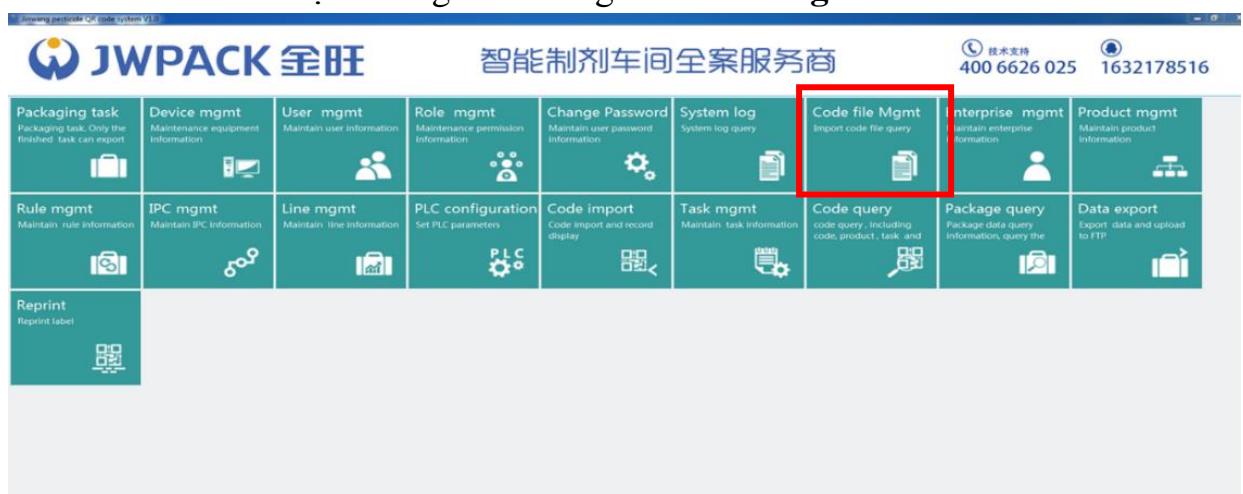


3. Thu thập QR code



◀ Chọn ứng dụng thu thập
Code Wing VDT

➤ Kiểm tra kế hoạch trong chức năng **Code file Mgmt**



File name	Bottle quantity	Box quantity	Bottle remaining quantity	Box remaining quantity	Product name	Task status	Force finish
20210120133755 1PHDAMV001 008367	0	0			Peran SEC	Uncom...	Force finish
20210120133428 1PHDAMV001 008366	0	0				Uncom...	Force finish
20210120132820 1PHDAMV001 008365	0	0				Uncom...	Force finish
20210120131420 1PHDAMV001 008364	0	0				Uncom...	Force finish
20210120131037 1PHDAMV001 008363	0	0				Uncom...	Force finish
20210120130632 1ANGUN5001 008362	0	0				Uncom...	Force finish
20210120130630 1PHDAMV001 008360	0	0				Uncom...	Force finish
20210120125364 1PHDAMV001 008360	0	0				Uncom...	Force finish
20210120124842 1PHDAMV001 008359	0	0				Uncom...	Force finish
20210120124243 1RADIAN001 008358	0	0				Uncom...	Force finish
202101201202050 1TOTA20001 008357	0	0				Uncom...	Force finish
202101201201700 1TOTA20001 008356	0	0				Uncom...	Force finish
2021012012009558 1RADIAN001 008355	0	0				Uncom...	Force finish
202101201200439 1RADIAN001 008354	0	0				Uncom...	Force finish
20210120095528 1DUPEXE001 008353	0	0				Uncom...	Force finish
20210120095302 1ANKL4001 008352	0	0				Uncom...	Force finish
20210120094555 1ANGUN5002 008351	0	0				Uncom...	Force finish
20210119141112 1NSURA001 008349	0	0				Uncom...	Force finish
20210119135468 1PHDAMV001 008347	0	0				Uncom...	Force finish
20210119135246 1PERANS5004 008347	15500	155	15500	155	Peran SEC	Uncom...	Force finish
20210119134750 1PHDAMV001 008345	0	0				Uncom...	Force finish
20210119133319 1PERANS5004 008344	3932	155	3932	155	Peran SEC	Uncom...	Force finish
2021011901518 1ANKL4001 008343	0	0				Uncom...	Force finish
20210119090222 1ANGUN5002 008342	0	0				Uncom...	Force finish
20210119085849 1ANGUN5001 008341	0	0				Uncom...	Force finish
20210119085437 1DUPEXE001 008340	0	0				Uncom...	Force finish
20210119085011 1TOPSHOT04 008339	4920	123	4920	123	topshop	Uncom...	Force finish
20210119083840 1RADIAN001 008336	0	0				Uncom...	Force finish
20210119083400 1RADIAN001 008335	0	0				Uncom...	Force finish
20210119082219 1TOTA20001 008333	0	0				Uncom...	Force finish

➤ Sau khi thực hiện reset ta tải kế hoạch về trong chức năng **Code Import**



B1: Click chuột vào ô Query để LOAD kế hoạch

* Lưu ý: Máy tính có kết nối internet thì mới LOAD được KH và chúng ta phải LOAD hết tất cả các KH.

➤ Tạo kế hoạch để chạy trong chức năng **Task Mgmt**



B1: Chọn mã vật tư

Line	Task code	Task name
Two level line	20210128073349	20210128073349
Two level line	20210126160534	20210126160534
Two level line	20210126072338	20210126072338
Two level line	20210123151238	20210123151230
Two level line	20210123073812	20210123073812
Two level line	20210123065807	20210123065807
Two level line	20210122073035	20210122073035
Two level line	20210120163826	20210120163826
Two level line	20210120074438	20210120074438
Two level line	20201219064916	20201219064916
Two level line	20201218065918	20201218065918
Two level line	20201217072756	20201217072756
Two level line	20201216130020	20201216130020
Two level line	20201216104953	20201216104953
Two level line	20201116092956	20201116092956
Two level line	20201115175002	20201115175002
Two level line	20201115163114	20201115163114
Two level line	20201115133430	20201115133430
Two level line	20201114180326	20201114180326
Two level line	20201114124609	20201114124609

B1: Chọn mã vật tư

B2: Kiểm tra quy cách đóng thùng

B3: Chọn sử dụng

Line	Task code	Task name
Two level line	20210128073349	20210128073349
Two level line	20210126160534	20210126160534
Two level line	20210126072338	20210126072338
Two level line	20210123151238	20210123151230
Two level line	20210123073812	20210123073812
Two level line	20210123065807	20210123065807
Two level line	20210122073035	20210122073035
Two level line	20210120163826	20210120163826
Two level line	20210120074438	20210120074438
Two level line	20201219064916	20201219064916
Two level line	20201218065918	20201218065918
Two level line	20201217072756	20201217072756
Two level line	20201216130020	20201216130020
Two level line	20201216104953	20201216104953
Two level line	20201116092956	20201116092956
Two level line	20201115175002	20201115175002
Two level line	20201115163114	20201115163114
Two level line	20201115133430	20201115133430
Two level line	20201114180326	20201114180326
Two level line	20201114124609	20201114124609

B2: Chọn mã lệnh kế hoạch

Line	Task code	Task name
Two level line	20210128073349	20210128073349
Two level line	20210126160534	20210126160534
Two level line	20210126072338	20210126072338
Two level line	20210123151238	20210123151230
Two level line	20210123073812	20210123073812
Two level line	20210123065807	20210123065807
Two level line	20210122073035	20210122073035
Two level line	20210120163826	20210120163826
Two level line	20210120074438	20210120074438
Two level line	20201219064916	20201219064916
Two level line	20201218065918	20201218065918
Two level line	20201217072756	20201217072756
Two level line	20201216130020	20201216130020
Two level line	20201216104953	20201216104953
Two level line	20201116092956	20201116092956
Two level line	20201115175002	20201115175002
Two level line	20201115163114	20201115163114
Two level line	20201115133430	20201115133430
Two level line	20201114180326	20201114180326
Two level line	20201114124609	20201114124609

Packaging task Packaging task. Only the finished task can export	Device mgmt Maintenance equipment information	User mgmt Maintain user information	Role mgmt Maintenance permission information	Change Password Maintain user password information	System log System log query	Code file Mgmt Import code file query	Enterprise mgmt Maintain enterprise information	Product mgmt Maintain product information																																																																																																
<table border="1"> <thead> <tr> <th colspan="2">File name:</th> <th colspan="2">Query (Q)</th> <th colspan="2">Close (R)</th> </tr> </thead> <tbody> <tr> <td>File name</td> <td>Bottle quantity</td> <td>Box quantity</td> <td>Bottle remaining quantity</td> <td>Box remaining quantity</td> <td>Product name</td> </tr> <tr> <td>20210305110127 1ANGUN5002 008899 25000</td> <td>50</td> <td>25000</td> <td>50</td> <td>50</td> <td></td> </tr> <tr> <td>20210304102543 1ANGUN5002 008864 26500</td> <td>53</td> <td>26500</td> <td>53</td> <td>53</td> <td></td> </tr> <tr> <td>2021031110305 1ANGUN5002 008856 25000</td> <td>50</td> <td>25000</td> <td>50</td> <td>50</td> <td></td> </tr> <tr> <td>20210302102846 1ANGUN5002 008835 27500</td> <td>55</td> <td>27500</td> <td>55</td> <td>55</td> <td></td> </tr> <tr> <td>20210301111155 1ANGUN5002 008801 25000</td> <td>50</td> <td>25000</td> <td>50</td> <td>50</td> <td></td> </tr> <tr> <td>20210227103143 1ANGUN5002 008778 50000</td> <td>100</td> <td>50000</td> <td>100</td> <td>100</td> <td></td> </tr> <tr> <td>20210226102152 1ANGUN5002 008762 50000</td> <td>100</td> <td>50000</td> <td>100</td> <td>100</td> <td></td> </tr> <tr> <td>20210225111129 1ANGUN5002 008734 50000</td> <td>100</td> <td>50000</td> <td>100</td> <td>100</td> <td></td> </tr> <tr> <td>20210224135132 1ANGUN5002 008719 50000</td> <td>100</td> <td>50000</td> <td>100</td> <td>100</td> <td></td> </tr> <tr> <td>20210223140228 1ANGUN5002 008704 50000</td> <td>100</td> <td>50000</td> <td>100</td> <td>100</td> <td></td> </tr> <tr> <td>20210221100307 1ANGUN5002 008677 37500</td> <td>75</td> <td>37500</td> <td>75</td> <td>75</td> <td></td> </tr> <tr> <td>20210220100340 1ANGUN5002 008667 36000</td> <td>72</td> <td>36000</td> <td>72</td> <td>72</td> <td></td> </tr> <tr> <td>20210219082414 1ANGUN5002 008594 17500</td> <td>35</td> <td>17500</td> <td>35</td> <td>35</td> <td></td> </tr> <tr> <td>20210208110521 1ANGUN5002 008586 15000</td> <td>30</td> <td>15000</td> <td>30</td> <td>30</td> <td></td> </tr> </tbody> </table> <p>Records 0, page 1, page 0 First page Pre page Next page Last page Go 1 page previous 20 records Save (S) Cancel (C)</p>									File name:		Query (Q)		Close (R)		File name	Bottle quantity	Box quantity	Bottle remaining quantity	Box remaining quantity	Product name	20210305110127 1ANGUN5002 008899 25000	50	25000	50	50		20210304102543 1ANGUN5002 008864 26500	53	26500	53	53		2021031110305 1ANGUN5002 008856 25000	50	25000	50	50		20210302102846 1ANGUN5002 008835 27500	55	27500	55	55		20210301111155 1ANGUN5002 008801 25000	50	25000	50	50		20210227103143 1ANGUN5002 008778 50000	100	50000	100	100		20210226102152 1ANGUN5002 008762 50000	100	50000	100	100		20210225111129 1ANGUN5002 008734 50000	100	50000	100	100		20210224135132 1ANGUN5002 008719 50000	100	50000	100	100		20210223140228 1ANGUN5002 008704 50000	100	50000	100	100		20210221100307 1ANGUN5002 008677 37500	75	37500	75	75		20210220100340 1ANGUN5002 008667 36000	72	36000	72	72		20210219082414 1ANGUN5002 008594 17500	35	17500	35	35		20210208110521 1ANGUN5002 008586 15000	30	15000	30	30	
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Kiểm tra mã Vật Tư
Kiểm tra mã KH
Số lượng GÓI
Số lượng THÙNG
Chọn sử dụng

Jinwang pesticide QR code system V1.0		智能制剂车间全案服务商	技术支持 400 6626 025 1632178516																																						
<table border="1"> <tr> <td>Task code: <input type="text"/></td> <td>Product: <input type="text"/></td> </tr> <tr> <td>Production: <input type="text"/></td> <td>Task: <input type="text"/></td> </tr> <tr> <td colspan="4"> <table border="1"> <tr> <td>Product: <input type="text"/> Choose</td> <td>File: <input type="text"/> Choose</td> </tr> <tr> <td>Task code: <input type="text"/> Task name: <input type="text"/></td> <td>Batch: <input type="text"/> Line: <input type="text"/> Two level lin</td> </tr> <tr> <td>MFG: <input type="text"/> Valid: <input type="text"/></td> <td>QA: <input type="text"/> Check date: <input type="text"/> 2021-01-28</td> </tr> <tr> <td>Check result: <input type="text"/> Qualified</td> <td>Item No: <input type="text"/> Task status: <input type="text"/></td> </tr> <tr> <td>Planned: <input type="text"/></td> <td>Date created: <input type="text"/> 2021-01-28</td> </tr> <tr> <td>Completed: <input type="text"/></td> <td>Remarks: <input type="text"/></td> </tr> <tr> <td colspan="2"> <input type="button" value="Save (S)"/> <input type="button" value="Cancel (C)"/> </td> </tr> </table> </td> </tr> <tr> <td colspan="4"> Đặt tên cho KH (Tên SP – Loại – ID – Tô trường – NĐG – Mã chuyển VD: Totan 20g 14009 Bình 220222 J10) </td> </tr> <tr> <td colspan="4"> Ghi Chú </td> </tr> <tr> <td colspan="4"> Tên người Kiểm Tra chuyên (KCS) </td> </tr> <tr> <td colspan="4"> Mục tiêu (có thể bỏ trống) </td> </tr> </table>				Task code: <input type="text"/>	Product: <input type="text"/>	Production: <input type="text"/>	Task: <input type="text"/>	<table border="1"> <tr> <td>Product: <input type="text"/> Choose</td> <td>File: <input type="text"/> Choose</td> </tr> <tr> <td>Task code: <input type="text"/> Task name: <input type="text"/></td> <td>Batch: <input type="text"/> Line: <input type="text"/> Two level lin</td> </tr> <tr> <td>MFG: <input type="text"/> Valid: <input type="text"/></td> <td>QA: <input type="text"/> Check date: <input type="text"/> 2021-01-28</td> </tr> <tr> <td>Check result: <input type="text"/> Qualified</td> <td>Item No: <input type="text"/> Task status: <input type="text"/></td> </tr> <tr> <td>Planned: <input type="text"/></td> <td>Date created: <input type="text"/> 2021-01-28</td> </tr> <tr> <td>Completed: <input type="text"/></td> <td>Remarks: <input type="text"/></td> </tr> <tr> <td colspan="2"> <input type="button" value="Save (S)"/> <input type="button" value="Cancel (C)"/> </td> </tr> </table>				Product: <input type="text"/> Choose	File: <input type="text"/> Choose	Task code: <input type="text"/> Task name: <input type="text"/>	Batch: <input type="text"/> Line: <input type="text"/> Two level lin	MFG: <input type="text"/> Valid: <input type="text"/>	QA: <input type="text"/> Check date: <input type="text"/> 2021-01-28	Check result: <input type="text"/> Qualified	Item No: <input type="text"/> Task status: <input type="text"/>	Planned: <input type="text"/>	Date created: <input type="text"/> 2021-01-28	Completed: <input type="text"/>	Remarks: <input type="text"/>	<input type="button" value="Save (S)"/> <input type="button" value="Cancel (C)"/>		Đặt tên cho KH (Tên SP – Loại – ID – Tô trường – NĐG – Mã chuyển VD: Totan 20g 14009 Bình 220222 J10)				Ghi Chú				Tên người Kiểm Tra chuyên (KCS)				Mục tiêu (có thể bỏ trống)			
Task code: <input type="text"/>	Product: <input type="text"/>																																								
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<table border="1"> <tr> <td>Product: <input type="text"/> Choose</td> <td>File: <input type="text"/> Choose</td> </tr> <tr> <td>Task code: <input type="text"/> Task name: <input type="text"/></td> <td>Batch: <input type="text"/> Line: <input type="text"/> Two level lin</td> </tr> <tr> <td>MFG: <input type="text"/> Valid: <input type="text"/></td> <td>QA: <input type="text"/> Check date: <input type="text"/> 2021-01-28</td> </tr> <tr> <td>Check result: <input type="text"/> Qualified</td> <td>Item No: <input type="text"/> Task status: <input type="text"/></td> </tr> <tr> <td>Planned: <input type="text"/></td> <td>Date created: <input type="text"/> 2021-01-28</td> </tr> <tr> <td>Completed: <input type="text"/></td> <td>Remarks: <input type="text"/></td> </tr> <tr> <td colspan="2"> <input type="button" value="Save (S)"/> <input type="button" value="Cancel (C)"/> </td> </tr> </table>				Product: <input type="text"/> Choose	File: <input type="text"/> Choose	Task code: <input type="text"/> Task name: <input type="text"/>	Batch: <input type="text"/> Line: <input type="text"/> Two level lin	MFG: <input type="text"/> Valid: <input type="text"/>	QA: <input type="text"/> Check date: <input type="text"/> 2021-01-28	Check result: <input type="text"/> Qualified	Item No: <input type="text"/> Task status: <input type="text"/>	Planned: <input type="text"/>	Date created: <input type="text"/> 2021-01-28	Completed: <input type="text"/>	Remarks: <input type="text"/>	<input type="button" value="Save (S)"/> <input type="button" value="Cancel (C)"/>																									
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Đặt tên cho KH (Tên SP – Loại – ID – Tô trường – NĐG – Mã chuyển VD: Totan 20g 14009 Bình 220222 J10)																																									
Ghi Chú																																									
Tên người Kiểm Tra chuyên (KCS)																																									
Mục tiêu (có thể bỏ trống)																																									

➤ Chọn kế hoạch để chạy trong chức năng Packaging task

Packaging task Packaging task. Only the finished task can export	Device mgmt Maintenance equipment information	User mgmt Maintain user information	Role mgmt Maintenance permission information	Change Password Maintain user password information	System log System log query	Code file Mgmt Import code file query	Enterprise mgmt Maintain enterprise information	Product mgmt Maintain product information
Rule mgmt Maintain rule information	IPC mgmt Maintain IPC information	Line mgmt Maintain line information	PLC configuration Set PLC parameters	Code import Code Import and record display	Task mgmt Maintain task information	Code query code query, including code, product, task and	Package query Package data query, including	Data export Export data and upload to FTP
Reprint Reprint label								
Chọn								

5002 [Init]

Line name:	Two level line
Batch:	5002
Task code:	20210305160004
Product:	angun
Product spec:	10g
Net content:	
Pack ratio:	1:500
Quantity:	0

Start **Pause** **Finish** **Rework**

Bắt đầu chạy KH

JWPACK 金旺 智能制剂车间全案服务商  技术支持
400 6626 025  1632178516

Task code	20210305160004	Packing spec	1:500	Level 1	0
batch	5002	Packing ratio	1:500	Level 2	0
Product	angun	MFG	2021-03-05		
Certificate No	1ANGUN5002	Valid until	2023-03-04		
Reject: 0	Bottle station	500001th	remove	Case station	Xóa bỏ thùng đã được quét
Complete: 0	Unpacked: 0		Zero box	Reject: 0	Code
Choose Code			Complete: 0 Case station Reject: 0		

Gỡ bỏ những code đã thu thập được

Xuất thùng lẻ

Dùng sung quét kiểm tra

Thay thế Code

Dùng KH

Xóa thông tin hiển thị

 ➤ Kết thúc kế hoạch bằng lệnh **Finish**

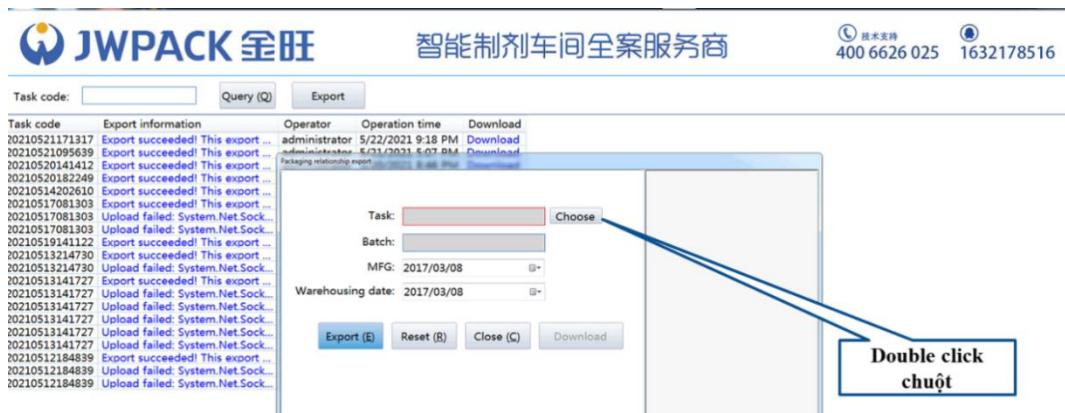
5002 [Init]

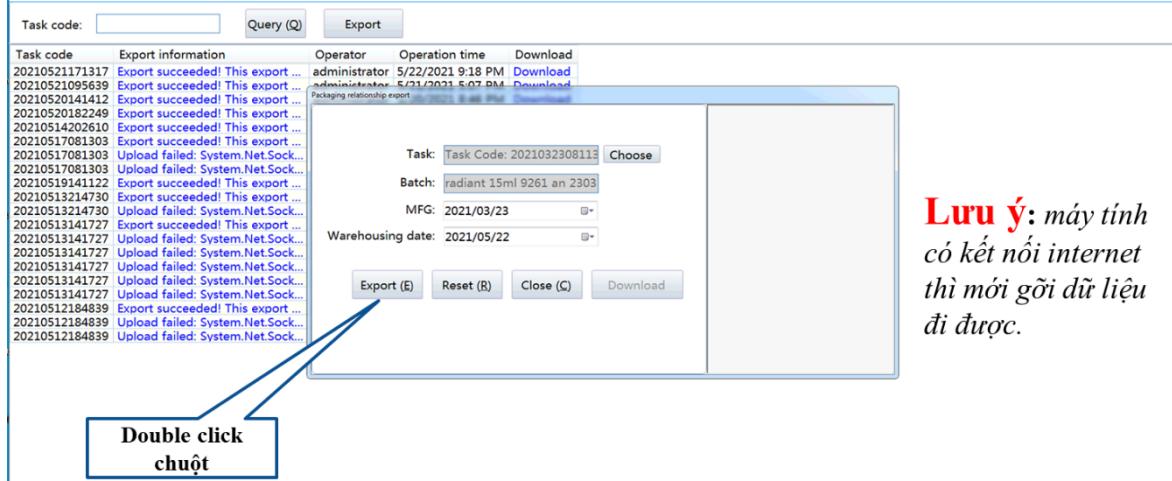
Line name:	Two level line
Batch:	5002
Task code:	20210305160004
Product:	angun
Product spec:	10g
Net content:	
Pack ratio:	1:500
Quantity:	0

Start **Pause** **Finish** **Rework**

Kết thúc KH

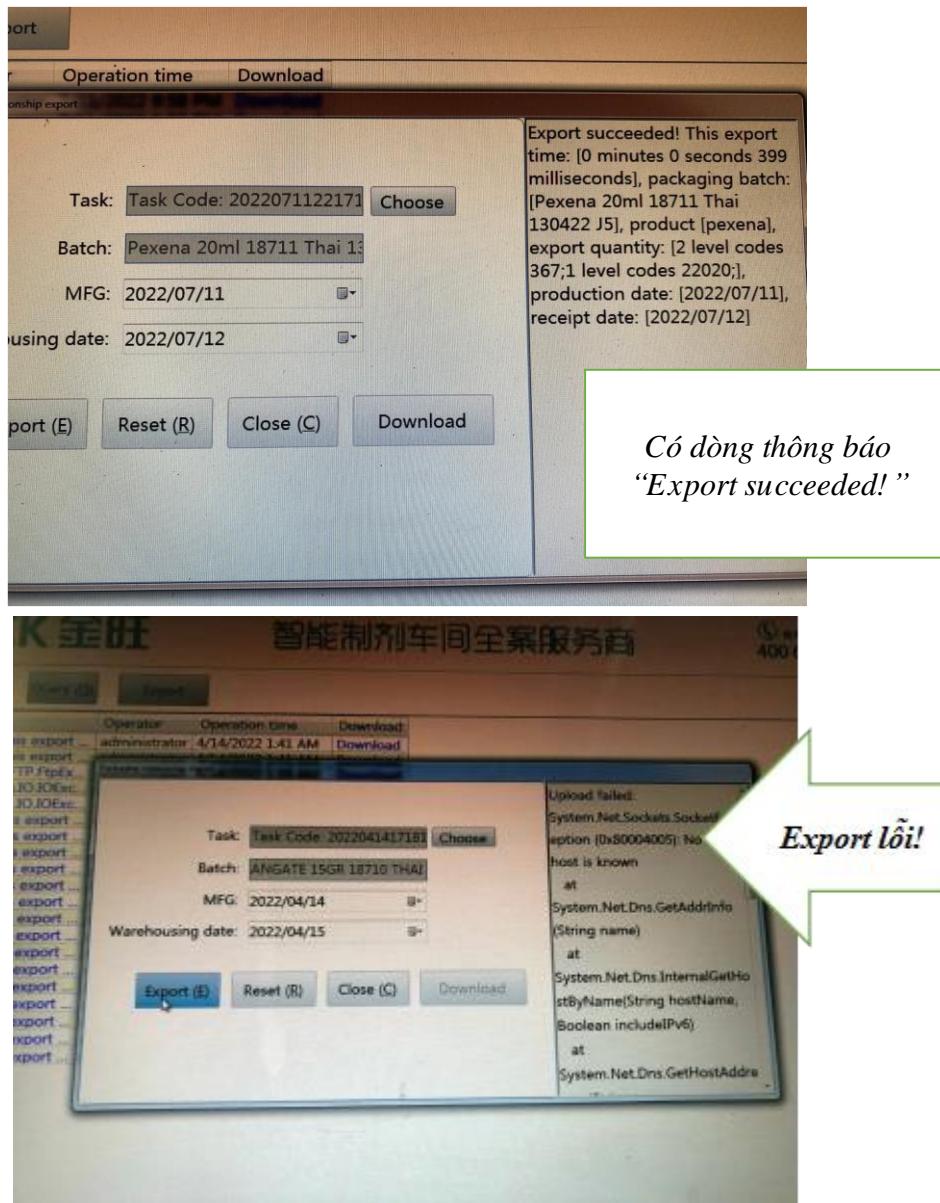
➤ Sau khi kết thúc kế hoạch ta gởi lên hệ thống trong chức năng **Data Export**





Lưu ý: máy tính có kết nối internet thì mới gửi dữ liệu đi được.

- ❖ **Chú ý:** Export thành công có dòng thông báo “Export succeeded!”.

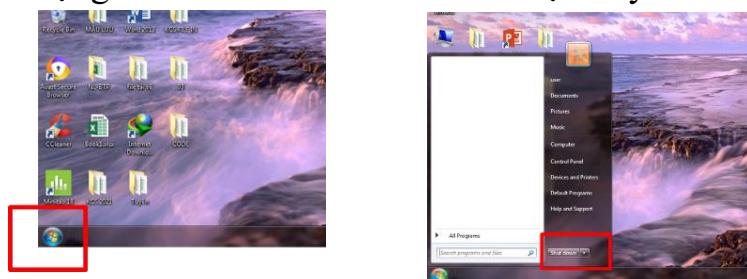


III. TẮT MÁY

➤ Đóng tất cả các ứng dụng lại **Close X** trên màn hình góc phải.

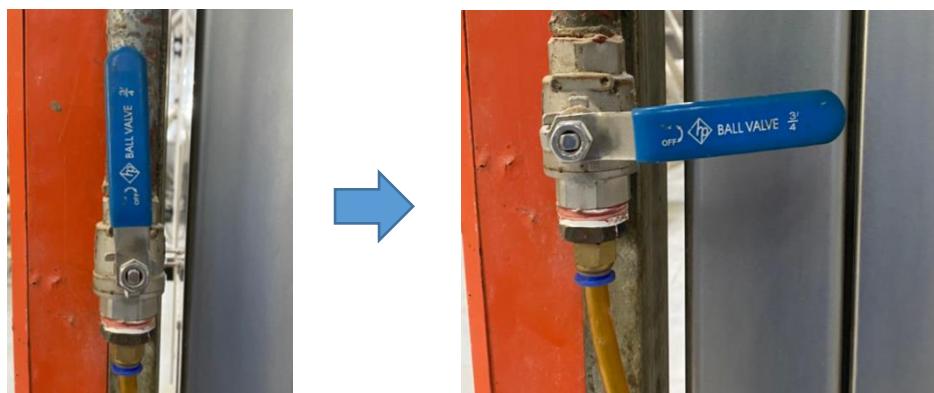


➤ Vào biểu tượng Windows → shut down → đợi máy tính tắt xong



▲ Ấn vào nút XANH để ngắt điện nguồn cho bộ UPS của máy vi tính

▲ Xoay công tắc NGUỒN đến vị trí CLOSE để ngắt điện nguồn



▲ Khóa van cung cấp khí nén

❖ Lưu ý:

- Vệ sinh sạch sẽ máy và phạm vi làm việc trước khi ra về.
- Không được tự ý hoặc cho người khác chỉnh sửa máy.
- Khi có sự cố phải dừng máy khẩn cấp và báo cho người có trách nhiệm biết để xử lý.