

Batch Record Report
5957004 - Fattiness SDD 0.25mg/0.5 ml D

BRR industry Released
MO industry Finished
Valid from ---
MBR for MO version 00000001

MBR ID/Version/Description 5957004/00000032/ Fattiness SDD 0.25mg/0.5mlD
Order size 30000 ea
Batch no. NHJM068881
MO no. NHJM00013246

Production unit	
simple operation	Production unit
0100 - SDD assembly	DF0601AL

Detailed BO				
Level	Step			industry
1		1 - 0100STR - Opstartsaktiviteter	Subtype: ---	Tabular execution: no NF
		Funktion håndterer alle opstartsaktiviteter: - Back-to-Back vurdering - Back-to-Back bekræftelse - Batchinformation (PID Board Information) - Allokering af udstyr - Prøveudtagnings beregninger - Batch download og start		
Level	Step			industry
2		1 - N0100DEC - Back to back?	Subtype: ---	NF
		Back to Back vælges hvis denne batch opstartes umiddelbart efter forgående batch. Opfylder denne ordre kriterierne for en back-to-back-ordre, vælges ja. Hvis ikke, vælg nej.		
		Decision type: User selection	Predecessor: Start	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step				industry
2	1 - N0110B2B - Bekræft back to back	Subtype: ---	Tabular execution: no	NF
	Denne funktion bekræfter valget af Back-to-Back.			
2.0	010 - Bekræft back to back	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	Bekræft at back to back betingelserne er opfyldt			
Level Step				industry
2	1 - N0140AL - [A] Alloker linje	Subtype: ---	Tabular execution: no	NF
	Funktionen allokerer linje til ordren. Hvis "ERROR" er linjen allokeret til en anden ordre.			
Level Step				industry
3	1 - M0130AL - [A] Linje allokering	Subtype: ---	NF	
	Allokerer linje til aktuelle ordre. Linjen kan ikke allokeres, hvis industry ikke er OK.			
	Set value	Actual value	User & date / Signature	industry
	ASSEM:Assembly Line / Workroom:AL0601 (Assembly Line 06.01)			
Level Step				industry
2	1 - N0230CAL - [A] Prøveudtagsberegninger	Subtype: ---	Tabular execution: no	NF
	Beregner prøve udtag ud fra valgte ordre.			
2.0	010 - Batch Size in Pens	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.1	020 - IPC	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.2	030 - OPC	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.3	040 - Reference	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.4	050 - ID	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	1 - N0250MBA - [A] Batch start	Subtype: ---	Tabular execution: no	NF
	Udfører batchstart mellem PAS-X og linjen.			

Level Step				industry
	3	1 - M0150DEC - [A] Start MOT udført?	Subtype: ---	NF
		Decision type: Formula	Predecessor: M0140MOT	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step				industry
	3	1 - M0160DEC - [A] Start FA udført ?	Subtype: ---	NF
		Decision type: Formula	Predecessor: M0161FA	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step				industry
	3	1 - M0170DEC - [A] Start PFS udført?	Subtype: ---	NF
		Decision type: Formula	Predecessor: M0171PFS	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step				industry
	3	1 - M0180DEC - [A] Start RA udført?	Subtype: ---	NF
		Decision type: Formula	Predecessor: M0181RA	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step				industry
1		1 - 0110MAN - [A] Redownload	Subtype: ---	Tabular execution: no NF
		Trin til redownload		
Level Step				industry
	2	1 - N0100DEC - [A] Redownload	Subtype: ---	NF
		Denne funktion er 'Nej' som standard. Ændres til 'Ja' ved behov for redownload.		
		Decision type: Formula	Predecessor: Start	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step				industry
1		1 - 0150MAT - [A] Materiale registrering	Subtype: ---	Tabular execution: no NF
		Scan komponenter ind til brug på linjen.		
Level Step				industry
1		2 - N0170LEM - Bekræft linje er tom	Subtype: ---	Tabular execution: no NF
		Bekræft linjen er tom.		
	1.0	010 - Udfør Line Empty	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		OK		
Level Step				industry
1		1 - N0180MBI - Batch stop	Subtype: ---	Tabular execution: no NF
		Trin i forbindelse med afslutning af batch.		
Level Step				industry
	2	1 - LNCLR - Linje Clearance	Subtype: ---	Tabular execution: no NF
Level Step				industry
	3	1 - CBF5 - Line Clearance Zone 1	Subtype: ---	Tabular execution: no NF

Level Step				industry
	4	1 - NO161ALC - Zone 1	Subtype: ---	Tabular execution: no NF
4.0		10 - LC1	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		Ok		
Level Step				industry
	4	1 - NO162ALC - Zone 1	Subtype: ---	Tabular execution: no NF
4.0		10 - LC2	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		Ok		
Level Step				industry
	3	1 - CBF3 - Line Clearance Zone 2	Subtype: ---	Tabular execution: no NF
Level Step				industry
	4	1 - NO161ALC - Zone 2	Subtype: ---	Tabular execution: no NF
4.0		10 - LC1	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		Ok		
Level Step				industry
	4	1 - NO162ALC - Zone 2	Subtype: ---	Tabular execution: no NF
4.0		10 - LC2	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		Ok		
Level Step				industry
	3	1 - CBF2 - Line Clearance Zone 3	Subtype: ---	Tabular execution: no NF
Level Step				industry
	4	1 - NO161ALC - Zone 3	Subtype: ---	Tabular execution: no NF
4.0		10 - LC1	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		Ok		
Level Step				industry
	4	1 - NO162ALC - Zone 3	Subtype: ---	Tabular execution: no NF
4.0		10 - LC2	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		Ok		
Level Step				industry
	3	1 - CBF4 - Line Clearance Zone 4	Subtype: ---	Tabular execution: no NF

Level Step				industry
4	1 - NO161ALC - Zone 4	Subtype: ---	Tabular execution: no	NF
4.0	10 - LC1	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	Ok			
Level Step				industry
4	1 - NO162ALC - Zone 4	Subtype: ---	Tabular execution: no	NF
4.0	10 - LC2	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	Ok			
Level Step				industry
3	1 - CBF1 - Line Clearance Zone 5	Subtype: ---	Tabular execution: no	NF
Level Step				industry
4	1 - NO161ALC - Zone 5	Subtype: ---	Tabular execution: no	NF
4.0	10 - LC1	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	Ok			
Level Step				industry
4	1 - NO162ALC - Zone 5	Subtype: ---	Tabular execution: no	NF
4.0	10 - LC2	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	Ok			
Level Step				industry
1	1 - 0140MANU - Manuel prøver	Subtype: ---	Tabular execution: no	NF
	Registrering af manuelle prøver			
Level Step				industry
2	1 - N0100DEC - Manuel prøver	Subtype: ---		NF
	Decision type: Formula	Predecessor: Start	Repetition: 1	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
1	1 - N0210ERL - Kassation	Subtype: ---	Tabular execution: no	NF
	Kasser materiale og kvitter			
Level Step				industry
2	1 - N0220ERL - Kassation 1. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 1. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	1 - N0230ERL - Kassation 2. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 2. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	2 - N0220ERL - Kassation 1. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 1. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	2 - N0230ERL - Kassation 2. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 2. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	3 - N0220ERL - Kassation 1. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 1. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	3 - N0230ERL - Kassation 2. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 2. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	4 - N0220ERL - Kassation 1. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 1. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
2	4 - N0230ERL - Kassation 2. kontrol	Subtype: ---	Tabular execution: no	NF
2.0	010 - Kassation 2. kontrol	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

Level Step				industry
1	1	1 - N0200FC - Optælling	Subtype: ---	Tabular execution: no NF
		Kontrol af antal prøver sammenhold med prøverudtagnings plan		
Level Step				industry
2	1	1 - N230CAL - [A] Forbrug	Subtype: ---	Tabular execution: no NF
		Kontrol af antal prøver sammenhold med prøverudtagnings plan		
	2.0	010 - OPC	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		>=52 ea		
	2.1	020 - IPC	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		>=20 ea		
	2.2	030 - REF	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		>=100 ea		
	2.3	040 - ID	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		>=2 ea		
	2.4	050 - PFS/Pen manuel kassation	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry

	2.5	060 - PFS automatiske kasserede	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry

	2.6	070 - PFS, indskannede	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		--- ea		
	2.9	100 - Stock Creation	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry

	2.10	110 - Udbytte	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		80 - 120 %		
	2.11	120 - Tilladt afvigelse	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry

	2.12	130 - Afvigelse	Subtype: ---	---
		Set value	Actual value	User & date / Signature industry
		-200 - 200		
Level Step				industry
2	1	1 - N240REP - Gentag recon beregning	Subtype: ---	NF
		Decision type: User selection	Predecessor: N230CAL	Repetition: 1
		Set value	Actual value	User & date / Signature industry

Level Step		industry		
2	2 - N230CAL - [A] Forbrug	Subtype: ---	Tabular execution: no	NF
	Kontrol af antal prøver sammenholdt med prøverudtagnings plan			
2.0	010 - OPC	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	>=52 ea			
2.1	020 - IPC	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	>=20 ea			
2.2	030 - REF	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	>=100 ea			
2.3	040 - ID	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	>=2 ea			
2.4	050 - PFS/Pen manuel kassation	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.5	060 - PFS automatiske kasserede	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.6	070 - PFS, indskannede	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	--- ea			
2.9	100 - Stock Creation	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.10	110 - Udbytte	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	80 - 120 %			
2.11	120 - Tilladt afvigelse	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry

2.12	130 - Afvigelse	Subtype: ---	---	
	Set value	Actual value	User & date / Signature	industry
	-200 - 200			
Level Step		industry		
2	2 - N240REP - Gentag recon beregning	Subtype: ---		NF
	Decision type: User selection	Predecessor: N230CAL	Repetition: 2	
	Set value	Actual value	User & date / Signature	industry
