FalconSFT
Shop Floor Tracker

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Ver 1.0

Operational Manual

FalconSFT
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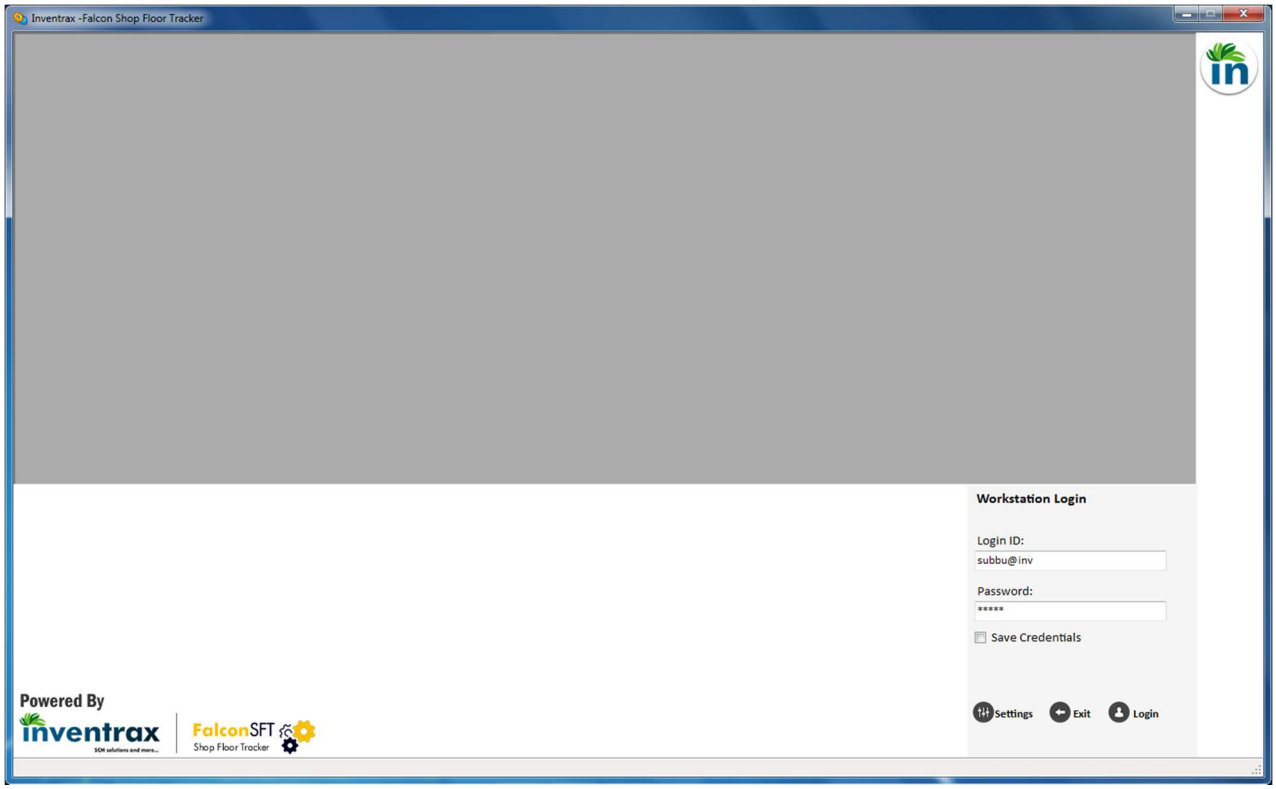
1. Work Station Login

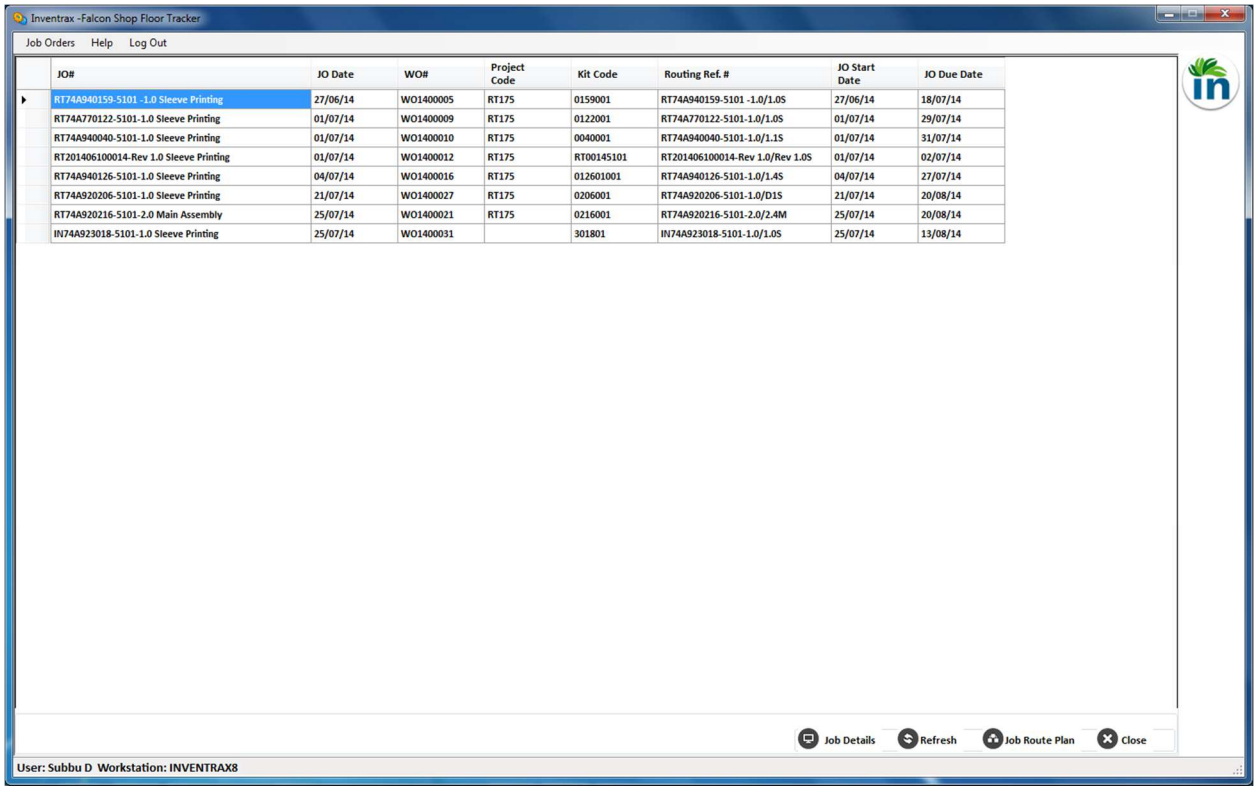
Login screen allows the assigned user of the work station to authenticate and authorize the system functionality. On successful login system directs the user to access job orders.



2. Kitting Process

Link >> Job Order >> Job Order List

System lists active Job Orders with routing type as main assembly for the workstation with Job Order#, Work Order#, Routing Ref#, KitCode information and user gets the raw material details on selection of Job Order.

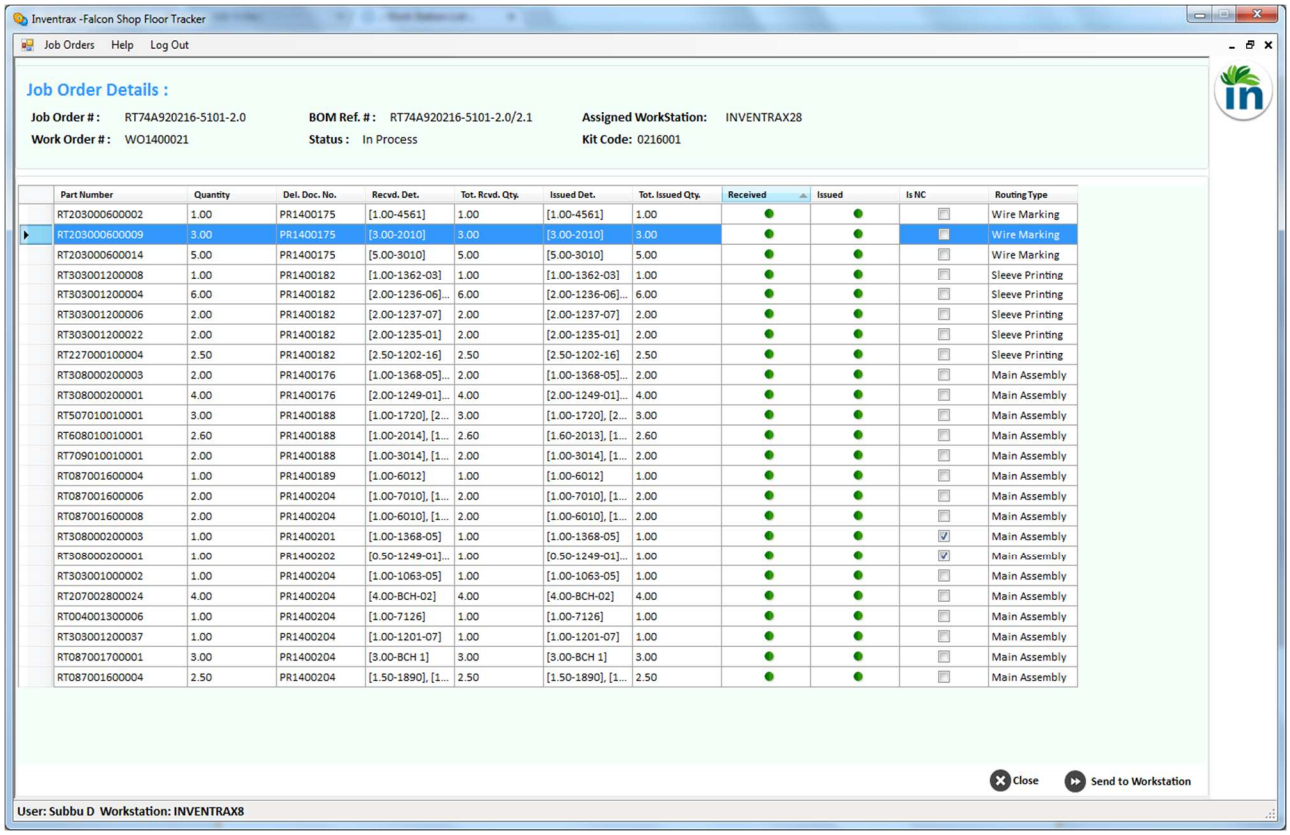


JO#	JO Date	WO#	Project Code	Kit Code	Routing Ref. #	JO Start Date	JO Due Date
RT74A940159-5101 -1.0 Sleeve Printing	27/06/14	WO1400005	RT175	0159001	RT74A940159-5101 -1.0/1.0S	27/06/14	18/07/14
RT74A770122-5101-1.0 Sleeve Printing	01/07/14	WO1400009	RT175	0122001	RT74A770122-5101-1.0/1.0S	01/07/14	29/07/14
RT74A940040-5101-1.0 Sleeve Printing	01/07/14	WO1400010	RT175	0040001	RT74A940040-5101-1.0/1.1S	01/07/14	31/07/14
RT201406100014-Rev 1.0 Sleeve Printing	01/07/14	WO1400012	RT175	RT00145101	RT201406100014-Rev 1.0/Rev 1.0S	01/07/14	02/07/14
RT74A940126-5101-1.0 Sleeve Printing	04/07/14	WO1400016	RT175	012601001	RT74A940126-5101-1.0/1.4S	04/07/14	27/07/14
RT74A920206-5101-1.0 Sleeve Printing	21/07/14	WO1400027	RT175	0206001	RT74A920206-5101-1.0/D1S	21/07/14	20/08/14
RT74A920216-5101-2.0 Main Assembly	25/07/14	WO1400021	RT175	0216001	RT74A920216-5101-2.0/2.4M	25/07/14	20/08/14
IN74A923018-5101-1.0 Sleeve Printing	25/07/14	WO1400031		301801	IN74A923018-5101-1.0/1.0S	25/07/14	13/08/14

Functionality

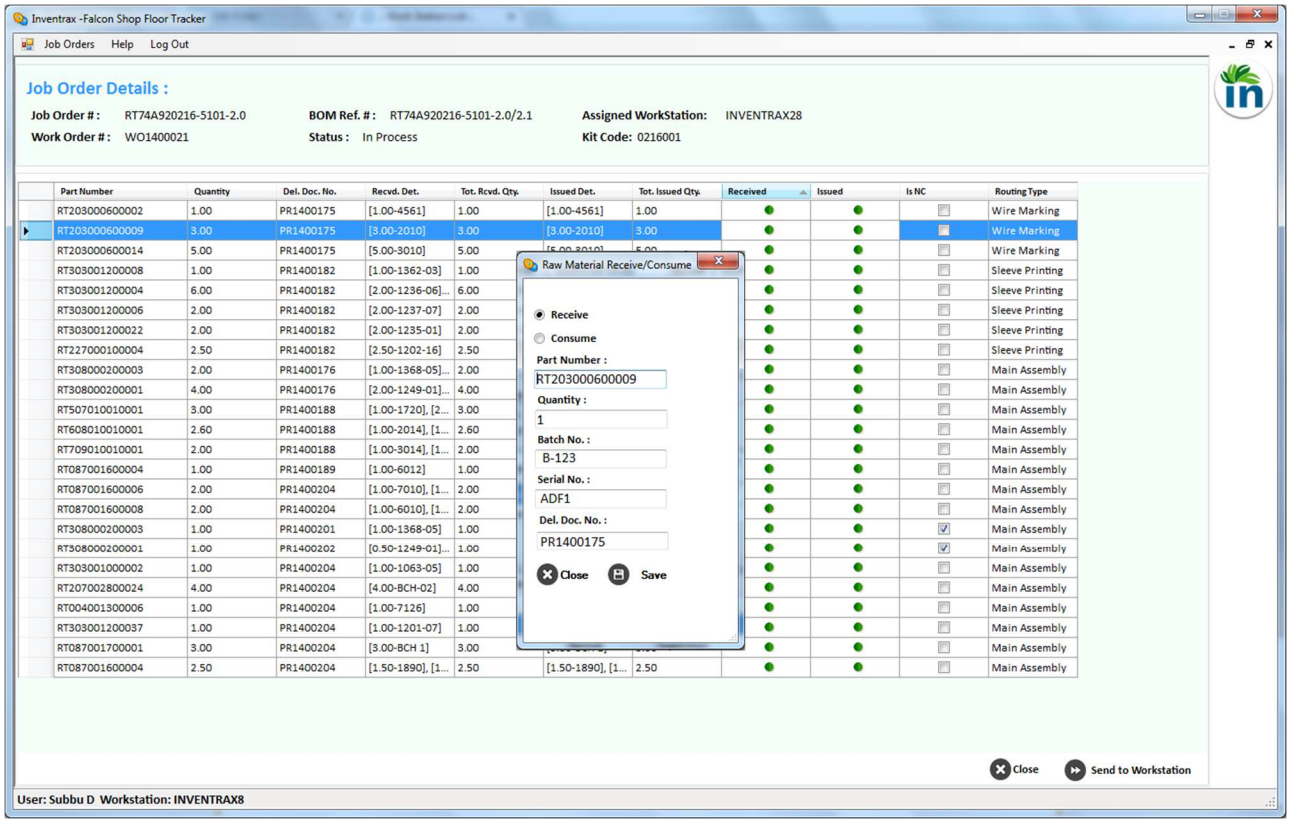
Job Details:

- System displays the selected job order details with part number, quantity configured in BOM (line items of finished material + line items of sub-assemblies), delivery. doc. no. obtained after releasing the job order for the related routing types



Part Number	Quantity	Del. Doc. No.	Recvd. Det.	Tot. Rcvd. Qty.	Issued Det.	Tot. Issued Qty.	Received	Issued	Is NC	Routing Type
RT203000600002	1.00	PR1400175	[1.00-4561]	1.00	[1.00-4561]	1.00	●	●	☐	Wire Marking
RT203000600009	3.00	PR1400175	[3.00-2010]	3.00	[3.00-2010]	3.00	●	●	☐	Wire Marking
RT203000600014	5.00	PR1400175	[5.00-3010]	5.00	[5.00-3010]	5.00	●	●	☐	Wire Marking
RT303001200008	1.00	PR1400182	[1.00-1362-03]	1.00	[1.00-1362-03]	1.00	●	●	☐	Sleeve Printing
RT303001200004	6.00	PR1400182	[2.00-1236-06]...	6.00	[2.00-1236-06]...	6.00	●	●	☐	Sleeve Printing
RT303001200006	2.00	PR1400182	[2.00-1237-07]	2.00	[2.00-1237-07]	2.00	●	●	☐	Sleeve Printing
RT303001200022	2.00	PR1400182	[2.00-1235-01]	2.00	[2.00-1235-01]	2.00	●	●	☐	Sleeve Printing
RT227000100004	2.50	PR1400182	[2.50-1202-16]	2.50	[2.50-1202-16]	2.50	●	●	☐	Sleeve Printing
RT308000200003	2.00	PR1400176	[1.00-1368-05]...	2.00	[1.00-1368-05]...	2.00	●	●	☐	Main Assembly
RT308000200001	4.00	PR1400176	[2.00-1249-01]...	4.00	[2.00-1249-01]...	4.00	●	●	☐	Main Assembly
RT507010010001	3.00	PR1400188	[1.00-1720], [2...	3.00	[1.00-1720], [2...	3.00	●	●	☐	Main Assembly
RT608010010001	2.60	PR1400188	[1.00-2014], [1...	2.60	[1.60-2013], [1...	2.60	●	●	☐	Main Assembly
RT709010010001	2.00	PR1400188	[1.00-3014], [1...	2.00	[1.00-3014], [1...	2.00	●	●	☐	Main Assembly
RT087001600004	1.00	PR1400189	[1.00-6012]	1.00	[1.00-6012]	1.00	●	●	☐	Main Assembly
RT087001600006	2.00	PR1400204	[1.00-7010], [1...	2.00	[1.00-7010], [1...	2.00	●	●	☐	Main Assembly
RT087001600008	2.00	PR1400204	[1.00-6010], [1...	2.00	[1.00-6010], [1...	2.00	●	●	☐	Main Assembly
RT308000200003	1.00	PR1400201	[1.00-1368-05]	1.00	[1.00-1368-05]	1.00	●	●	☑	Main Assembly
RT308000200001	1.00	PR1400202	[0.50-1249-01]...	1.00	[0.50-1249-01]...	1.00	●	●	☑	Main Assembly
RT303001000002	1.00	PR1400204	[1.00-1063-05]	1.00	[1.00-1063-05]	1.00	●	●	☐	Main Assembly
RT207002800024	4.00	PR1400204	[4.00-BCH-02]	4.00	[4.00-BCH-02]	4.00	●	●	☐	Main Assembly
RT004001300006	1.00	PR1400204	[1.00-7126]	1.00	[1.00-7126]	1.00	●	●	☐	Main Assembly
RT303001200037	1.00	PR1400204	[1.00-1201-07]	1.00	[1.00-1201-07]	1.00	●	●	☐	Main Assembly
RT087001700001	3.00	PR1400204	[3.00-BCH 1]	3.00	[3.00-BCH 1]	3.00	●	●	☐	Main Assembly
RT087001600004	2.50	PR1400204	[1.50-1890], [1...	2.50	[1.50-1890], [1...	2.50	●	●	☐	Main Assembly

- User scans the material using barcode scanner, system displays raw material receiving grid and enters del. doc. no., batch no., quantity and clicks ‘save’ button, system displays the received qty. in received details column
- Once selected material is transferred to work station, quantity received with different batch no.’s will be displayed in the consumed details column



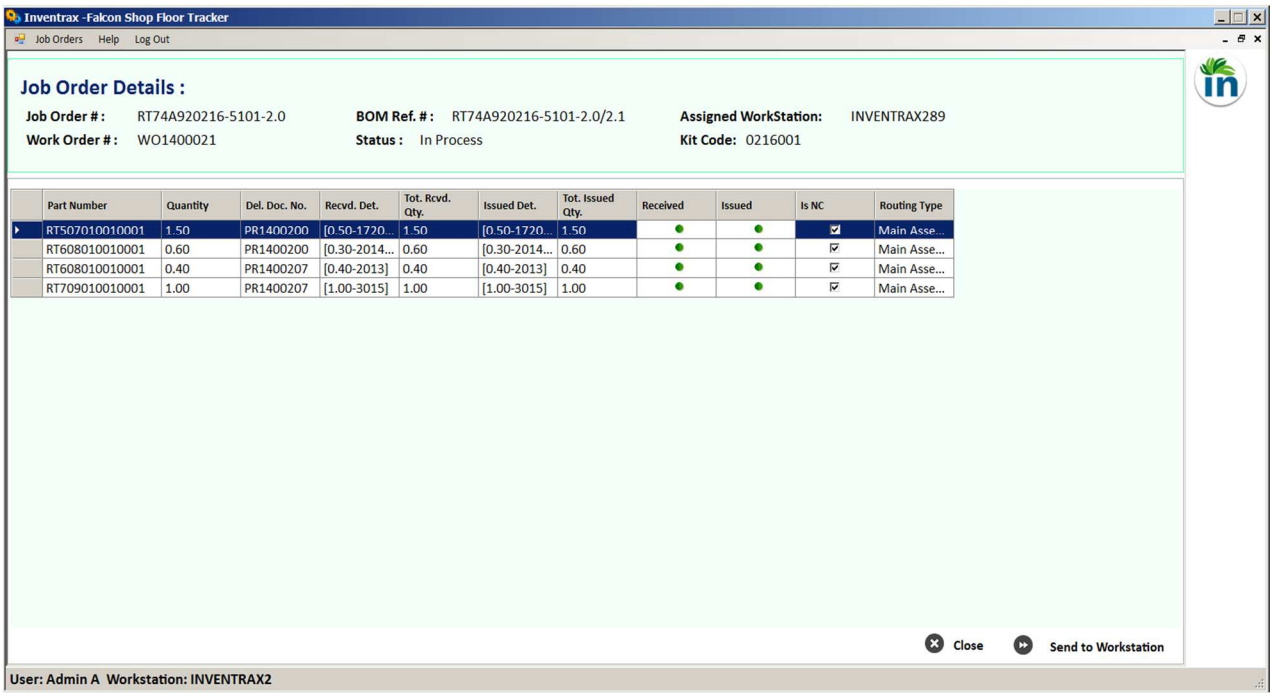
On transferring the total quantity of materials to work station, Issue check box will be enabled

Business Rules

- Only the job orders with status as 'In Process' will be available in the list
- If NC is raised for a material by supervisor/QCI during production process, delivery doc. no. will be generated, material will be displayed in kitting checklist page and 'Is NC' checkbox gets enabled
- Until sleeve printing and wire marking job orders are closed, cannot receive sleeve printing and wire marking materials in kitting
- Quantity should be one for serial no
- Entered quantity is greater than the delivery doc. qty.

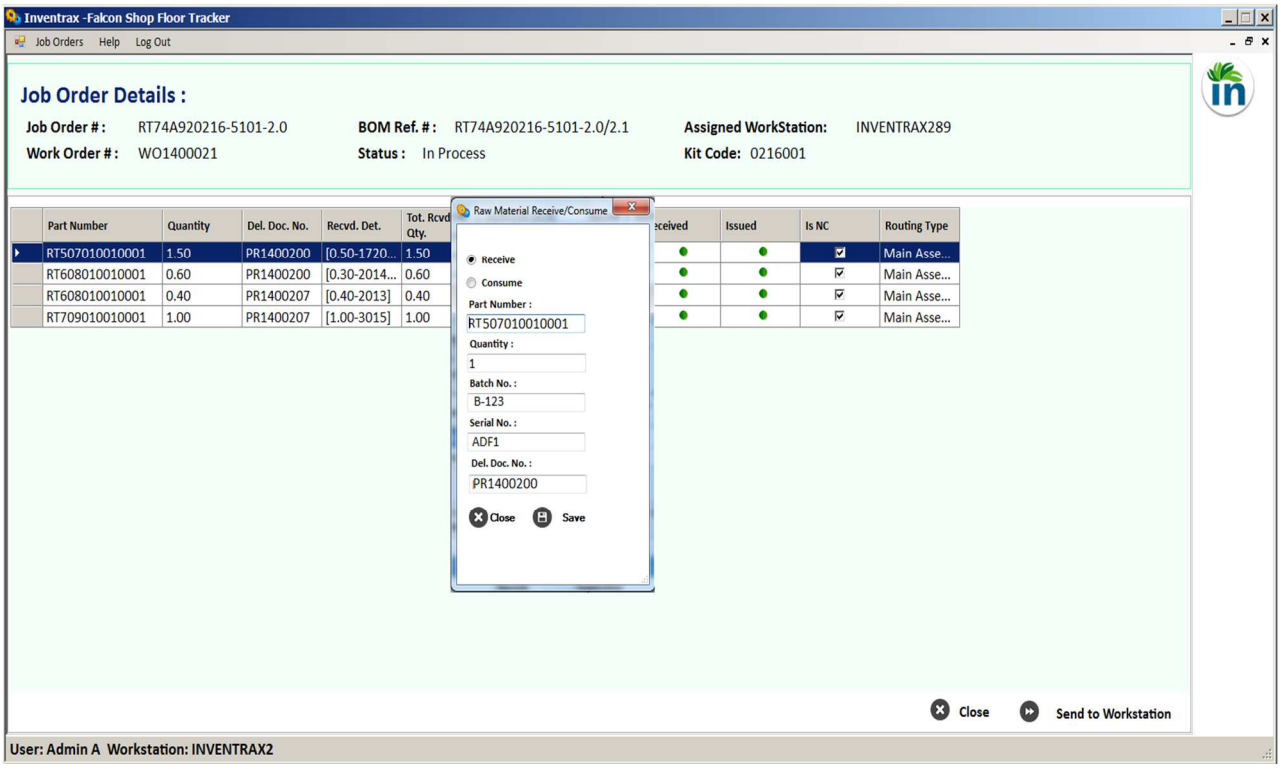
3. Pan Stock Workstation

System lists NC raised materials with routing type as main assembly for the workstation with Job Order#, Work Order#, BOM Ref#, KitCode information.



Functionality

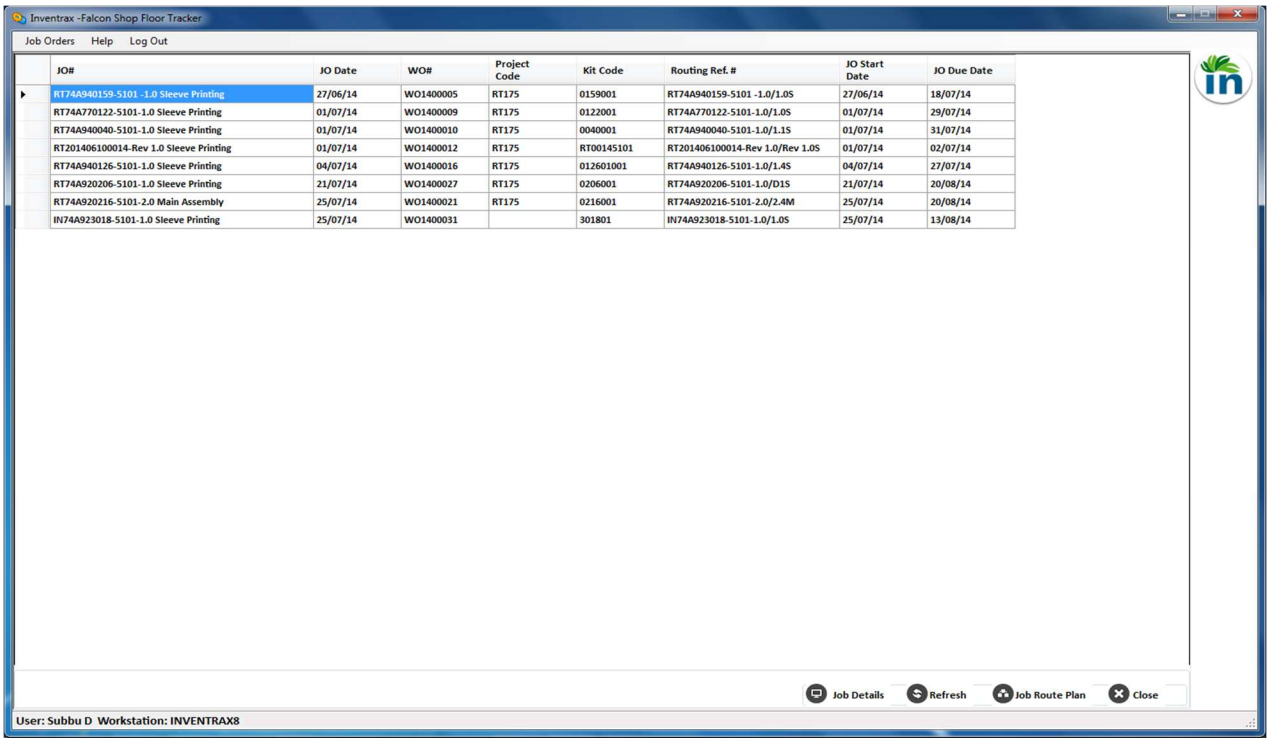
- System displays the NC raised material details with part number, quantity raised at NC, delivery. doc. no.
- User scans the material using barcode scanner, system displays raw material receiving grid and enters del. doc. no., batch no., quantity and clicks ‘save’ button, system displays the received qty. in received details column
- Once selected material is received at panstock workstation, quantity received with different batch no.’s will be transferred to Fabrication Workstation



4. Work-In Process Inventory

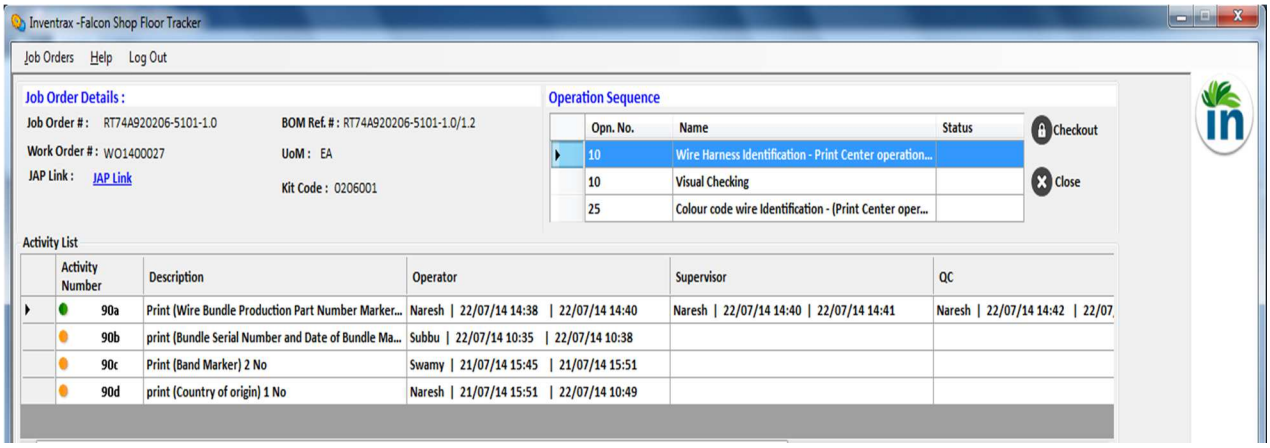
4.1. Raw Material Receiving & Consuming

On successful login system directs the user to access job orders. System displays active job orders for the workstation (Depending on the work station logged in)



4.1.1. General Operation

System displays the selected job order details with job order header data, list of operation sequence and activities as shown



a. Job Order Header Details with Job Order #, Work Order# and UoM
b. Lists Operation Sequence in the grid box with 1st operation selected
    i. Shows the sequence Name
    ii. Status (Green if all activities in this sequence is completed)

iii. On selection of an operation sequence the activity grid changes with its respective activities

c. Lists the activities for a Sequence selected in Sequence Grid
   i. Shows activities with the operation cell enabled as configured in the routing(JRP)
   ii. Shows the Activity Code, Name,
   iii. Operator Info, with start/end date time and result captured
   iv. Supervisor Info ,with start/end date time and result captured
   v. QC Inspector Info, with start/end date time and result captured
   vi. Customer QC Info, with start/end date time and result captured

d. On selection of operation sequence and with its respective activity, system lists the components configured in routing

e. User(only authorized operator for workstation) scans the material using barcode scanner to receive, system displays the raw material receiving grid

f. User enters quantity, batch no., serial no. and system displays the received material in the 'Material Received' grid

g. Displays panel to list material received at this workstation
   i. Any of the authorized user with operator role for this workstation will receive material using a barcode scanner
      - System checks for valid material configured in activities for this workstation
      - Operator enters other parameters like Batch No., CoC data , Serial No. etc. for each received material

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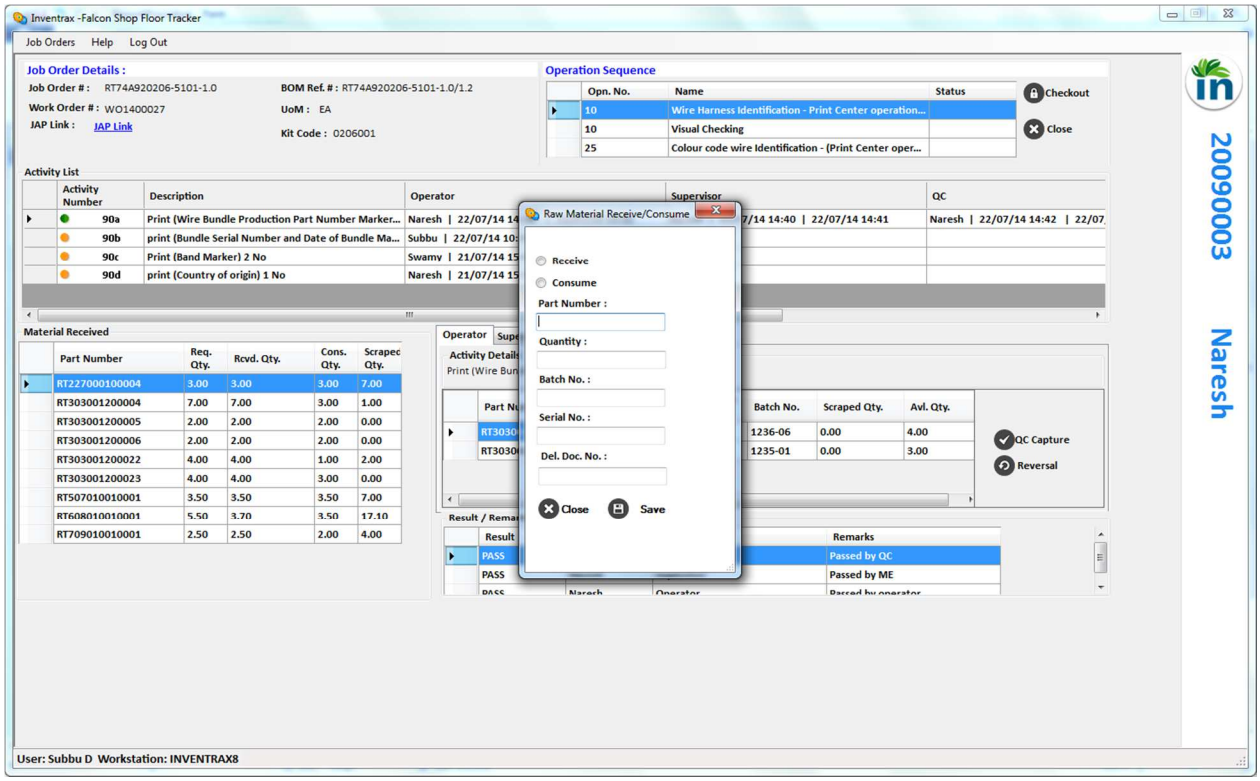
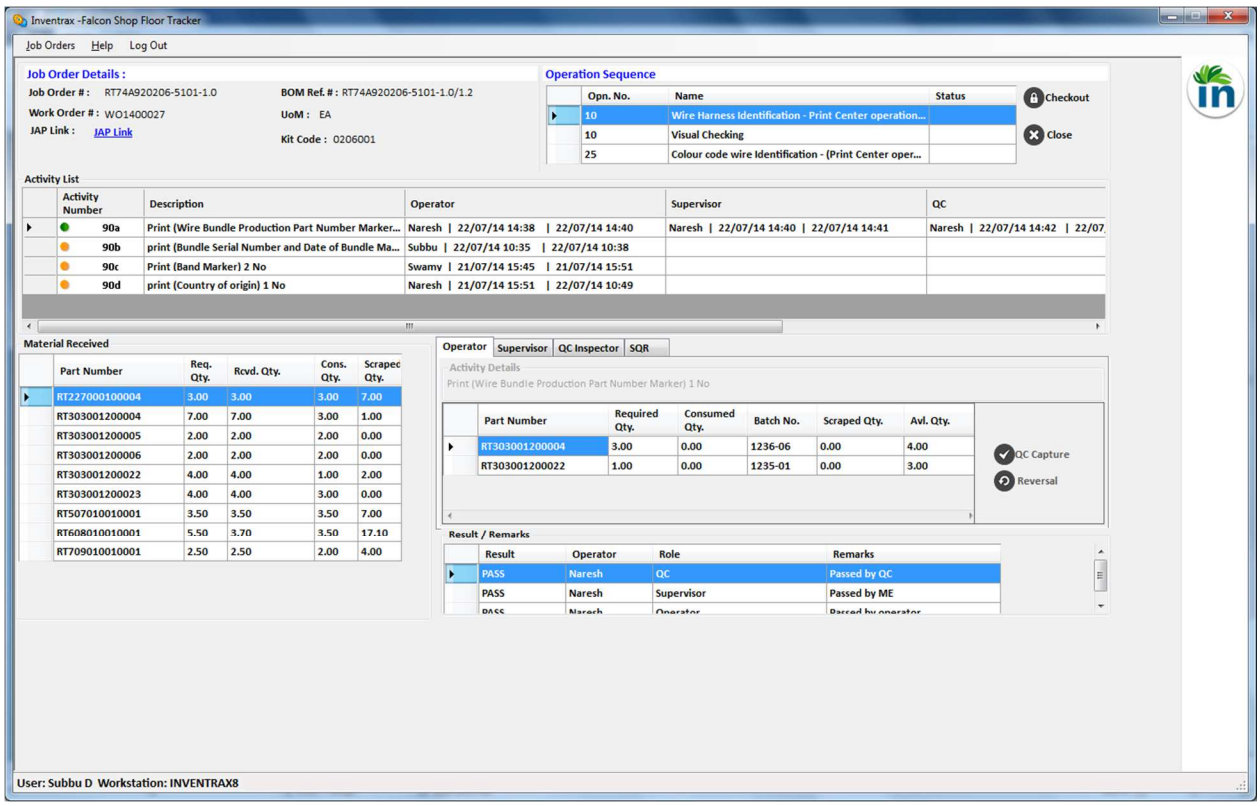
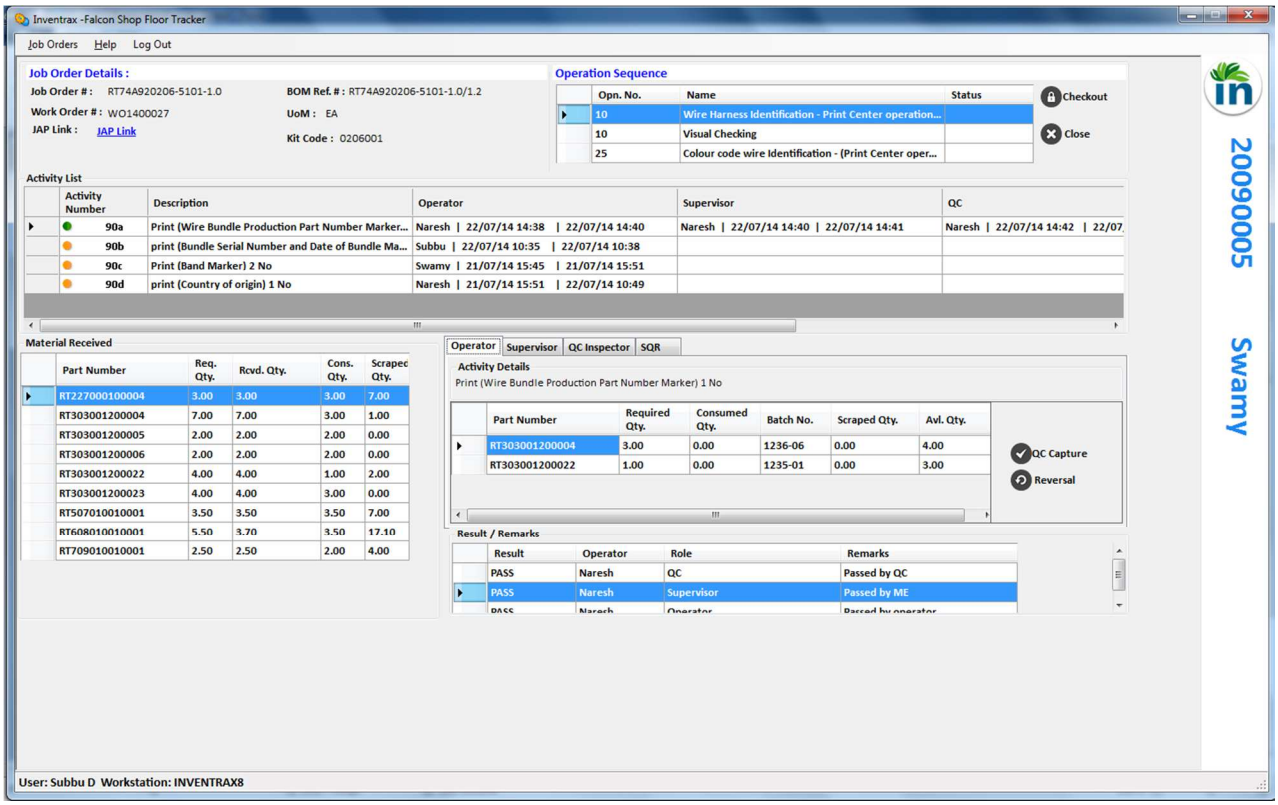




4.1.2. Role Based Operation

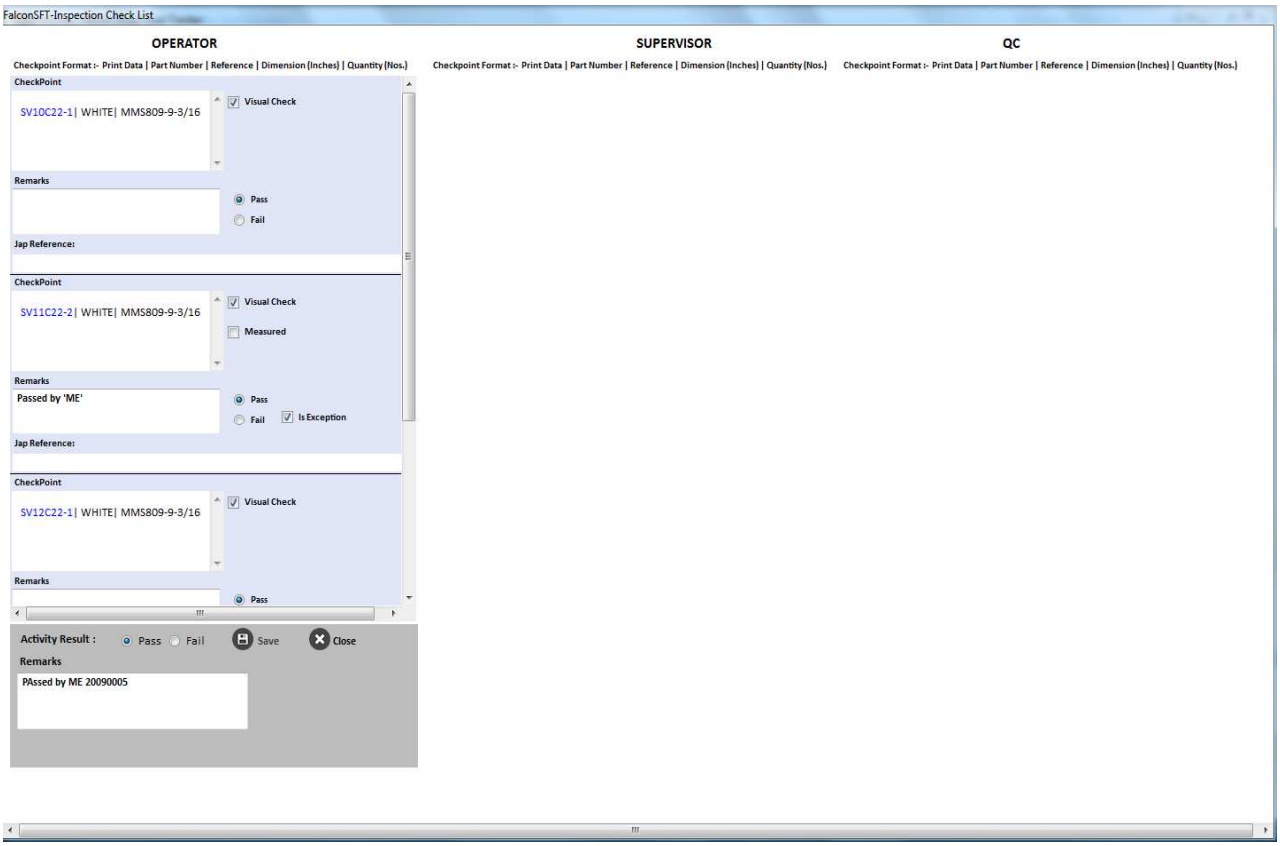
4.1.2.1. Operator

1) Operator scans his ID card using barcode scanner and Check IN as an active user
2) Operator will select the sequence and from there selects an activity and system lists the material details in the material consumed grid (required qty, consumed qty, batch no., scraped qty)
3) Operator will start the activity and scans the material to be consumed with entered quantity, batch no. and system displays the consumed qty. of material in material consumed grid
4) Once activity is started, QC capture button gets enabled



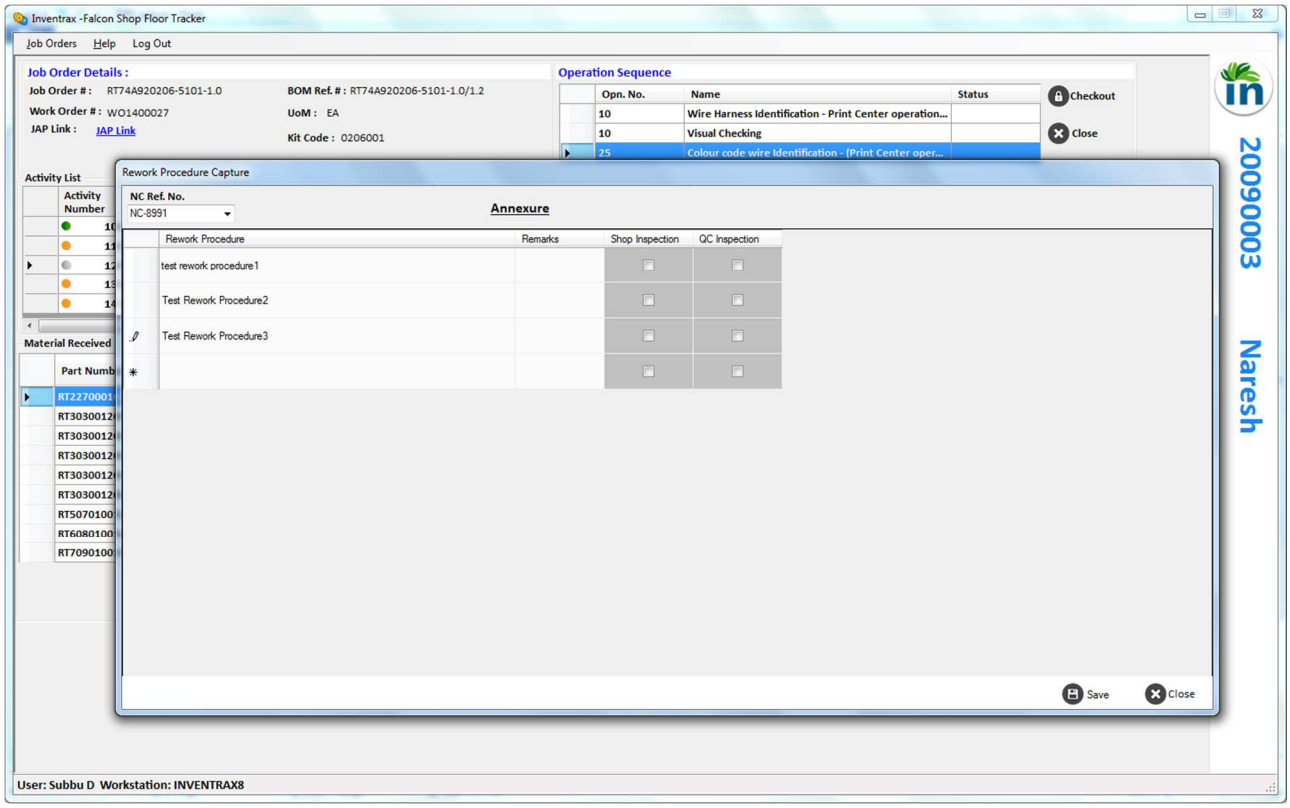
QC Capture:

- System displays inspection check list page, which contains the checkpoints that are configured for activities in routing to capture, enters remarks, records 'Pass/Fail'
- User selects the final result as 'Pass/Fail' , system saves the result



Reversal

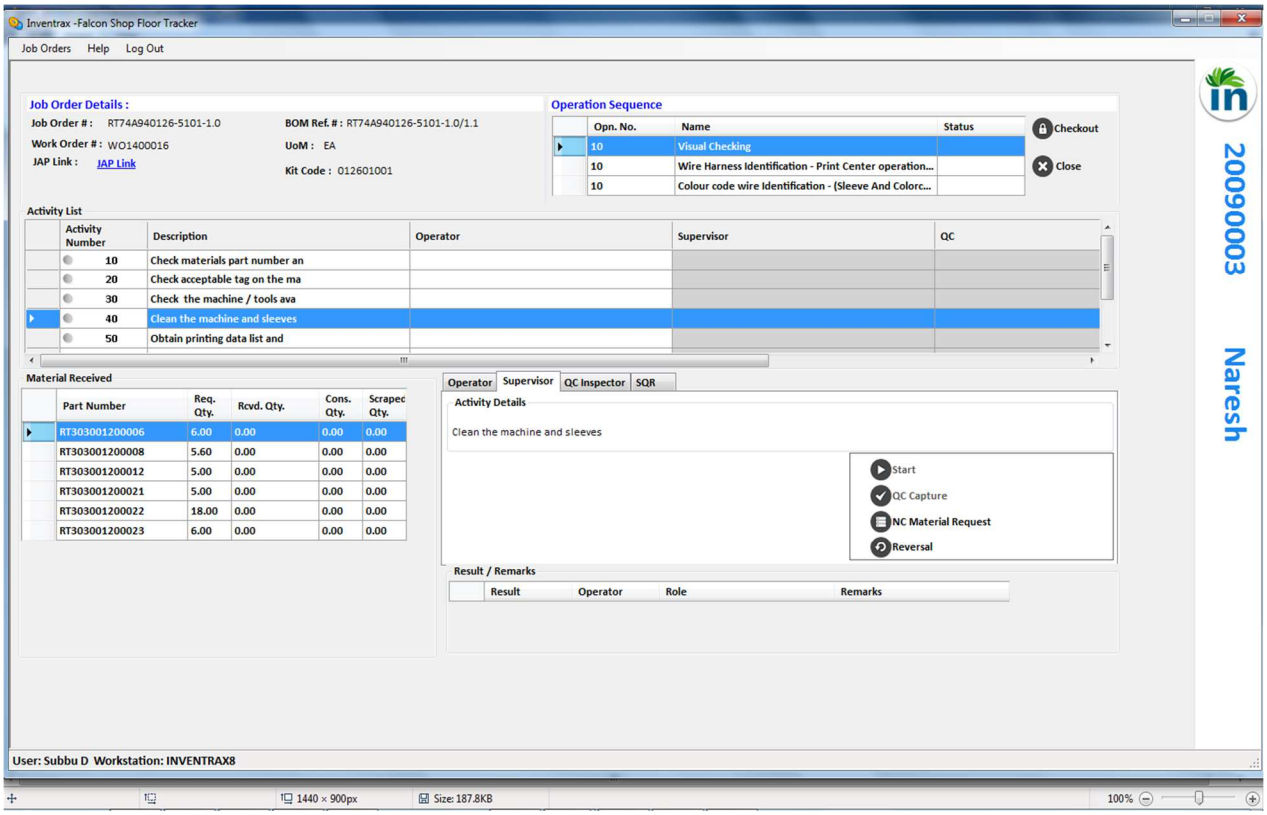
- System displays ‘Rework ’ with NC Ref. No. raised at activity level
- User enters the rework procedure to the NC materials and clicks ‘save’ button, system saves the update
- User clicks ‘close’ button, system closes the rework procedure capture screen



5) Operator will 'stop' the activity which will be enabled after recording the result of activity i.e., Pass/Fail and QC capture button gets disabled
6) Operator clicks 'Check-Out' button to become inactive, so other users can work on

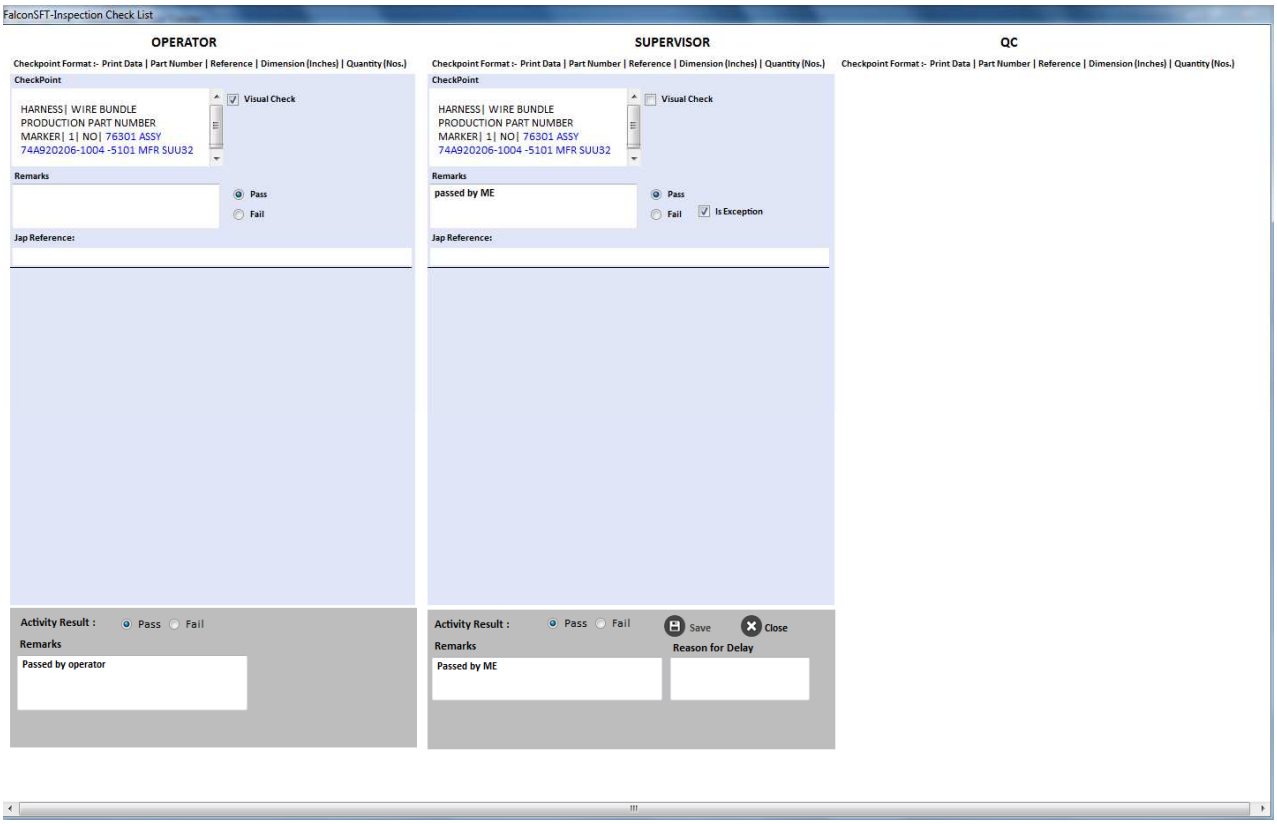
4.1.2.2. Supervisor

1) Supervisor scans his ID card using barcode scanner and Check IN as an active user
    a. System checks if this activity is configured for 'Supervisor' operation in the routing configuration
    b. System checks if **Operator cleared his operation** for this activity prior, and enables from doing his updates
2) Supervisor will select the sequence and from there selects an activity and system lists the material details in the material consumed grid (required qty, consumed qty, batch no., scraped qty)
3) Supervisor will start the activity and verifies the consumed material and checks for scrap items if any and captures them in 'NC request form'
4) Once activity is started, QC capture, NC request from, Positive recall buttons gets enabled



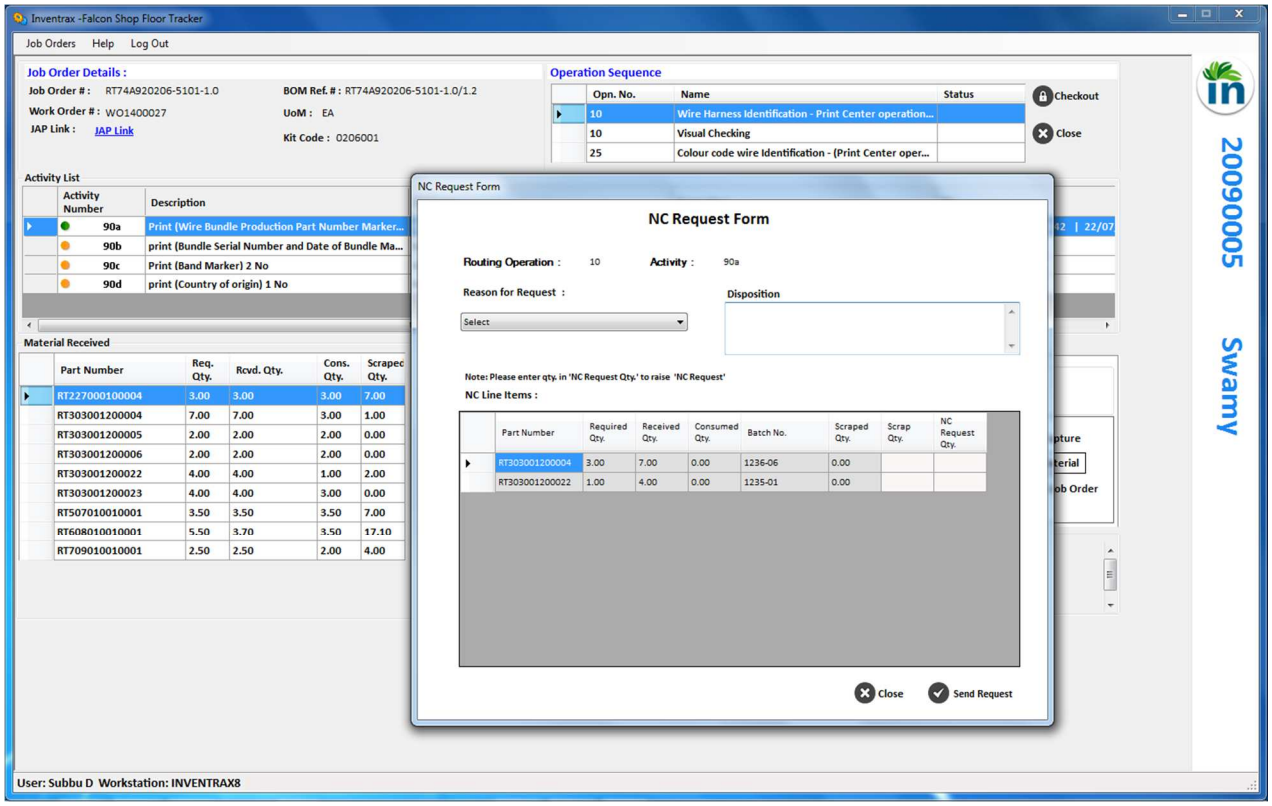
QC Capture:

- System displays inspection check list page, which contains the checkpoints that are configured for activities in routing to capture, enters remarks, records ‘Pass/Fail’
- User selects the final result as ‘Pass/Fail’ , system saves the result



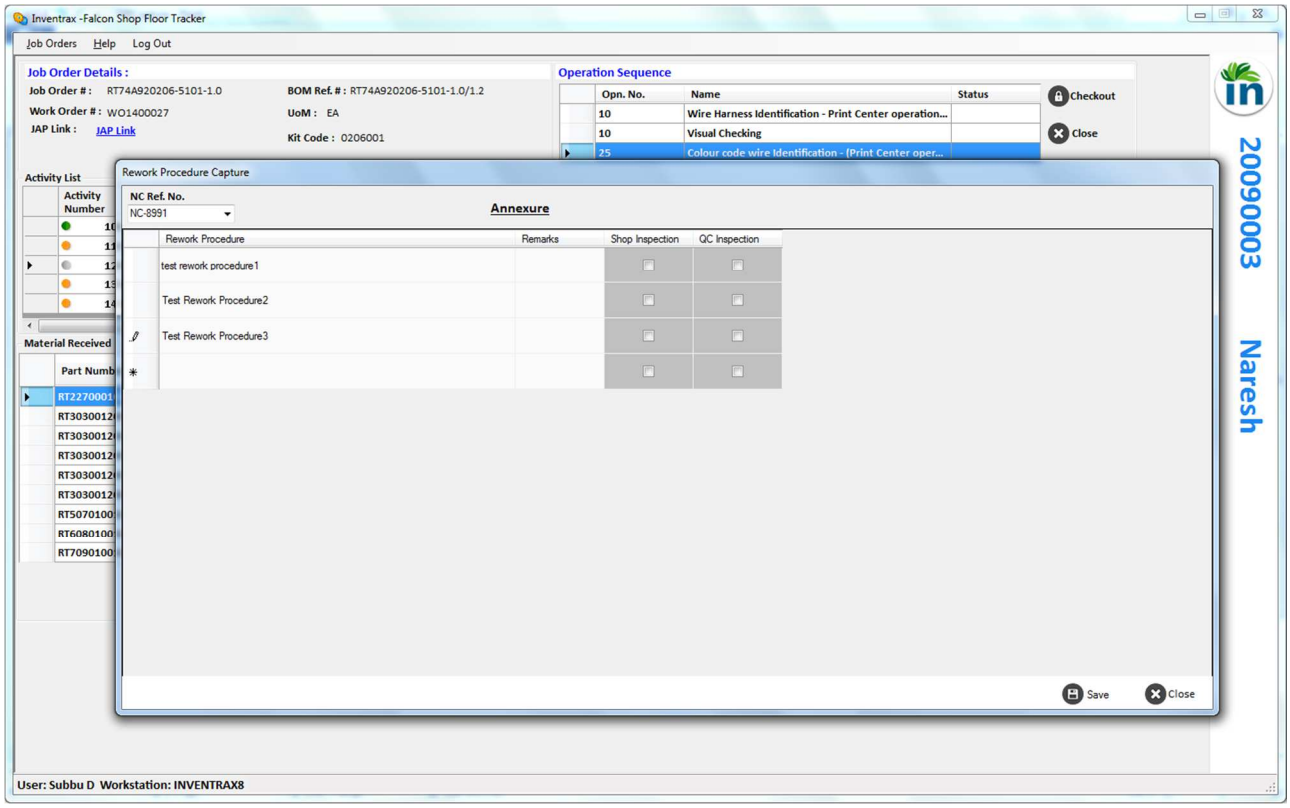
NC Material Request:

- System displays ‘NC Request Form’ with listed NC line items
- For items to be scraped, scrap qty to be entered and reason for request to be selected
- NC order will be raised with the entered NC qty, and an outbound will be generated with a delivery pick note



Reversal

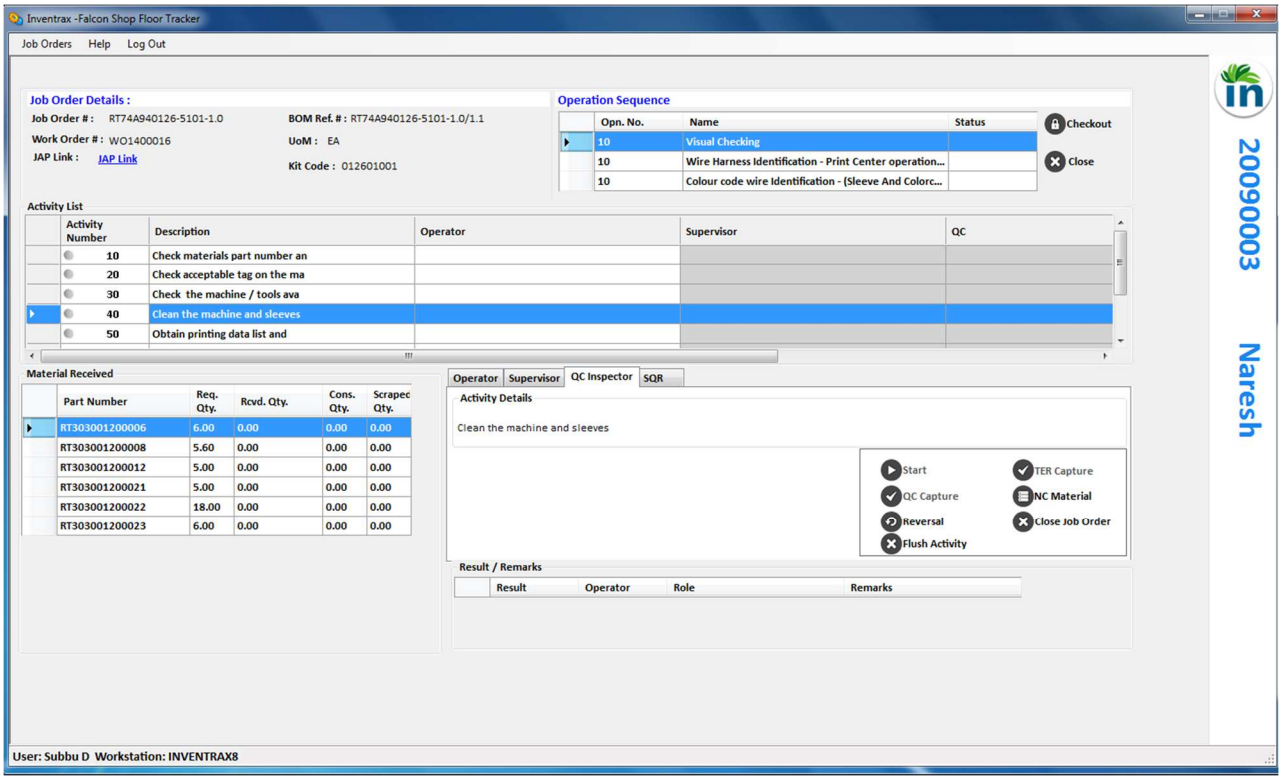
- System displays ‘Rework ’ with NC Ref. No. raised at activity level
- User enters the rework procedure to the NC materials and clicks ‘save’ button, system saves the update
- User clicks ‘close’ button, system closes the rework procedure capture screen



5) Supervisor will 'stop' the activity which will be enabled after recording the result of activity i.e., Pass/Fail and QC capture button gets disabled

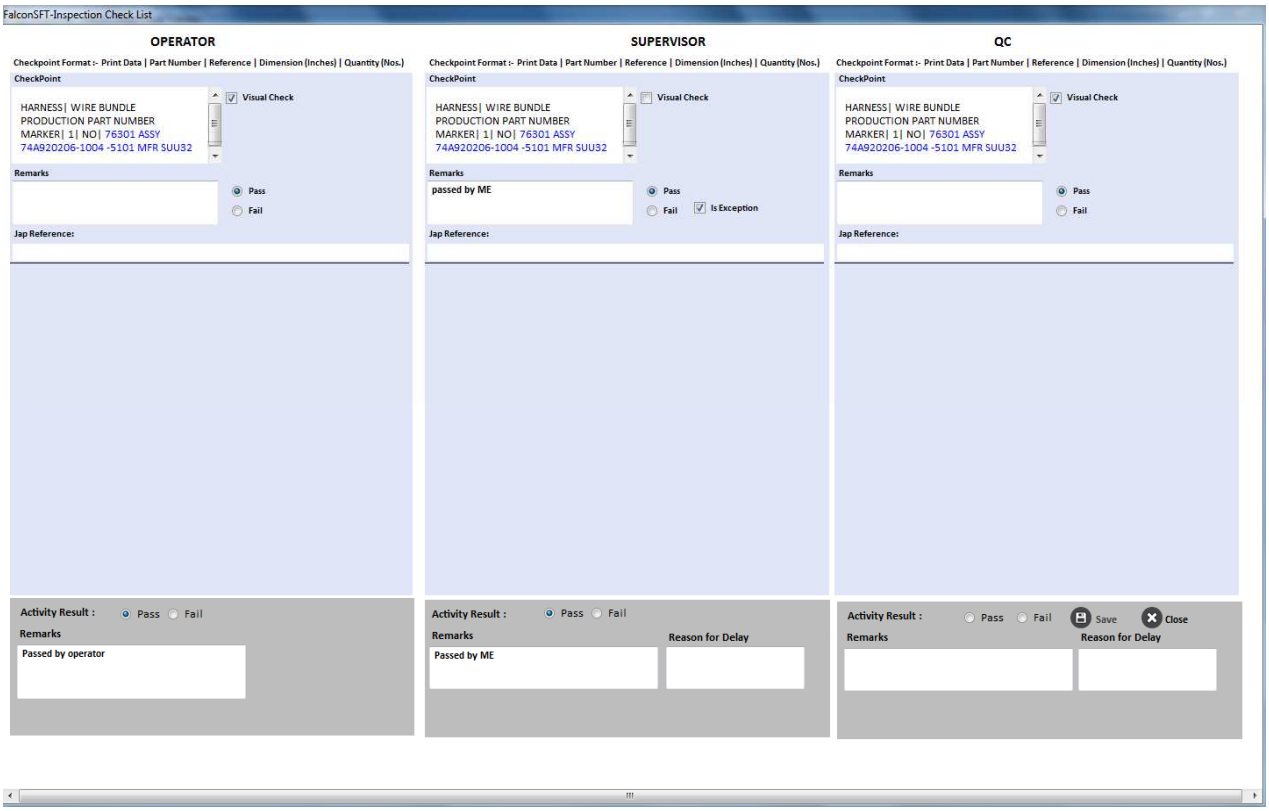
4.1.2.3. QC Inspector (QCI)

1) QCI scans his ID card using barcode scanner and Check IN as an active user
    a. System checks if this activity is configured for 'Supervisor' operation in the routing configuration
    b. System checks if **Supervisor cleared his operation** for this activity prior, and enables from doing his updates
2) QCI will select the sequence and from there selects an activity and system lists the material details in the material consumed grid (required qty, consumed qty, batch no., scraped qty)
3) QCI will start the activity and verifies the consumed material and checks for scrap items if any and captures them in 'NC request form'
4) Once activity is started, QC capture, NC request from, Positive recall buttons gets enabled



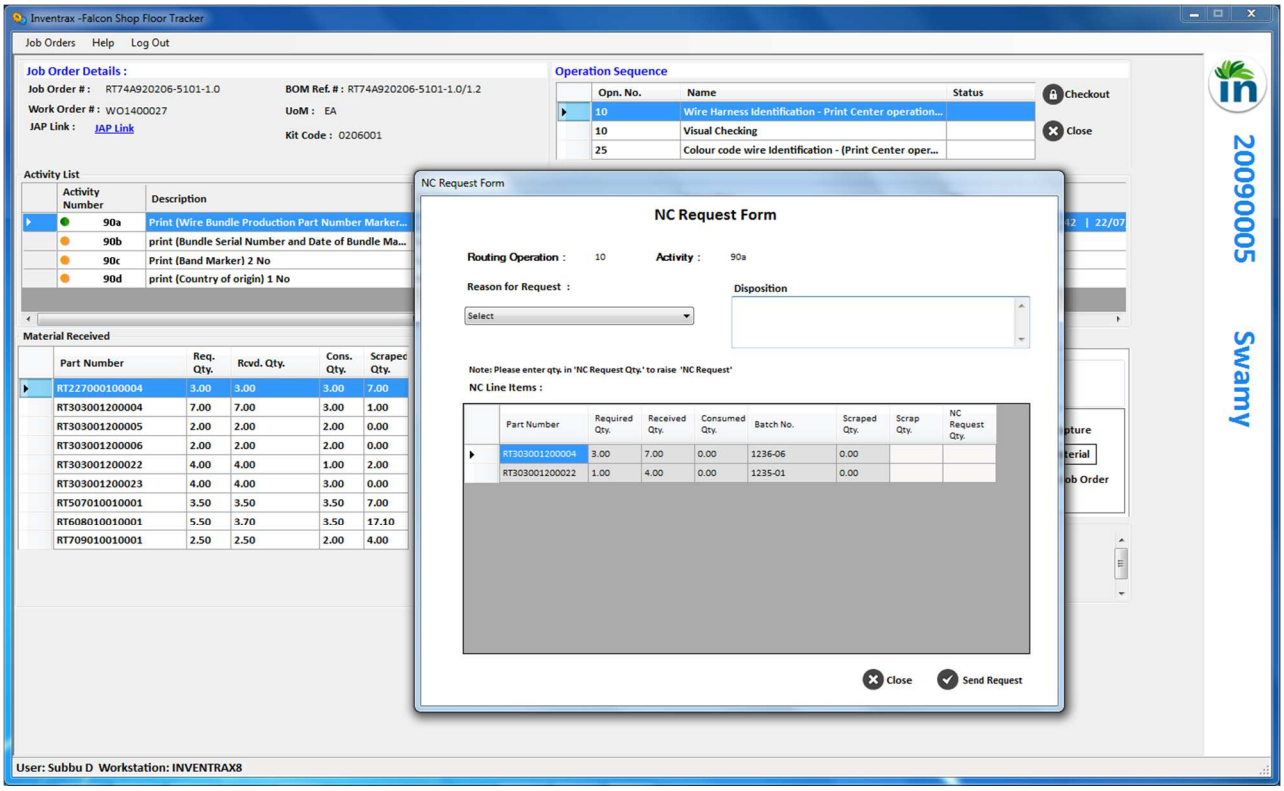
QC Capture:

- System displays inspection check list page, which contains the checkpoints that are configured for activities in routing to capture, enters remarks, records 'Pass/Fail'
- User selects the final result as 'Pass/Fail' , system saves the result



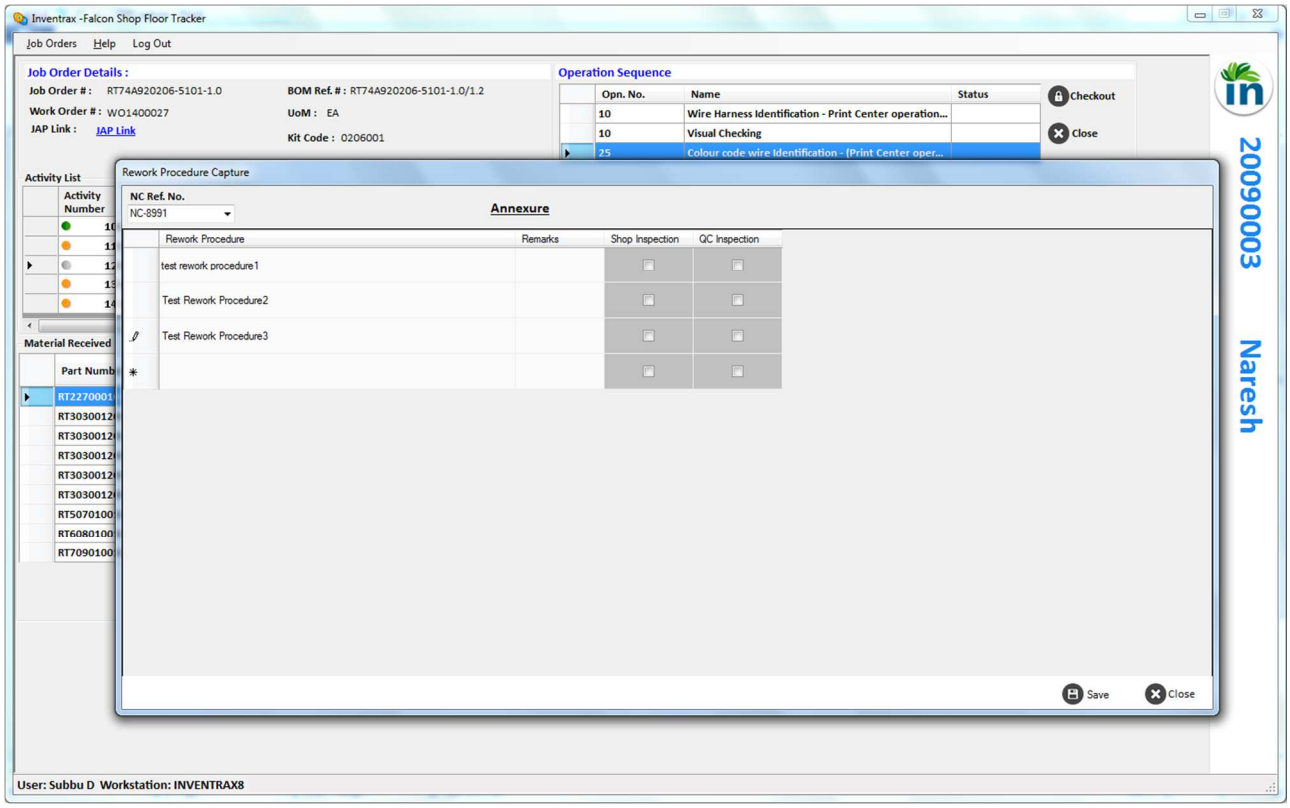
NC Material Request:

- System displays ‘NC Request Form’ with listed NC line items
- For items to be scraped, scrap qty to be entered and reason for request to be selected
- NC order will be raised with the entered NC qty, and an outbound will be generated with a delivery pick note



Reversal

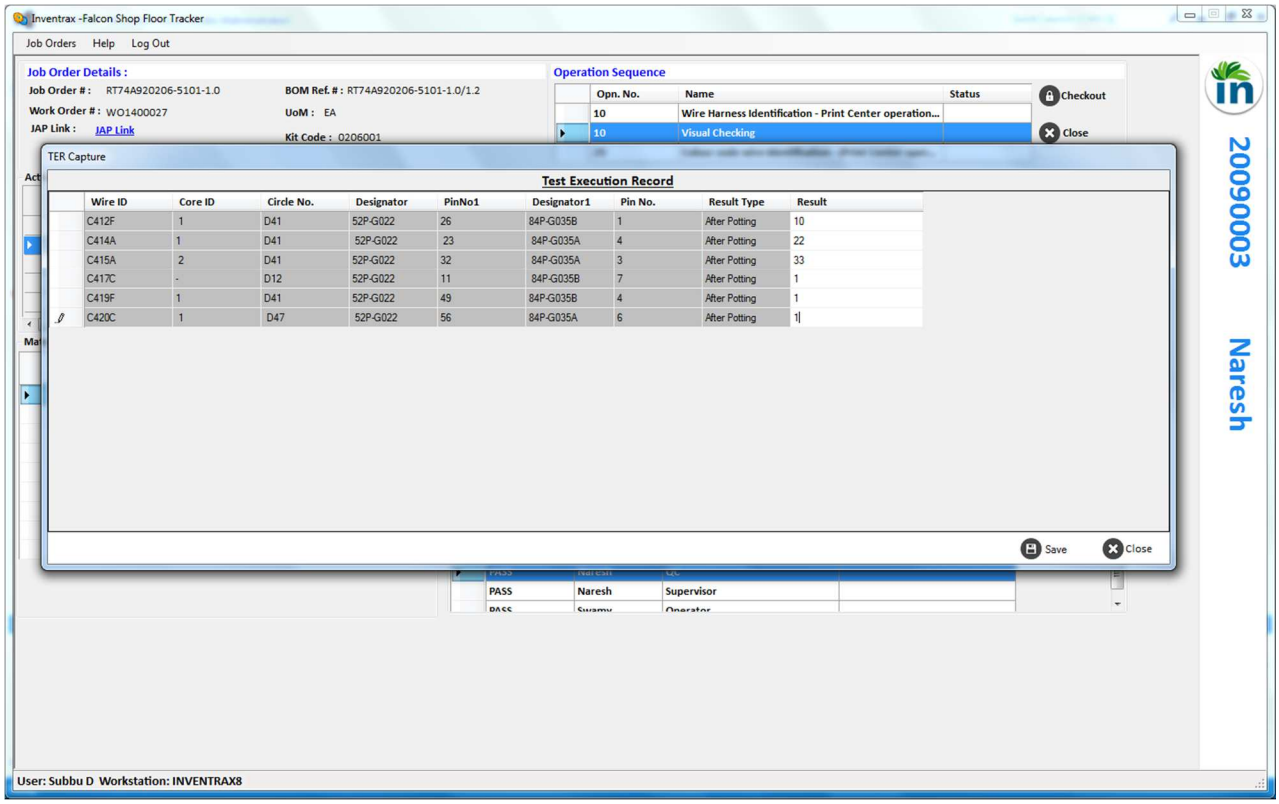
- System displays ‘Rework ’ with NC Ref. No. raised at activity level
- User enters the rework procedure to the NC materials and clicks ‘save’ button, system saves the update
- User clicks ‘close’ button, system closes the rework procedure capture screen



6) Supervisor will 'stop' the activity which will be enabled after recording the result of activity i.e., Pass/Fail and QC capture button gets disabled

Test Execution Record-TER Capture

- System displays 'TER Capture' with the checkpoints values configured in routing
- On defined type of TER ,QCI capture the TER with given range of values



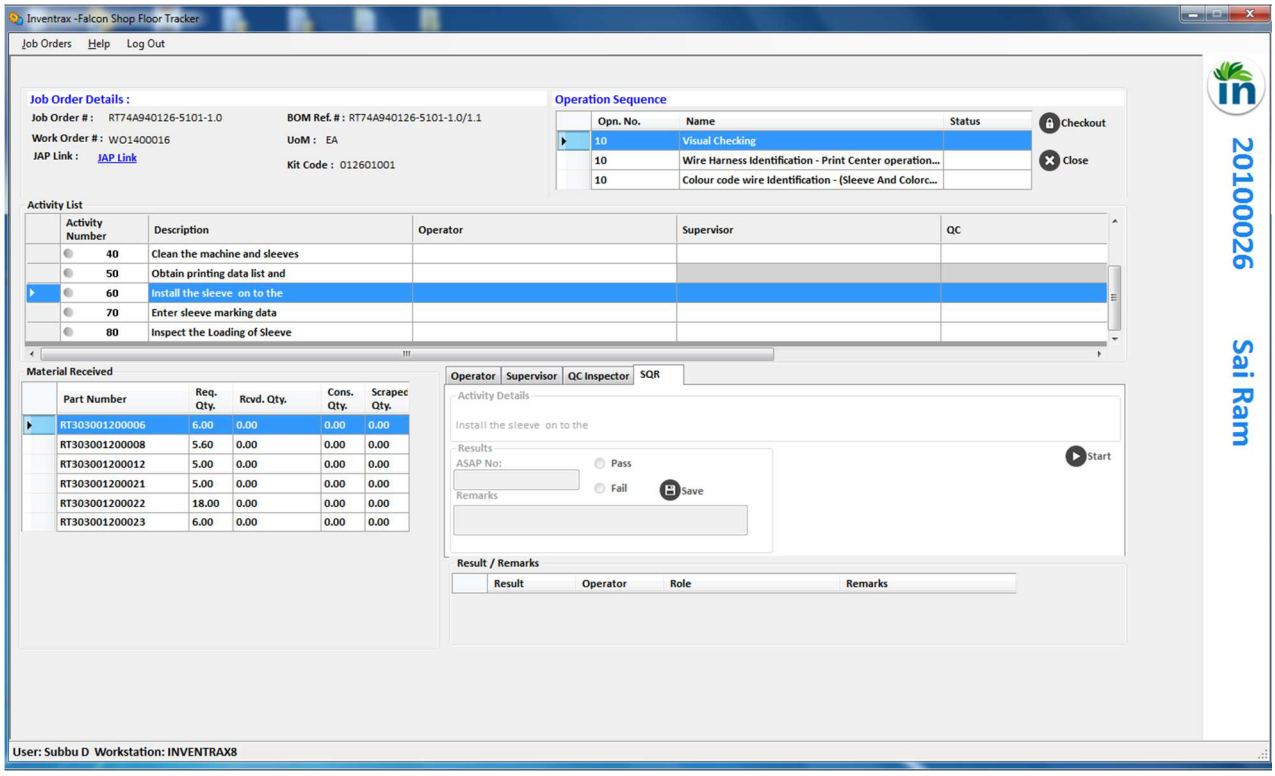
Flush Activity:

- On 'Flushes Activity 'click, system pops scrap activity page
- User enters reason for delete/flush and clicks 'save' button, system deletes the consumed qty's
- User selects 'close' button, system closes the page

Close Job Order: On selection of this close job order, system closes the Job order

4.1.2.4. Customer Inspection (SQR)

SQR will record the results with ASAP No.



Business Rules:

- Until materials are consumed in each activity, cannot stop the process
- If a material is configured in different operations which are in different work stations, and total quantity of material is received in one work station, then that will not be displayed in the other work station
- After completion of operations of all activities, status of the respective operation sequence will be in 'Finished' state
- If 'positive recall' flag is 'ON', then cannot close the job order
- If production process for all activities is completed, then the job order should be closed
- If item is scraped, then Supervisor/QCI will save the result as 'failed' and the operator again restart the process of receiving and consuming the scraped materials with a batch no. received in kitting
- Materials should be transferred from the kitting work station , in order to receive them in 'Main Assembly'
- Received qty. always less than or equal BOM qty. (Rcvd.Qty <= BOM.Qty.)
- Consumed qty. less than or equal to received qty. (Cons.Qty <= Rcvd.Qty.)
- Consumed qty. less than or equal to scrap qty. (Cons.Qty. <= Scrap Qty.)
- Supervisor is permitted to 'ON' the 'Positive Recall' and only QCI can 'OFF'
- In inspection check list, only the authorized users can raise the 'Is exception'
- Reversal procedure exists only for the failed activities for which NC is raised

- If NC is raised for panstock items in fabrication, then those should be received in ‘pan stock’ workstation and then to be transferred to fabrication workstation