

PK MES– FACTORY MODULE

MANUAL 1.6

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1. LOGIN TO MES FACTORY MODULE

PK2: <http://mespk2.pungkookvn.com/>

PK3: <http://mespk3.pungkookvn.com/>

Ben Tre: <http://mespkbt.pungkookvn.com>

Grobogan (INDO): <http://mespkig.pungkookvn.com/>

My Tho: <http://mespkmt.pungkookvn.com/>

Joon Sai Gon: <http://mespkjs.pungkookvn.com/>

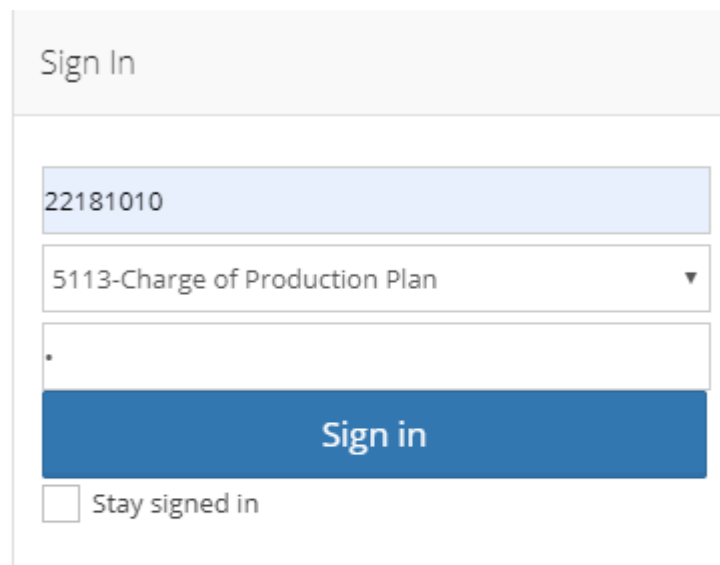
Subang: <http://mespkis.pungkookvn.com:8080/>

You should input:

- UserID
- Role
- Password

After that, press the “Sign in” button to access.

On successful login user may continue using MES features based on the rights assigned to the role they used for login.

A screenshot of a web-based sign-in form. The form has a light gray header with the text "Sign In". Below the header, there are three input fields: a text field containing "22181010", a dropdown menu showing "5113-Charge of Production Plan" with a downward arrow, and a password field with a single dot. Below these fields is a large blue button with the text "Sign in". At the bottom of the form is a checkbox labeled "Stay signed in".

Sign In

22181010

5113-Charge of Production Plan ▼

•

Sign in

☐ Stay signed in

- Or sign in using -



2. MES

2.1. PRODUCTION PLAN

Description: You can REVIEW, ADD, EDIT the **Mes Package** in Production Plan tab.

❖ SEARCH PACKAGE GROUP

1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can see all the Packages Group (AO No, Style Code, Style Size, Plan Start, Plan Finish...)

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Dashboards QCO MES Quality Cutting Plan WMS HRM Factory Reports Admin Tools Help

Production Plan

Dates: (1) 2020/03/23 - 2020/04 (2) Filter By AO No: Buyer: Style Info: (3) Search

(4)

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
P2C1-2002-000000050	P2C1	AD-KUU-0138	KUU0176	XLG	008	001	200	0	RO	2020-03-23	2020-03-23
P2C1-2002-000000051	P2C1	AD-KUU-0139	KUU0176	XLG	009	001	600	0	RO	2020-03-24	2020-03-25
P2C1-2002-000000052	P2C1	AD-KUU-0138	KUU0176	XLG	005	001	250	0	RO	2020-03-25	2020-03-25
P2C1-2003-000000005	P2C1	AD-BCA-0040	BCA0067	XLG	006	001	252	0	RO	2020-03-23	2020-03-23
P2C1-2003-000000006	P2C1	AD-BCA-0040	BCA0075	SMA	001	001	501	0	RO	2020-03-24	2020-03-26
P2C1-2003-000000007	P2C1	AD-BCA-0040	BCA0072	RGL	001	002	1027	0	RO	2020-03-19	2020-03-23
P2C1-2003-000000008	P2C1	AD-BCA-0040	BCA0069	RGL	001	003	748	0	RO	2020-03-24	2020-03-26
P2C1-2003-000000009	P2C1	AD-OVX-0020	OVX0014	RGL	001	004	730	0	RO	2020-03-23	2020-03-25
P2C1-2003-000000016	P2C1	AD-MUT-0446	MUT0621	RGL	004	001	304	0	RO	2020-03-21	2020-03-23
P2C1-2003-000000017	P2C1	AD-MUT-0446	MUT0586	RGL	003	003	552	0	RO	2020-03-23	2020-03-25

❖ ADD PACKAGE GROUP (MES –MPS)

1. ADD: Add new Package group in Package Plan
2. AOMTOP: Choose module AOMTOP to the system get data from AOMTOP
3. Choose date, factory, buyer which you need to create MES PP
4. Search: Press SEARCH button to show data
5. You can see all the Production Packages. You will choose one or more PP which you need to create MES PP and right click => Create MES PACKAGE.
6. LINE NO: Choose line to make the Package (can choose multi Lines)
7. Per Target Qty: It's the target per package for the chosen line => You can change the value in here but must less than the-total package quantity
8. Start Date: Choose start date for the Package => Click CREATE
9. You will see MES PP in MES Packages since you press CREATE button
10. SAVE: You should press SAVE button to save data.
11. You press search button to view Package Group which you created.

Note: If you want to delete any production packages, you can choose the PP at MES package and right click => delete => choose delete => save.

Please view detail steps in bellow pictures

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Production Plan

Dates: 2020/03/23 - 2020/04/12 Factory: PKS2-C Filter By AO No: Buyer: Style Info: Search

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
No records to view											

Page 1 of 0 10

MES P. Packages	MES Line	Start Plan	Target Qty	Confirm
Total			0	(1)

Edit Add

AOMTOPS Schedules

2020/03/23 - 2020/ PKS2-C OSP - OSP...x

AO Number Style Info Search

Production Packages (2) AOMTOP QCO Ranking

LINE	March 2020							April 2020						
	23	24	25	26	27	28	29	30	31	1	2	3	4	
LINE01	P_OSP		P_OSP		P_OSP	P_OSP								
LINE41			P_OSP	P_OSP	P_OSP									
LINE57														

Create MES package

MES Schedules

PKS2-C

2020/03/23 - 2020/ Search MES Save

Mes Packages MES

LINE	March 2020							April 2020						
	23	24	25	26	27	28	29	30	31	1	2	3	4	
LINE 1A	M_OSP	M_OSP	M_OSP											
LINE 10A														
LINE 11A														
LINE 12A														
LINE13A														
LINE 14A														
LINE 2A														
LINE 3A														
LINE 4A														
LINE 5A														

Divide production package

Line No LINE 10A Per Package Qty 193 OPS Target Qty 193 Total Qty 52 Start Date 2020/03/23 + Create

Create all

Cancel

LINE	March 2020							April 2020						
	23	24	25	26	27	28	29	30	31	1	2	3	4	
LINE01	P_OSP		P_OSP		P_OSP	P_OSP								
LINE41			P_OSP	P_OSP	P_OSP									
LINE57														

LINE	March 2020							April 2020						
	23	24	25	26	27	28	29	30	31	1	2	3	4	
LINE 1A	M_OSP	M_OSP	M_OSP											
LINE 10A														
LINE 11A														
LINE 12A														
LINE13A														
LINE 14A														
LINE 2A														
LINE 3A														
LINE 4A														

AOMTOPS Schedules

2020/03/23 - 2020/ PKS2-C OSP - OSP...x

AO Number Style Info Search

Production Packages AOMTOP QCO Ranking

LINE	March 2020							April 2020						
	23	24	25	26	27	28	29	30	31	1	2	3	4	
LINE01	P_OSP		P_OSP		P_OSP	P_OSP								
LINE41			P_OSP	P_OSP	P_OSP									
LINE57														

MES Schedules

PKS2-C

2020/03/23 - 2020/ Search MES Save

Mes Packages MES

LINE	March 2020							April 2020						
	23	24	25	26	27	28	29	30	31	1	2	3	4	
LINE 1A	M_OSP	M_OSP	M_OSP											
LINE 10A	M_OSP													
LINE 11A														
LINE 12A														
LINE13A														
LINE 14A														
LINE 2A														
LINE 3A														
LINE 4A														
LINE 5A														

❖ EDIT PACKAGE GROUP

1. SEARCH: Press Search button to view data
2. Choose the Group/MPS with the package you need to edit
3. EDIT: press Edit button to edit
4. Choose date, factory, buyer and search to find the package
5. You can delete package and create new package
6. SAVE: you need save the data after finished edit.

Dashboards
QCO
MES
Quality
Cutting Plan
WMS
HRM
Factory
Reports
Admin
Tools
Help

Production Plan

Dates: 2020/03/23 - 2020/04/12
Factory: PKS2-C
Filter By:
AO No:
Buyer:
Style Info:
(1) Search

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
P2C1-2003-000000018	P2C1	AD-LLM-0199	LLM0415	MDI	002	001	1959	0	RO	2020-03-14	2020-03-25
P2C1-2003-000000020	P2C1	AD-OSP-0337	OSP1253	SMA	006	002	328	0	RO	2020-03-21	2020-03-23
P2C1-2003-000000021	P2C1	AD-OSP-0341	OSP1248	MDI	006	001	250	0	RO	2020-03-24	2020-03-24
P2C1-2003-000000022	P2C1	AD-OSP-0341	OSP1248	MDI	005	002	90	0	RO	2020-03-25	2020-03-25
P2C1-2003-000000023	P2C1	AD-MUT-0445	MUT0694	RGL	001	002	604	0	RO	2020-03-23	2020-03-24
P2C1-2003-000000024	P2C1	AD-MUT-0445	MUT0694	RGL	002	002	504	0	RO	2020-03-25	2020-03-26
P2C1-2003-000000025	P2C1	AD-MUT-0445	MUT0701	RGL	002	002	504	0	RO	2020-03-27	2020-03-28
P2C1-2003-000000026	P2C1	AD-OSP-0337	OSP1247	SMA	005	002	52	0	RO	2020-03-23	2020-03-23

(2)
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MES P. Packages
MES Line
Start Plan
Target Qty
Confirm

M_OSP-0337_1_OSP1247SMA005002_01_01	LINE 10A	2020-03-23	52	Confirm
Total			52	

(3)
Edit
Add

Production Schedule

AOMTOPS Schedules

2020/03/23 - 2020
PKS2-C
OSP - OS...

AO Number
Style Info
Search
(4)

Production Packages
AOMTOP
QCO Ranking

LINE	March 2020							April 2020				
	23	24	25	26	27	28	29	30	31	1	2	3
LINE01	P_OSP	P_OSP	P_OSP	P_OSP	P_OSP	P_OSP						
LINE41			P_OSP	P_OSP	P_OSP	P_OSP						
LINE57												

MES Schedules

PKS2-C
2020/03/23 - 2020
Search MES
(6)
Save

Mes Packages
MES

LINE	March 2020							April 2020				
	23	24	25	26	27	28	29	30	31	1	2	3
LINE 1A	M_OSP	M_OSP	M_OSP									
LINE 10A	M_OSP											
LINE 11A												
LINE 12A												
LINE 13A												
LINE 14A												
LINE 2A												
LINE 3A												
LINE 4A												
LINE 5A												

Delete
(5)

2.2. PACKAGE MANAGEMENT

Description: You can REVIEW, START, RESET the MES Package in Package Management.

❖ SEARCH PACKAGE GROUP

1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can see all the Package Group (AO No, Style Code, Style Size, Plan Start, Plan Finish...)

MES Management

Dates: (1) 2020/03/23 - 2020/04/ (2) Filter By AO No: Buyer: Style Info: (3) Search

(4)

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish	Complete
P2C1-2002-000000050	P2C1	AD-KUU-0138	KUU0176	XLG	008	001	200	0	RO	2020-03-23	2020-03-23	Complete
P2C1-2002-000000051	P2C1	AD-KUU-0139	KUU0176	XLG	009	001	600	0	RO	2020-03-24	2020-03-25	Complete
P2C1-2002-000000052	P2C1	AD-KUU-0138	KUU0176	XLG	005	001	250	0	RO	2020-03-25	2020-03-25	Complete
P2C1-2003-000000005	P2C1	AD-BCA-0040	BCA0067	XLG	006	001	252	0	RO	2020-03-23	2020-03-23	Complete
P2C1-2003-000000006	P2C1	AD-BCA-0040	BCA0075	SMA	001	001	501	0	RO	2020-03-24	2020-03-26	Complete
P2C1-2003-000000007	P2C1	AD-BCA-0040	BCA0072	RGL	001	002	1027	0	RO	2020-03-19	2020-03-23	Complete
P2C1-2003-000000008	P2C1	AD-BCA-0040	BCA0069	RGL	001	003	748	0	RO	2020-03-24	2020-03-26	Complete
P2C1-2003-000000009	P2C1	AD-OVX-0020	OVX0014	RGL	001	004	730	0	RO	2020-03-23	2020-03-25	Complete
P2C1-2003-000000016	P2C1	AD-MUT-0446	MUT0621	RGL	004	001	304	0	RO	2020-03-21	2020-03-23	Complete
P2C1-2003-000000017	P2C1	AD-MUT-0446	MUT0586	RGL	003	003	552	0	RO	2020-03-23	2020-03-25	Complete

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❖ START, RESET MES PACKAGE

1. Choose a package group to view MES Package
2. You can see MES Package in here
3. Production readiness checklist shows statuses of each readiness parameters.
4. You can press START button after all parameters show '100% ready status'

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish	Complete
P2C1-2003-000000018	P2C1	AD-LLM-0199	LLM0415	MDI	002	001	1959	0	RO	2020-03-14	2020-03-25	Complete
P2C1-2003-000000020	P2C1	AD-OSP-0337	OSP1253	SMA	006	002	328	0	RO	2020-03-21	2020-03-23	Complete
P2C1-2003-000000021	P2C1	AD-OSP-0341	OSP1248	MDI	006	001	250	0	RO	2020-03-24	2020-03-24	Complete
P2C1-2003-000000022	P2C1	AD-OSP-0341	OSP1248	MDI	005	002	90	0	RO	2020-03-25	2020-03-25	Complete
P2C1-2003-000000023	P2C1	AD-MUT-0445	MUT0694	RGL	001	002	604	0	RO	2020-03-23	2020-03-24	Complete
P2C1-2003-000000024	P2C1	AD-MUT-0445	MUT0694	RGL	002	002	504	0	RO	2020-03-25	2020-03-26	Complete
P2C1-2003-000000025	P2C1	AD-MUT-0445	MUT0701	RGL	002	002	504	0	RO	2020-03-27	2020-03-28	Complete
P2C1-2003-000000026	P2C1	AD-OSP-0337	OSP1247	SMA	005	002	52	0	RO	2020-03-23	2020-03-23	Complete

(1)

AOMTOPS P. Packages

AOMTOPS P. Packages	Qty	Remain Qty
P_OSP-0337_1_OSP1247SMA005002_01	52	0
Total	52	

MES P. Packages

MES Line	Completed Qty	Target Qty	Manual Qty	MES F
LINE 10A	0	52	0	M_OS
Total	0	52		

(2)

Production readiness

1. MES Operation Plan	0%	6. Treatments	0%
2. BOM, Patterns	0%	7. Tools	0%
3. PP Meeting Confirm	0%	8. Machines	0%
4. Material readiness	Detail	9. Jig (Requested)	0%
5. Cutting Status	0%	10. Line Setup	0%

(3)

Reset Start Excel

(4)

MATERIAL READINESS FORMULA:

Item Code	Item Name	Item Color	Required Quantity	Received Qty (100%)	Received Qty * Nor. Rate	ETA within 5 Days (50%)	ETA within 5 * Normalize Rate	ETA within 10 Days (30%)	ETA within 5 * Normalize Rate	ETA > Package Start Date (10%)	ETA > Package Start Date * Nor. Rate
BNFMBL0000001	BOARD LEATHER (150x100)cm T0.3mm #688	002 - BLACK	2.25	2.25	2.25	0	0	0	0	0	0
BSTMBL00000023	THREAD NYLON BONDED IBN 2800 3PLY BLACK M-30	001 - BLACK	7500	0	0	7500	3750	0	0	0	0
BSTMBL00000024	THREAD NYLON BONDED IBN 2100 3PLY BLACK M-40	001 - BLACK	10500	10000	10000	0	0	500	150	0	0
FABMBL00000040	100% PVC - 0.75mm CLEAR PVC UNBACKED T-29295-01 122cm	002 - CLEAR-9061	54.75	0	0	0	0	0	0	54.75	5.48
FABMBL00000052	NY6 210d OXFORD PU20g 58" W/STICKER	003 - BLACK	0.3	0.3	0.3	0	0	0	0	0	0
FOMMBL00000044	FOAM PE HD 0.5mm	020 - WHITE (5x5)CM	750	0	0	500	250	250	75	0	0
LBLMBL00000006	STICKER MONTBLANC	001 - WHITE	18	0	0	0	0	0	0	0	0
LTRMBL00000002	REAL COW 1.2*1.3mmTHICK ART SIRIA	001 - BLACK	25.05	25.05	25.05	0	0	0	0	0	0
MTLMBL00000018	LOGO - 1031462 CENTERING DISK FOR LEATHER	001 - NICKEL	750	750	750	0	0	0	0	0	0
MTLMBL00000019	LOGO - 1099321 DISK FOR RU Ø6,6MM POL	001 - BLACK NICKEL	750	750	750	0	0	0	0	0	0
MTLMBL00000025	PULLER W11mm H40mm MB T4.3mm ANTI SLIP	001 - MATTE BLACK	765	765	765	0	0	0	0	0	0
PSTMBL00000034	PLASTIC LOGO 1028768 WITH PIN Ø6,5MM C	001 - BLACK	750	750	750	0	0	0	0	0	0
WEBMBL00000013	POLY WEBBING 15mm -3/4in LIGHTWEIGHT GROSSGRAIN W-13101-01	012 - BLACK-001-P0382	585			0	0	0	0	0	0
ZPRMBL00000004	CHAIN NYLON #3 W24mm P12 3 CF DYED HANK YKK	001 - S80	183.6	183.6	183.6	0	0	0	0	0	0
ZPRMBL00000017	SLIDER NYLON #3 NO TAB NON LOCK 03 C ZF X6 YKK	002 - MATTE BLACK	765	765	765	0	0	0	0	0	0
Percentage					59.79		17.09		-		0.02
Material Readiness Formula Detail											
(1) Total Request Quantity			=SUM(D3:D17)	23,398.95							
(2) Total WMS Quantity			=SUM(F3:F17)	13,991.20							
(3) Total ETA within 5 days			=SUM(G3:G17)	4,000.00							
(4) Total ETA within 10 days			=SUM(H3:H17)	225.00							
(5) Total ETA > Package Start Date			=SUM(I3:I17)	5.48							
6. Material Readiness = [(2) + (3) + (4) + (5)] / (1)				77.87							

2.3. PACKAGE OPERATION PLAN

Description: Operation plan must be created before a package can be executed in production line.

❖ SEARCH PACKAGE GROUP

1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can see all the Package Group (AO No, Style Code, Style Size, Plan Start, Plan Finish...)

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Production Plan Package Management

Dates: (1) 2020/03/23 - 2020/04/ (2) Filter By AO No: Buyer: Style Info: (3) Search

(4)

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
P2C1-2002-000000050	P2C1	AD-KUU-0138	KUU0176	XLG	008	001	200	0	RO	2020-03-23	2020-03-23
P2C1-2002-000000051	P2C1	AD-KUU-0139	KUU0176	XLG	009	001	600	0	RO	2020-03-24	2020-03-25
P2C1-2002-000000052	P2C1	AD-KUU-0138	KUU0176	XLG	005	001	250	0	RO	2020-03-25	2020-03-25
P2C1-2003-000000005	P2C1	AD-BCA-0040	BCA0067	XLG	006	001	252	0	RO	2020-03-23	2020-03-23
P2C1-2003-000000006	P2C1	AD-BCA-0040	BCA0075	SMA	001	001	501	0	RO	2020-03-24	2020-03-26
P2C1-2003-000000007	P2C1	AD-BCA-0040	BCA0072	RGL	001	002	1027	0	RO	2020-03-19	2020-03-23
P2C1-2003-000000008	P2C1	AD-BCA-0040	BCA0069	RGL	001	003	748	0	RO	2020-03-24	2020-03-26
P2C1-2003-000000009	P2C1	AD-OVX-0020	OVX0014	RGL	001	004	730	0	RO	2020-03-23	2020-03-25
P2C1-2003-000000016	P2C1	AD-MUT-0446	MUT0621	RGL	004	001	304	0	RO	2020-03-21	2020-03-23
P2C1-2003-000000017	P2C1	AD-MUT-0446	MUT0586	RGL	003	003	552	0	RO	2020-03-23	2020-03-25

❖ REGISTERING PLAN FOR PACKAGE

1. SEARCH: Press search to view data
2. You can choose line which you need to register plan
3. You can choose a MES Package to register plan
4. Choose Register Plan to create operation plan
5. You see screen operation plan but don't have data (You will know how to create MES operation plan on OPS system as below)
6. You will see line MES in here which get data from OPS system since you created MES operation plan on OPS system and choose it.
7. Register: Press register plan to create plan.
8. You can choose a MES Package to view data which created operation plan
9. You can see all the layout which get data from OPS system (MES Operation Layout)
10. DELETE PLAN: You can press delete plan button if you can change it.

Dates: 2019/07/04 - 2019/07/24
 Factory: PKS2-C
 AO No:
 Buyer:
 Style Info:
 (1) Search

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
P2C1-1906-000000024	P2C1	AD-LLM-0084	LLM0243	MDI	001	001	12	0	RO	2019-07-04	2019-07-06
P2C1-1906-000000025	P2C1	AD-LLM-0084	LLM0242	MDI	001	001	12	0	RO	2019-07-04	2019-07-04
P2C1-1906-000000027	P2C1	AD-KUU-0107	KUU0086	LRG	015	001	800	0	RO	2019-07-05	2019-07-06
P2C1-1907-000000001	P2C1	AD-OSP-0292	OSP1149	RGL (2)	004	001	460	0	RO	2019-07-05	2019-07-07
P2C1-1907-000000002	P2C1	AD-OSP-0292	OSP1155	RGL	003	001	400	0	RO	2019-07-04	2019-07-05
P2C1-1907-000000004	P2C1	AD-LLM-0084	LLM0241	MDI	001	001	12	0	RO	2019-07-09	2019-07-09
P2C1-1907-000000005	P2C1	AD-OSP-0292	OSP1155	RGL	004	001	10	0	RO	2019-07-09	2019-07-10
P2C1-1907-000000006	P2C1	AD-LLM-0098	LLM0248	MDI	001	001	6	0	RO	2019-07-10	2019-07-10

< << Page 1 of 1 >> >>> 10 View 1 - 8 of 8

MES P. Packages	(3)	Line No	Start Plan	Target Qty
M_OSP-0292_1_OSP1155RGL003001_01_01		LINE02		200
M_OSP-0292_1_OSP1155RGL003001_01_02		LINE02		200
Total				400

Activate Windows Go to Settings to activate Windows. (4) Register plan

Edition	Style Code	Style Size	Color	Revision	Op Revision	Op Time	Workers	Machine count	Op Count	Status	Op Price
(5)											

Page 1 of 1

☐ Register as neutral color
 ☒ Copy tool, machine linking
 ☒ Copy the selected plan

Style Code: OSP11! Color: 003 Processes: Workers: Op Revision: 001
 Style Size: RGL Revision: 001 Machines: Time: Target edition: MES

 Activate Windows
 Go to Settings to activate Windows.

Edition	Style Code	Style Size	Color	Revision	Op Revision	Op Time	Workers	Machine count	Op Count	Status	Op Price
MES	OSP1155	RGL	003 - FW19 - LILAC GR	001	001	115	117	85	93		

Page 1 of 1

☐ Register as neutral color
 ☒ Copy tool, machine linking
 ☒ Copy the selected plan

Style Code: OSP11! Color: 003 Processes: 93 Workers: 117 Op Revision: 001
 Style Size: RGL Revision: 001 Machines: 85 Time: 115 Target edition: MES

 Activate Windows
 Go to Settings to activate Windows.

MES P. Packages	(8)	Line No	Start Plan	Target Qty
M_OSP-0292_1_OSP1155RGL003001_01_01		LINE02		200
M_OSP-0292_1_OSP1155RGL003001_01_02		LINE02		200
Total				400

(10)

Delete plan

Plan Layout

MES Operation Layout

OP Line Mapping

(9)

Page 1 of 1

Back Panel

Bottom Panel

Front Panel-Lining

Gusset-Main gusset

Shoulder harness-

Hip

[22] Ráp dây v...

[15] [1] KM-340BL

[51] Máy dịnh m...

[110] [1] KM-340BL

[33] Lược kết đ...

[70] [1] KM-340BL

[28] Viên hai b...

[100] [1] KM-340BL

[42] Ráp suppl...

[110] [1] KM-340BL

[76] Máy thun r...

[80] [1] KM-340BL

Activate Windows

Go to Settings to activate Windows

Copy/Register new MES Operation Plan on OPS system

This step is pre-require for Register plan on MES system:

1. Search Style code No
2. You can choose line which you need to create MES
3. ADD: Choose add to add MES line
4. Paste Style Code in column Style
5. Search to view data
6. Choose line have Style code, Style size, Color, Rev no which you need to register
7. Choose line have Style code, Style size, Color, Rev no which you need to register
8. Target edition choose MES
9. Factory: you choose the factory which the factory need to register
10. Register: press register button to create MES line
11. You will see the data (MES Line) since you created.

PK OPS **Operation Plan** Master Data Settings Help

OSP1155

(1)

Ops Register (3)

Plan Management

Plan Layout

Engineering Data

Style Code: OSP1155 | Revision: 001 | Op Revision: 001

All	Style Code	Color	Buyer Code	Buyer Name	Style Size	Revision	Op Revision	Op Time	Machine count
PDM	OSP1155	003 - FW'19 - LILAC GREY	Raven 10 w/Res	Raven 10 w/Res	RGL	001	001	115	85

(2)

Copy / Register new operation plan

Buyer: Select Buyer Ao Number: Style: OSP1155 Search (4) (5)

Style Code	Style Size	Color	Revno	Style Name	Buyer
OSP1155	RGL	001 - 001 - BLACK - FW'19	001	Raven 10 w/Res	
OSP1155	RGL	002 - 002 - FW'19 - BLACK	001	Raven 10 w/Res	
OSP1155	RGL	003 - 003 - FW'19 - LILAC GREY	001	Raven 10 w/Res	
OSP1155	RGL	004 - 004 - FW'19 - BLUE EME	001	Raven 10 w/Res	
OSP1155	RGL	005 - 005 - SS'20 - BLACK	001	Raven 10 w/Res	

(6)

Edition	Style Code	Style Size	Color	Revision	Op Rev
PDM	OSP1155	RGL	003 - FW'19 - LILAC GR	001	001

(7)

Register as neutral color ☐ Copy tool, machine linking ☒

Tiếng Việt Translate

Copy the selected plan ☒ Register an empty plan ☐ Import from file (GSD) CSV

(9)

Style Code: OSP1155 Color: 003 Processes: 93 Workers: 117 Op Revision: 001 PK52-C

Style Size: RGL Revision: 001 Machines: 85 Time: 115 Target edition: MES

(8) (10)

Register

PK OPS									
Operation Plan Master Data Settings Help									
OSP1155									
Ops Registry									
Add Confirm Delete									
Style Code: OSP1155 Size: RGL Color: 003 Revision: 001 Op Revision: 001									
All	Style Code	Color	Buyer Code	Buyer Name	Style Size	Revision	Op Revision	Op Time	Machine count
x	x	x	x	x	x	x	x	x	x
MES	OSP1155	003 - FW'19 - LILAC GREY	Raven 10 w/Res	Raven 10 w/Res	RGL	001	001	115	85
PDM	OSP1155	003 - FW'19 - LILAC GREY	Raven 10 w/Res	Raven 10 w/Res	RGL	001	001	115	85

(11)

❖ OP LINE MAPPING (PACKAGE OPERATION PLAN)

1. Choose the line MES Package
2. Choose module OP Line Mapping
3. User can drag and drop the process detail (left side) to each position in the line layout (right side).

MES P. Packages	Line No	Start Plan	Target Qty
M_OSP-0292_1_OSP1155RGL003001_01_01	LINE02		200
M_OSP-0292_1_OSP1155RGL003001_01_02	LINE02		200
Total			400

(1)

Delete plan

Plan Layout

MES Operation Layout

OP Line Mapping

(2)

(3)

[93] Đóng gói | Gắn sticker túi thành phẩm | Vệ sinh túi

[92] Chuyển pho | KCS | Chuyển trường | Kỹ thuật | Phối

[91] Cắt nhiệt dây viền | Cắt phụ kiện

[90] Thắt tết đầu kéo | Xò dây rút | Xò khóa

[891] Vò

[881] Cắt

LINE02A

LINE02B

1

Activate Windows
Go to Settings to activate Windows

2.4. BILL OF MATERIALS

1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can choose one Package Group to view BOM
5. You can see all of materials belong a Package Group.

Navigation bar: Dashboards, QCC, MES, Quality, Cutting Plan, WMS, HRM, Factory, Reports, Admin, Tools, Help.

BOM Section:

- Production Plan
- Package Management
- Package Operation Plan
- Bill Of Materials (selected)

Filter By: (1) 2020/03/24 - 2020/04 (2) * (3) Search

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
P2C1-2002-000000051	P2C1	AD-KUU-0139	KUU0176	XLG	009	001	600	0	RO	2020-03-24	2020-03-25
P2C1-2002-000000052	P2C1	AD-KUU-0138	KUU0176	XLG	005	001	250	0	RO	2020-03-25	2020-03-25
P2C1-2003-000000006	P2C1	AD-BCA-0040	BCA0075	SMA	001	001	501	0	RO	2020-03-24	2020-03-26
P2C1-2003-000000008	P2C1	AD-BCA-0040	BCA0069	RGL	001	003	748	0	RO	2020-03-24	2020-03-26
P2C1-2003-000000009	P2C1	AD-OVX-0020	OVX0014	RGL	001	004	730	0	RO	2020-03-23	2020-03-25
P2C1-2003-000000017	P2C1	AD-MUT-0446	MUT0586	RGL	003	003	552	0	RO	2020-03-23	2020-03-25
P2C1-2003-000000018	P2C1	AD-LLM-0199	LLM0415	MDI	002	001	1959	0	RO	2020-03-14	2020-03-25
P2C1-2003-000000021	P2C1	AD-OSP-0341	OSP1248	MDI	006	001	250	0	RO	2020-03-24	2020-03-24
P2C1-2003-000000022	P2C1	AD-OSP-0341	OSP1248	MDI	005	002	90	0	RO	2020-03-25	2020-03-25
P2C1-2003-000000023	P2C1	AD-MUT-0445	MUT0694	RGL	001	002	604	0	RO	2020-03-23	2020-03-24

Page 1 of 2 View 1 - 10 of 12

Bill Of Materials Section:

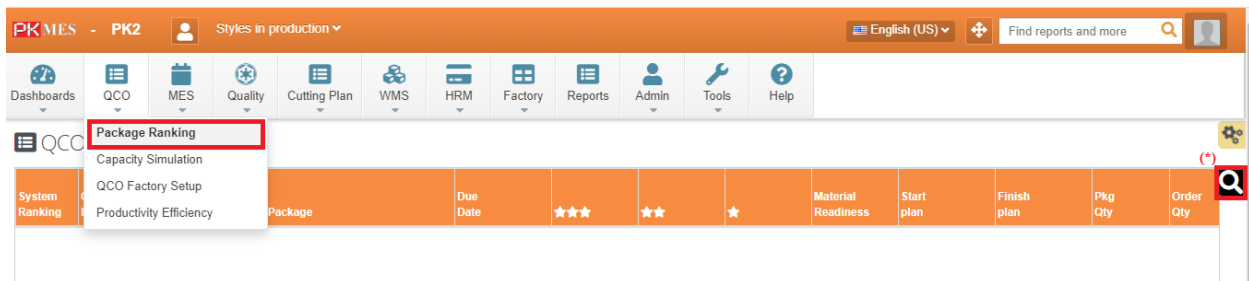
(5) Engineering BOM Module BOM

Item Code	Item Name	Item Color	Purchase Cons	Consumption Unit	Qty	Standard Price	Currency	Registry Date	Register Name	Pattern Cons	Poly Consumption	Auto Cons	Auto C
BNFKUU00000048	STAY ALUMINUM W8mm		1	PC	1	0	USD	29-10-2019 10:05		0	0		
BNFKUU00000050	SHEET PE 1.0mm MOUL		1	PC	1	0	USD	29-10-2019 10:05		93.45	92.06		
BNFKUU00000051	FRAME ALUMINUM T2mm		1	PC	1	0	USD	29-10-2019 10:05		0	0		

3. QCO

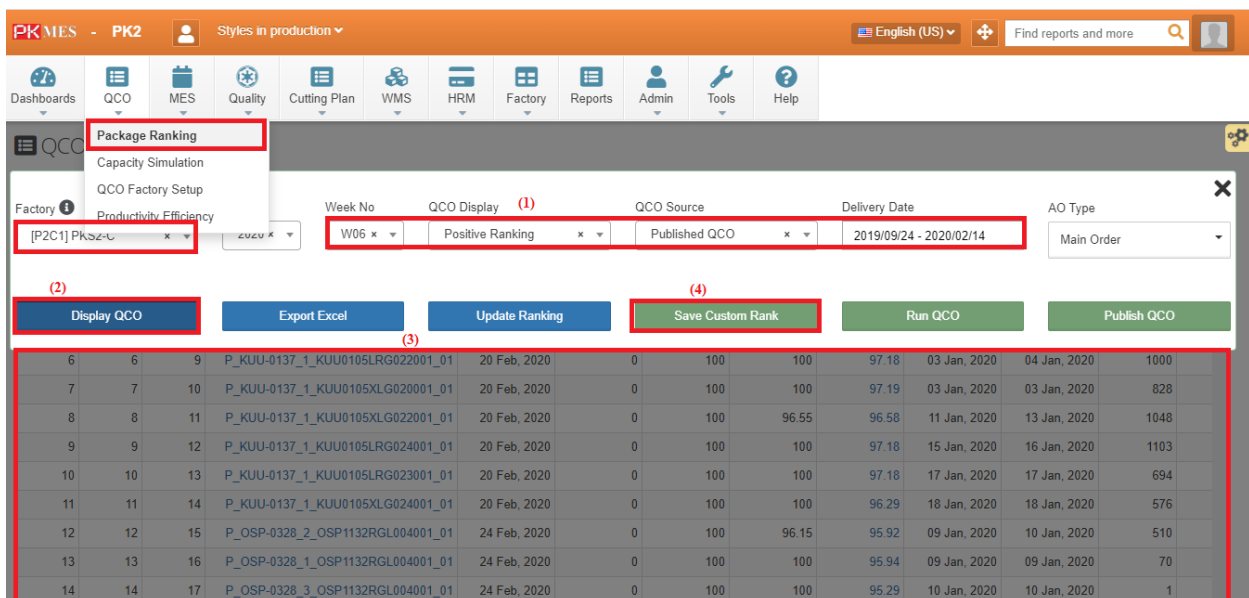
3.1. PACKAGE RANKING

(*) You can choose symbol  to search the data at Package Ranking as below:



❖ DISPLAY QCO

1. Choose Factory, Year, Week no, QCO Source which you need to find
2. Press Display QCO button to show data
3. You can see all the data Package ID in here
4. Save Custom Rank when you have to change.

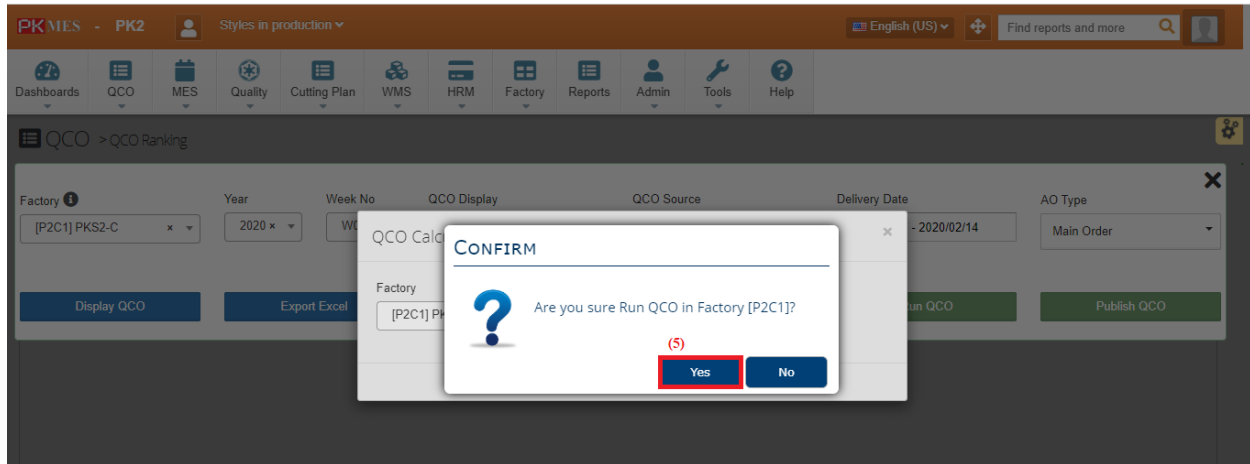


❖ RUN QCO

1. Choose Factory, Year, Week no, QCO Source which you need to find
2. Press Run QCO button
3. Factory: Choose the factory which you need to Run QCO (but you can use this features later 12:00 PM on Saturday)
4. Press Confirm button to confirm it.
5. Press Yes button to make sure Run QCO.

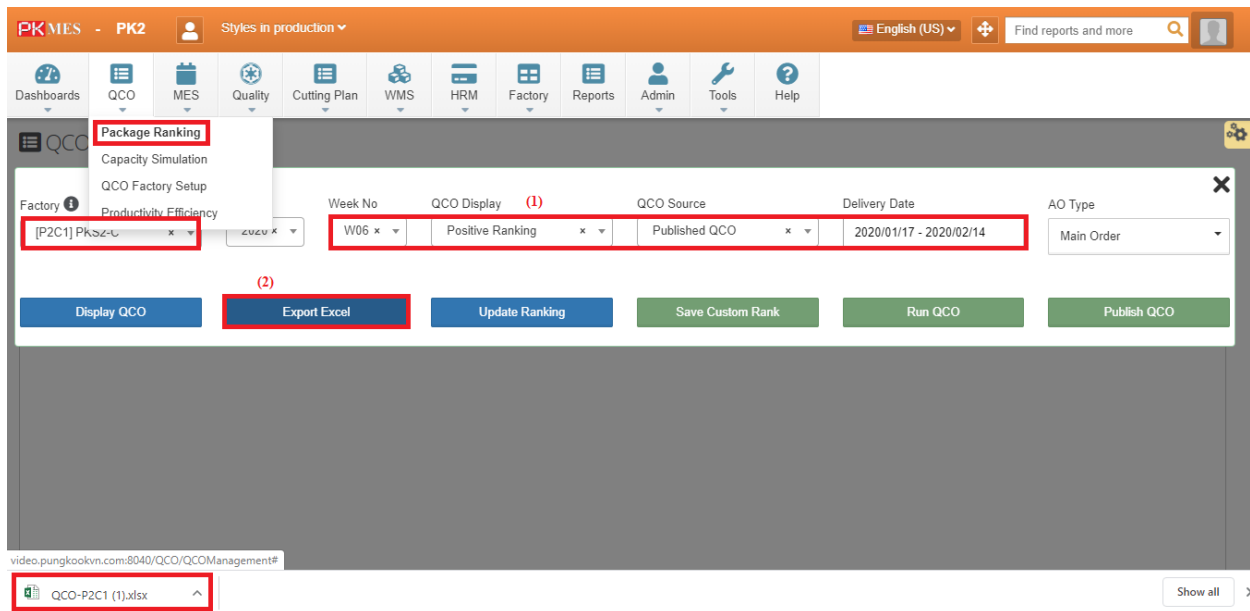
The screenshot shows the PKMES - PK2 interface. The top navigation bar includes 'Dashboards', 'QCO', 'MES', 'Quality', 'Cutting Plan', 'WMS', 'HRM', 'Factory', 'Reports', 'Admin', 'Tools', and 'Help'. The 'QCO' menu is expanded, showing 'Package Ranking' (highlighted with a red box), 'Capacity Simulation', 'QCO Factory Setup', and 'Productivity Efficiency'. The 'Package Ranking' sub-menu is also visible. The main form has fields for 'Week No' (W06), 'QCO Display' (Positive Ranking, labeled (1)), 'QCO Source' (Published QCO), 'Delivery Date' (2020/01/17 - 2020/02/14), and 'AO Type' (Main Order). The 'Run QCO' button is highlighted with a red box and labeled (2). Other buttons include 'Display QCO', 'Export Excel', 'Update Ranking', 'Save Custom Rank', and 'Publish QCO'.

The screenshot shows the PKMES - PK2 interface with the 'QCO Calculation' dialog box open. The dialog box has a 'Factory' field (labeled (3)) with a dropdown menu showing various factory codes. The 'Confirm' button is highlighted with a red box and labeled (4). The background shows the 'QCO Ranking' form with fields for 'Factory' (P2C1) PKS2-C, 'Year' (2020), 'Week No' (W06), 'QCO Display' (Positive Ranking), 'QCO Source' (Published QCO), 'Delivery Date' (2020/01/17 - 2020/02/14), and 'AO Type' (Main Order). The 'Run QCO' button is also visible.



❖ EXPORT EXCEL

1. Choose Factory, Year, Week no, QCO Source which you need to find
2. Press Export Excel button to export data.



QCO-P2C1.xlsx - Excel

FILEHOME

INSERTPAGE LAYOUTFORMULASDATAVIEWVIEW

CutCopyFormat Painter

Clipboard

Calibri11

B

I

U

Font

Wrap Text

Alignment

General

Number

Conditional Formatting

Format as Table

Cell Styles

Styles

Insert

Delete

Format

Cells

AutoSum

Fill

Clear

Editing

Sort & Find & Filter

Select

A1

QCOSOURCE

RANKING

STYLENAN

BUYERSTY

BUYERSTY

STYLECOL

QCOFACT

QCOYEAR

QCOWEEK

QCORANK

CUSTOMR

PRECUSTC

FACTORY

LINENO

AONO

ADTYPE/BUYER

STYLECOD

STYLESIZE

STYLECOL

REVNO

2	QCO	1	HSMK DUF NFOA4SJ7	HSMK DUF S20 S96 PE P2C1				2020	W06	1	1	4	P2C1	LINE18	AD-TNF-1' Main Ord	TNF1305	RGL	001	001
3	QCO	59	HSMK DUF NFOA4SJ7	HSMK DUF S20 S96 PE P2C1				2020	W06	2	2	5	P2C1	LINE18	AD-TNF-1' Main Ord	TNF1305	RGL	001	001
4	QCO	101	HSMK DUF NFOA4SJ7	HSMK DUF S20 S96 PE P2C1				2020	W06	3	3	6	P2C1	LINE18	AD-TNF-1' Main Ord	TNF1305	RGL	001	001
5	QCO	145	LU9AFXS 3 LU9AFXS 3	SU20 0463 P2C1				2020	W06	4	4	7	P2C1	LINE25	AD-LLM-0' Sample Oi	LLM0446	MDI	001	001
6	QCO	194	HSMK DUF NFOA4SJ7	HSMK DUF S20 S96 PE P2C1				2020	W06	5	5	8	P2C1	LINE18	AD-TNF-1' Main Ord	TNF1305	RGL	001	001
7	QCO	239	BINO HAR 80010-BIN	BINO HAR S20 VERDE P2C1				2020	W06	6	6	9	P2C1	LINE49	AD-KUU-0 Main Ord	KUU0105	LRG	022	001
8	QCO	287	BINO HAR 80010-BIN	BINO HAR S20 MAJO P2C1				2020	W06	7	7	10	P2C1	LINE49	AD-KUU-0 Main Ord	KUU0105	XLG	020	001
9	QCO	334	BINO HAR 80010-BIN	BINO HAR S20 VERDE P2C1				2020	W06	8	8	11	P2C1	LINE49	AD-KUU-0 Main Ord	KUU0105	XLG	022	001
10	QCO	386	BINO HAR 80010-BIN	BINO HAR S20 GUNW P2C1				2020	W06	9	9	12	P2C1	LINE49	AD-KUU-0 Main Ord	KUU0105	LRG	024	001
11	QCO	442	BINO HAR 80010-BIN	BINO HAR S20 VIAS 2 P2C1				2020	W06	10	10	13	P2C1	LINE49	AD-KUU-0 Main Ord	KUU0105	LRG	023	001
12	QCO	481	BINO HAR 80010-BIN	BINO HAR S20 GUNW P2C1				2020	W06	11	11	14	P2C1	LINE49	AD-KUU-0 Main Ord	KUU0105	XLG	024	001
13	QCO	524	Jet 18	Jet 18	Jet 18	FW'20 - W P2C1		2020	W06	12	12	15	P2C1	LINE57	AD-OSP-0 Main Ord	OSP1132	RGL	004	001
14	QCO	611	Jet 18	Jet 18	Jet 18	FW'20 - W P2C1		2020	W06	13	13	16	P2C1	LINE57	AD-OSP-0 Main Ord	OSP1132	RGL	004	001
15	QCO	617	Jet 18	Jet 18	Jet 18	FW'20 - W P2C1		2020	W06	14	14	17	P2C1	LINE57	AD-OSP-0 Main Ord	OSP1132	RGL	004	001
16	QCO	671	Ultralight	Ultralight	Ultralight	FW'20 - SH P2C1		2020	W06	15	15	18	P2C1	LINE26	AD-OSP-0 After Serv	OSP0286	LRG	005	001
17	QCO	716	Jet 18	Jet 18	Jet 18	FW'20 - CC P2C1		2020	W06	16	16	19	P2C1	LINE57	AD-OSP-0 Main Ord	OSP1132	RGL	005	001
18	QCO	799	Jet 18	Jet 18	Jet 18	FW'20 - CC P2C1		2020	W06	17	17	20	P2C1	LINE57	AD-OSP-0 Main Ord	OSP1132	RGL	005	001
19	QCO	822	ULTRALIGI	ULTRALIGI	ULTRALIGI	FW'20 - EL P2C1		2020	W06	18	18	22	P2C1	LINE61	AD-OSP-0 Main Ord	OSP0407	RGL	009	001
20	QCO	860	ULTRALIGI	ULTRALIGI	ULTRALIGI	FW'20 - SH P2C1		2020	W06	19	19	23	P2C1	LINE61	AD-OSP-0 Main Ord	OSP0410	RGL	011	001
21	QCO	896	ULTRALIGI	ULTRALIGI	ULTRALIGI	FW'20 - SH P2C1		2020	W06	20	20	26	P2C1	LINE61	AD-OSP-0 Main Ord	OSP0410	RGL	011	001
22	QCO	987	ULTRALIGI	ULTRALIGI	ULTRALIGI	FW'20 - SH P2C1		2020	W06	21	21	27	P2C1	LINE61	AD-OSP-0 Main Ord	OSP0410	RGL	011	001
23	QCO	988	Sirrus 50	Sirrus 50	Sirrus 50	FW'20 - BL P2C1		2020	W06	22	22	29	P2C1	LINE01	AD-OSP-0 After Serv	OSP1253	SMA	006	001

❖ UPDATE RANKING

1. Choose Factory, Year, Week no, QCO Source which you need to find
2. Press Update Ranking button to update data when you need to change the data at Package Ranking.
3. Choose file Excel to update data.
4. Press Upload button to upload file excel which you need to change the data.

PKMES - PK2 | Styles in production | English (US) | Find reports and more

Package Ranking

Capacity Simulation

QCO Factory Setup

Productivity Efficiency

Factory: [P2C1] PKSZ-C

Week No: W06

QCO Display: (1) Positive Ranking

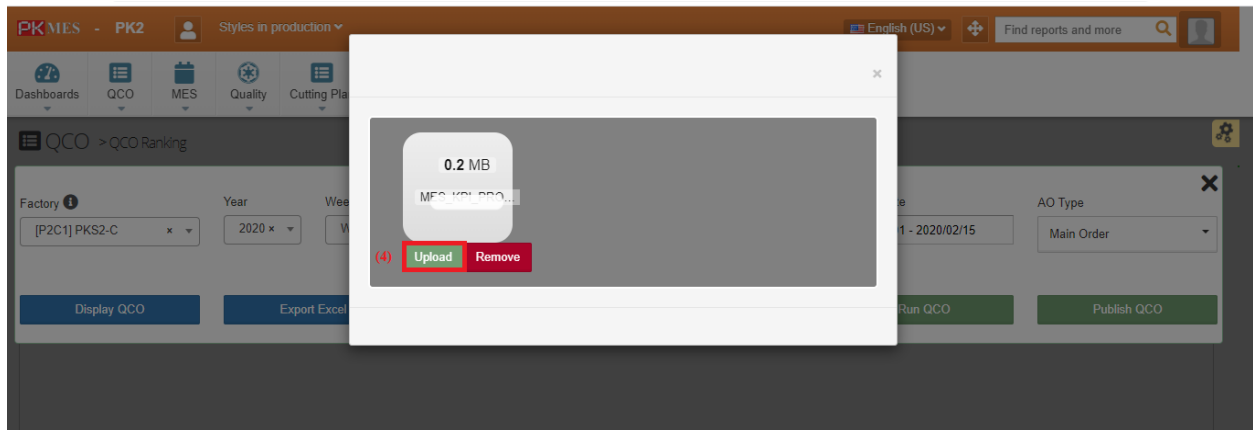
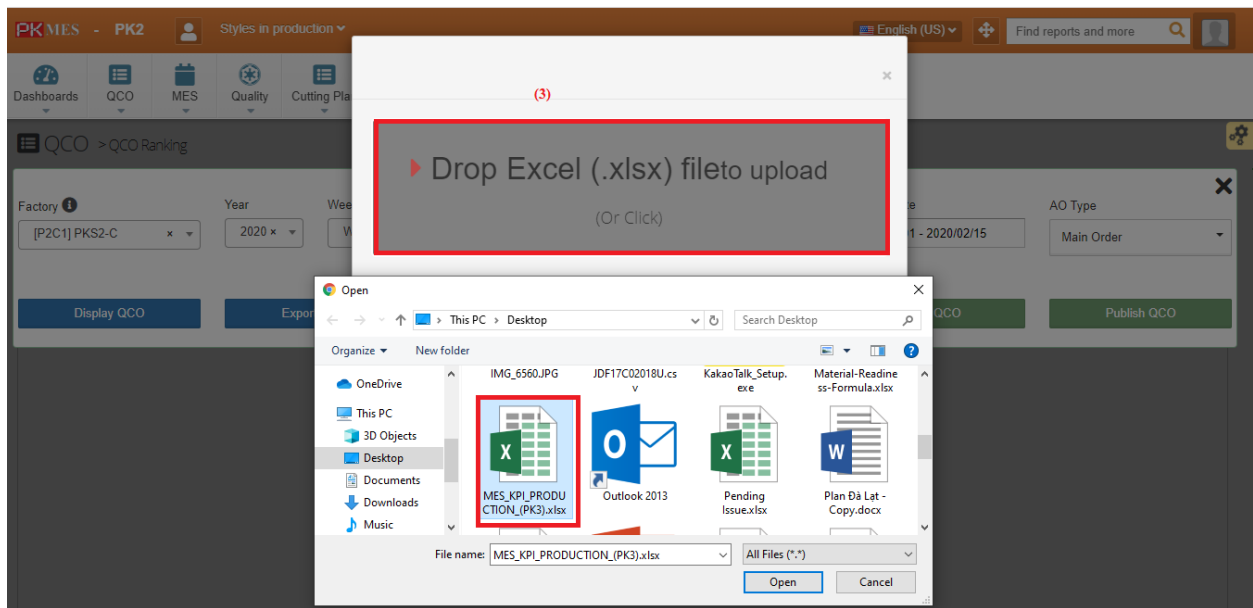
QCO Source: Published QCO

Delivery Date: 2020/02/01 - 2020/02/15

AO Type: Main Order

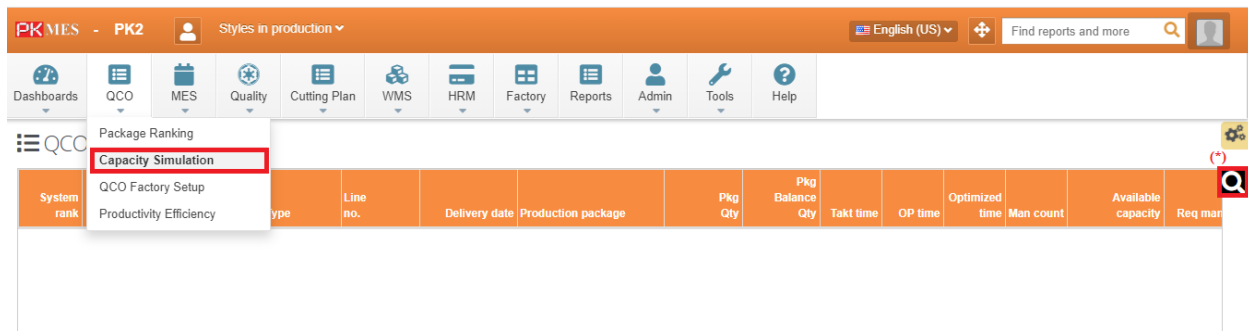
(2)

Display QCO | Export Excel | Update Ranking | Save Custom Rank | Run QCO | Publish QCO



3.2 CAPACITY SIMULATION

(*) You can choose symbol  to search the data at Capacity Simulation as below



❖ DISPLAY QCO CAPACITY SIMULATION

This screen simulates the factory capacity and potential usage of capacity for producing the pending production packages.

Available Weekly Capacity for the factory = Weekly working hours * total workforce (from MES Weekly working sheet screen)

Required capacity for a production package = Package Qty * (Optime + (Optime * (2 - 2 * Efficiency Factor)))

Efficiency Factor is defined through Factory->Efficiency Factor screen by factory, by week.

1. Choose Factory, Year, Week no, QCO Week which you need to find
2. Press Display button to show data
3. You can see all the data Production Package in here

NOTE: + The package on top will have start with full capacity for the week, and the balance is arrived at deducting required capacity for executing the package

+ Until balance becomes insufficient packages are listed deducting the required capacity during the current week. When the available capacity is finished then capacity for coming working week is loaded and the packages week for the next package onwards will be assigned to next working week.

PKMES - PK2 Styles in production English (US) Find reports and more

Dashboards QCO MES Quality Cutting Plan WMS HRM Factory Reports Admin Tools Help

Package Ranking
Capacity Simulation

QCO Factory Setup
Productivity Efficiency

Factory: [P2C1] PKS2-C (1) QCO Week: 2020 W06 Est. Prod. Period: W05 ~ W07 (2) Display Reallocate Export BOM

System rank	Custom rank	AO No.	AO Type	Line no.	Delivery date	Production package	Pkg Qty	Pkg Balance Qty	Takt time	OP time	Optimized time	Man count	Available capacity	Req man
-49	-49	AD-LLM-0207	Sample Order	LINE03	26 Dec, 2019	P_LLM-0207_1_LLM0396	30	30	100	292	438	22	58264.71	
-48	-48	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0444	30	30	75	1670	2505	35	58261.07	
-47	-47	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0404	30	30	100	2465	3697.5	41	58240.19	
-46	-46	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0404	30	30	100	2465	3697.5	41	58209.38	
-45	-45	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0406	30	30	100	2465	3697.5	41	58178.57	
-44	-44	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0436	30	30	100	2405	3607.5	41	58147.76	
-43	-43	AD-LLM-0207	Sample Order	LINE48	26 Dec, 2019	P_LLM-0207_1_LLM0426	30	30	90	9060	13590	92	58117.7	
-42	-42	AD-LLM-0207	Sample Order	LINE48	26 Dec, 2019	P_LLM-0207_1_LLM0427	30	30	90	9060	13590	92	58004.45	
-41	-41	AD-LLM-0207	Sample Order	LINE15	26 Dec, 2019	P_LLM-0207_1_LLM0441	30	30	85	2160	3240	41	57891.2	
-40	-40	AD-LLM-0207	Sample Order	LINE15	26 Dec, 2019	P_LLM-0207_1_LLM0442	30	30	85	2160	3240	41	57864.2	
-39	-39	AD-LLM-0207	Sample Order	LINE15	26 Dec, 2019	P_LLM-0207_1_LLM0443	30	30	85	2160	3240	41	57837.2	

Dashboards QCO MES Quality Cutting Plan WMS HRM Factory Reports Admin Tools Help

QCO > QCO Capacity

System rank	Custom rank	AO No.	AO Type	Line no.	Delivery date	Production package	Pkg Qty	Pkg Balance Qty	Takt time	OP time	Optimized time	Man count	Available capacity	Req man
-51	-51	AD-LLM-0130	Sample Order	LINE67	01 Aug, 2019	P_LLM-0130_1_LLM0251	1	1	110	8150	12225	65	58275	
-50	-50	AD-LLM-0168	Sample Order	LINE41	11 Oct, 2019	P_LLM-0168_1_LLM0337	9	2	100	8280	12420	102	58271.61	
-49	-49	AD-LLM-0207	Sample Order	LINE03	26 Dec, 2019	P_LLM-0207_1_LLM0396	30	30	100	292	438	22	58264.71	
-48	-48	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0444	30	30	75	1670	2505	35	58261.07	
-47	-47	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0404	30	30	100	2465	3697.5	41	58240.19	
-46	-46	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0404	30	30	100	2465	3697.5	41	58209.38	
-45	-45	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0406	30	30	100	2465	3697.5	41	58178.57	
-44	-44	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0436	30	30	100	2405	3607.5	41	58147.76	
-43	-43	AD-LLM-0207	Sample Order	LINE48	26 Dec, 2019	P_LLM-0207_1_LLM0426	30	30	90	9060	13590	92	58117.7	
-42	-42	AD-LLM-0207	Sample Order	LINE48	26 Dec, 2019	P_LLM-0207_1_LLM0427	30	30	90	9060	13590	92	58004.45	
-41	-41	AD-LLM-0207	Sample Order	LINE15	26 Dec, 2019	P_LLM-0207_1_LLM0441	30	30	85	2160	3240	41	57891.2	
-40	-40	AD-LLM-0207	Sample Order	LINE15	26 Dec, 2019	P_LLM-0207_1_LLM0442	30	30	85	2160	3240	41	57864.2	
-39	-39	AD-LLM-0207	Sample Order	LINE15	26 Dec, 2019	P_LLM-0207_1_LLM0443	30	30	85	2160	3240	41	57837.2	
-38	-38	AD-LLM-0207	Sample Order	LINE18	26 Dec, 2019	P_LLM-0207_1_LLM0422	30	30	100	4505	6757.5	63	57810.2	

1. Choose Factory, Year, QCO Week No which you need to find
2. Press Excel button to export data.

[illegible]

NOTE: You can export the data by BOM (excel) or BOM (PDF), you can select the column you wish to see on BOM (PDF)

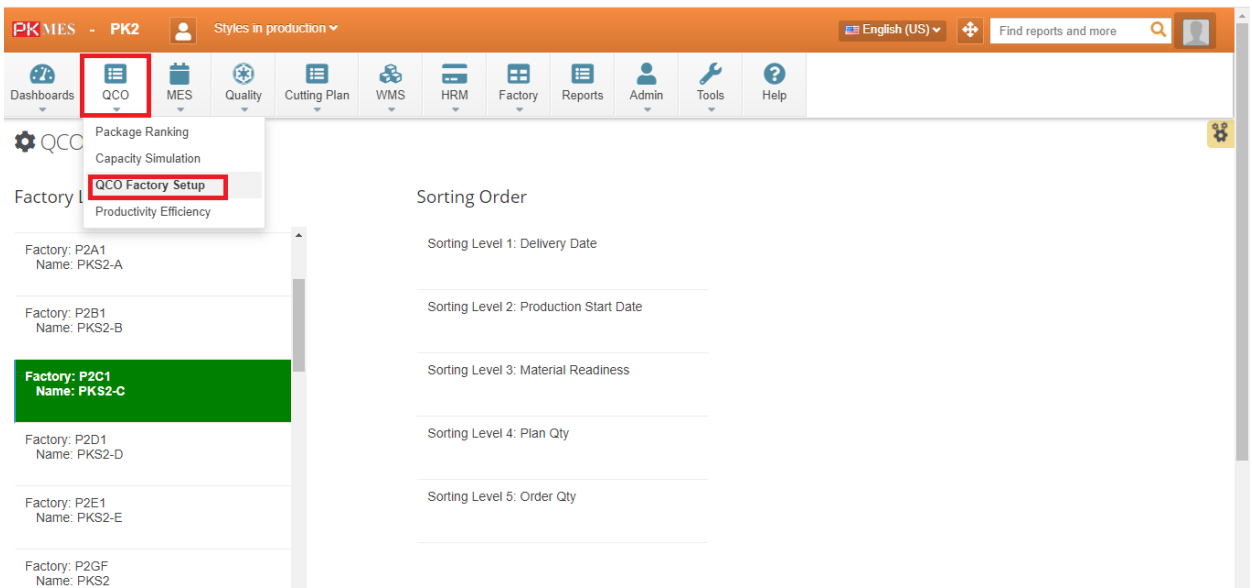
The screenshot shows the QCO Capacity Simulation interface. The top navigation bar includes icons for Dashboards, QCO, MES, Quality, Cutting Plan, WMS, HRM, Factory, Reports, Admin, Tools, and Help. The QCO menu is expanded, showing options like Package Ranking, Capacity Simulation (highlighted with a red box), QCO Factory Setup, and Productivity Efficiency. Below the menu, there are filters for Factory ([P2C1] PKS2-C), QCO Week (2020), and Est. Prod. Period (W05 to W07). Buttons for Display, Realocate, Export, and BOM (Excel) and BOM (PDF) (both highlighted with red boxes) are visible. A data table is displayed below, showing columns for QCO Year, QCO Week No, QCO Ranking, Style Code, Rev No, Item Color Ways, and various capacity metrics.

QCO Year	QCO Week No	QCO Ranking	Style Code	Rev No	Item Color Ways	Capacity Metrics
2020	W05	100	2465	3697.5	41	58209.38
2020	W06	100	2465	3697.5	41	58178.57
2020	W07	100	2405	3607.5	41	58147.76
2020	W08	90	9060	13590	92	58117.7
2020	W09	90	9060	13590	92	58004.45
2020	W10	85	2160	3240	41	57891.2
2020	W11	85	2160	3240	41	57864.2
2020	W12	85	2160	3240	41	57837.2
2020	W13	100	4505	6757.5	63	57810.2

The screenshot shows the QCO Capacity Simulation interface with the QCO Capa Column Selection dialog box open. The dialog box has a title "QCO Capa Column Selection" and a subtitle "Please select the column you wish to see on PDF file." It contains two sections: "Standard Columns" and "More Columns". The "Standard Columns" section lists columns like QCO Year, QCO Week No, QCO Ranking, Style Code, Rev No, Item Color Ways, QCO Factory, Factory, Style Size, Package ID, Assign Week Capa, QCO Week No, AO No, Style Color Serial, Item Code, and Custom Ranking. The "More Columns" section lists columns like OP Time, Begin Capa, Custom OP Time by Package, ETA in 5 days, Balance Qty, Efficiency Rate, Req. Man Hour, Request Quantity, ETA in 10 days, Custom OP Time, Remain Capa, WMS Qty, and ETA > Prod. Start Date. There are "Select All" and "Deselect All" buttons. The "Confirm" and "Cancel" buttons are at the bottom right. The background shows the same interface as the previous screenshot, with the BOM (PDF) button highlighted with a red box.

3.3 QCO FACTORY SETUP

You can view know how create QCO- Factory Setup



3.4 . PRODUCTIVITY EFFICIENCY

1. Choose Factory, Start Year, End Week which you need to find
2. Press Search button to search the data.
3. You can see Efficiency Rate in here.

The screenshot displays the PK MES software interface. At the top, there's a navigation bar with various modules like Dashboards, QCO, MES, Quality, Cutting Plan, WMS, HRM, Factory, Reports, Admin, Tools, and Help. A dropdown menu for 'Factory' is open, showing options like Package Ranking, Capacity Simulation, QCO Factory Setup, and Productivity Efficiency (which is highlighted). Below this, there are input fields for 'Start Week' (labeled (1)) and 'End Week' (labeled (2)), both set to 'W06' and 'W07' respectively. A 'Search' button (labeled (2)) is next to them. Below the search fields are 'Confirm Efficiency' and 'New Setting' buttons. At the bottom, a table (labeled (3)) shows the results of the search.

Pick	Factory	Year	Week No	Efficiency Rate	Confirm (Y/N)	Confirm By	Confirm Date
<input type="checkbox"/>	P2C1	2020	W06	75	N		
<input type="checkbox"/>	P2C1	2020	W07	75	N		

4. FACTORY

4.1. FACTORY LINE SETUP

❖ ADD LINE

In this screen MES (Physical lines can be created) keeping a mapping to AOMTOPS line for maintaining the relationship.

A line in MES doesn't visualize the tables or seats in the line. For physical orientation, we need to draw tables and seats under the line using the drawing tools provided

1. Choose the Factory which you need to add line
2. Press ADD LINE button to start add line
3. Choose line at AOMTOPs Line to add line
4. Input Amtop line, Actual Line, Workers
5. You can choose color at Background Color
6. Press CREATE button to create line
7. You will see the data which you just created.

The screenshot displays the PKMES Factory Line Setup interface. The navigation bar at the top includes 'Home', 'Dashboards', 'MES', 'QCO', 'Factory', 'WMS', 'HRM', 'Reports', 'Admin', 'Tools', and 'Help'. The 'Factory' menu item is selected, and the 'Factory Line Setup' sub-menu is visible. The main content area is divided into two panels: 'Factories' and 'Lines'. The 'Factories' panel shows a table with columns: Factory, FactoryName, No of Lines, Total Tables, Total Machines, and Premises. The 'Lines' panel shows a table with columns: Line, MTOPS Line, Workers, and DisplayColor. The 'Add Line' button is highlighted in red at the bottom right.

Factory	FactoryName	No of Lines	Total Tables	Total Machines	Premises
P2A1	PKS2-A	3	3		
P2B1	PKS2-B	28	28		
P2C1	PKS2-C	30	30		
P2D1	PKS2-D				
P2F1	PKS2-F				

Line	MTOPS Line	Workers	DisplayColor
Line 1A	LINE01	100	
Line 1B		150	
Line 2		40	

PKMES Styles in production English (US) Find reports and more

Home Dashboards MES

Creating new Line

AMTOPS Lines

Line	(3) Description	Capacity
LINE01	A1	0
LINE02	A2	0
LINE03	A3	0
LINE04	A4	0
LINE05	A5	0
LINE06	A6	0

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(4)

Antop Line LINE01

Actual Line LINE01

Workers 100

Background Color (5)

(6) Close Create

Factories

Factory	FactoryName	No of Lines	Total Tables	Total Machines	Premises
P2A1	PKS2-A	3	3		
P2B1	PKS2-B	28	28		
P2C1	PKS2-C	30	30		
P2D1	PKS2-D				
P2F1	PKS2-F				

Page 1 of 1 200 View 1 - 6 of 6

Workers DisplayColor

100	
150	
40	

200 View 1 - 3 of 3

Update Line Add Line

PKMES Styles in production English (US) Find reports and more

Home Dashboards MES QCO Factory WMS HRM Reports Admin Tools Help

Corporation CÔNG TY PUNGKOOK SA...

Factories

Factory	FactoryName	No of Lines	Total Tables	Total Machines	Premises
P2A1	PKS2-A	3	3		
P2B1	PKS2-B	28	28		
P2C1	PKS2-C	30	30		
P2D1	PKS2-D				
P2F1	PKS2-F				

Page 1 of 1 200 View 1 - 6 of 6

Lines

Line	(7) MTOPS Line	Workers	DisplayColor
Line 1A	LINE01	100	
Line 1B		150	
Line 2		40	

Page 1 of 1 200 View 1 - 3 of 3

Update Line Add Line

❖ UPDATE LINE

1. Choose the Factory which you need to update line
2. Choose a line at Lines to update it
3. Press UPDATE LINE button to start update line
4. Choose line at AOMTOPs Line to update line
5. You can update at Amtop line, Actual Line, Workers
6. You can update color again at Background Color
7. Press UPDATE button to update line

Corporation: CÔNG TY PUNGKOOK SA...

Factory	FactoryName	No of Lines	Total Tables	Total Machines	Premises
P2A1	PKS2-A	3	3		
P2B1	PKS2-B	28	28		
P2C1	PKS2-C	30	30		
P2D1	PKS2-D				
P2F1	PKS2-F				

Line	MTOPS Line	Workers	DisplayColor
Line 1A	LINE01	100	
Line 1B		150	
Line 2		40	

Page 1 of 1 | 200 | View 1 - 6 of 6

Page 1 of 1 | 200 | View 1 - 3 of 3

Update Line **Add Line**

Updating a Line

Line	Description	Capacity
LINE01	A1	0
LINE02	A2	0
LINE03	A3	0
LINE04	A4	0
LINE05	A5	0
LINE06	A6	0

Page 1 of 1 | 200 | View 1 - 17

Amtop Line: LINE01

Actual Line: Line 1A

Workers: 100

Background Color:

Update

❖ CREATE TABLE

1. Choose the Factory which you need to create table
2. Choose a line at Lines to create table
3. Press CREATE TABLE button to start create table
4. You can choose seat type for suitable
5. You can change number in Seat Total, Width, Length.
6. You can change number in Set Distance, Display Width, Display Length
7. Press CREATE button to create table
8. You will see the table which you created.
9. Press SAVE CHANGES to save the data.

Factories

Factory	FactoryName	No of Lines	Total Tables	Total Machines	Premises
P2A1	PKS2-A	3	3		
P2B1	PKS2-B	26	26		
P2C1	PKS2-C	30	30		
P2D1	PKS2-D				
P2F1	PKS2-F				

Page 1 of 1 200 View 1 - 6 of 6

Lines

Line	MTOP'S Line	Workers	DisplayColor
Line 1A	LINE01	100	
Line 1B		150	
Line 2		40	

Page 1 of 1 200 View 1 - 3 of 3

[Update Line](#) [Add Line](#)

Line 1A

1	3	5	7	9	11	13	15	17	19
2	4	6	8	10	12	14	16	18	20

(3)

[Create Table](#)
[Delete Table](#)
[Add Seat](#)
[Remove Seat](#)

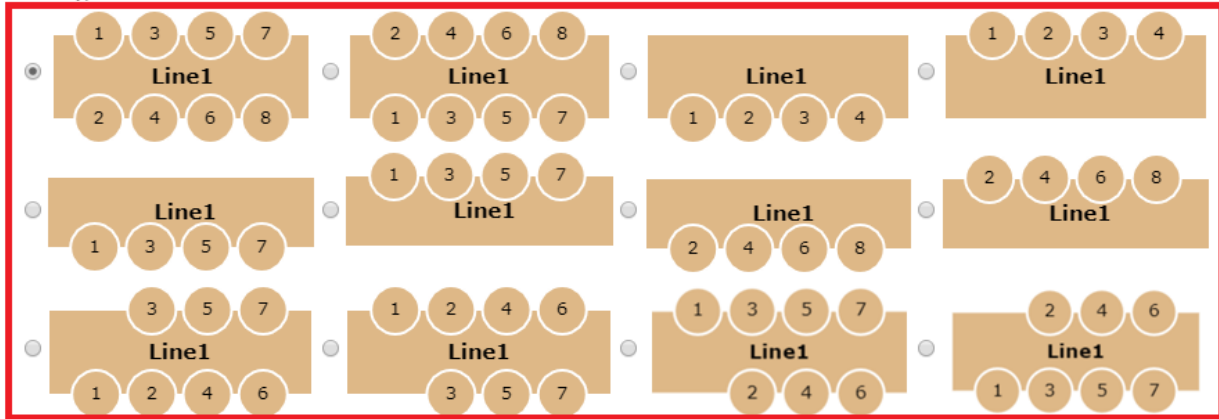
[Save Changes](#)

Line*

Line 1A

Seat Type*

(4)



Seat Total

(5)

Width*

Length*

20

550

cm

60

cm

.....

Seat Distance

(6)

Display Width*

Display Length*

5

pixel

192

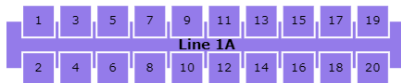
pixel

50

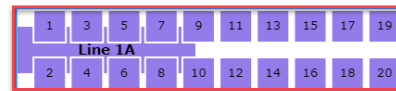
pixel

Close

Create



(8)



(9)

Create Table

Delete Table

Add Seat

Remove Seat

Save Changes

Activate Windows

❖ DELETE TABLE

1. Choose a table to delete
2. Press DELETE TABLE button delete it
3. Press Yes button to make sure you want to delete it
4. Press Save to save data

(1)

(2)

CONFIRMATION

Are you sure to delete?

(3)

Yes No

1	3	5	7	9	11	13	15	17	19
Line 1A									
2	4	6	8	10	12	14	16	18	20

[Create Table](#)
[Delete Table](#)
[Add Seat](#)
[Remove Seat](#)

Activate Windows (4)
 Go to Settings to activate Windows

[Save Changes](#)

❖ ADD SEAT

1. Choose a table to add seat
2. Press ADD SEAT button
3. You will see the table increase the seat
4. Press Save to save data

(1)

Line 1A

(2)

Create Table Delete Table Add Seat Remove Seat

Activate Windows
Go to Settings to activate

Save Changes

(3)

Line 1A

(4)

Create Table Delete Table Add Seat Remove Seat

Activate Windows
Go to Settings to activate

Save Changes

❖ REMOVE SEAT

1. Choose a table to remove seat
2. Press REMOVE SEAT button
3. You will see the table change the seat
4. Press Save to save data

(1)

Line 1A

Line 1A

(2)

Create Table Delete Table Add Seat Remove Seat

Activate Windows
Go to Settings to activate

Save Changes

(3)

Line 1A

Line 1A

(4)

Create Table Delete Table Add Seat Remove Seat

Activate Windows
Go to Settings to activate

Save Changes

5. DASHBOARD

Description: This dashboard allow user monitor the working status of indicate MES. It display the target, achieved, remaining (in real time).

1. Choose Factory, Date which you need to find
2. Choose Package which you need to find
3. You can see Target, Achieved, Defect, Pending (in real time).

The screenshot displays the PKMES dashboard interface. The top navigation bar includes the PKMES logo, user profile, and language settings. The main menu on the left lists various modules: Dashboards, QCO, MES, Quality, Cutting Plan, WMS, HRM, Factory, Reports, Admin, Tools, and Help. The 'Dashboards' module is selected, and the 'Line Dashboard' is chosen from the sub-menu. The dashboard shows the following metrics:

Target (units)	Achieved (units)	Defect (units)	Pending (units)
188	139	0	49

The dashboard also includes a date selector (1) set to 24/03/2020 and a package selector (2) set to M_BCA-0040_1_BCA0075SMA001001_01_01. The data source is set to IoT Direct. The bottom status bar shows the factory (PZC1), line (LINE02), and package (M_BCA-0040_1_BCA0075SMA001001_01_01).

6. WMS

6.1 SUPER MARKET

6.2. WIP

Description: You can export MES Packages information at WIP

1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can see all the Package Group (AO No, Style Code, Style Size, Plan Start, Plan Finish...)
5. You can choose a line MES Package to export excel
6. Press Excel button to export data.

Work In Process

Dates: (1) 2019/09/20 - 2019/10/10

Factory: (2) PKS2-C

Buyer:

Style Info: (3)

Search

(4)

Package Group	Factory	AO No	Style Code	Style Size	Color	Rev No	Target	Completed	Status	Plan Start	Plan Finish
P2C1-1909-000000018	P2C1	AD-LLM-0146	LLM0364	MDI	001	001	1000	0	RO	2019-09-20	2019-09-21
P2C1-1909-000000023	P2C1	AD-OSP-0307	OSP0284	SMA	004	001	750	0	RO	2019-09-20	2019-09-21

Page 1 of 1

View 1 - 2 of 2

MES Line	Completed Qty (5)	Target Qty	MES P. Packages	Actual Start Plan
LINE 8A	0	600	M_LLM-0146_1_LLM0364MDI001001_01_01	
LINE 8A	0	400	M_LLM-0146_1_LLM0364MDI001001_01_02	
Total	0	1000		

Work In Process

Assembly	Factory	Module Name	ModuleId	Target	ModuleId	Total Made	Balance	Shipped

Activate Windows
Go to Settings to activate Windows

Excel (6)

6.3 FINISHED GOODS