PK MES– FACTORY MODULE

MANUAL 1.6

PKERP
PUNGKOOK | VN

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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/

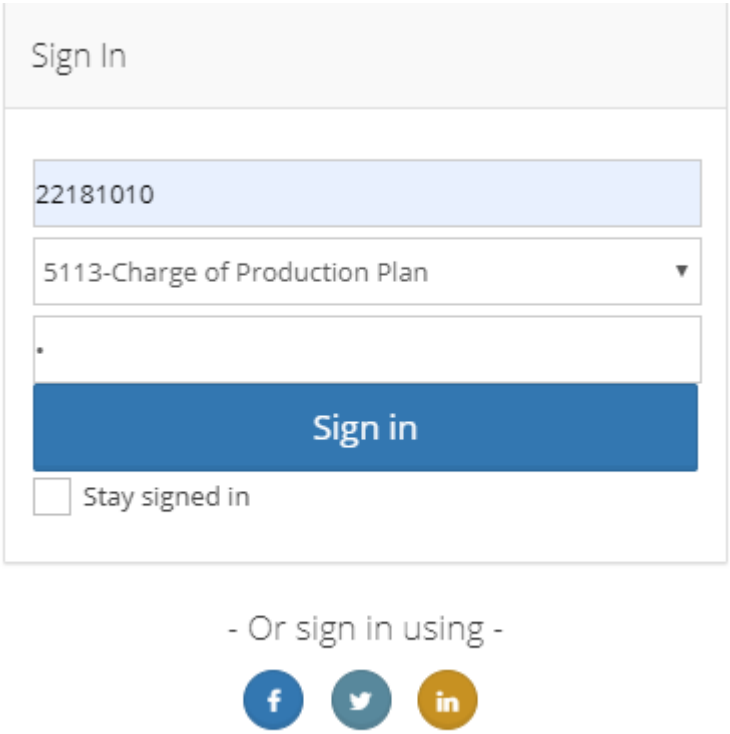
Subang: http://mespkis.pungkookvn.com:8080/

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.



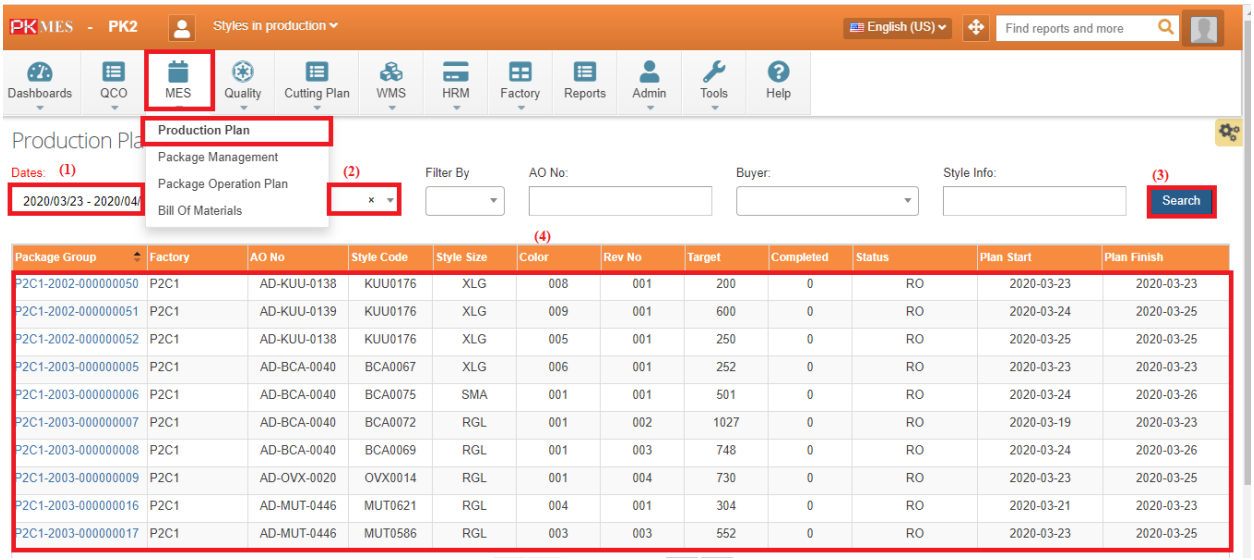
2. MES

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…)

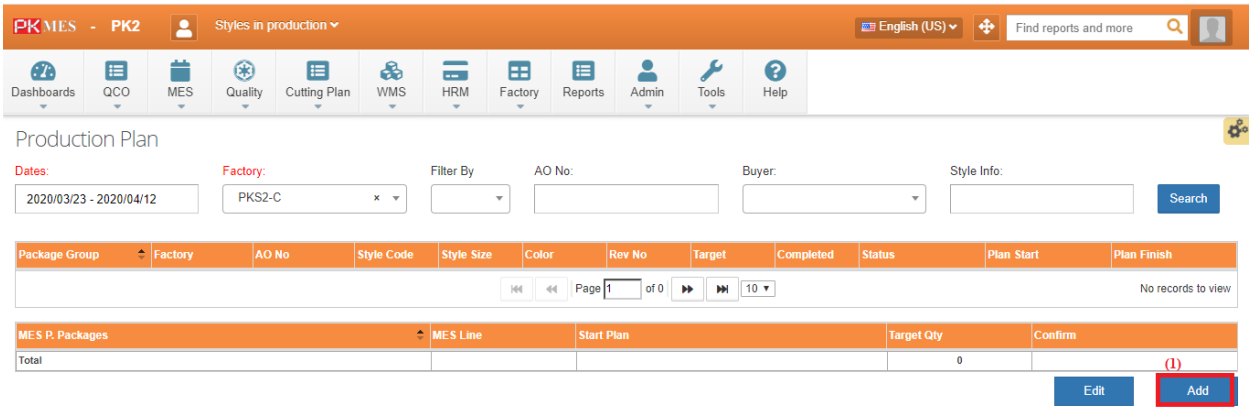


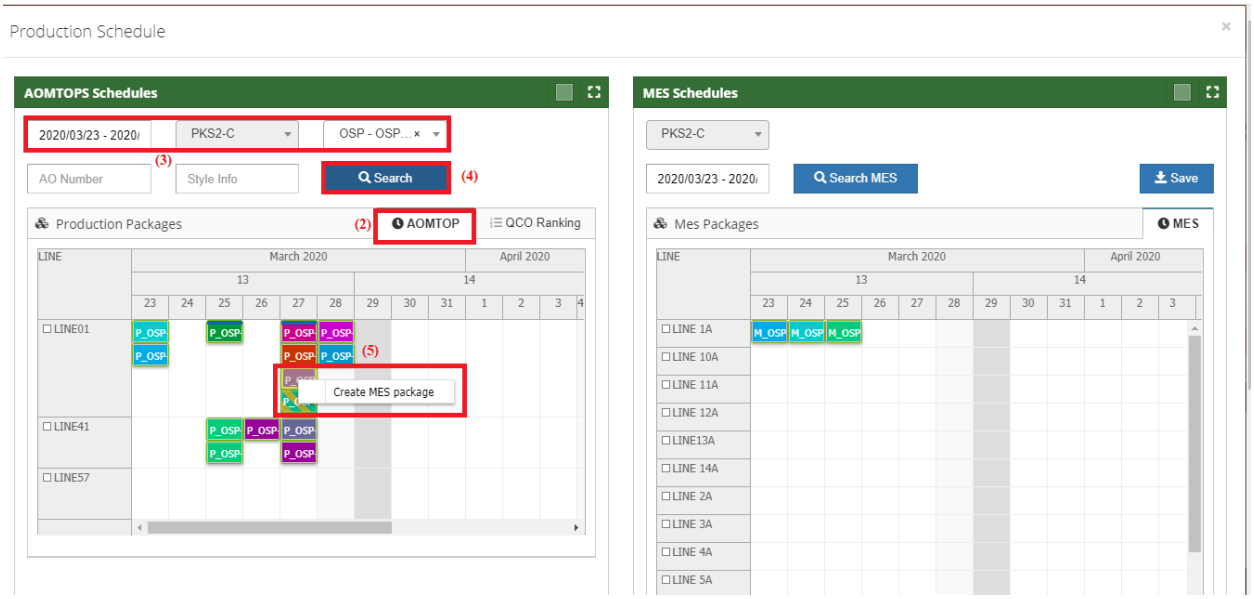
❖ ADD PACKAGE GROUP (MES –MPS)

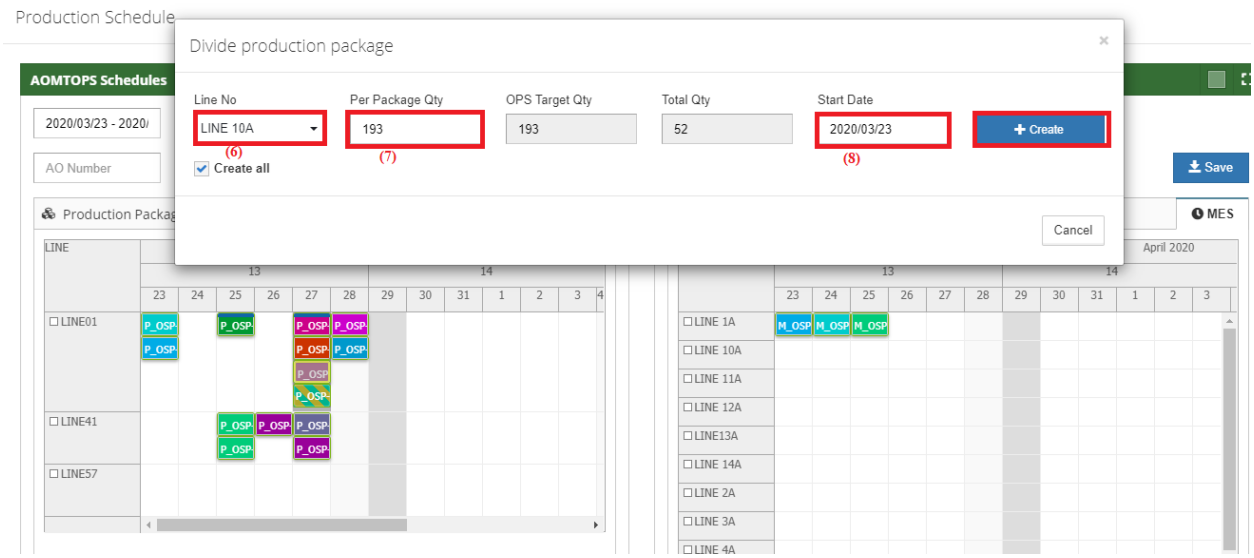
1. ADD: Add new Package group in Package Plan
2. AOMTOP: Choose module AOMTOP to the system get data from AOMTOP
3. Choose date, factory, buyer which you need to create MES PP
4. Search: Press SEARCH button to show data
5. You can see all the Production Packages. You will choose one or more PP which 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.

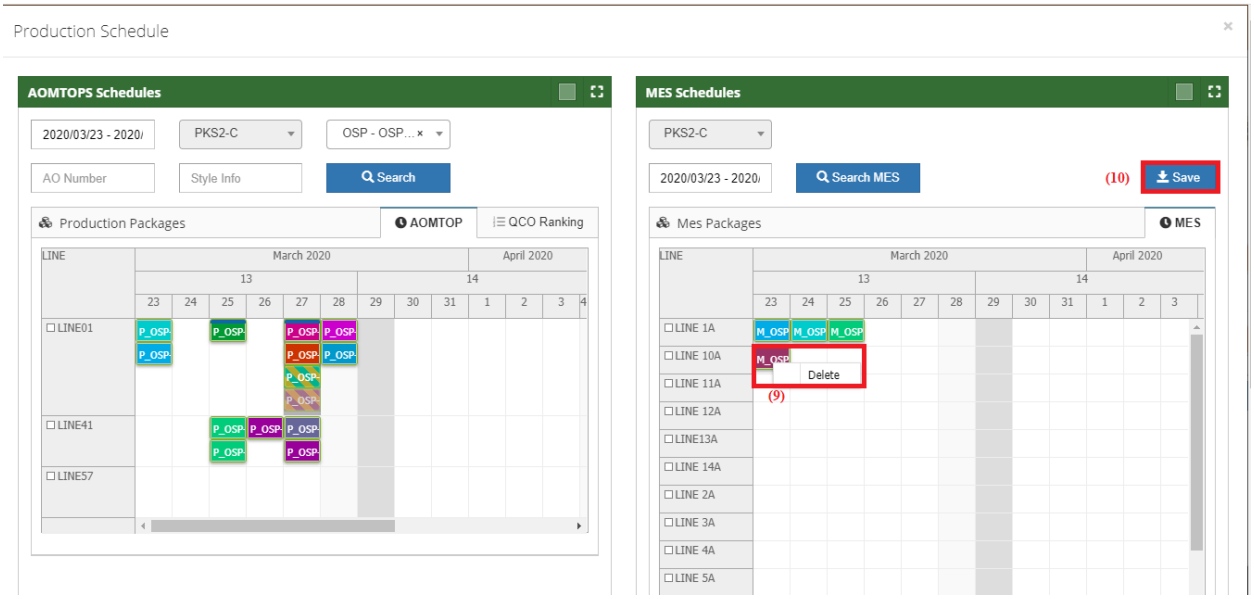
Note: ***If you want to delete any production packages, you can choose the PP at MES package and right click => delete => choose delete => save.***

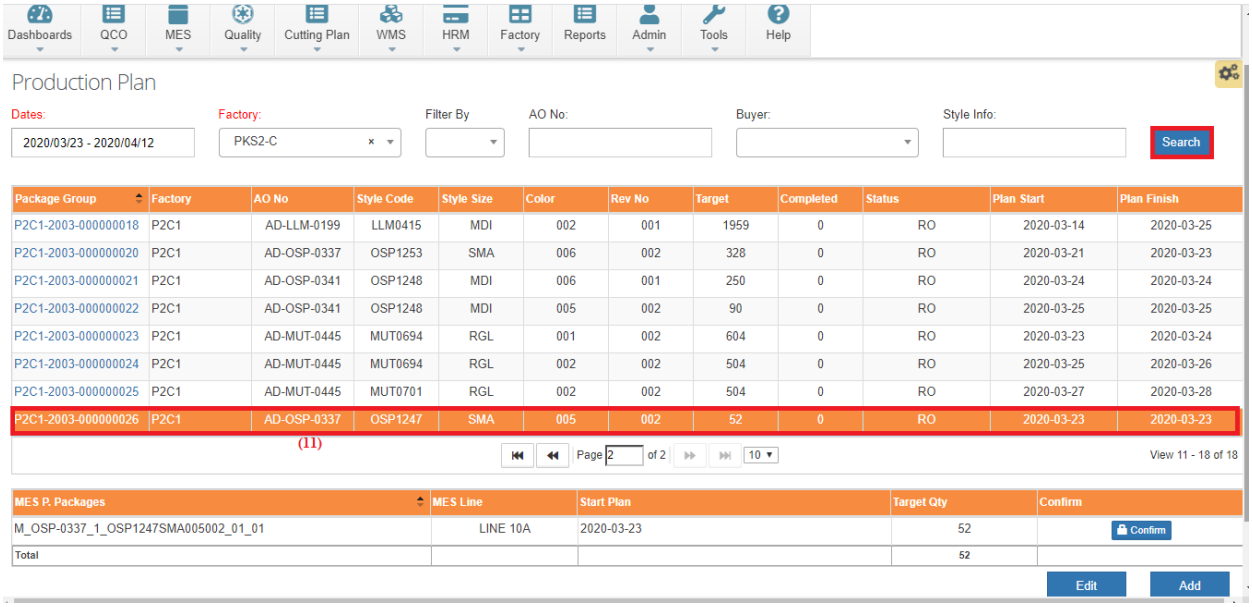
Please view detail steps in bellow pictures




Production Schedule
AOMTOPS Schedules
2020/03/23 - 2020/
PKS2-C
OSP - OSP... ×
(3)
AO Number
Style Info
Search
(4)
Production Packages
(2)
AOMTOP
QCO Ranking
LINE
March 2020
April 2020
13
14
23 24 25 26 27 28 29 30 31 1 2 3 4
LINE01
LINE41
LINE57
P_OSP
(5)
Create MES package
MES Schedules
PKS2-C
2020/03/23 - 2020/
Search MES
Save
Mes Packages
MES
LINE 1A
LINE 10A
LINE 11A
LINE 12A
LINE13A
LINE 14A
LINE 2A
LINE 3A
LINE 4A
LINE 5A
M_OSP

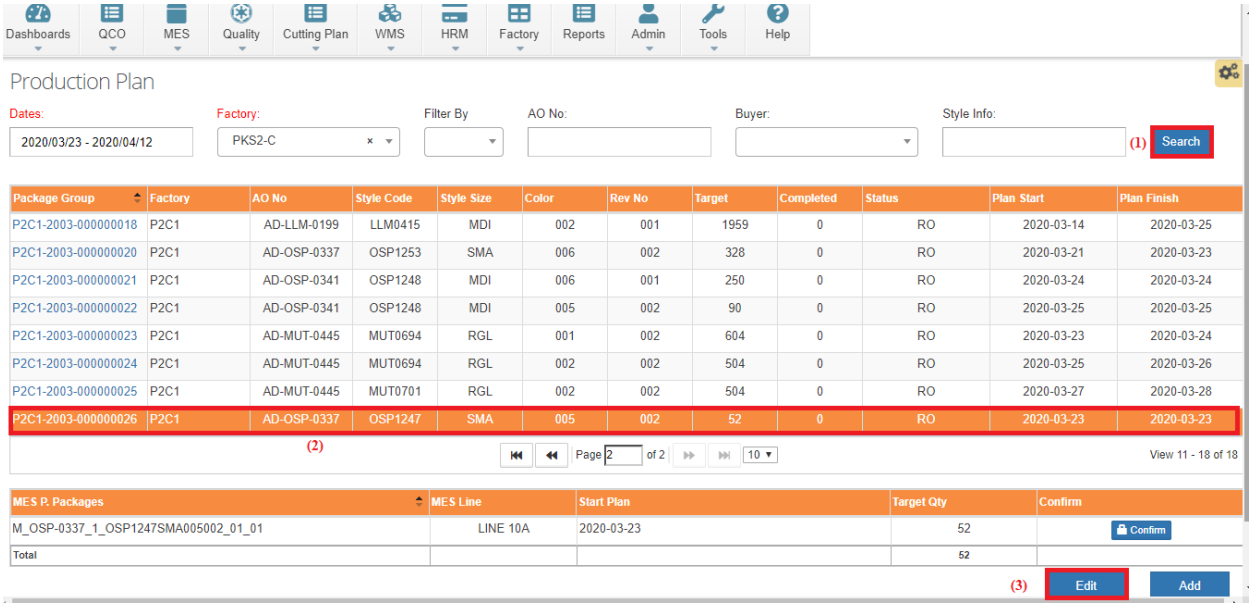

Production Schedule
Divide production package
Line No
LINE 10A
(6)
Create all
Per Package Qty
193
(7)
OPS Target Qty
193
Total Qty
52
Start Date
2020/03/23
(8)
Create
Cancel
AOMTOPS Schedules
Save
MES
LINE01
LINE41
LINE57
LINE 1A
LINE 10A
LINE 11A
LINE 12A
LINE13A
LINE 14A
LINE 2A
LINE 3A
LINE 4A

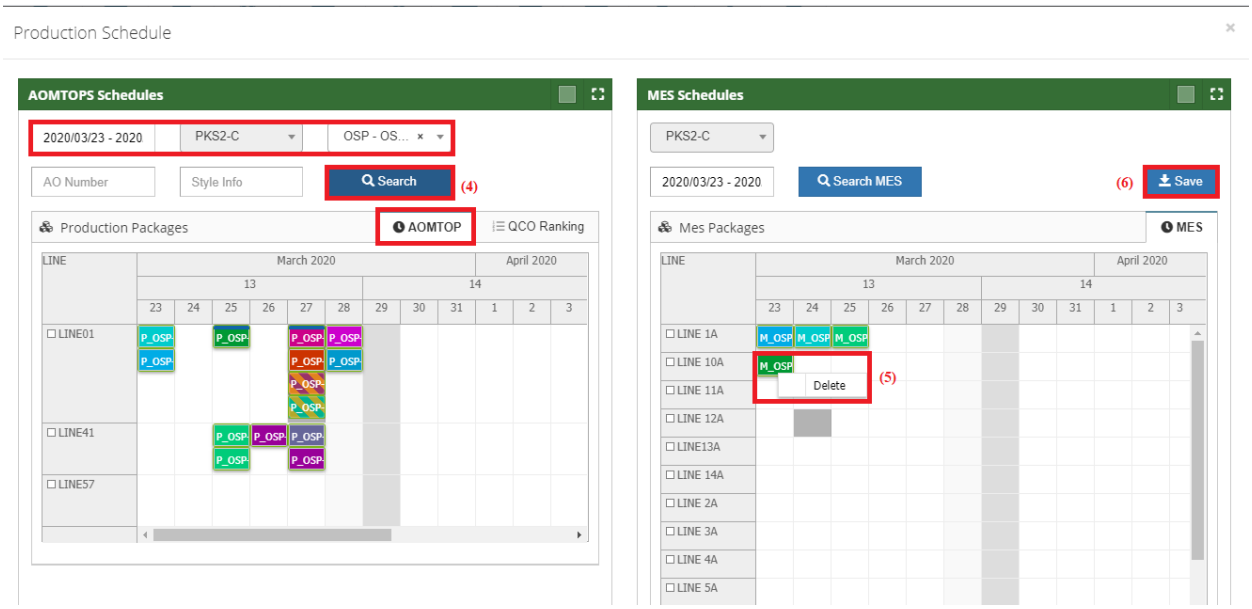

Production Schedule
AOMTOPS Schedules
2020/03/23 - 2020/
PKS2-C
OSP - OSP... ×
AO Number
Style Info
Search
Production Packages
AOMTOP
QCO Ranking
LINE
March 2020
April 2020
LINE01
LINE41
LINE57
P_OSP
MES Schedules
PKS2-C
2020/03/23 - 2020/
Search MES
(10)
Save
Mes Packages
MES
LINE 1A
LINE 10A
LINE 11A
LINE 12A
LINE13A
LINE 14A
LINE 2A
LINE 3A
LINE 4A
LINE 5A
M_OSP
Delete
(9)


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:
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
(11)
Page 2 of 2
10
View 11 - 18 of 18
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
Edit
Add

❖ 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.



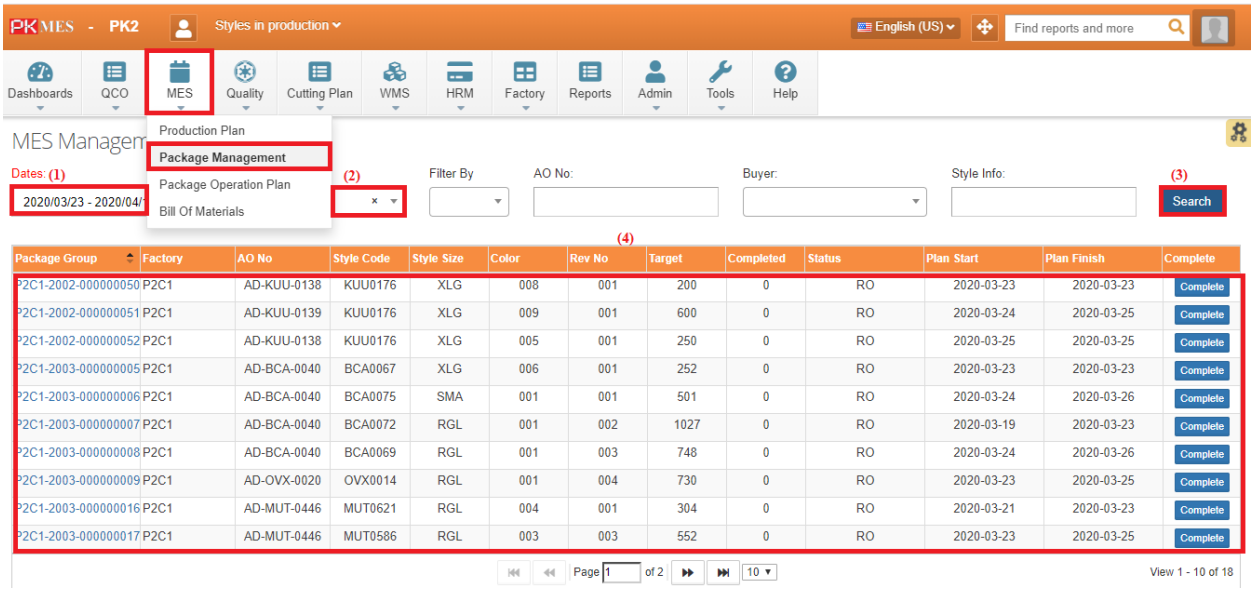


2.2. PACKAGE MANAGEMENT

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

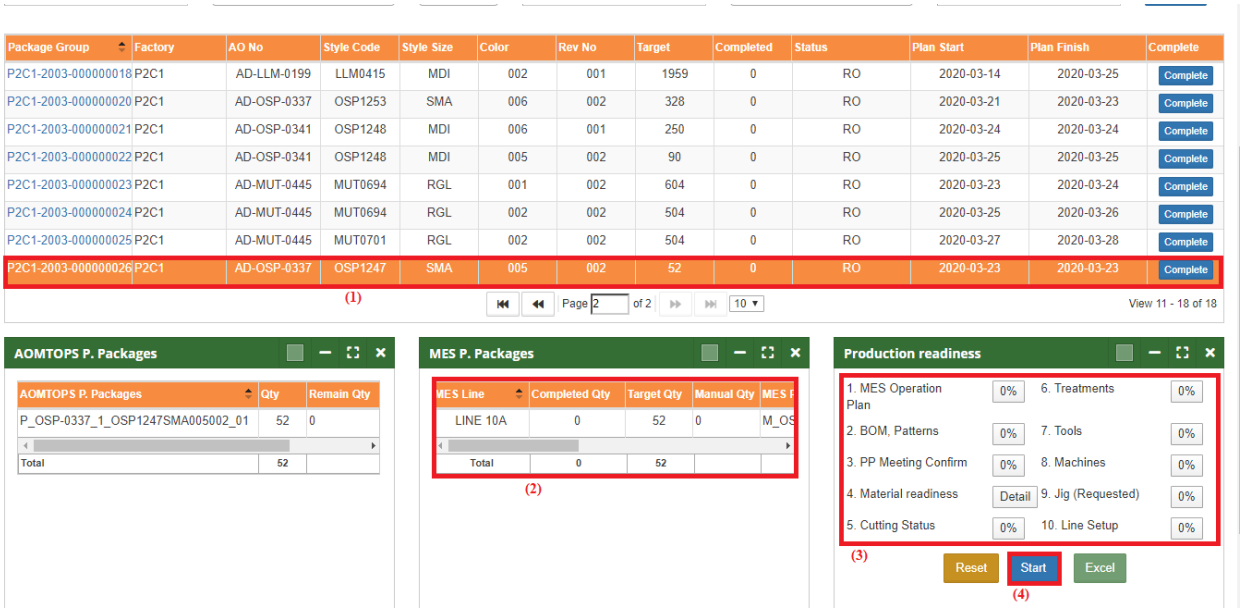
❖ SEARCH PACKAGE GROUP

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…)



❖ 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'



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
BSTMBL0000023	THREAD NYLON BONDED IBN 280D 3PLY BLACK M-30	001 - BLACK	7500	0	0	7500	3750	0	0	0	0
BSTMBL0000024	THREAD NYLON BONDED IBN 210D 3PLY BLACK M-40	001 - BLACK	10500	10000	10000	0	0	500	150	0	0
FABMBL0000040	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
FABMBL0000052	NY6 210d OXFORD PU20g 58" W/STICKER	003 - BLACK	0.3	0.3	0.3	0	0	0	0	0	0
FOMMBL0000044	FOAM PE HD 0.5mm	020 - WHITE (5x5)CM	750	0	0	500	250	250	75	0	0
LBLMBL0000006	STICKER MONTBLANC	001 - WHITE	18	0	0	0	0	0	0	0	0
LTRMBL0000002	REAL COW 1.2"1.3mmTHICK ART SIRIA	001 - BLACK	25.05	25.05	25.05	0	0	0	0	0	0
MTLMBL0000018	LOGO - 1031462 CENTERING DISK FOR LEATHER	001 - NICKEL	750	750	750	0	0	0	0	0	0
MTLMBL0000019	LOGO - 1099321 DISK FOR RU Ø6,6MM POL	001 - BLACK NICKEL	750	750	750	0	0	0	0	0	0
MTLMBL0000025	PULLER W11mm H40mm MB T4.3mm ANTI SLIP	001 - MATTE BLACK	765	765	765	0	0	0	0	0	0
PSTMBL0000034	PLASTIC LOGO 1028768 WITH PIN Ø6,5MM C	001 - BLACK	750	750	750	0	0	0	0	0	0
WEBMBL0000013	POLY WEBBING 19mm -3/4in LIGHTWEIGHT GROSGRAIN W-13101-01	012 - BLACK-001-P0382	585	[06-12-19][2]: CREATE ITEMCODE REQUEST	[06-12-19][2]: CREATE ITEMCODE REQUEST	0	0	0	0	0	0
ZPRMBL0000004	CHAIN NYLON #3 W24mm P12 3 CF DYED HANK YKK	001 - 580	183.6	183.6	183.6	0	0	0	0	0	0
ZPRMBL0000017	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

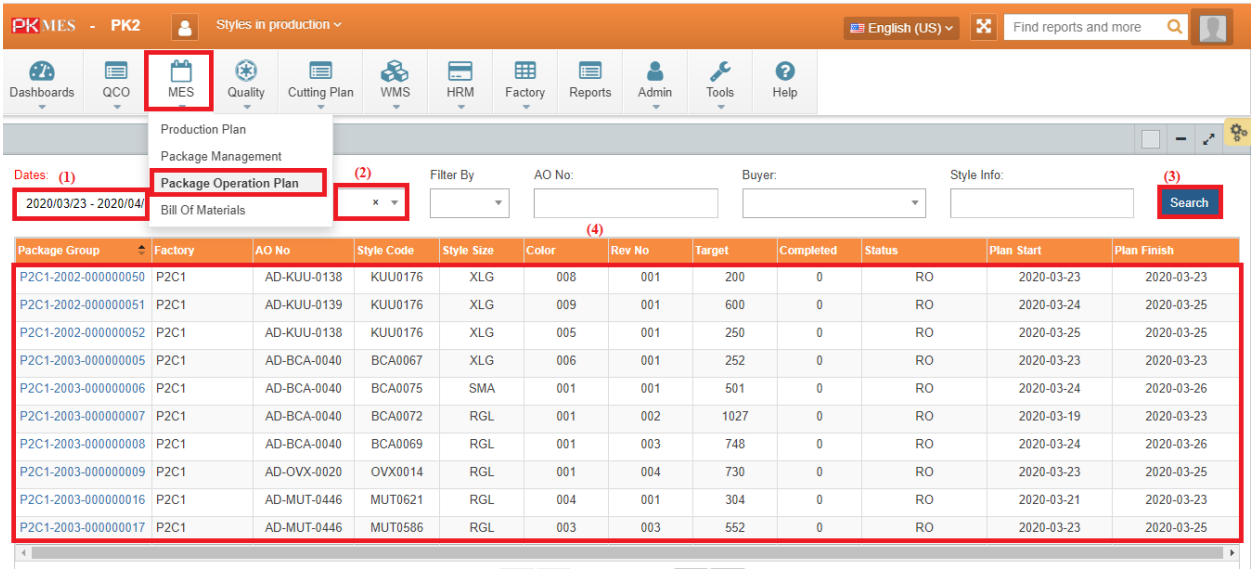
Material Readiness Formula Detail		
(1) Total Request Quantity	=SUM(D3:D17)	23,398.95
(2) Total WMS Quantity	=SUM(F3:F17)	13,991.20
(3) Total ETA within 5 days	=SUM(G3:G17)	4,000.00
(4) Total ETA within 10 days	=SUM(H3:H17)	225.00
(5) Total ETA > Package Start Date	=SUM(I3:I17)	5.48
6. Material Readiness = [(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.

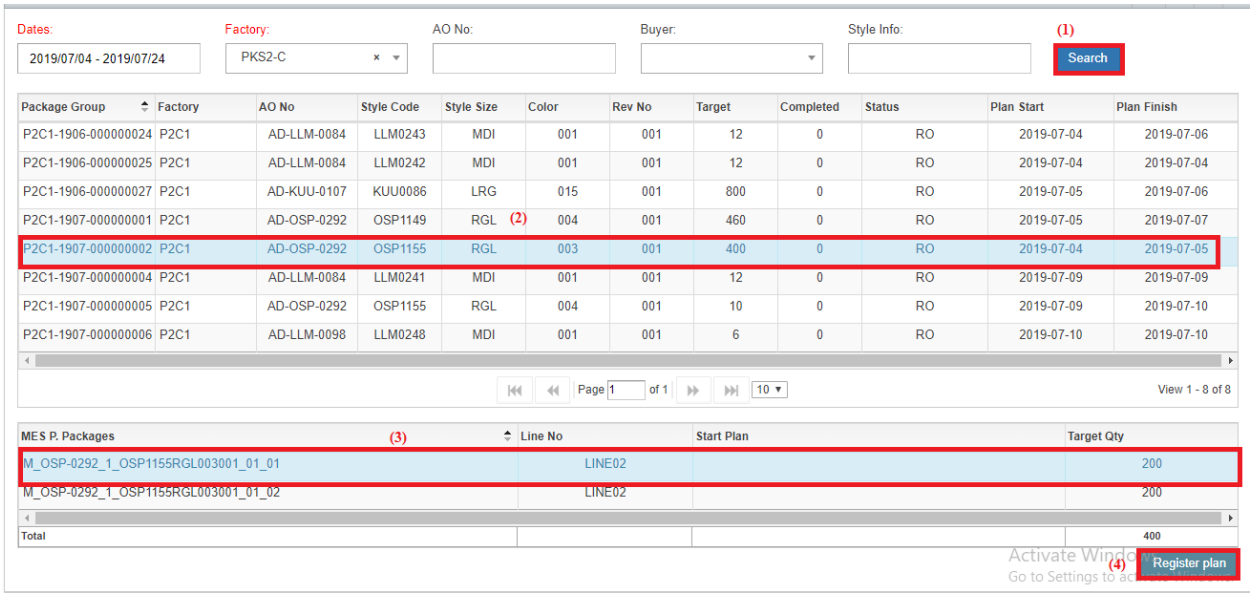
❖ SEARCH PACKAGE GROUP

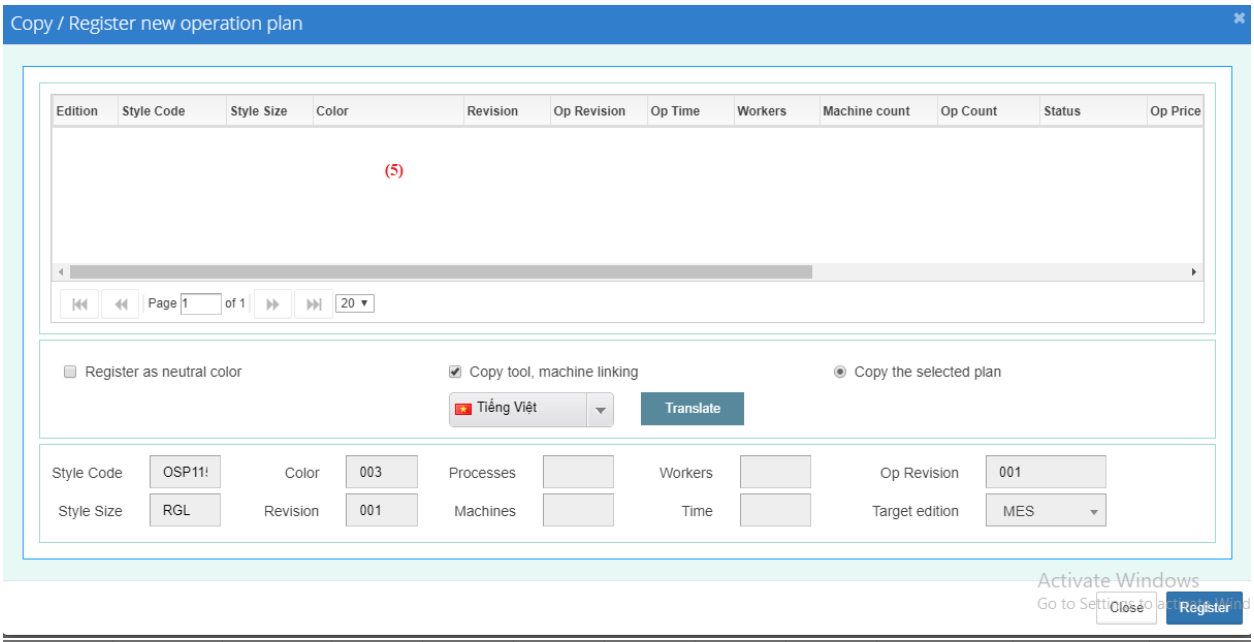
1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can see all the Package Group (AO No, Style Code, Style Size, Plan Start, Plan Finish…)

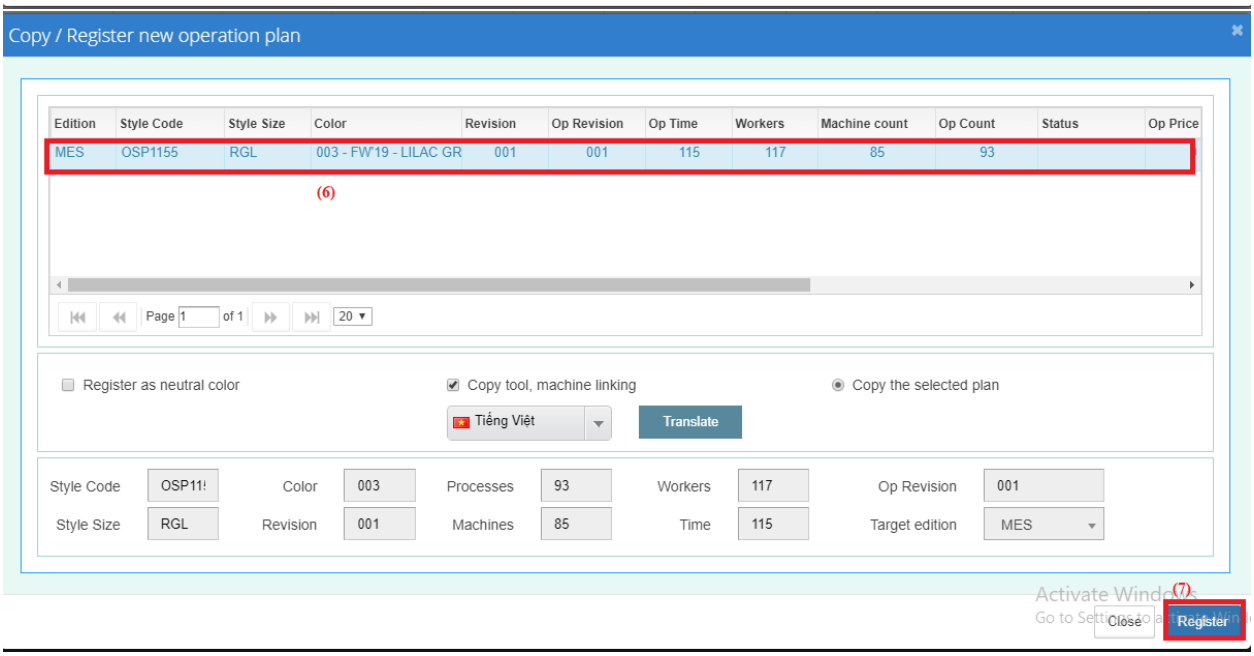


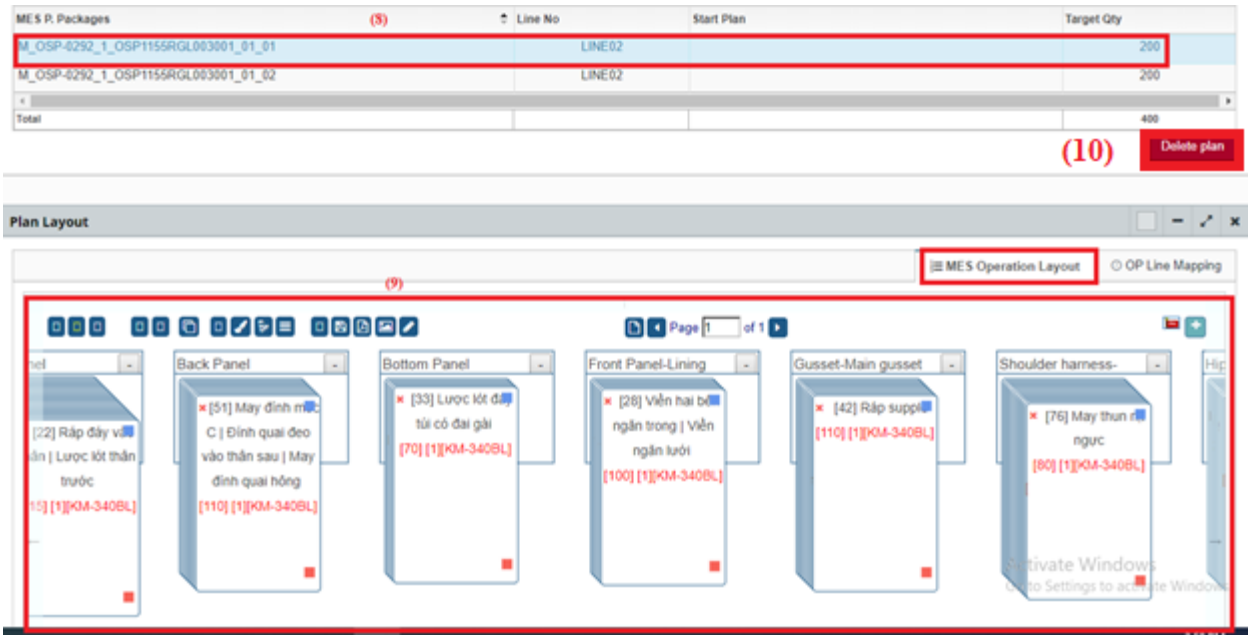
❖ REGISTERING PLAN FOR PACKAGE

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.




Copy / Register new operation 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
20
Register as neutral color
Copy tool, machine linking
Copy the selected plan
Tiếng Việt
Translate
Style Code
OSP11!
Color
003
Processes
Workers
Op Revision
001
Style Size
RGL
Revision
001
Machines
Time
Target edition
MES
Activate Windows
Close
Register

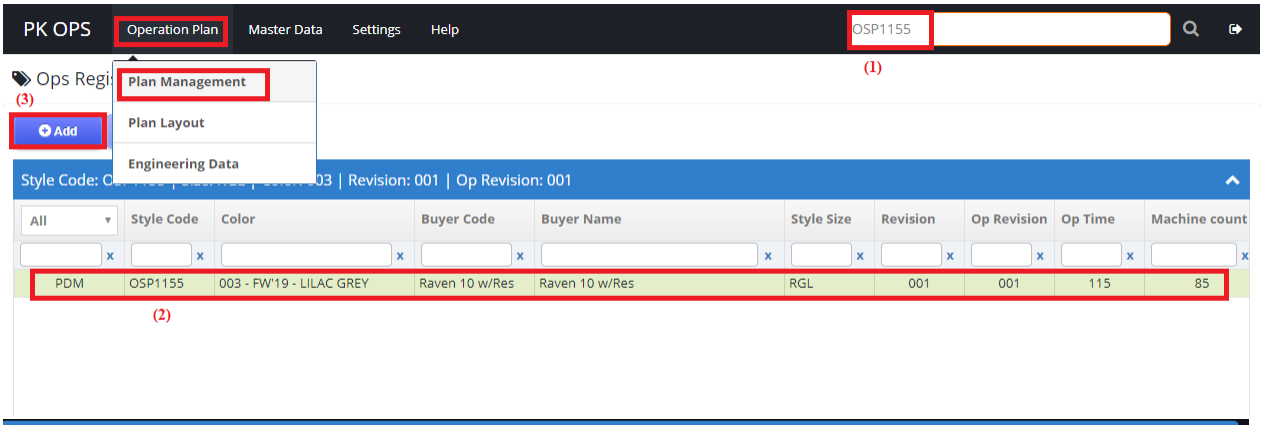

Copy / Register new operation plan
Edition
Style Code
Style Size
Color
Revision
Op Revision
Op Time
Workers
Machine count
Op Count
Status
Op Price
MES
OSP1155
RGL
003 - FW'19 - LILAC GR
001
001
115
117
85
93
(6)
Page 1 of 1
20
Register as neutral color
Copy tool, machine linking
Copy the selected plan
Tiếng Việt
Translate
Style Code
OSP11!
Color
003
Processes
93
Workers
117
Op Revision
001
Style Size
RGL
Revision
001
Machines
85
Time
115
Target edition
MES
(7)
Activate Windows
Close
Register

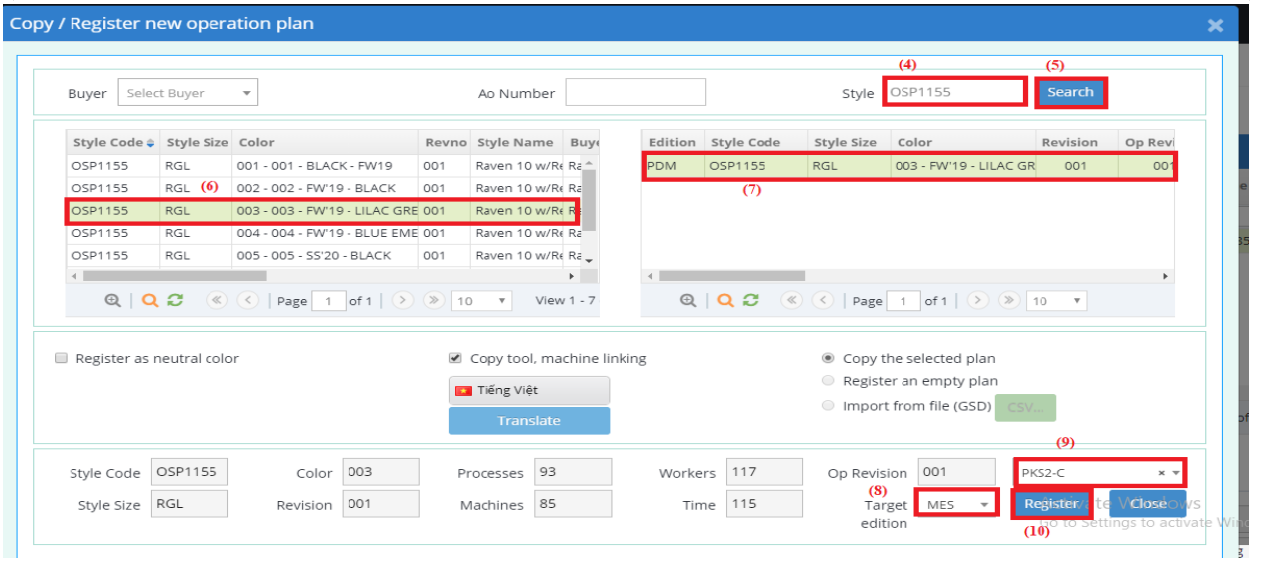

MES P. Packages
(8)
Line No
Start Plan
Target Qty
M_OSP-0292_1_OSP1155RGL003001_01_01
LINE02
200
M_OSP-0292_1_OSP1155RGL003001_01_02
LINE02
200
Total
400
(10)
Delete plan
Plan Layout
MES Operation Layout
OP Line Mapping
(9)
Page 1 of 1
Back Panel
Bottom Panel
Front Panel-Lining
Gusset-Main gusset
Shoulder harness-
[51] May đính mặt C | Đính quai đeo vào thân sau | May đính quai hông
[110] [1][KM-340BL]
[33] Lược lót đáy túi có đai gài
[70] [1][KM-340BL]
[28] Viền hai bên ngăn trong | Viền ngăn lưới
[100] [1][KM-340BL]
[42] Ráp suppl
[110] [1][KM-340BL]
[76] May thun mặt ngực
[80] [1][KM-340BL]

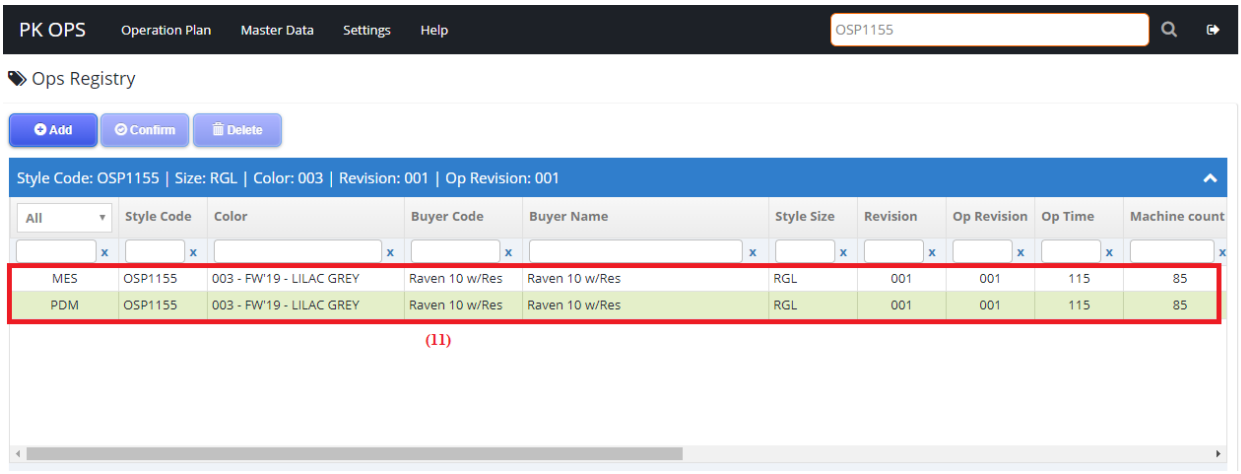
Copy/Register new MES Operation Plan on OPS system

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.

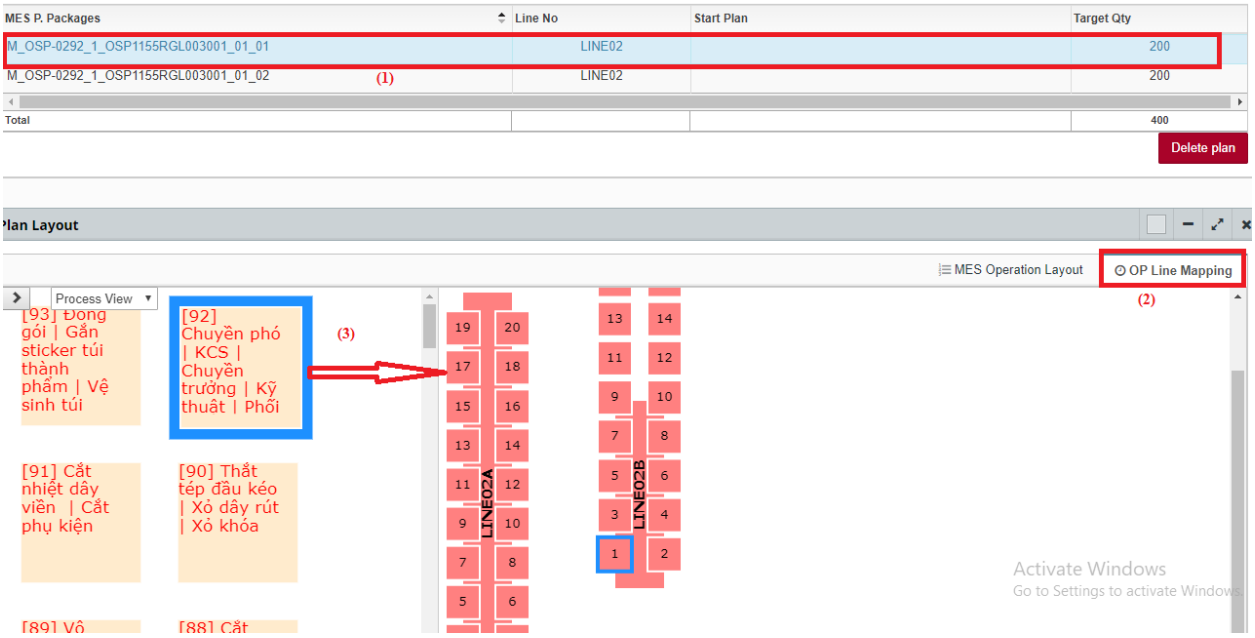






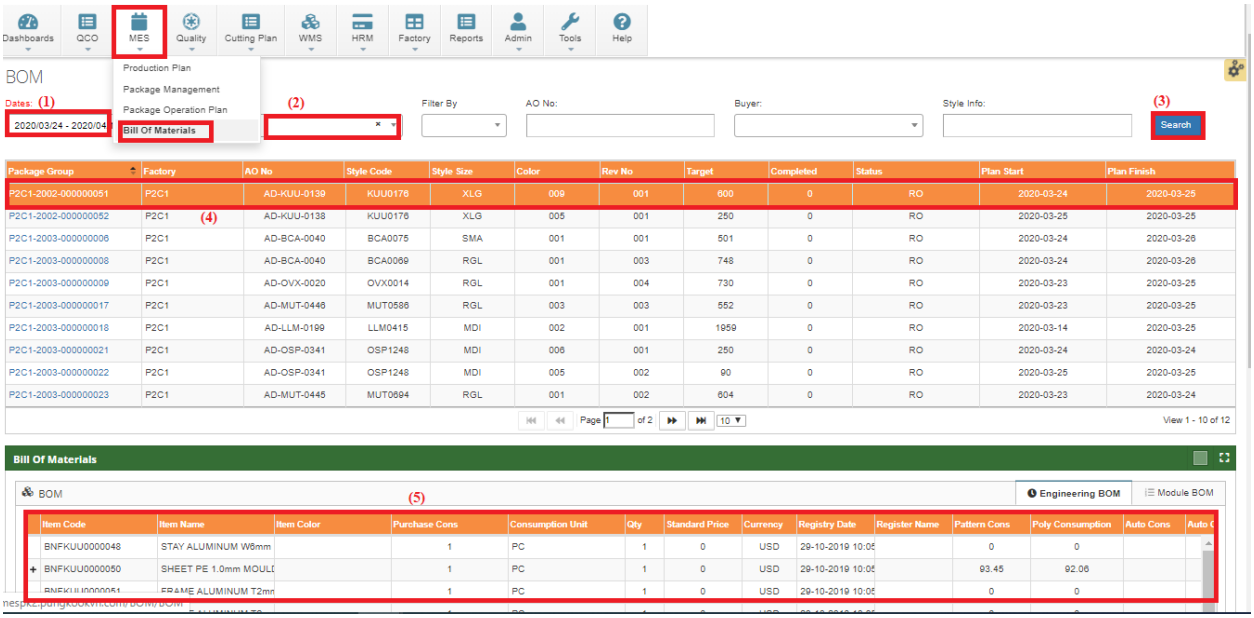
❖ OP LINE MAPPING (PACKAGE OPERATION PLAN)

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).



2.4. BILL OF MATERIALS

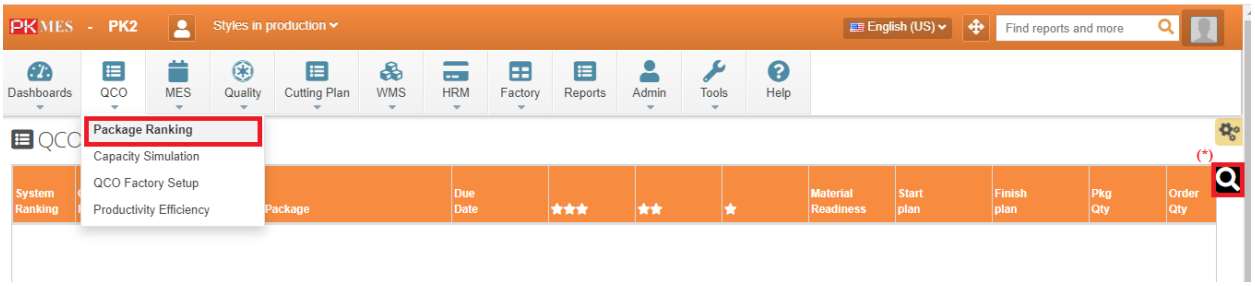
1. Date: Choose date the Package Group to view data
2. Factory : Choose the Factory need to view data
3. Search: Press SEARCH button to show data
4. You can choose one Package Group to view BOM
5. You can see all of materials belong a Package Group.



3. QCO

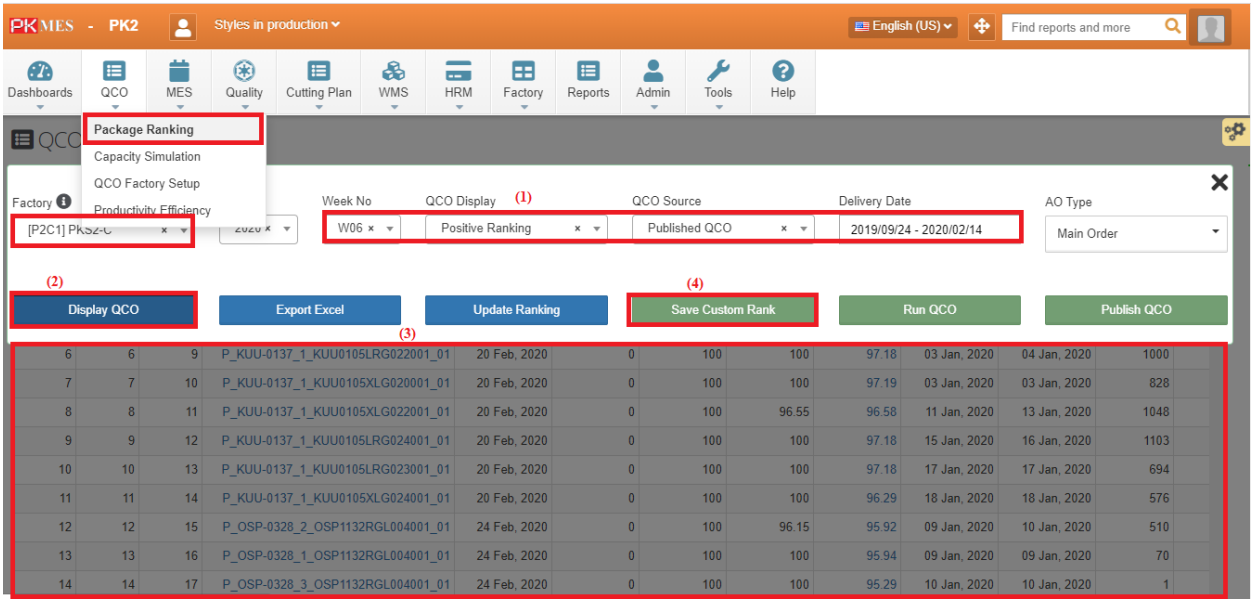
3.1. PACKAGE RANKING

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



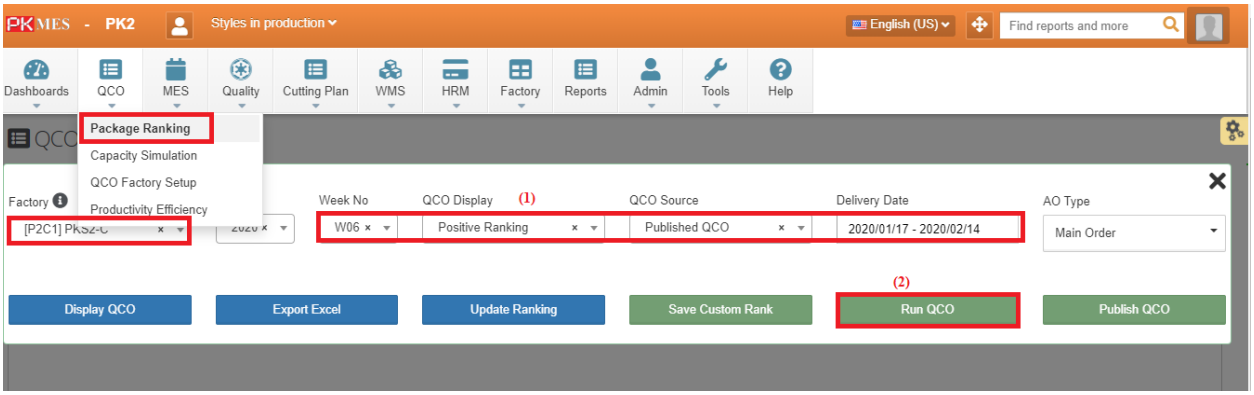
❖ DISPLAY QCO

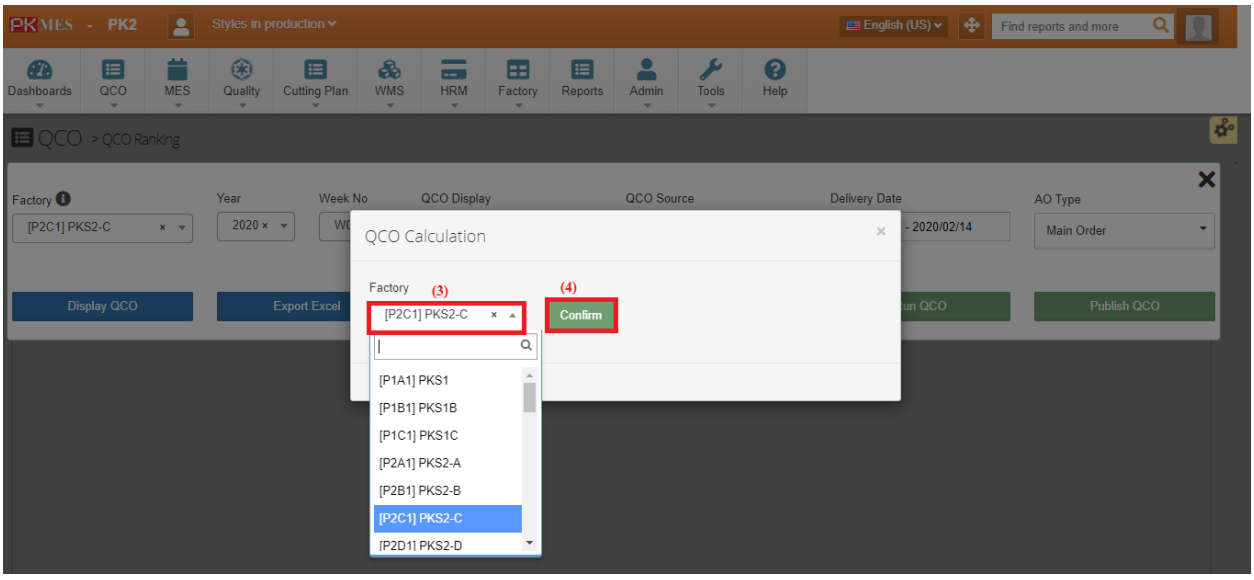
1. Choose Factory, Year, Week no, QCO Source which you need to find
2. Press Display QCO button to show data
3. You can see all the data Package ID in here
4. Save Custom Rank when you have to change.

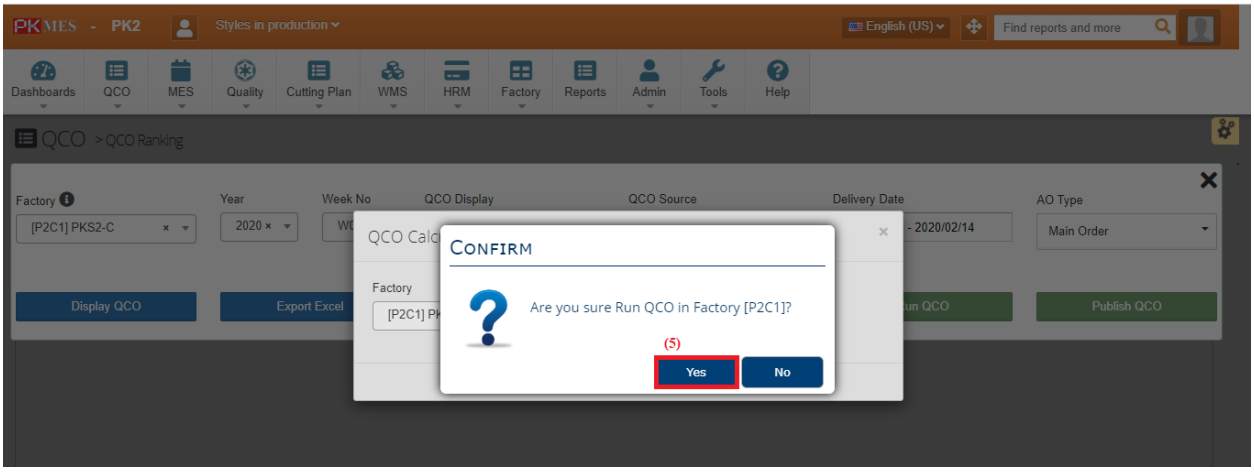


❖ RUN QCO

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.

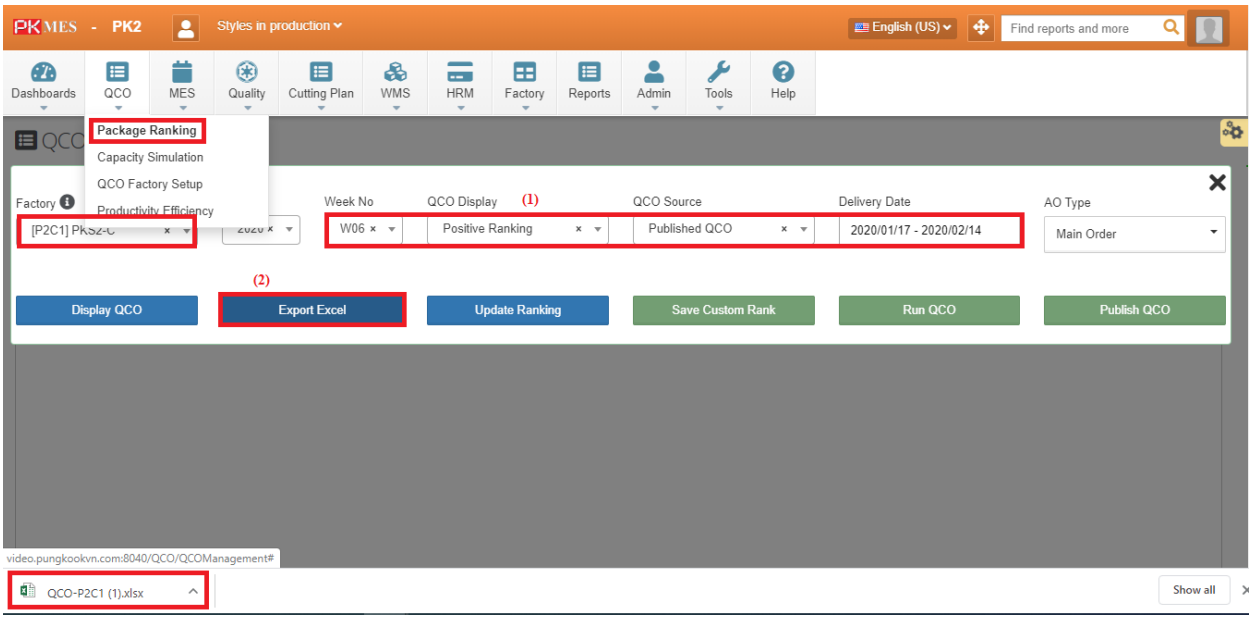


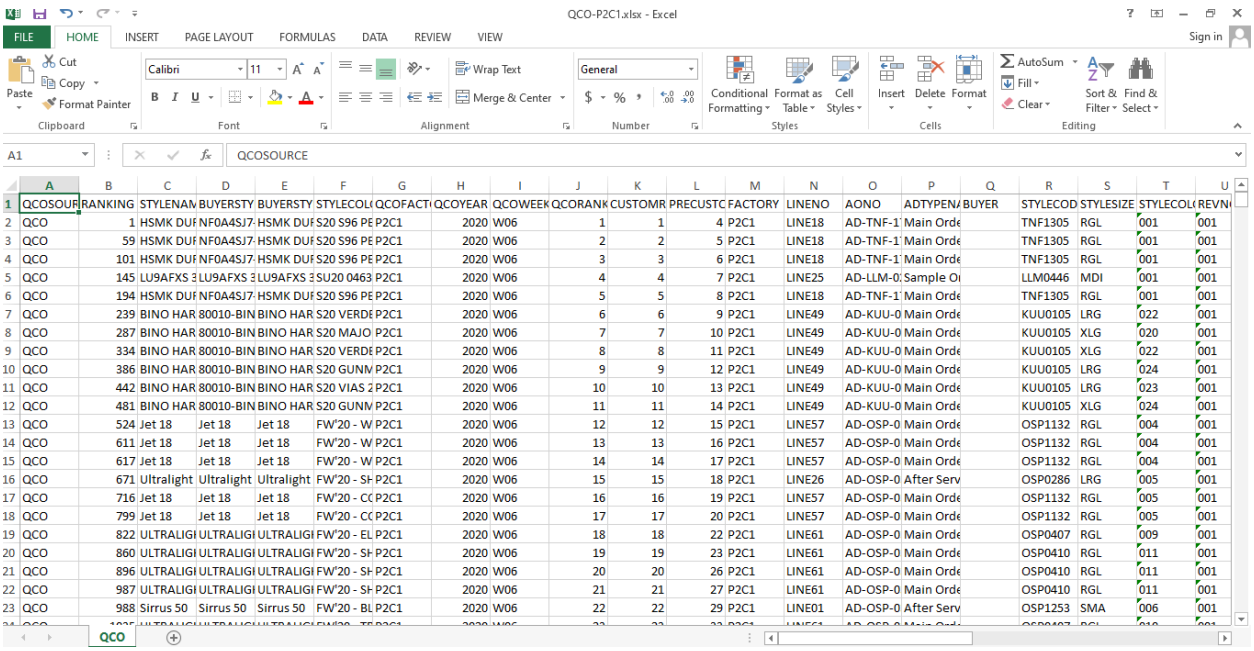




❖ EXPORT EXCEL

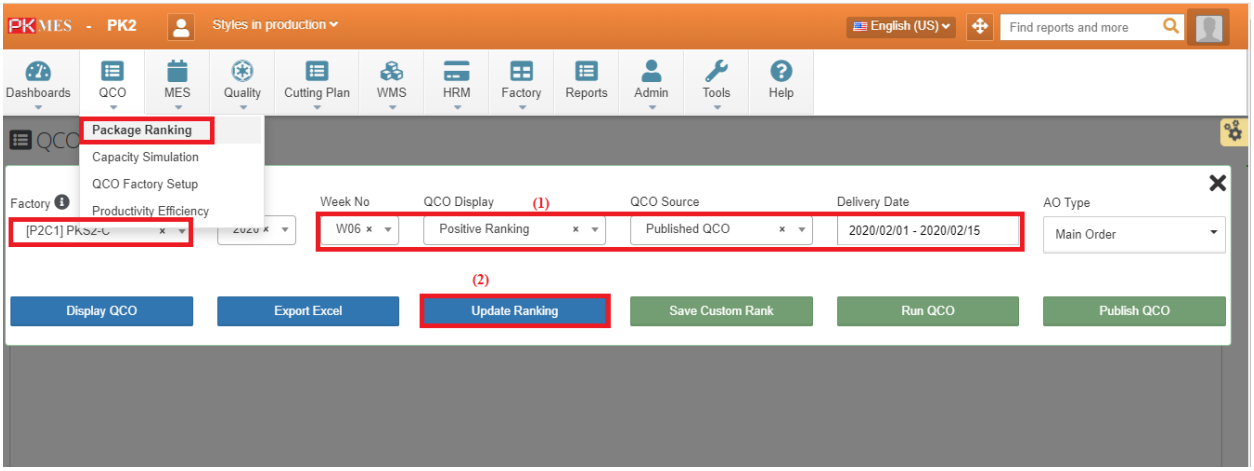
1. Choose Factory, Year, Week no, QCO Source which you need to find
2. Press Export Excel button to export data.

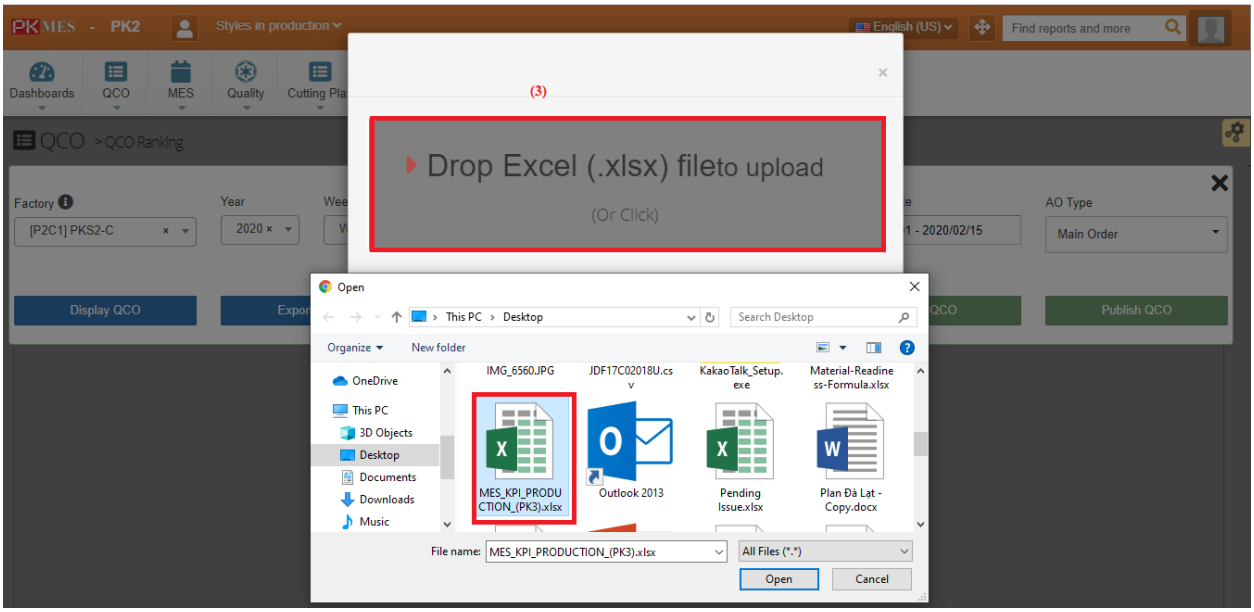


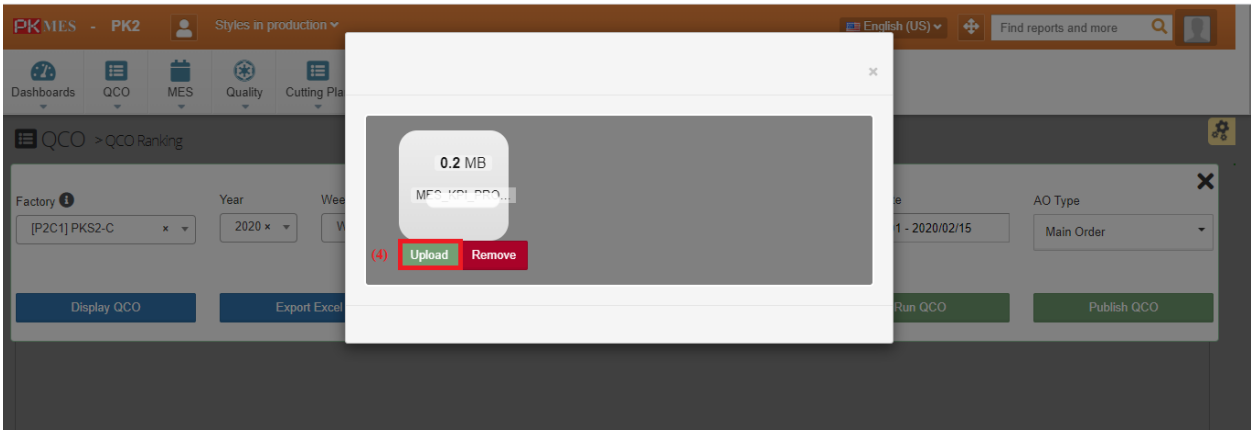


❖ UPDATE RANKING

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.

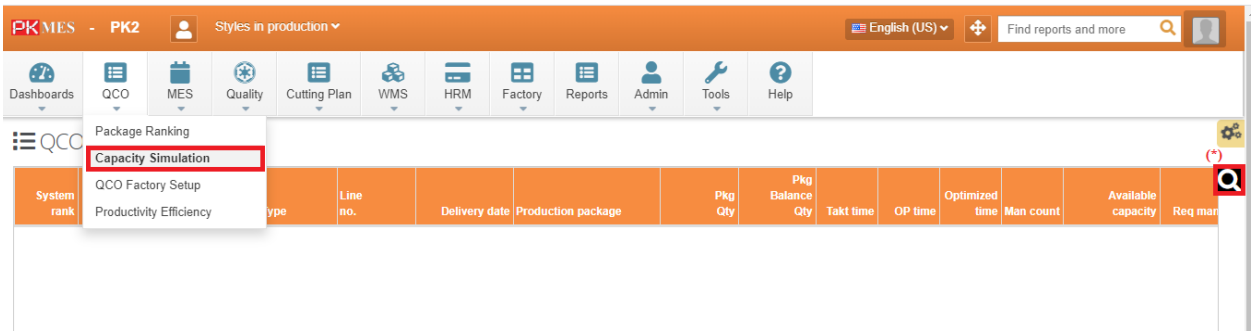



PK MES - PK2
Styles in production
English (US)
Find reports and more
Dashboards
QCO
MES
Quality
Cutting Pla
QCO > QCO Ranking
Factory
[P2C1] PKS2-C
Year
2020
AO Type
Main Order
Display QCO
Publish QCO
(3)
Drop Excel (.xlsx) fileto upload
(Or Click)
Open
This PC > Desktop
Search Desktop
Organize
New folder
OneDrive
This PC
3D Objects
Desktop
Documents
Downloads
Music
IMG_6560.JPG
JDF17C02018U.csv
KakaoTalk_Setup.exe
Material-Readiness-Formula.xlsx
MES_KPI_PRODUCTION_(PK3).xlsx
Outlook 2013
Pending Issue.xlsx
Plan Đà Lạt - Copy.docx
File name: MES_KPI_PRODUCTION_(PK3).xlsx
All Files (*.*)
Open
Cancel


PK MES - PK2
Styles in production
English (US)
Find reports and more
Dashboards
QCO
MES
Quality
Cutting Pla
QCO > QCO Ranking
Factory
[P2C1] PKS2-C
Year
2020
AO Type
Main Order
Display QCO
Export Excel
Run QCO
Publish QCO
0.2 MB
(4)
Upload
Remove

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)

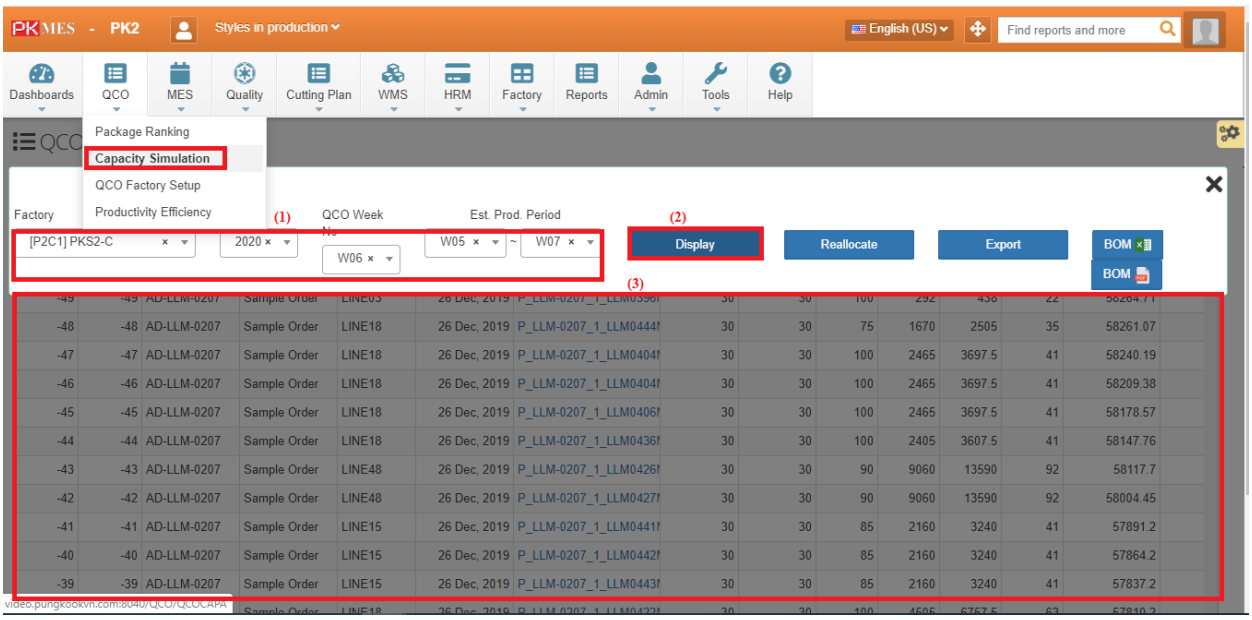
Required capacity for a production package = Package Qty * (Optime + (Optime *(2- 2 *Efficiency Factor)))

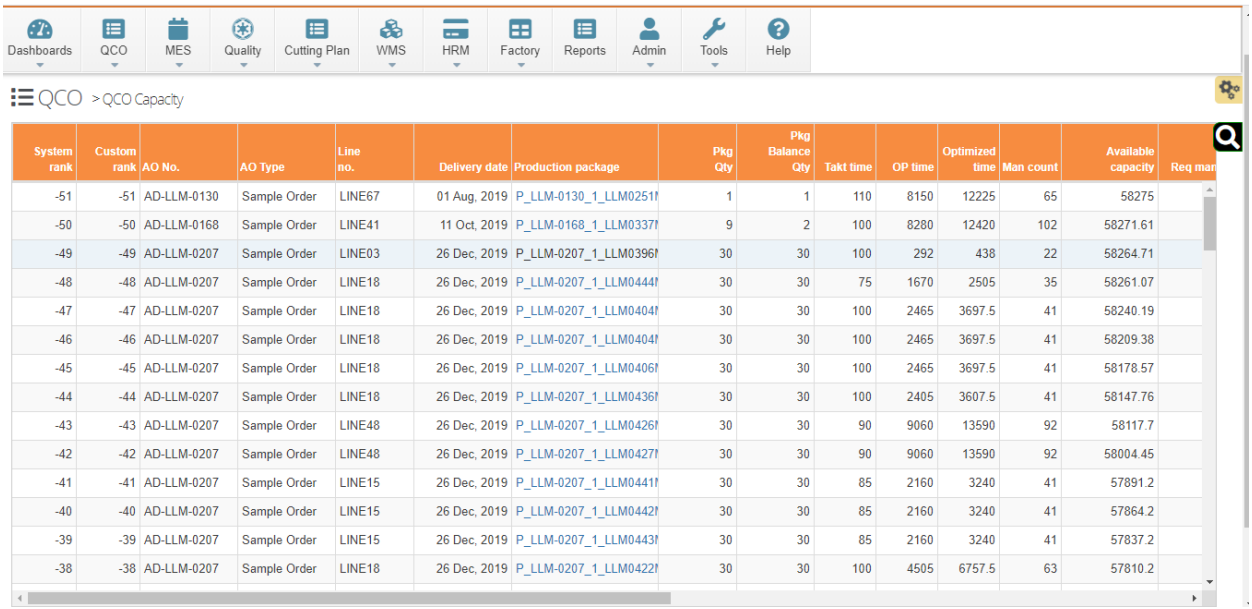
Efficiency Factor is defined through Factory->Efficiency Factor screen by factory, by week.

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 deducing 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.

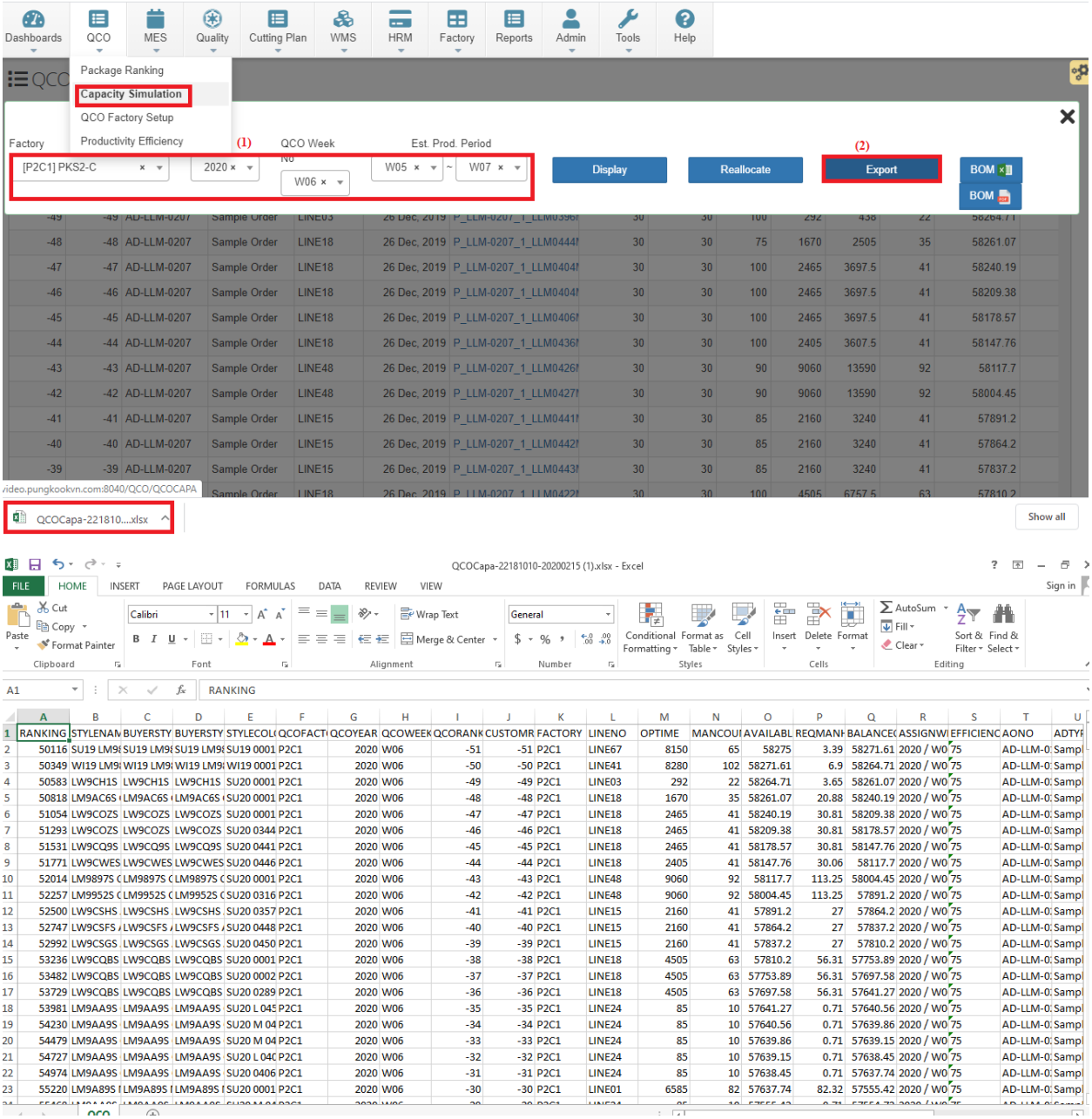




System rank	Custom rank	AO No.	AO Type	Line no.	Delivery date	Production package	Pkg Qty	Pkg Balance Qty	Takt time	OP time	Optimized time	Man count	Available capacity	Req man
-51	-51	AD-LLM-0130	Sample Order	LINE67	01 Aug, 2019	P_LLM-0130_1_LLM0251	1	1	110	8150	12225	65	58275	
-50	-50	AD-LLM-0168	Sample 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	

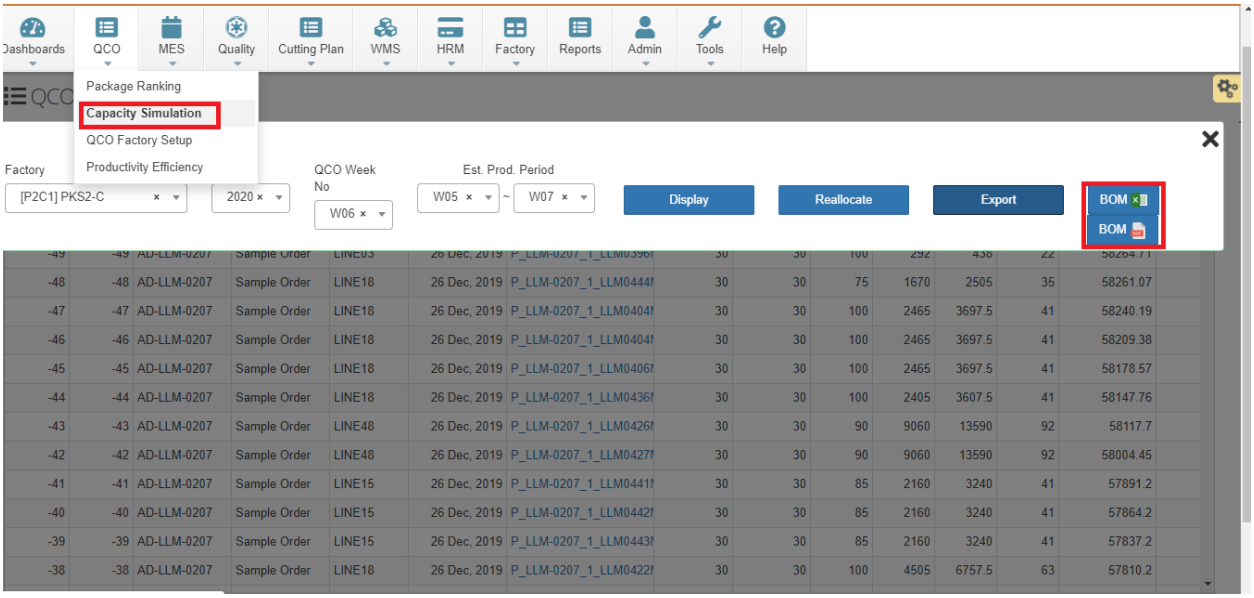
❖ EXPORT

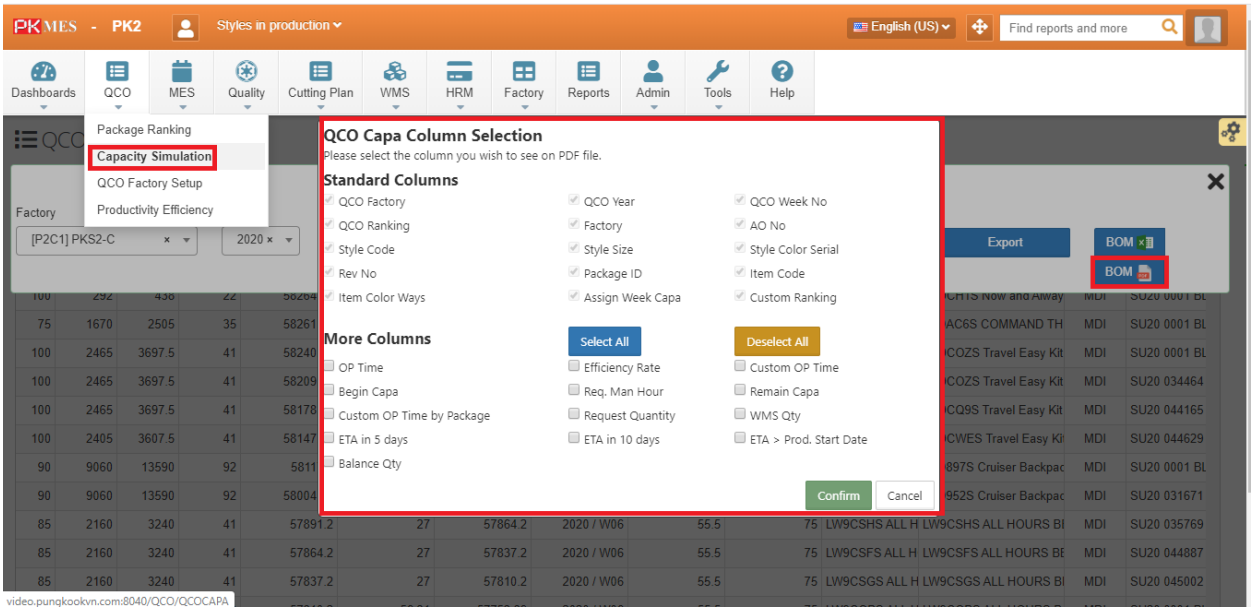
1. Choose Factory, Year, QCO Week No which you need to find
2. Press Excel button to export data.



RANKING	STYLENAM	BUYERSTY	BUYERSTY	STYLECOL	QCOFACT	QCOYEAR	QCOWEEK	QCORANK	CUSTOMR	FACTORY	LINENO	OPTIME	MANCOU	AVAILABL	REQMANH	BALANCE	ASSIGNW	EFFICIENC	AONO	ADTYP
50116	SU19 LM9	SU19 LM9	SU19 LM9	SU19 0001	P2C1	2020	W06	-51	-51	P2C1	LINE67	8150	65	58275	3.39	58271.61	2020 / W0	75	AD-LLM-0	Sampl
50349	WI19 LM9	WI19 LM9	WI19 LM9	WI19 0001	P2C1	2020	W06	-50	-50	P2C1	LINE41	8280	102	58271.61	6.9	58264.71	2020 / W0	75	AD-LLM-0	Sampl
50583	LW9CH1S	LW9CH1S	LW9CH1S	SU20 0001	P2C1	2020	W06	-49	-49	P2C1	LINE03	292	22	58264.71	3.65	58261.07	2020 / W0	75	AD-LLM-0	Sampl
50818	LM9AC6S	LM9AC6S	LM9AC6S	SU20 0001	P2C1	2020	W06	-48	-48	P2C1	LINE18	1670	35	58261.07	20.88	58240.19	2020 / W0	75	AD-LLM-0	Sampl
51054	LW9COZS	LW9COZS	LW9COZS	SU20 0001	P2C1	2020	W06	-47	-47	P2C1	LINE18	2465	41	58240.19	30.81	58209.38	2020 / W0	75	AD-LLM-0	Sampl
51293	LW9COZS	LW9COZS	LW9COZS	SU20 0344	P2C1	2020	W06	-46	-46	P2C1	LINE18	2465	41	58209.38	30.81	58178.57	2020 / W0	75	AD-LLM-0	Sampl
51531	LW9CQ9S	LW9CQ9S	LW9CQ9S	SU20 0441	P2C1	2020	W06	-45	-45	P2C1	LINE18	2465	41	58178.57	30.81	58147.76	2020 / W0	75	AD-LLM-0	Sampl
51771	LW9CWES	LW9CWES	LW9CWES	SU20 0446	P2C1	2020	W06	-44	-44	P2C1	LINE18	2405	41	58147.76	30.06	58117.7	2020 / W0	75	AD-LLM-0	Sampl
52014	LM9897S	LM9897S	LM9897S	SU20 0001	P2C1	2020	W06	-43	-43	P2C1	LINE48	9060	92	58117.7	113.25	58004.45	2020 / W0	75	AD-LLM-0	Sampl
52257	LM9952S	LM9952S	LM9952S	SU20 0316	P2C1	2020	W06	-42	-42	P2C1	LINE48	9060	92	58004.45	113.25	57891.2	2020 / W0	75	AD-LLM-0	Sampl
52500	LW9CSHS	LW9CSHS	LW9CSHS	SU20 0357	P2C1	2020	W06	-41	-41	P2C1	LINE15	2160	41	57891.2	27	57864.2	2020 / W0	75	AD-LLM-0	Sampl
52747	LW9CSFS	LW9CSFS	LW9CSFS	SU20 0448	P2C1	2020	W06	-40	-40	P2C1	LINE15	2160	41	57864.2	27	57837.2	2020 / W0	75	AD-LLM-0	Sampl
52992	LW9CSGS	LW9CSGS	LW9CSGS	SU20 0450	P2C1	2020	W06	-39	-39	P2C1	LINE15	2160	41	57837.2	27	57810.2	2020 / W0	75	AD-LLM-0	Sampl
53236	LW9CQBS	LW9CQBS	LW9CQBS	SU20 0001	P2C1	2020	W06	-38	-38	P2C1	LINE18	4505	63	57810.2	56.31	57753.89	2020 / W0	75	AD-LLM-0	Sampl
53482	LW9CQBS	LW9CQBS	LW9CQBS	SU20 0002	P2C1	2020	W06	-37	-37	P2C1	LINE18	4505	63	57753.89	56.31	57697.58	2020 / W0	75	AD-LLM-0	Sampl
53729	LW9CQBS	LW9CQBS	LW9CQBS	SU20 0289	P2C1	2020	W06	-36	-36	P2C1	LINE18	4505	63	57697.58	56.31	57641.27	2020 / W0	75	AD-LLM-0	Sampl
53981	LM9AA9S	LM9AA9S	LM9AA9S	SU20 L 045	P2C1	2020	W06	-35	-35	P2C1	LINE24	85	10	57641.27	0.71	57640.56	2020 / W0	75	AD-LLM-0	Sampl
54230	LM9AA9S	LM9AA9S	LM9AA9S	SU20 M 04	P2C1	2020	W06	-34	-34	P2C1	LINE24	85	10	57640.56	0.71	57639.86	2020 / W0	75	AD-LLM-0	Sampl
54479	LM9AA9S	LM9AA9S	LM9AA9S	SU20 M 04	P2C1	2020	W06	-33	-33	P2C1	LINE24	85	10	57639.86	0.71	57639.15	2020 / W0	75	AD-LLM-0	Sampl
54727	LM9AA9S	LM9AA9S	LM9AA9S	SU20 L 04(	P2C1	2020	W06	-32	-32	P2C1	LINE24	85	10	57639.15	0.71	57638.45	2020 / W0	75	AD-LLM-0	Sampl
54974	LM9AA9S	LM9AA9S	LM9AA9S	SU20 0406	P2C1	2020	W06	-31	-31	P2C1	LINE24	85	10	57638.45	0.71	57637.74	2020 / W0	75	AD-LLM-0	Sampl
55220	LM9A89S	LM9A89S	LM9A89S	SU20 0001	P2C1	2020	W06	-30	-30	P2C1	LINE01	6585	82	57637.74	82.32	57555.42	2020 / W0	75	AD-LLM-0	Sampl

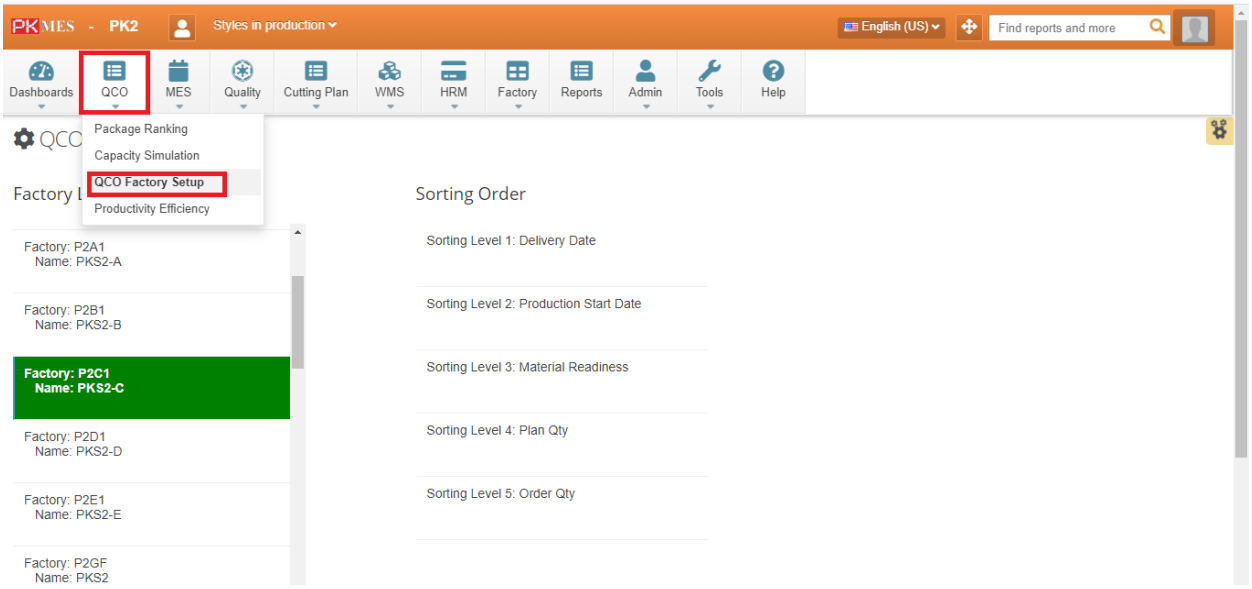
NOTE: You can export the data by BOM (excel) or BOM (PDF), you can select the column you wish to see on BOM (PDF)





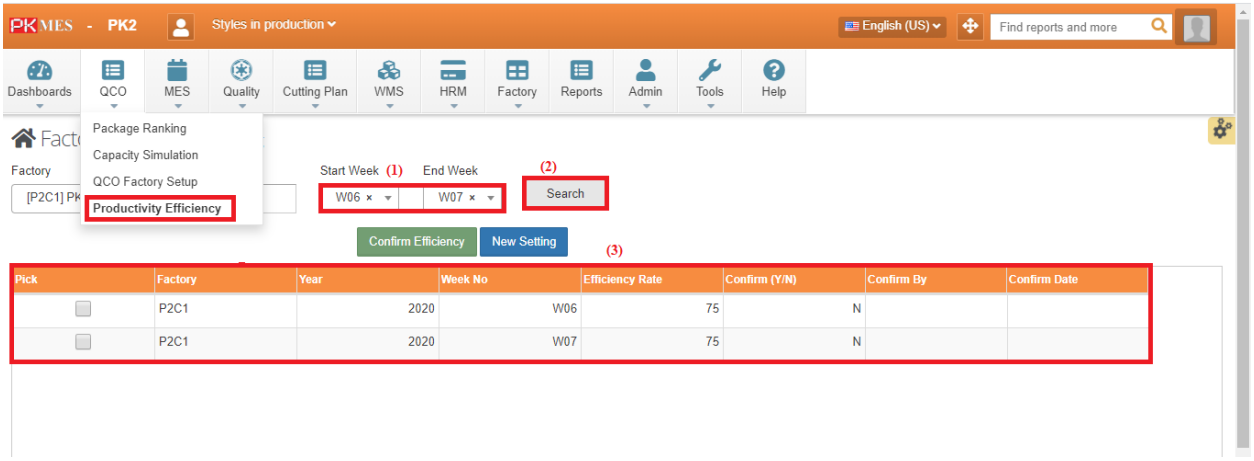
3.3 QCO FACTORY SETUP

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.



4. FACTORY

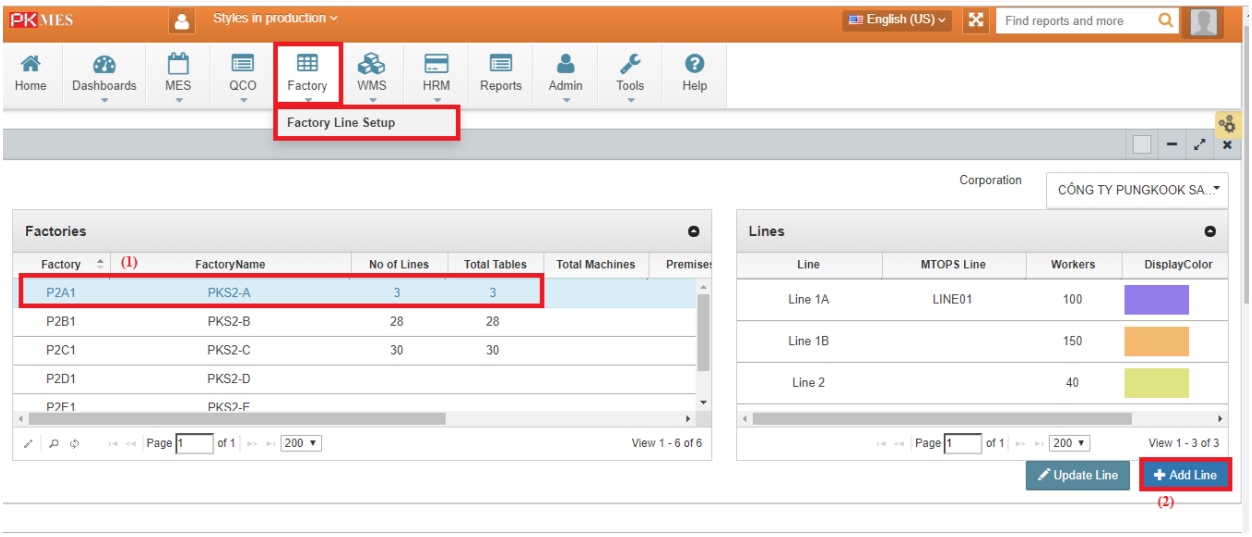
4.1. FACTORY LINE SETUP

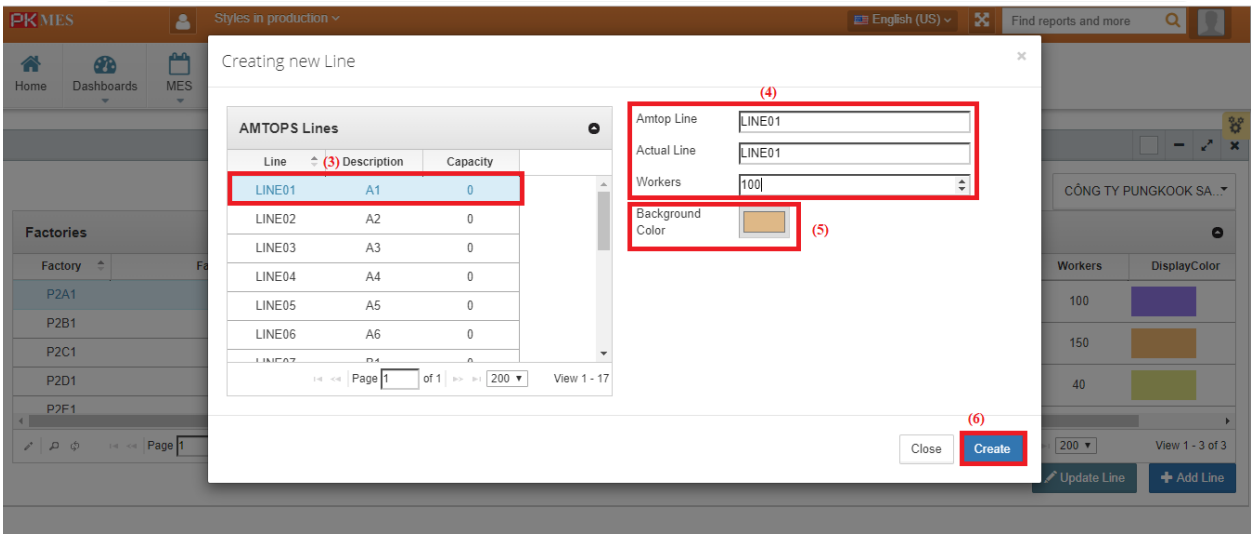
❖ ADD LINE

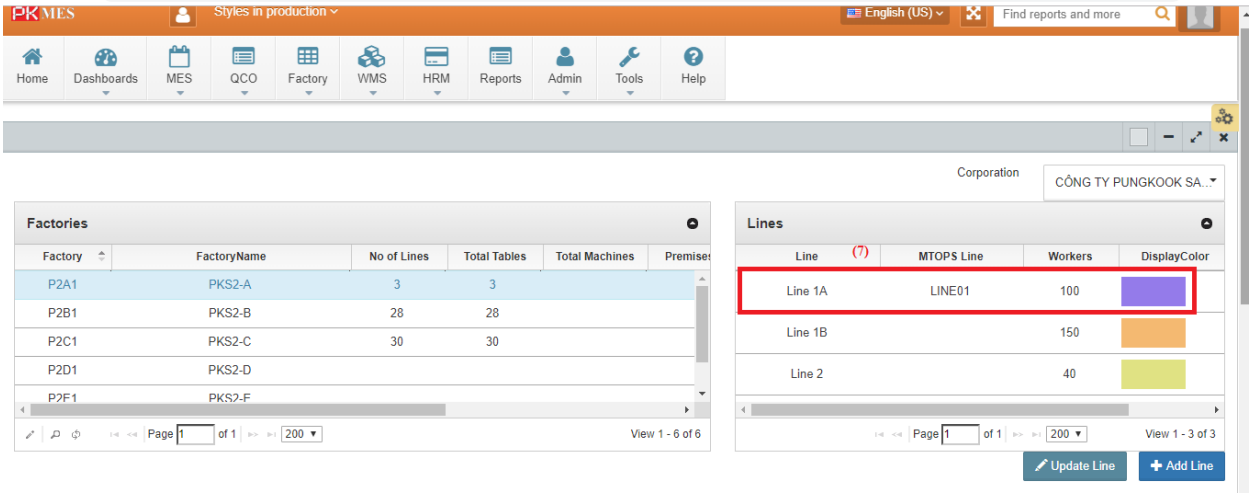
In this screen MES (Physical lines can be created) keeping a mapping to AOMTOPS line for maintaining the relationship.

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.

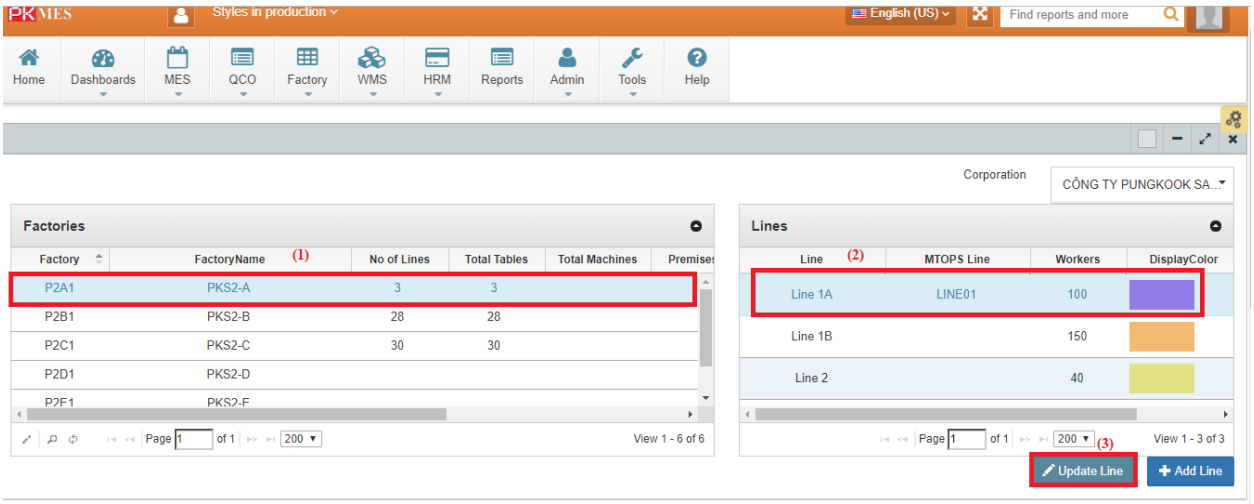


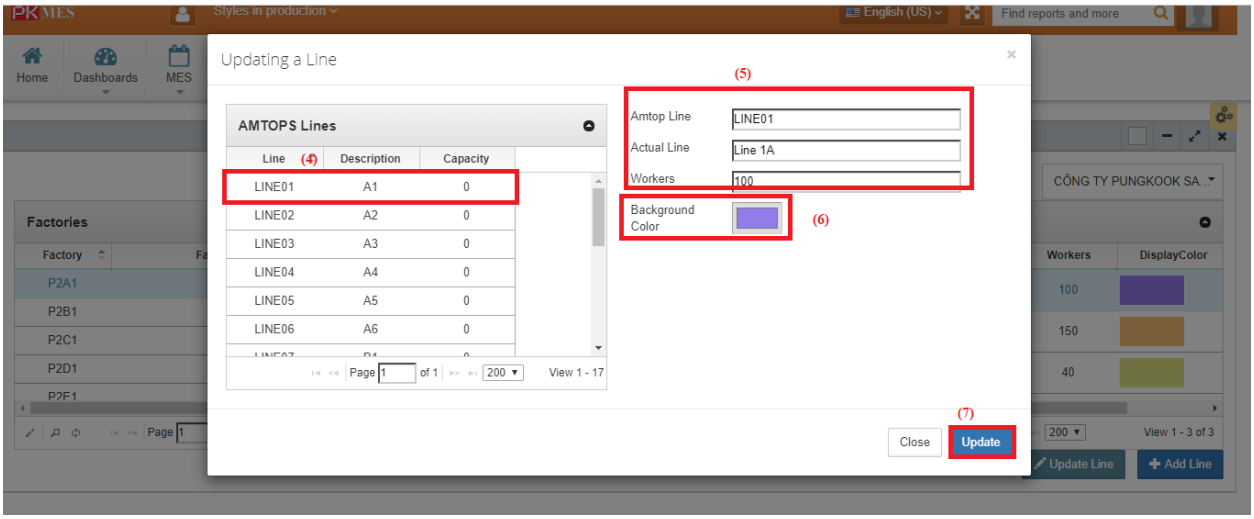

Creating new Line
AMTOPS Lines
Line
(3) Description
Capacity
LINE01 A1 0
LINE02 A2 0
LINE03 A3 0
LINE04 A4 0
LINE05 A5 0
LINE06 A6 0
(4)
Amtop Line
LINE01
Actual Line
LINE01
Workers
100
Background Color
(5)
(6)
Close
Create
Factories
Factory
Workers
DisplayColor
P2A1
P2B1
P2C1
P2D1
P2F1
100
150
40
Update Line
Add Line


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
P2A1 PKS2-A 3 3
P2B1 PKS2-B 28 28
P2C1 PKS2-C 30 30
P2D1 PKS2-D
P2F1 PKS2-F
View 1 - 6 of 6
Lines
(7)
Line
MTOPS Line
Workers
DisplayColor
Line 1A LINE01 100
Line 1B 150
Line 2 40
View 1 - 3 of 3
Update Line
Add Line

❖ UPDATE LINE

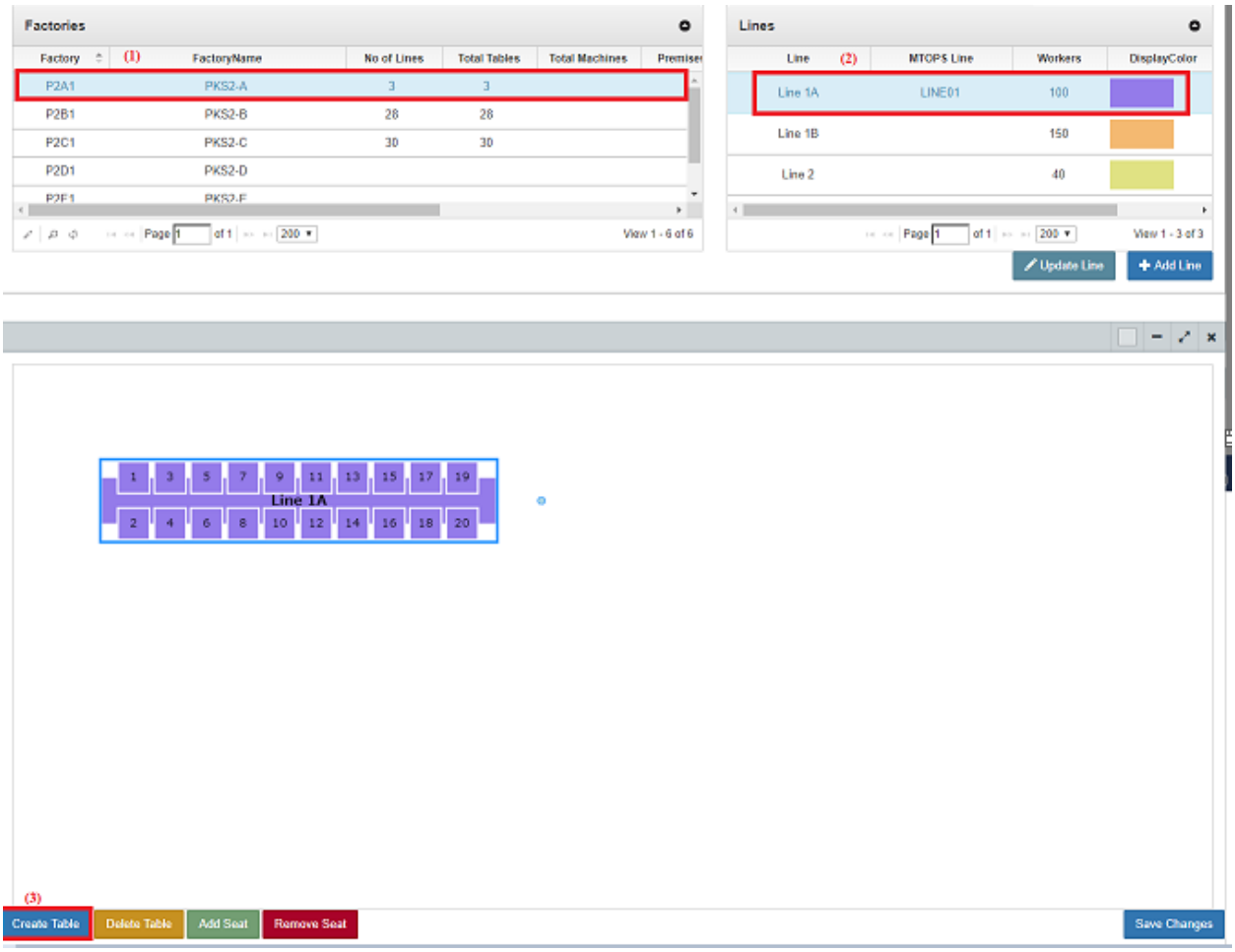
1. Choose the Factory which you need to update line
2. Choose a line at Lines to update it
3. Press UPDATE LINE button to start update line
4. Choose line at AOMTOPs Line to update line
5. You can update at Amtop line, Actual Line, Workers
6. You can update color again at Background Color
7. Press UPDATE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

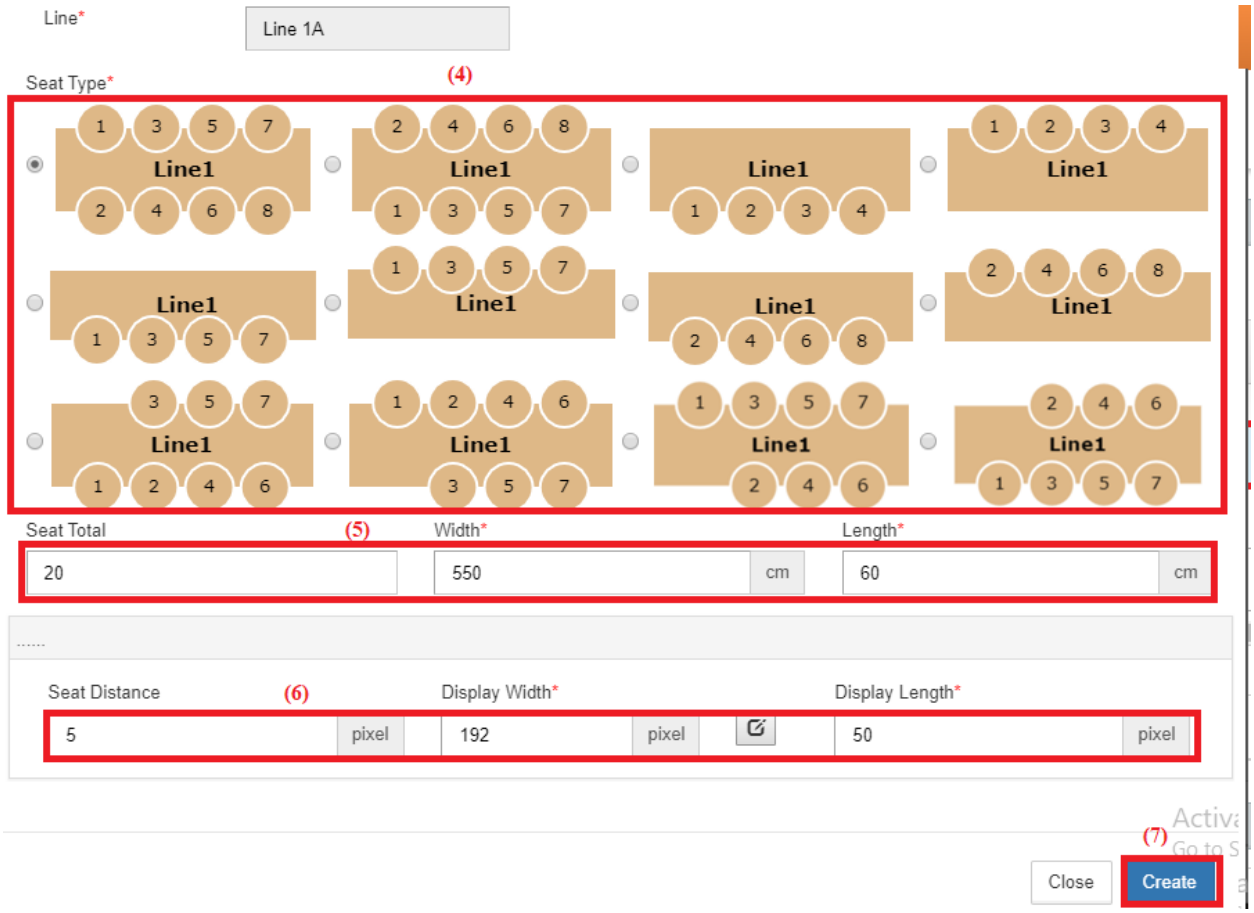


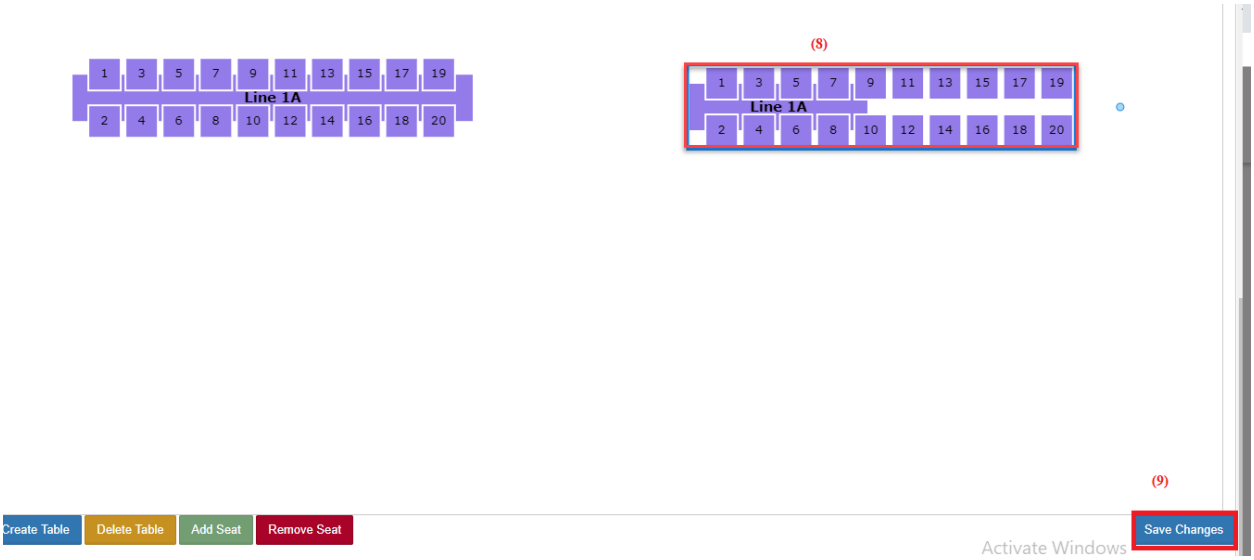


❖ CREATE TABLE

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.

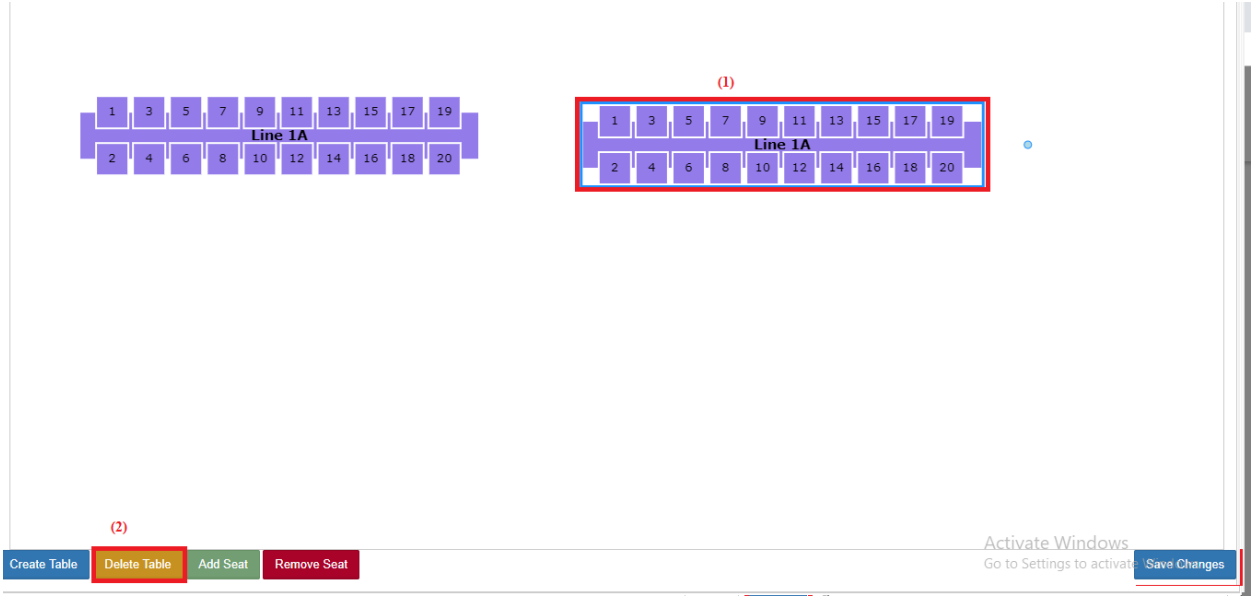


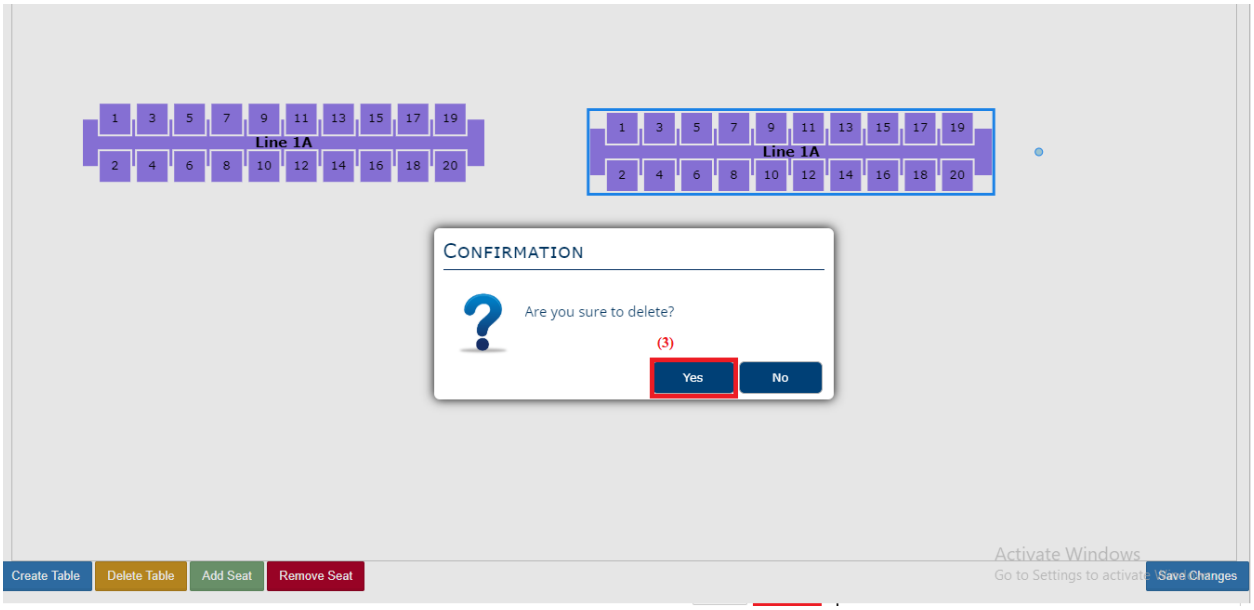

Line*
Line 1A
Seat Type*
(4)
Line1
Seat Total
(5)
Width*
Length*
20
550
cm
60
cm
Seat Distance
(6)
Display Width*
Display Length*
5
pixel
192
pixel
50
pixel
(7)
Close
Create

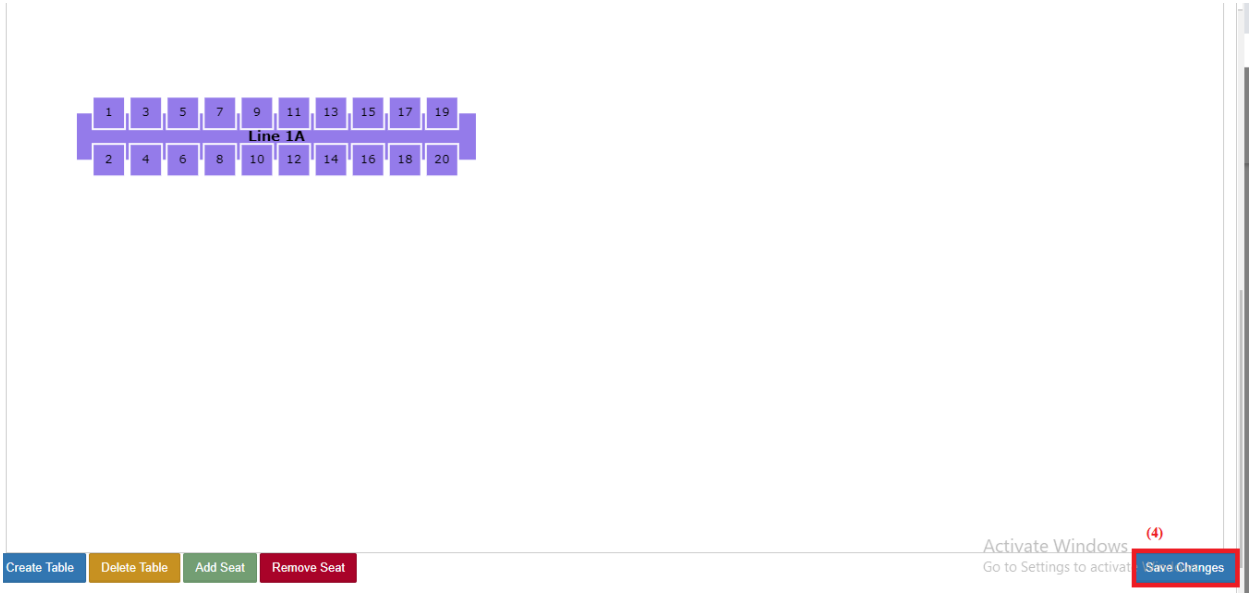

Line 1A
(8)
Line 1A
(9)
Create Table
Delete Table
Add Seat
Remove Seat
Save Changes

❖ 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

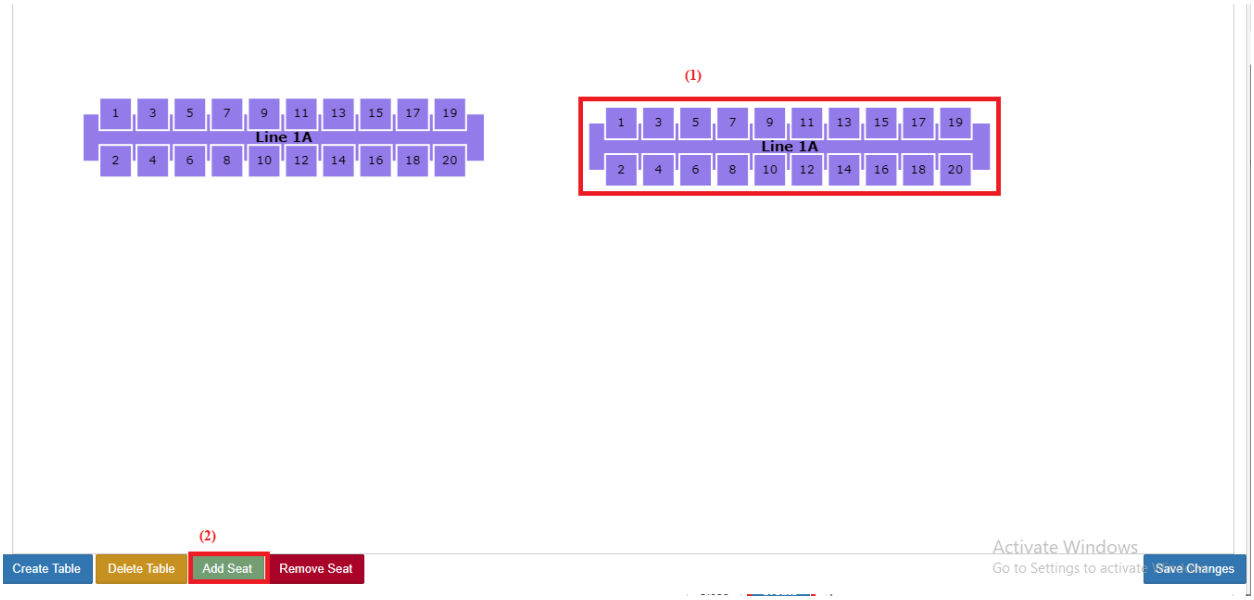


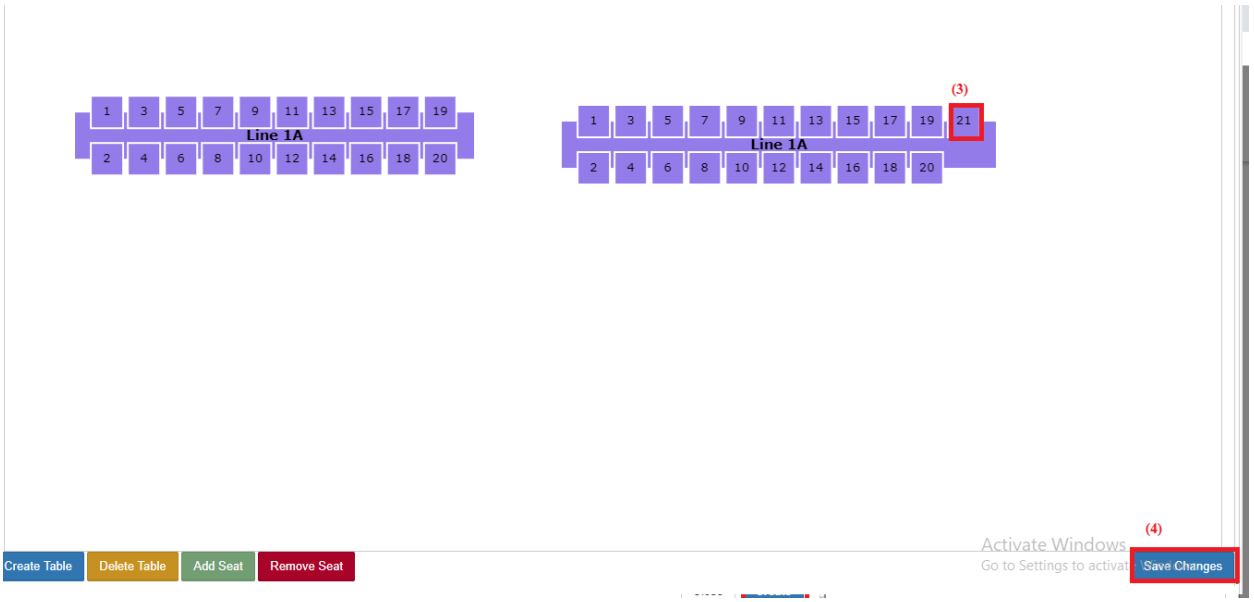



1 3 5 7 9 11 13 15 17 19
Line 1A
2 4 6 8 10 12 14 16 18 20
Activate Windows
Go to Settings to activat
(4)
Create Table
Delete Table
Add Seat
Remove Seat
Save Changes

❖ ADD SEAT

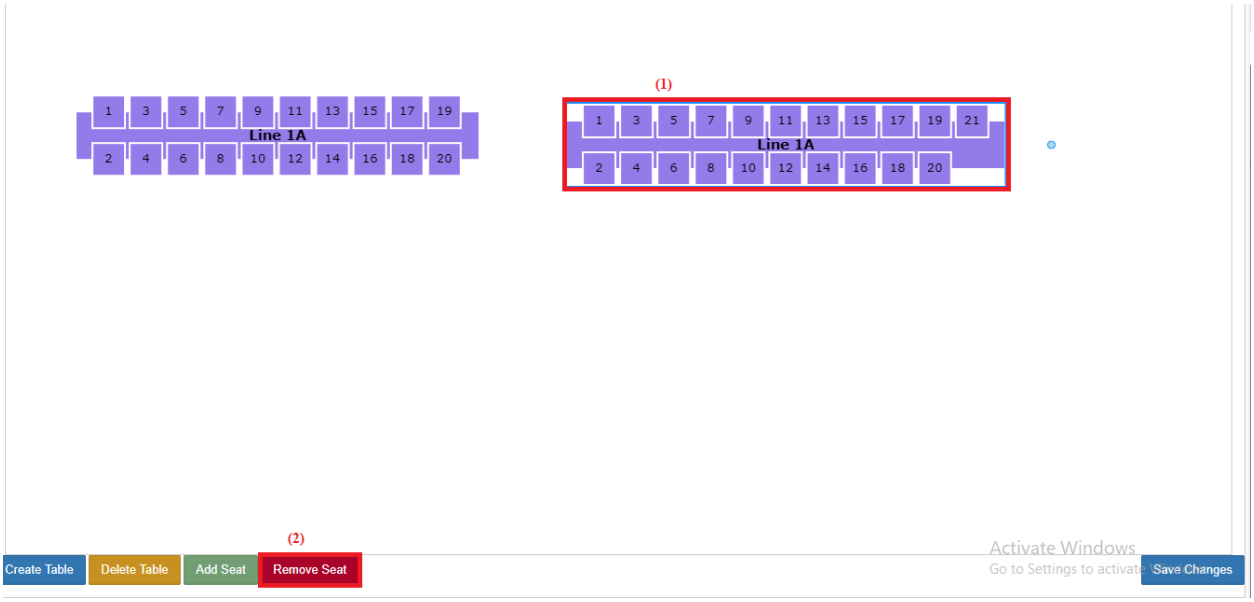
1. Choose a table to add seat
2. Press ADD SEAT button
3. You will see the table increase the seat
4. Press Save to save data

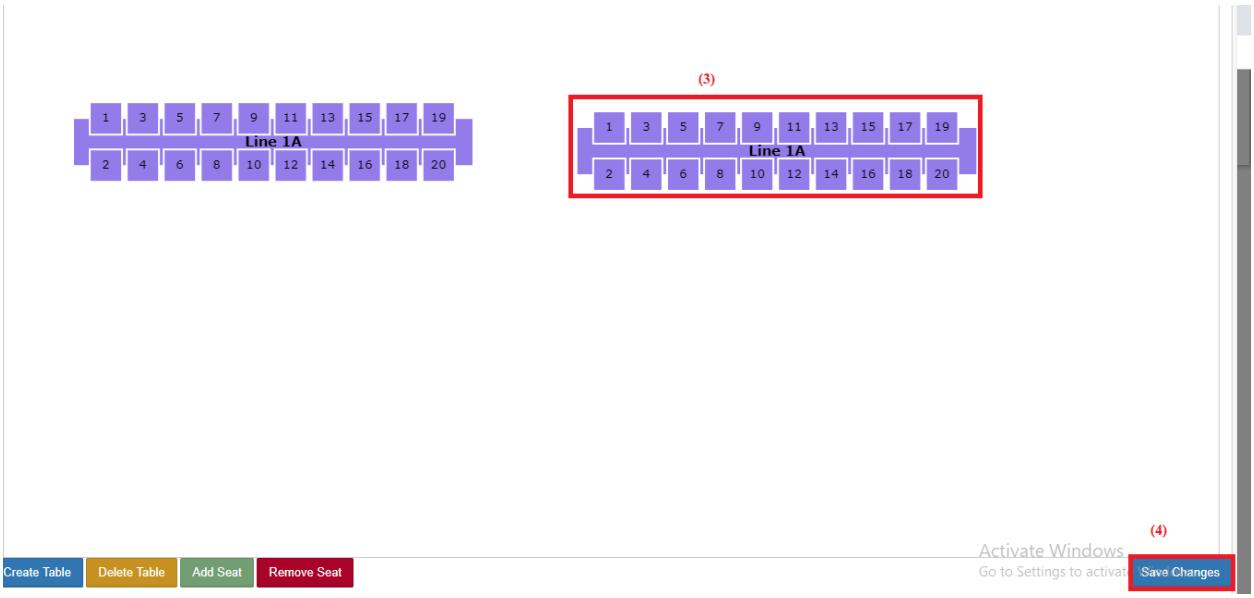




❖ REMOVE SEAT

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

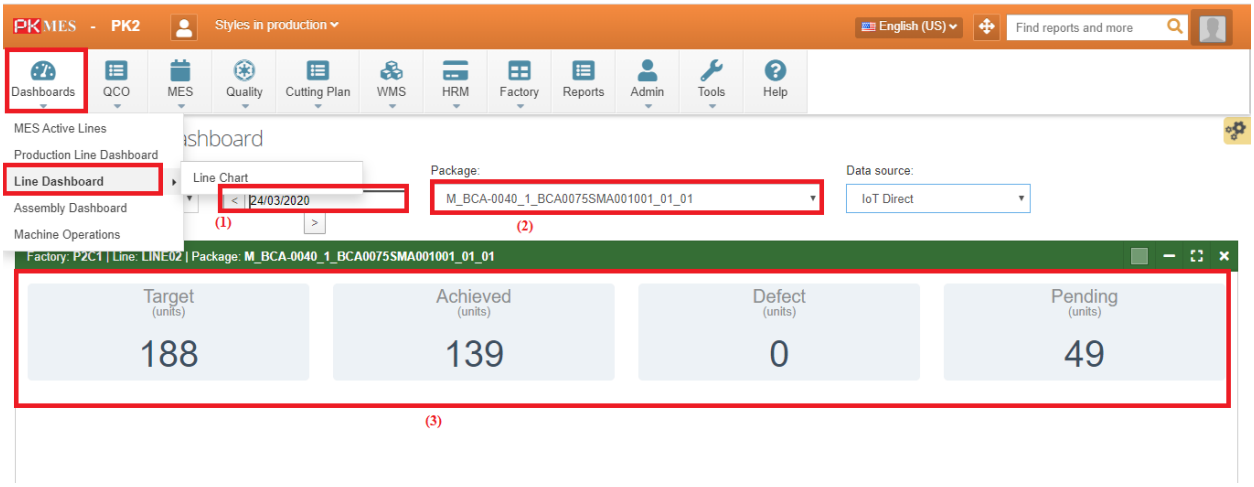




5. DASHBOARD

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).



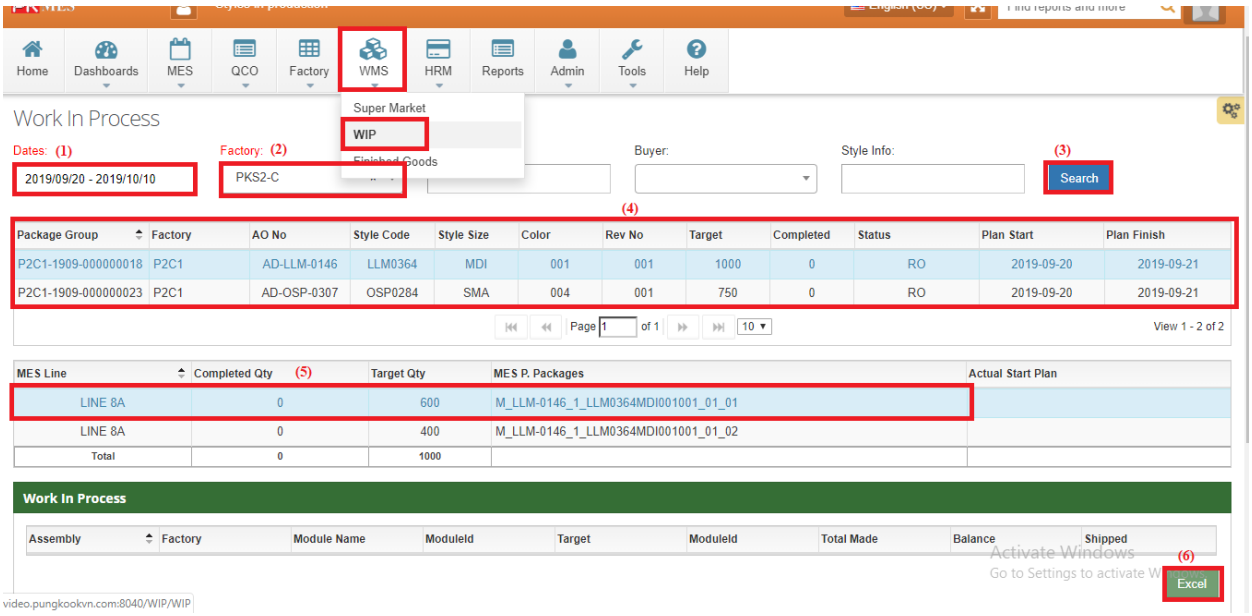
6. WMS

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.



6.3 FINISHED GOODS