

STEP 1: Maintain Material Master with Inspection Type 03

Execute T-code: MM02

1. Select QM View
2. Activate **Inspection Type 03 – In-Process Inspection**
3. Save

STEP 2: Maintain MIC – Master Inspection Characteristics

Execute T-code: QS21

Create 3 MICs:

- Diameter Check
- Weight Check
- Surface Finish Check

Fields to maintain:

- Qualitative / Quantitative
- Lower limit & Upper limit
- Target value

STEP 3: Create Routing & Assign MICs

Execute T-code: CA01

1. Assign material
2. Create Operation (e.g., 0010 – Cutting)
3. Assign the MICs created in QS21
4. Save routing

STEP 4: Create Production Order

Execute T-code: CO01

1. Enter Material & Plant
2. Enter Order Quantity
3. Release Order

Order release automatically and it trigger an Inspection Lot (03).

STEP 5: Display Inspection Lot

Execute T-code: QA03

You will see:

- Inspection Lot Number
- Material
- Order number
- Status will be REL

STEP 6: Record Results

Execute T-code: QE51N

Enter:

- Actual diameter
- Actual weight
- Actual surface finish
- Inspector name
- Notes

System automatically calculates pass/fail based on tolerance limits.

STEP 7: Perform Usage Decision

Execute T-code: QA11

It will display the inspection lot and provide the UD Code based on your requirement [below are the two examples]

Choose:

- A – Accepted
- R – Rejected

Add comments (optional), Save.

STEP 8: Final Documentation

Includes:

- Recorded results
- UD
- Lot history
- Order completion