



Production Executive System

User Manual

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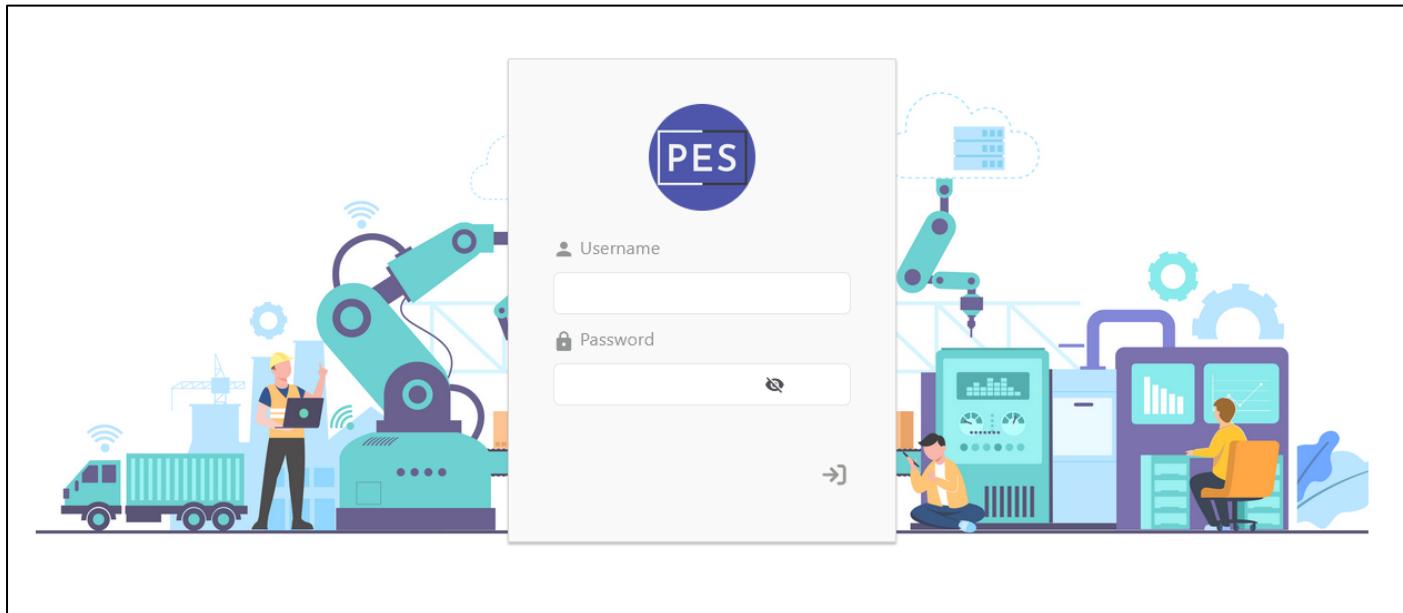
1. General Information

This document explains how to use Production Executive System (PES) on daily basis for monitoring the manufacturing industry.

2. Login Page

Production Executive System (PES), can be accessed using the provided URL in any web browser. Registered users can log in with their credentials. The Application Admin can create new users and update existing user profiles.

<https://pes.digitusbiz.net/>



3. 3.Home Page

- On successful login, user will be on home page of the application as shown below.



- Click on the right corner so that you can view all the modules available. In addition, under Admin modules sub modules can be viewed based on the logged in user's user role as shown in below images.



PES

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510



AGIS - Bangalore

Welcome to PES

ADMIN SCHEDULER QUALITY ASSURANCE

2024 — © Digitus Business Solutions

Home
Shop Floor Viewer
Admin
Attribute
Test Plan
Test plan Mapper
Shop Floor
Production Line
Shift Maint
Shift Calender
Holiday
Workorder
Reason Code
User Maintenance

4. Admin Module

General Information

In the Admin Module, users can:

- **Add (+)**: Create new records. Success and error messages will be displayed, and the new record will appear in the view table (only for User Maintenance).
- **Create**: Create new record with the mandatory entries and Save.
- **Edit (✎)**: Modify existing records. Success and error messages will confirm the update, with the edited record shown in the view table.
- **Delete (trash)**: Remove records if they are not linked to other data. A confirmation message will be displayed upon successful deletion, and the view table will be updated. Errors will be shown if there are issues with linked records.
- **Save**: Save changes made to records. A success message will confirm that the changes have been saved. If there are errors, an appropriate error message will be provided.
- **Cancel**: Discard any unsaved changes and return to the previous state. No changes will be saved.

User Maintenance

In this module, you can:

- **ADD USER**: Creates new user.
- **Edit**: Modify existing users.

Additionally, manage user roles, which define access limitations within the application. For example, roles like Engineer and Team Leader etc., will have restricted access to Shop-Floor and Line Master, which can also be added and edited in this module. Users will use their username and password to log in to the application.

	First Name	Last Name	Email Id	Phone Number	Active	Role	Shop Floor Access	PL Access	Actions
1	Sundar	S	shanmuga.sundar@digitusbiz.com	344552323235	✓	Engineer	125FSA	CUTM01,CUTM1,SFSAS	
2	PES	Admin	admin	563332228	✓	Business Admin			
3	RANGANATH	BK	rangabk@gmail.com	0000000000	✓	Business Admin			
4	admin	pes	adminpes@gmail.com	00099899	✓	Business Admin			
5	business	admin	businessadmin@gmail.com	123456	✓	Business Admin			
6	Pradeep	D	test@gmail.com	9090909090	✓	Admin			
7	Pradeep	Desireddy	pradeep@test.com	123456789	✓	Plant Manager			
8	Shanmuga	Sundar	spshanmuga01@gmail.com	9807898766	✓	Engineer	125FSA	CUTM1,SFSAS	
9	Ranganath	BK	ranganath@digitusbiz.com	08976566786	✓	Plant Manager			
10	Pradeep	DReddy	pradeep@digitusbiz.com	09689077663	✓	Business Admin			

5. User role List

6. Shop Floor List

Add User

▲

- Plant Manager
- Operation Head
- Deputy Manager
- Engineer
- Supervisor
- Team Leader

▼

- 12SFSA
- 12SFWH
- 12SFSE

SAVE
CANCEL

Add User

▼

▲

- Select All
- 12SFSA
- 12SFWH
- 12SFSE

SAVE
CANCEL

- Line Master List

Add User

- Select All
- CUTM3
- SFSA1
- SFSA2

12SFSA, 12SFWH, 12SFSE, 12SCUT, 12SFFO, 12SFTEST, TEST01

SAVE
CANCEL

- User role – Access Matrix

User role	Attribute	Test plan	Test plan mapper	Shop floor	Production Line	Shift Calender	Holiday	Work Order	Reason Code	PL Status	User Maintanance	Scheduler	QA
Plant Manager	Applicable	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable
Operation Head	Applicable	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable
Supervisor	Applicable	Applicable	NA	NA	Applicable	NA	Applicable	Applicable	Applicable	Applicable	NA	NA	NA
Team Leader	NA	NA	NA	Applicable	Applicable	NA	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable
Deputy Manager	Applicable	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable
Engineer	NA	NA	Applicable	NA	Applicable	NA	Applicable	Applicable	Applicable	Applicable	NA	Applicable	Applicable
Admin	NA	NA	NA	Applicable	Applicable	Applicable	Applicable	Applicable	Applicable	Applicable	NA	Applicable	NA

Shop Floor Maintenance

In this module, you can:

- **Save:** Create new shop floors with a unique name and code.
- **Edit:** Modify existing shop floors.
- **Delete:** Remove shop floors, provided they are **not linked with any Line Master**.

Each shop floor must be associated with a Line Master and must have a unique shop floor name and shop floor code.

- **View Shop Floor**

Shop Floor Maintenance

Add Shop Floor

Shop Floor Code	Shop Floor Name	SAVE	CANCEL
-----------------	-----------------	------	--------

Shop Floor Maintenance

Shop Floor Code	Shop Floor Name	Actions
12SFSA	Systems Assembly	
12SFWH	Wiring Harness	
12SFSE	Schneider Electric	
12SCUT	Cutting & Crimping	
12SFFO	Fiber Optics	
12SFTEST	TESTING	
TEST01	TEST02	

- **Edit Shop Floor (only on shop floor name)**

Edit Shop Floor Maintenance

Shop Floor Name	SAVE	CANCEL
Systems Assembly		

Production Line Maintenance

In this module, you can:

- **Save:** Create production lines under a shop floor.
- **Edit:** Modify existing production lines.
- **Delete:** Remove production lines only if no job orders are planned on that production line.

Additionally, you can specify details for each production line, including the item family that can be used, units per hour, and the setup time required.

- **Add & View Table**

Production Line Maintenance

Add Production Line Maintenance

PL Line	Shop Floor	Item Family	Description	Unit/Hours	Setup Time	SAVE	CANCEL
CUTM1	12SFSA	4950	49510	1CC Machine	NA	150	1
CUTM2	12SFWH	4950	49510	C&C Machine2	NA	500	0
CUTM3	12SFWH	4950	49510	C&c Machine3	NA	750	1
SFSA1	12SFWH	4950	49510	PL1 FOR 12SFSA	632	150	1
SFSA2	12SFWH	4950	49510	PL2 FOR 12SFSA	632	150	1
SFSA4	12SFSE	4950	49510	PL4 FOR 12SFSA	632	150	1
SFSE1	12SFSE	4950	49510	PL1 FOR 12SFSE	632	50	1

- **Edit Production Line**

Edit Production Line Maintenance

Item Family NA	Description 1CC Machine	Units/Hours 150	Setup Time 1
		SAVE	CANCEL

Reason code

In this module, you can:

- **Save:** Create new reason codes.
- **Edit:** Modify existing reason codes.
- **Delete:** Remove reason codes only if they are not in use.

Additionally, you can specify details for each reason code, including its type for generic use in multiple modules and a description.

- **Add & View Table**

Reason Code			
Add Reason Code			
Reason Code Type	Reason Code	Reason Code Description	Actions
BREAKDOWN	BD102	TESTING	/
SCRAP	RB101	SHRINK MARK	/
REJECT	RJ101	Cable Damage	/
REWORK	RW101	Rework-1	/
REWORK	RW102	Rework-2	/
TEST1	TEST	Test1	/
BREAKDOWN	BD101	Machine Breakdown	/
MAINTENANCE	MAN101	cable shortage	/

- **Edit**

Edit Reason Code

Reason Code Description	SAVE	CANCEL
Cable Damage		

Machine Maintenance

In this module, you can:

- Save: Create new machines for operations.
- Edit: Modify existing machines.
- Delete: Remove machines only if they are not in use.

- **Create new machine & View table**

Machine Maintenance

Add Machine

Operation	▼	Machine Number	SAVE	CANCEL
-----------	---	----------------	-------------	---------------

Machine List

Operation	Machine Number	Actions
10	MACHINE-Stripping2	
10	MACHINE-CUT1	
10	MACHINE-CUT2	
20	MACHINE-Stripping	
20	MACHINE-CUT3	
20	MACHINE-Preparing	
30	MACHINE-CRIMPING2	

- Edit

Edit Machine Details

Operation 10	Machine Number MACHINE-Stripping2
-----------------	--------------------------------------

SAVE **CANCEL**

Applicator Maintenance

In this module, you can:

- **Save:** Create new applicators for an operation and specify the machine used in that operation.
 - **Edit:** Modify existing applicators and update their associated machine and operation details.
 - **Delete:** Remove applicators as needed
-
- **Create new applicator & View Table**

Applicator Maintenance

Add Applicator

Operation Machine Number Applicator Name SAVE CANCEL

Applicator List

Operation	Machine Number	Applicator Name	Actions
10	MACHINE-CUT2	#APPL001	
10	MACHINE-Stripping2	#APPL_STRP2	
10	MACHINE-CUT1	#APPL_CUT1	
10	MACHINE-CUT2	#APPL_CUT2	
20	MACHINE-Crimping2	#APPL_CRIMP2	
20	MACHINE-CRIMPING2	#APPL_CRIMP1	
20	MACHINE-Stripping	#APPL_STRP1	

- **Edit**

Edit Applicator Details

Operation Machine Number Applicator Name SAVE CANCEL

10 MACHINE-CUT1 #APPL_CUT2

Shift Maintenance

In this module, you can:

- **Edit:** Adjust shift hours and the shift start time. The end time of the shift is automatically calculated as the start time plus the shift duration.
 - For example, if the shift hours are set to 8 and the start time is 07:00:00, the end time will be 15:00:00.
 - This records will be considered as the shift timing and used for scheduler and production line status entry.
-
- **View Table**

Shift Maintenance						
Site	Hours	Start Time	End Time	Productivity	Actions	
49510	2	08:00:00	10:00:00	100.0		
Monday	8	07:00:00	15:00:00	100.0		
Tuesday	8	07:00:00	15:00:00	100.0		
Wednesday	8	07:00:00	15:00:00	100.0		
Thursday	8	07:00:00	15:00:00	100.0		
Friday	8	07:00:00	15:00:00	100.0		
Saturday	8	07:00:00	15:00:00	100.0		

- **Edit**

Edit Shift Calendar Maintenance

Start Time
07 : 00 : 00 am

Shift Hours
8

Shift Productivity
100.0

SAVECANCEL

Quality Attribute Maintenance

In this module, you can:

- **Create:** Add new attributes, which can be of two types:
 - **Numerical:** Includes inputs for unit type (cm, m) and decimal format (number of decimal places).
 - **Logical:** Includes a logical format (e.g., Y/N, OK/NOK).
- **Edit:** Modify existing attributes, with the restriction that the attribute type cannot be changed.
- **Delete:** Remove attributes only if they are not used in any test plans.

- **Create new attribute and View Table.**

- **Numerical Attribute**

Quality Attribute Maintenance

Add New Attribute

Attribute Name	Unit Type Numerical	UOM BX	Decimal Format	SAVE	CANCEL
----------------	------------------------	-----------	----------------	-------------	---------------

* Attributes already mapped are not editable

Attribute List

Name	UOM	Type	Decimal Format	Logical Format	Actions
LENGTH M	M	Numerical	2		
LENGTH_CM	BX	Numerical	1		
LENGTH_MM	MM	Numerical	2		
HEIGHTM	BX	Numerical	2		
HEIGHT CM	CM	Numerical	3		
HEIGHT MM	MM	Numerical	2		

REFRESH

- **Logical Attribute**

Quality Attribute Maintenance

Add New Attribute

Attribute Name	Unit Type Logical	Logical Format	SAVE	CANCEL
----------------	----------------------	----------------	-------------	---------------

* Attributes already mapped are not editable

Attribute List

Name	UOM	Type	Decimal Format	Logical Format	Actions
LENGTH M	M	Numerical	2		
LENGTH_CM	BX	Numerical	1		
LENGTH_MM	MM	Numerical	2		
HEIGHTM	BX	Numerical	2		
HEIGHT CM	CM	Numerical	3		
HEIGHT MM	MM	Numerical	2		

REFRESH

- **Edit**

Edit Attribute

Attribute Name FORCE	Unit Type Numerical ▾	UOM KG ▾	Decimal Format 2
* Attribute's unit type cannot be changed. If required delete and recreate the attribute			
		SAVE	CANCEL

Quality Test Plan

Test Plan Creation

- **Item Name:** [Input Field for Identification]
 - This will serve as the unique identifier for the test plan.

Adding Attributes

- **Numerical Attributes:**
 - **Description:** [Input Field]
 - A brief explanation in the text field.
 - **Reference Value:** [Input Field]
 - The default or standard value for the attribute.
 - **Upper Limit:** [Input Field]
 - The maximum allowable value.
 - **Lower Limit:** [Input Field]
 - The minimum allowable value.

Example:

- Attribute: Length
 - Reference Value: 2.6cm
 - Upper Limit: 0.1cm
 - Lower Limit: 0.1cm
- **Logical Attributes:**
 - **Description:** [Input Field]
 - A brief explanation in the text field.
 - **Reference Value:** [Checkbox]
 - If checked, the test should be conducted as a positive case.
 - If unchecked, the test should be conducted as a negative case.

Example:

- Attribute: Power On Status
 - Positive Case: [Checked]
 - Indicates that the item should be tested to confirm it powers on correctly.

Editing Attributes

- **Editing Process:**
 - Edits can be made to the attributes within the test plan.
 - **Note:** Changes will not affect existing work order mapping & test results. They will only be applied to future tests.

Deleting Attributes

- **Deletion Process:**
 - Click on the  delete button on the end of the row.
 - Also, Deletion of attributes follows the same process as editing.
 - **Note:** Once attribute deleted, they will no longer appear in future tests.
- Creation of new Test Plan Name

Quality Test Plan Name

List Test Plan

ShowCancel

Add New Test Plan

Add NewCancel

* Test Plan / Details already mapped is not deletable

Test Plan Name:								
Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
Select Test Plan								

- Clone of new Test Plan with existing test plan (Duplicate Form is a drop down will list all the existing test plan name)

Quality Test Plan Name

List Test Plan

ShowCancel

Add New Test Plan

Add NewCancel

* Test Plan / Details already mapped is not deletable

Test Plan Name:								
Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
Select Test Plan								

Excel Upload for New Test Plan

- **Template Download:**
 - **Download Template:** [Button to Download Excel Template]
 - Provides a pre-defined Excel template for entering attributes.
 - The template includes fields for Attribute, Description, Reference Value, Upper Limit, Lower Limit
- Template Columns:
 - **Attribute Name** (should be present as Quality Attribute. Also check for spelling)
 - **Description**
 - **Reference Value** (for Numerical attributes)
 - **Upper Limit** (for Numerical attributes)
 - **Lower Limit** (for Numerical attributes)
 - **Reference Value** (for Logical attributes, with 1 or 0 where 1 considered as positive case and 0 considered as negative case)
- **Upload Excel File:**
 - **Upload Button:** [Button to Upload Excel File]
 - Allows users to upload the completed Excel file.
 - File must adhere to the downloaded template format.
- **Validation and Import:**
 - **Validation:** The system will check the uploaded file for correct formatting and required fields.
 - **Import:** If validation is successful, the attributes from the Excel file will be imported into a new test plan.

Error Handling:

- **Error Messages:** Provide specific error messages if the file format is incorrect or required fields are missing.

Example:

- **Uploaded File Content:**

For Numerical Attribute

- **Attribute Name:** Voltage
- **Reference Value:** 220V
- **Upper Limit:** 0.01V
- **Lower Limit:** 0.01V

For Logical Attribute

- **Attribute Name:** Colour
- **Reference Value:** 1 (Yes)

- **Excel to be uploaded**

A	B	C	D	E
Attribute	Description	ReferenceValue	LowerLim	UpperLimit
COLOR	color of the cable	1		
VOLTAGE	voltage of cable	220	0.01	0.01

- **Imported data from the uploaded excel**

Quality Test Plan Name

List Test Plan

Test Plan List
0W49255BT

Show
Cancel

Add New Test Plan

Duplicate From

Add New
Cancel

* Test Plan / Details already mapped is not deletable

Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
COLOR	color of the cable	<input checked="" type="checkbox"/>						█
VOLTAGE	voltage of cable	220	0.01	0.01				█

Add Attributes for a Test Plan

- To add the quality attributes for new or existing test plan from the test plan screen.

Quality Test Plan Name

List Test Plan

Test Plan List
0W49255B

Show
Cancel

Add New Test Plan

Duplicate From

Add New
Cancel

* Test Plan / Details already mapped is not deletable

Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
CONNECTOR	L-End A Braid to vendor ID label 70z	70	-5	5	MM	Numerical	2	█
CONNECTOR	L-Braid to destination label A side 5l	50	-5	5	MM	Numerical	2	█
NICK MARK	Nick mark As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	█
CUT	Terminal cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	█
CUT	strands cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	█
BEND	Terminal bend As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	█

Implementation Steps

1. Edit Mode Activation

- Click on the "Edit" button to enable the addition or modification of attributes.

The screenshot shows the 'Quality Test Plan Name' interface. At the top, there are two panels: 'List Test Plan' (with a dropdown menu showing 'Test Plan List 0W49255B', a 'SHOW' button, and a 'CANCEL' button) and 'Add New Test Plan' (with input fields for 'Test Plan Name' and 'Duplicate From', and buttons for 'ADD NEW' and 'CANCEL'). Below these is a table titled 'Test Plan Name: 0W49255B'. The table has columns: Attribute, Description, Reference Value, Lower Limit, Upper Limit, UOM, Type, Format, and Actions. The data in the table is as follows:

Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
CONNECTOR	L-End A Braid to vendor ID label 70±	70	-5	5	MM	Numerical	2	
CONNECTOR	L-Braid to destination label A side 5l	50	-5	5	MM	Numerical	2	
NICK MARK	Nick mark As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
CUT	Terminal cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
CUT	strands cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
BEND	Terminal bend As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	

* Test Plan / Details already mapped is not deletable

2. Adding a New Attribute

- Click on the "Add Row" button to add a new quality attribute.
- Select Attribute:** Choose from the dropdown list.
- Description:** Enter a brief explanation in the text field.
- Reference Value:**
 - For numerical attributes, input the value in the text field.
 - For logical attributes, check or uncheck the checkbox.
- Upper Limit:** Input the maximum allowable value in the text field (for numerical attributes).
- Lower Limit:** Input the minimum allowable value in the text field (for numerical attributes).

The screenshot shows the same 'Quality Test Plan Name' interface after adding a new attribute. The table now includes a new row for 'CONNECTOR' with a reference value of '70'. The rest of the data remains the same as in the previous screenshot.

Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
CONNECTOR	L-End A Braid to vendor ID label 70±	70	-5	5	MM	Numerical	2	
CONNECTOR	L-Braid to destination label A side 5l	50	-5	5	MM	Numerical	2	
NICK MARK	Nick mark As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
CUT	Terminal cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
CUT	strands cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
BEND	Terminal bend As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	

* Test Plan / Details already mapped is not deletable

3. Deleting an Existing Attribute

- Locate the attribute you wish to delete.
- Click the delete button (?) last to the attribute row.
- Confirm the deletion by a confirmation dialog.

Quality Test Plan Name

✓ Row deleted successfully

List Test Plan

Test Plan List
OW49255B

Show
Cancel

Add New Test Plan

Test Plan Name

Duplicate From
Add New
Cancel

* Test Plan / Details already mapped is not deletable

Test Plan Name: OW49255B		Search Attribute	Add Row	Edit	Save	Refresh		
Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Delete
CONNECTOR	L-Braid to destination label A side S1	50	-5	5	MM	Numerical	2	
NICK MARK	Nick mark As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
CUT	Terminal cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
CUT	strands cut As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
BEND	Terminal bend As per Req.	<input checked="" type="checkbox"/>				Logical	OK/NOK	
DAMAGE	free from Connector damage As per	<input checked="" type="checkbox"/>				Logical	OK/NOK	

4. Saving Changes

- After editing or adding attributes, ensure changes are saved by clicking the "Save" or equivalent button.

5. Search Attribute

- In the toolbar, search attribute can be used to search the attribute from the list and perform the actions for the specific attribute.

Quality Test Plan Name

List Test Plan

Test Plan List
OW49255B

Show
Cancel

Add New Test Plan

Test Plan Name

Duplicate From
Add New
Cancel

* Test Plan / Details already mapped is not deletable

Test Plan Name: OW49255B		Search Attribute	Add Row	Edit	Save	Refresh		
Attribute	Description	Reference Value	Lower Limit	Upper Limit	UOM	Type	Format	Actions
COLOR	Cable color Black	<input checked="" type="checkbox"/>				Logical	OK/NOK	

Example Fields in a Test Plan

- Quality Attribute:** Circumference
- Description:** Measures the circumference of the wire.
- Reference Value:** 0.5mm
- Upper Limit:** 0.01mm
- Lower Limit:** 0.01mm

- **Quality Attribute:** Damage
- **Description:** check the package for any damage
- **Reference Value:** Checked (checkbox for logical)

Work Order Detail Viewer

Overview

The **Work Order Detail Viewer** is a read-only interface designed to display comprehensive details about a work order and its associated operations. This view-only screen is intended for users to review and analyze information related to a specific work order without the ability to create or edit data. It provides a snapshot of the work order's attributes, operations, and any job orders scheduled or created for that work order.

Key Features

1. Read-Only Display

- **Purpose:** Provides a detailed, non-editable view of work order information.
- **Functionality:** Users can view all details related to the work order but cannot make changes.

2. Work Order Details

- **Information Displayed:**
 - **Work Order Number:** Unique identifier for the work order.
 - **Item Description:** Description of the work order.
 - **Item Number:** item number of the work order.
 - **Quantity:** Total quantity of the work order.
 - **Routing Lot:** Routing lot assigned to the work order.
 - **Running Time:** Expected total run time for the work order.
 - **Setup Time:** Expected total setup time for the work order.

3. Operation Details

- **Information Displayed:**
 - **Operation Number:** Unique identifier for each operation.
 - **Description:** Detailed description of each operation involved in the work order.
 - **Mile Stone Status:** status of the operation (e.g., true, false).
 - **Standard run and setup time:** run and setup times for each of the operation.
 - **Work Centre:** work centre where the operation is assigned.

4. Job Orders

- **Information Displayed:**
 - **Job Order Number:** Unique identifier for job orders created for the work order.
 - **Operation Description:** operation description of each job order.
 - **Job Planned Date:** Planned date for each job order.
 - **Scheduled Dates:** Planned Start and end dates for each job order.
 - **Job Quantity:** Quantity for the job order.

- **Work order view table**

Work Order Detail Viewer				
Work Order List		Search Work Order		
Work Order	Lot	Item	Quantity	Item Type
289090	8386950	2P026885-004LF	1750	632
289084	8386946	BE0312B001MNNLF	100	632
289083	8386945	0w49323CLF	100	632
289092	8386952	RPM2531610-030M	228	634
289094	8386954	BE0312B001MNNLF	320	632
289082	8386944	RPM2531610-030M	90	634
289080	8386942	2P026885-004LF	1770	632
289080	8386942	2P026885-004LF	1770	632
289093	8386953	0w49323CLF	400	632

Work Order Routing									
Op	Operation Desc	MileStone Operation	MchPer Operation	Standard RunTime	Standard SetupTime	Yield Percentage	Queue Time	Work Center	WaitTime
No data available									

Job Order					
Job Order	Operation	Job Date	Planned Start Date	Planned End Date	Load Qty
No data available					

- **Work order view table with its operations and job orders created.**

Work Order Detail Viewer				
Work Order List		Search Work Order		
Work Order	Lot	Item	Quantity	Item Type
289090	8386950	2P026885-004LF	1750	632
289084	8386946	BE0312B001MNNLF	100	632
289083	8386945	0w49323CLF	100	632
289092	8386952	RPM2531610-030M	228	634
289094	8386954	BE0312B001MNNLF	320	632
289082	8386944	RPM2531610-030M	90	634
289080	8386942	2P026885-004LF	1770	632
289080	8386942	2P026885-004LF	1770	632
289093	8386953	0w49323CLF	400	632

Work Order Routing									
Op	Operation Desc	MileStone Operation	MchPer Operation	Standard RunTime	Standard SetupTime	Yield Percentage	Queue Time	Work Center	WaitTime
10	Cable Cutting/Stripping	false	1	0.023	0.013	100	0	4302	0
20	Crimping	false	1	0.013	0.03	100	0	4302	0
30	Cable Twisting	false	1	0.033	0.03	100	0	4302	0
40	Housing	false	1	0.073	0.05	100	0	4302	0
50	Braid Cutting	false	1	0.043	0.05	100	0	4302	0

Job Order					
Job Order	Operation	Job Date	Planned Start Date	Planned End Date	Load Qty
289090-01	10	07/08/2024	07/08/2024 23:00:00	07/08/2024 23:27:36	20
289090-01	20	07/08/2024	07/08/2024 23:27:36	07/08/2024 23:43:12	20
289090-01	140	08/08/2024	08/08/2024 07:00:00	08/08/2024 07:51:36	20

Work order Test Plan Mapping

Overview

The **Work Order Test Plan Mapper** is designed to facilitate the mapping of work orders to test plans. It involves selecting a work order and test plan from dropdown lists, then mapping test plan descriptions to work order operations. The feature includes a status display for each description and an option to clone mappings from recent work orders with the same item.

- Initial Screen

Functional Components

- 1. Work Order Dropdown**
 - Field Type:** Dropdown list
 - Purpose:** Allows users to select a specific work order.
 - Options:** List of available work orders.
- 2. Test Plan Dropdown**
 - Field Type:** Dropdown list
 - Purpose:** Allows users to select a specific test plan.
 - Options:** List of available test plans.
- 3. Get Mapping Button**
 - Field Type:** Button
 - Purpose:** Fetches and displays all test plan descriptions and the operations involved in the selected work order.
- 4. Test Plan Description and Operation Mapping**
 - Field Type:** Dropdown list (for operations)
 - Purpose:** Allows users to map each test plan description to an operation from the selected work order.
 - Editable:** Only operations can be selected; descriptions are read-only.
- 5. Mapping Status Display**

- **Field Type:** Status indicator or message
- **Purpose:** Shows the current status of each test plan description (e.g., whether it is correctly mapped or if any mappings are missing).

6. Clone Mapping Option

- **Field Type:** Button
- **Purpose:** Allows users to clone mappings from a recent work order with the same item.
- **Action:** Clicking the clone button duplicates the recent mapping setup, which can then be adjusted if needed.

Implementation Steps

1. Select Work Order

- **Action:** Use the dropdown lists to select the desired work order and Click the **GET MAPPING** "Get Mapping" button.
- **Result:** If no cloning possible is there Test plan dropdown will be released, else a confirmation pop up will be showed for cloning ([Clone Recent Mapping](#))

2. Fetch Mappings

- **Action:** Select the test plan required from the dropdown.
- **Result:** The system retrieves and displays all test plan descriptions for the selected test plan and the operations available for the selected work order.

Work Order-Test Plan Mapping

Work Order: 289095 Test Plan: 0W49255B GET MAPPING CANCEL

Test Parameter	Map status
L-End A Braid to vendor ID label 70±5	Not Mapped
L-Braid to destination label A side 50±5	Not Mapped
Nick mark As per Req.	Not Mapped
Terminal cut As per Req.	Not Mapped
strands cut As per Req.	Not Mapped

Test Parameter List

Test Plan Parameters	Operation	Operation Description	Actions
L-End A Braid to vendor ID label 70±5	0	▼	
L-Braid to destination label A side 50±5	0	▼	
Nick mark As per Req.	0	▼	
Terminal cut As per Req.	0	▼	
strands cut As per Req.	0	▼	
Terminal bend As per Req.	0	▼	
free from Connector damage As per Req.	0	▼	

EDIT ADD ROW SAVE REFRESH

3. Map Descriptions to Operations

- Action:** For each test plan description, select an operation from the dropdown list.
- Requirement:** Each test plan description must be mapped to an operation. This mapping is mandatory for scheduling.

PES

Work Order-Test Plan Mapping

Work Order: 289095 Test Plan: 0W49255B GET MAPPING CANCEL

Test Parameter	Map status
L-End A Braid to vendor ID label 70±5	Mapped
L-Braid to destination label A side 50±5	Not Mapped
Nick mark As per Req.	Not Mapped
Terminal cut As per Req.	Not Mapped
strands cut As per Req.	Not Mapped

Test Parameter List

Test Plan Parameters	Operation	Operation Description	Actions
L-End A Braid to vendor ID label 70±5	10	Cable Cutting/Stripping	
L-Braid to destination label A side 50±5	0	▼	
Nick mark As per Req.	0	▼	
Terminal cut As per Req.	0	▼	
strands cut As per Req.	0	▼	
Terminal bend As per Req.	0	▼	
free from Connector damage As per Req.	0	▼	

EDIT ADD ROW SAVE REFRESH

4. View Mapping Status

- Action:** The status of each description is displayed above the mapping area.

Work Order-Test Plan Mapping

Work Order 289095	Test Plan 0W49255B	GET MAPPING	CANCEL																								
Work Order Details																											
Work Order : 289095	Routing Lot : 8386942																										
Item Number : 2P026885-004LF	Run Time : 1456.71																										
Description : 2P026885-004LF IOMC-SNS CBL	Setup Time : 0.4590000000000001																										
Order Quantity : 1770	Sales Order : 0																										
Item Type : 632	Test Plan : 0W49255B																										
<table border="1"> <thead> <tr> <th>Test Parameter</th> <th>Map status</th> </tr> </thead> <tbody> <tr> <td>L-End A Braid to vendor ID label 70±5</td> <td>Mapped</td> </tr> <tr style="background-color: yellow;"> <td>L-Braid to destination label A side 50±5</td> <td>Not Mapped</td> </tr> <tr> <td>Nick mark As per Req.</td> <td>Mapped</td> </tr> <tr> <td>Terminal cut As per Req.</td> <td>Mapped</td> </tr> <tr> <td>strands cut As per Req.</td> <td>Mapped</td> </tr> </tbody> </table>				Test Parameter	Map status	L-End A Braid to vendor ID label 70±5	Mapped	L-Braid to destination label A side 50±5	Not Mapped	Nick mark As per Req.	Mapped	Terminal cut As per Req.	Mapped	strands cut As per Req.	Mapped												
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Test Parameter List <div style="text-align: right; margin-right: 10px;"> EDIT ADD ROW SAVE REFRESH </div> <table border="1"> <thead> <tr> <th>Test Plan Parameters</th> <th>Operation</th> <th>Operation Description</th> <th>Actions</th> </tr> </thead> <tbody> <tr> <td>L-End A Braid to vendor ID label 70±5</td> <td>10</td> <td>Cable Cutting/Stripping</td> <td></td> </tr> <tr style="background-color: yellow;"> <td>L-Braid to destination label A side 50±5</td> <td>0</td> <td>Cable Twisting</td> <td></td> </tr> <tr> <td>Nick mark As per Req.</td> <td>30</td> <td>Cable Twisting</td> <td></td> </tr> <tr> <td>Terminal cut As per Req.</td> <td>40</td> <td>Housing</td> <td></td> </tr> <tr> <td>strands cut As per Req.</td> <td>70</td> <td>Housing Terminal Insert</td> <td></td> </tr> </tbody> </table>				Test Plan Parameters	Operation	Operation Description	Actions	L-End A Braid to vendor ID label 70±5	10	Cable Cutting/Stripping		L-Braid to destination label A side 50±5	0	Cable Twisting		Nick mark As per Req.	30	Cable Twisting		Terminal cut As per Req.	40	Housing		strands cut As per Req.	70	Housing Terminal Insert	
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L-End A Braid to vendor ID label 70±5	10	Cable Cutting/Stripping																									
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Nick mark As per Req.	30	Cable Twisting																									
Terminal cut As per Req.	40	Housing																									
strands cut As per Req.	70	Housing Terminal Insert																									

5. Save Mappings

- **Action:** Ensure all mappings are complete and correct.
- **Validation:** The system may provide feedback or require confirmation before allowing the work order to be scheduled.
- **Status Example:** "Mapped," "Not Mapped," or any other relevant status indicator.

Clone Recent Mapping

- The **Clone Mapping** feature allows users to quickly replicate mappings from a recent work order with the same item. This functionality aids in streamlining the mapping process by reusing existing setups.

Example Workflow

1. Initiate Cloning
 - User selects the relevant work order.
 - Clicks the "Get Mapping" button.
 - If Cloning available, it opens a confirmation dialog
2. Confirmation Dialog
 - A dialog box appears: "Item number "Item Number" of workorder "work order number" is previously mapped with test plan. Do you want to clone?"
 - User clicks OK to proceed with cloning.

Work Order-Test Plan Mapping

Work Order: 289095 Test Plan: 2P026885-004LF GET MAPPING CANCEL

Test Parameter Map status

No data available

Work Order Details

Work Order: 289095 Item Number: 2P026885-004LF Description: 2P026885-004LF IOMC-SNS CBL Order Quantity: 1770 Item Type: 632 Routing Lot: 8386942 Run Time: 1456.71 Setup Time: 0.4590000 Sales Order: 0 Test Plan:

Item number 2P026885-004LF of workorder 289090 is previously mapped with test plan . Do you want to clone ?

OK Cancel EDIT ADD ROW SAVE REFRESH

Test Parameter List

Test Plan Parameters Operation

No Test Plan Mapped

3. View and Edit Cloned Data

- The system populates the mapping fields with the cloned data.
- User reviews and, if necessary, modifies the data.

PES PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Work Order-Test Plan Mapping

Work Order: 289095 Test Plan: 2P026885-004LF GET MAPPING CANCEL

Test Parameter Map status

Wire gauge 28AWG	Mapped
Wire gauge 26AWG	Mapped
UL Type 1061	Mapped
UL Type 1007	Mapped
Cable color Black/Yellow	Mapped

Work Order Details

Work Order: 289095 Item Number: 2P026885-004LF Description: 2P026885-004LF IOMC-SNS CBL Order Quantity: 1770 Item Type: 632 Routing Lot: 8386942 Run Time: 1456.71 Setup Time: 0.4590000000000001 Sales Order: 0 Test Plan: 2P026885-004LF

Test Parameter List

Test Plan Parameters	Operation	Operation Description	Actions
Wire gauge 28AWG	10	Cable Cutting/Stripping	EDIT ADD ROW SAVE REFRESH
Wire gauge 26AWG	10	Cable Cutting/Stripping	
UL Type 1061	10	Cable Cutting/Stripping	
UL Type 1007	10	Cable Cutting/Stripping	
Cable color Black/Yellow	10	Cable Cutting/Stripping	
cable part no 1CBL1P28AWG1061B/Y	10	Cable Cutting/Stripping	
cable part no 1CBL28AWG1007BLK	10	Cable Cutting/Stripping	

4. Save or Adjust.

Holiday

The Holiday Viewer is a read-only interface designed to display the holidays recognized at a site, which are factored into scheduling processes. Users cannot edit or delete records through this view. Key features include:

- **Holiday List:** Display of all holidays observed at the site.
- **Holiday Details:** Dates and descriptions of each holiday.

This viewer provides a comprehensive overview of site holidays to assist in accurate scheduling without allowing modifications.

Holiday			
Business Unit	Site	Date	Holiday Name
4950	49510	26-02-2024	Lockdown
4950	49510	29-03-2024	Good Friday
4950	49510	15-08-2024	Independence day
4950	49510	02-10-2024	GANDHI JAYANTHI
4950	49510	25-12-2024	CHRISTMAS

Items per page: 25 ▾ 1-5 of 5 | < >

Production Line Status

Overview

The **Production Line Status** screen provides a real-time overview of the operational status of various production lines within a manufacturing facility. This feature is designed to help managers to monitor the performance and current state of each production line, enabling timely decisions and efficient operations.

- Initial Screen

The screenshot shows the 'Production Line Status' interface. At the top, there's a search bar labeled 'Add Production Line Status' with dropdowns for 'PL Line', 'PL Status', and 'Reason', and date/time fields for 'Start Date & Time' and 'End Date & Time'. Below this is a large table titled 'Production Line Status' with columns for PL Line, Shift, PL Status, Reason, Start Time, End Time, Job Order, Op, OEE, Availability, Qty, Perf, Planned Qty, Actual Qty, and Actions. The table lists several entries for different production lines like CUTM1, SFSA1, SFWH1, etc., with various status types such as Completed, In Progress, and Planned.

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:27:36	289093-01	10							
CUTM1	S1	Completed		25/03/2024 07:27:36	25/03/2024 07:43:12	289093-01	20							
SFSA1	S1	Completed		25/03/2024 07:43:12	25/03/2024 08:22:48	289093-01	30							
SFWH1	S1	Completed		25/03/2024 08:22:48	25/03/2024 09:32:24	289093-01	999	6469.86	9242.66	93.33	75	20	15	
CUTM3	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:55:12	289094-01	10							
CUTM3	S1	Completed		25/03/2024 07:55:12	25/03/2024 08:26:24	289094-01	20							
CUTM3	S1	Completed		25/03/2024 08:26:24	25/03/2024 10:45:36	289094-01	999	2669.64	3955.03	90	75	40	30	
CUTM4	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:34:30	289084-01	10							
CUTM4	S1	In Progress		25/03/2024 07:34:30	25/03/2024 07:54:00	289084-01	20							
SFWH4	S1	Planned		12/07/2024 08:27:00	12/07/2024 09:54:00	289084-01	999							

Key Features

1. Create or Edit Production Line Status

- Purpose:** Allows users to define and update the status of each production line.
- Statuses:**
 - Breakdown:** Indicates that the production line is non-operational due to equipment failure or other issues.
 - Idle:** Represents a state where the production line is operational but not currently in use.
 - Maintenance:** Denotes that the production line is undergoing maintenance and is temporarily out of service.
 - Planned:** Shows upcoming scheduled activities by the scheduler.

2. Scheduling Integration

- Purpose:** Prevents scheduling conflicts by considering the current status of production lines.
- Functionality:** The system will cross-reference scheduled jobs with the production line status to avoid overlapping with periods of Breakdown, Idle, or Maintenance.

3. Efficiency Monitoring

- Purpose:** Tracks the performance and utilization of production lines.
- Functionality:** Provides metrics on how often production lines are in each status, helping to identify areas for improvement and optimize production scheduling.

4. Avoid Scheduling Conflicts

- **Purpose:** Ensures that new jobs or production schedules do not overlap with existing statuses.
- **Functionality:** Alerts users if a scheduled job conflicts with a production line's current status (e.g., scheduling a job during a Maintenance period).

Create or Edit Status

- **Creation:**
 - **Fields Required:** Select Production line, status type (Breakdown, Idle, Maintenance), reason, enter start time, end time.
 - **Save:** Confirm and save the new status.
- Entry of new record with Production Line, PL status, Reason, Start time and End time
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 12:17:00
 - End Time: 20-08-2024 15:17:00

Production Line Status

Add Production Line Status

PL Line CUTM1	PL Status Breakdown	Reason BD101 - Machine Breakdown	Start Date & Time 20-08-2024 12:17	End Date & Time 20-08-2024 15:17	SAVE	CANCEL
------------------	------------------------	-------------------------------------	---------------------------------------	-------------------------------------	-------------	---------------

Production Line Status

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:27:36	289093-01	10							
CUTM1	S1	Completed		25/03/2024 07:27:36	25/03/2024 07:43:12	289093-01	20							
SFSA1	S1	Completed		25/03/2024 07:43:12	25/03/2024 08:22:48	289093-01	30							
SFWH1	S1	Completed		25/03/2024 08:22:48	25/03/2024 09:32:24	289093-01	999	6469.86	9242.66	93.33	75	20	15	
CUTM3	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:55:12	289094-01	10							
CUTM3	S1	Completed		25/03/2024 07:55:12	25/03/2024 08:26:24	289094-01	20							
CUTM3	S1	Completed		25/03/2024 08:26:24	25/03/2024 10:45:36	289094-01	999	2669.64	3955.03	90	75	40	30	
CUTM4	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:34:30	289084-01	10							
CUTM4	S1	In Progress		25/03/2024 07:34:30	25/03/2024 07:54:00	289084-01	20							
SFWH4	S1	Planned		12/07/2024 08:27:00	12/07/2024 09:54:00	289084-01	999							

- The new record got added and got split based on shift hours (S1 – 07:00:00 to 15:00:00, S2 – 15:00:00 to 23:00:00, S3 – 23:00:00 to 07:00:00)
 - Record 1:
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 12:17:00
 - End Time: 20-08-2024 15:00:00
 - Record 2:
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 15:00:00
 - End Time: 20-08-2024 15:17:00

Production Line Status											Filter Status 			
Production Line Status											Search 			
PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									 
CUTM1	S2	Maintenance	MAN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									 
CUTM1	S3	Maintenance	MAN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									 
CUTM1	S1	Maintenance	MAN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									 
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:17:00	20/08/2024 15:00:00									 
CUTM1	S2	Breakdown	BD101- Machine Breakdown	20/08/2024 15:00:00	20/08/2024 15:17:00									 

- Editing (only for the future statuses):**
 - Action:** Select an existing status from the list.
 - Fields Editable:** Update status type, start time, end time, and notes.
 - Save:** Confirm and save the changes.
- Editing the existing record
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 12:17:00
 - End Time: 20-08-2024 15:00:00

Edit PL Status

PL Line CUTM1	PL Status Breakdown	Reason BD101 - Machine Breakdown	Start Time 20-08-2024 12:17	End Time 20-08-2024 15:00	SAVE	CANCEL
------------------	------------------------	-------------------------------------	--------------------------------	------------------------------	-------------	---------------

Production Line Status

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									
CUTM1	S2	Maintenance	MAN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									
CUTM1	S3	Maintenance	MAN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									
CUTM1	S1	Maintenance	MAN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:17:00	20/08/2024 15:00:00									
CUTM1	S2	Breakdown	BD101- Machine Breakdown	20/08/2024 15:00:00	20/08/2024 15:17:00									

- Editing the start time of the record
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 12:00:00 (from 12:17:00)**
 - End Time: 20-08-2024 15:17:00

Edit PL Status

PL Line CUTM1	PL Status Breakdown	Reason BD101 - Machine Breakdown	Start Time 20-08-2024 12:00	End Time 20-08-2024 15:00	SAVE	CANCEL
------------------	------------------------	-------------------------------------	--------------------------------	------------------------------	-------------	---------------

Production Line Status

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									
CUTM1	S2	Maintenance	MAN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									
CUTM1	S3	Maintenance	MAN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									
CUTM1	S1	Maintenance	MAN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:17:00	20/08/2024 15:00:00									
CUTM1	S2	Breakdown	BD101- Machine Breakdown	20/08/2024 15:00:00	20/08/2024 15:17:00									

Aug 2024

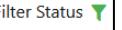
Mo	Tu	We	Th	Fr	Sa	Su
29	30	31	1	2	3	4
5	6	7	8	9	10	11
12	13	14	15	16	17	18
19	20	21	22	23	24	25
26	27	28	29	30	31	1

12 : 00

- Edit record saved
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 12:00:00**
 - End Time: 20-08-2024 15:17:00

Production Line Status												Filter Status 		
Add Production Line Status														
PL Line	Shift	PL Status	Reason	Start Date & Time	End Date & Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									 
CUTM1	S2	Maintenance	MAN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									 
CUTM1	S3	Maintenance	MAN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									 
CUTM1	S1	Maintenance	MAN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									 
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:00:00	20/08/2024 15:00:00									 
CUTM1	S2	Breakdown	BD101- Machine Breakdown	20/08/2024 15:00:00	20/08/2024 15:17:00									 

- Delete (only for future statuses):**
 - Action:** Select the status to be deleted. Confirm it from the dialogue box and also the data won't be considered for upcoming scheduling.
 - Selecting the record for deletion**
 - Production Line: CUTM1
 - PL Status: Breakdown
 - Start Time: 20-08-2024 15:00:00
 - End Time: 20-08-2024 15:17:00

Production Line Status												Filter Status 		
Add Production Line Status														
PL Line	Shift	PL Status	Reason	Start Date & Time	End Date & Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									 
CUTM1	S2	Maintenance	MAN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									 
CUTM1	S3	Maintenance	MAN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									 
CUTM1	S1	Maintenance	MAN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									 
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:00:00	20/08/2024 15:00:00									 
CUTM1	S2	Breakdown	BD101- Machine Breakdown	20/08/2024 15:00:00	20/08/2024 15:17:00									 

- Confirmation before deleting the record.**

Production Line Status

Add Production Line Status

PL Line	PL Status	Reason	Start Date & Time	End Date & Time	SAVE	CANCEL
---------	-----------	--------	-------------------	-----------------	------	--------

Are you sure you want to delete this item?

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAIN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									/ \
CUTM1	S2	Maintenance	MAIN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									/ \
CUTM1	S3	Maintenance	MAIN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									/ \
CUTM1	S1	Maintenance	MAIN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									/ \
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:00:00	20/08/2024 15:00:00									/ \
CUTM1	S2	Breakdown	BD101- Machine Breakdown	20/08/2024 15:00:00	20/08/2024 15:17:00									/ \

- **Record got deleted.**

- Production Line: CUTM1
- PL Status: Breakdown
- Start Time: 20-08-2024 15:00:00
- End Time: 20-08-2024 15:17:00

Production Line Status

Add Production Line Status

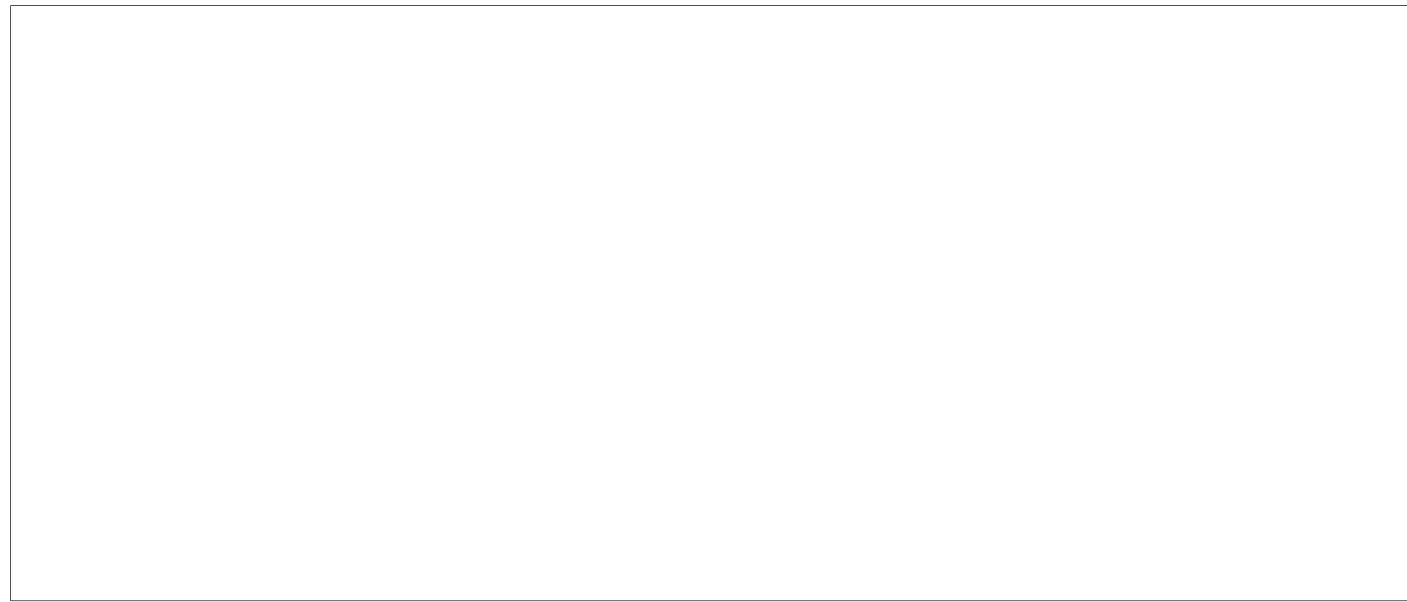
PL Line	PL Status	Reason	Start Date & Time	End Date & Time	SAVE	CANCEL
---------	-----------	--------	-------------------	-----------------	------	--------

Are you sure you want to delete this item?

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAIN101- cable shortage	23/09/2024 10:12:00	23/09/2024 15:00:00									/ \
CUTM1	S2	Maintenance	MAIN101- cable shortage	23/09/2024 15:00:00	23/09/2024 23:00:00									/ \
CUTM1	S3	Maintenance	MAIN101- cable shortage	23/09/2024 23:00:00	24/09/2024 07:00:00									/ \
CUTM1	S1	Maintenance	MAIN101- cable shortage	24/09/2024 07:00:00	24/09/2024 10:22:00									/ \
CUTM1	S1	Breakdown	BD101- Machine Breakdown	20/08/2024 12:00:00	20/08/2024 15:00:00									/ \

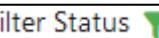
Shift-Based Data Storage

- **Description:** Data is stored based on shifts, where each shift represents an 8-hour period.
- **Example:** If a production line status of "Maintenance" is recorded from 22/03/2024 07:00:00 to 23/03/2024 07:00:00 (24 hours), this period will be automatically divided into three shifts:
 - **Shift 1 (S1):** 22/03/2024 07:00:00 to 22/03/2024 15:00:00
 - **Shift 2 (S2):** 22/03/2024 15:00:00 to 22/03/2024 23:00:00
 - **Shift 3 (S3):** 22/03/2024 23:00:00 to 23/03/2024 07:00:00



Other Features

- **Filtering by Date Range:**

- **Purpose:** Allows users to view statuses within a specific date range, improving the ability to manage and analyze data for particular periods.
- **Steps:**
 - Click on **Filter Status**  filter icon on top right.
 - Select start and end dates, apply filter, view results.

Production Line Status												Filter Status 		
Add Production Line Status												SEARCH		
PL Line	Shift	PL Status	Reason	Start Date & Time	End Date & Time	SAVE	CANCEL							
PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:27:36	289093-01	10							
CUTM1	S1	Completed		25/03/2024 07:27:36	25/03/2024 07:43:12	289093-01	20							
SFSA1	S1	Completed		25/03/2024 07:43:12	25/03/2024 08:22:48	289093-01	30							
SFWH1	S1	Completed		25/03/2024 08:22:48	25/03/2024 09:32:24	289093-01	999	6469.86	9242.66	93.33	75	20	15	
CUTM3	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:55:12	289094-01	10							
CUTM3	S1	Completed		25/03/2024 07:55:12	25/03/2024 08:26:24	289094-01	20							
CUTM3	S1	Completed		25/03/2024 08:26:24	25/03/2024 10:45:36	289094-01	999	2669.64	3955.03	90	75	40	30	
CUTM4	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:34:30	289084-01	10							
CUTM4	S1	In Progress		25/03/2024 07:34:30	25/03/2024 07:54:00	289084-01	20							
SFWH4	S1	Planned		12/07/2024 08:27:00	12/07/2024 09:54:00	289084-01	999							

- Selection of Start and End time
 - Start Time: 01-08-2024 12:08:00
 - End Time: 31-08-2024 12:08:00

Production Line Status

Add Production Line Status

PL Line	Shift	PL Status	Reason	Start Date & Time	End Date & Time	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Completed		25/03/2024 07:43:12	25/03/2024 08:22:48	289093-01	30			
CUTM1	S1	Completed		25/03/2024 08:22:48	25/03/2024 09:32:24	289093-01	999	6469.86	9242.66	93.33 75 20 15
SFSA1	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:55:12	289094-01	10			
CUTM3	S1	Completed		25/03/2024 07:55:12	25/03/2024 08:26:24	289094-01	20			
CUTM3	S1	Completed		25/03/2024 08:26:24	25/03/2024 10:45:36	289094-01	999	2669.64	3955.03	90 75 40 30
CUTM4	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:34:30	289084-01	10			
CUTM4	S1	In Progress		25/03/2024 07:34:30	25/03/2024 07:54:00	289084-01	20			
SFWH4	S1	Planned		12/07/2024 08:27:00	12/07/2024 09:54:00	289084-01	999			

Filter Options

Start Date & Time: 01-08-2024 12:08 End Date & Time: 31-08-2024 12:08

SEARCH

Filter Status ▾

SAVE CANCEL

- Records available for the Selected Dates
 - First Page

Production Line Status

Add Production Line Status

PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Maintenance	MAN101- cable shortage	05/08/2024 07:00:00	05/08/2024 10:31:00									edit
CUTM1	S2	Planned		06/08/2024 08:00:00	06/08/2024 09:09:00	289080-11	10							
CUTM1	S2	Planned		06/08/2024 09:09:00	06/08/2024 09:48:00	289080-11	20							
CUTM1	S1	Planned		06/08/2024 09:48:00	06/08/2024 10:50:06	289090-05	10							
SFSA1	S2	Planned		06/08/2024 09:48:00	06/08/2024 11:57:00	289080-11	140							
CUTM1	S1	Planned		06/08/2024 10:50:06	06/08/2024 11:25:12	289090-05	20							
SFFO1	S1	Planned		06/08/2024 11:25:12	06/08/2024 13:21:18	289090-05	140							
SFSE1	S2	Planned		06/08/2024 11:57:00	06/08/2024 14:06:00	289080-11	150							
SFWH1	S2	Planned		06/08/2024 14:06:00	06/08/2024 17:00:00	289080-11	999							
SFSA1	S2	Planned		06/08/2024 15:00:00	06/08/2024 16:56:06	289090-05	150							

Search REFRESH

Items per page: 10 1-10 of 154

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- Last page

Production Line Status

Add Production Line Status

PL Line

PL Status

Reason

Start Date & Time
End Date & Time

Production Line Status										Search	REFRESH			
PL Line	Shift	PL Status	Reason	Start Time	End Time	Job Order	Op	OEE	Availability	Qty	Perf	Planned Qty	Actual Qty	Actions
SFSE3	S3	Planned		29/08/2024 02:09:36	29/08/2024 03:52:48	289080-35	140							
SFWH4	S3	Planned		29/08/2024 03:52:48	29/08/2024 06:12:00	289080-34	999							
SFSE4	S3	Planned		29/08/2024 03:52:48	29/08/2024 05:36:00	289080-35	150							
SFWH4	S1	Planned		29/08/2024 07:00:00	29/08/2024 09:19:12	289080-35	999							

Items per page: 151-154 of 154 |< < > >|

- **Search Across Data:**

- **Purpose:** Enables users to quickly locate specific statuses based on various criteria such as status type, production line, or reason.
- **Steps:** Enter search like production line, status, start or end time and view results.

Production Line Status

Add Production Line Status

Filter Status 

PL Line	PL Status	Reason	Start Date & Time	End Date & Time	SAVE	CANCEL
CUTM1	S1	MaintenanceMAN101- cable shortage	05/08/2024 07:00:00	05/08/2024 10:31:00		
CUTM1	S3	MaintenanceMAN101- cable shortage	26/08/2024 23:18:00	27/08/2024 07:00:00		
CUTM1	S1	MaintenanceMAN101- cable shortage	27/08/2024 07:00:00	27/08/2024 15:00:00		
CUTM1	S2	MaintenanceMAN101- cable shortage	27/08/2024 15:00:00	27/08/2024 16:19:00		

Scheduling Work Bench

Overview

The Scheduling Work Bench is designed to efficiently manage work orders, including splitting large quantities into smaller job orders, editing schedules, and providing comprehensive views of production line statuses. This tool enhances scheduling accuracy and resource management by offering real-time insights and graphical representations of production schedules.

Initial Page

Scheduling Work Bench

WorkOrder :	Item Number :	Description :	Order Quantity :	Sales Order :	Routing Lot :	Run Time :	Setup Time :	Test Plan :	Item Type:	GET PL	REFRESH	ADD ROW
289080	2P026885-004LF/ 1770				140 - Electrical Testing	26/03/2024	26/03/2024 15:43:12	26/03/2024 16:34:48	SFSA2	S2	20	<input type="checkbox"/>
289080	2P026885-004LF/ 1770				150 - Packing	26/03/2024	26/03/2024 16:34:48	26/03/2024 17:26:24	SFSE2	S2	20	<input type="checkbox"/>
289093	0w49323CLF/ 400				10 - Cable Cutting	24/04/2024	24/04/2024 15:00:00	24/04/2024 15:14:35	CUTM3	S2	10	<input checked="" type="checkbox"/>
289093	0w49323CLF/ 400				20 - Crimping	24/04/2024	24/04/2024 15:14:35	24/04/2024 15:22:23	CUTM2	S2	10	<input type="checkbox"/>
289093	0w49323CLF/ 400				30 - Housing	24/04/2024	24/04/2024 23:00:00	24/04/2024 23:21:36	CUTM4	S3	10	<input checked="" type="checkbox"/>
289093	0w49323CLF/ 400				999 - SF Wkctr for WH	24/04/2024	24/04/2024 23:21:36	24/04/2024 23:56:24	SFSE2	S3	10	<input type="checkbox"/>

Items per page: All 1-285 of 285 | < < > >|

YESTERDAY TODAY TOMORROW SELECT DATE

Today Schedule

Search PL # GET PL SCHE

P L #	Shift 1	Shift 2	Shift 3
		No data available	

Scroll Down for Production Line Status Graphical Chart View

YESTERDAY TODAY TOMORROW SELECT DATE

Today Schedule

Search PL # GET PL SCHEDULE

P L #	Shift 1	Shift 2	Shift 3
		No data available	

Items per page: 10 0-0 of 0 | < < > >| GET SCHEDULED DE

YESTERDAY TODAY TOMORROW SELECT DATE

- Scroll Down for PL Status Graph View

The screenshot shows a software application for scheduling production. At the top, there are tabs for "YESTERDAY", "TODAY" (which is selected), "TOMORROW", and "SELECT DATE". Below these tabs, the interface is titled "Today Schedule". There are four columns: "P L #" (Production Line Number), "Shift 1", "Shift 2", and "Shift 3". Under "Shift 2", it displays the message "No data available". At the bottom right of the main area, there is a blue circular icon containing a white upward-pointing arrow.

Key Features

1. Bulk Quantity Splitting:

- **Work Order Management:** Start with a bulk work order, e.g., 1000 units.
- **Job Order Creation:** Divide the bulk quantity into smaller, manageable job orders. For example, split 1000 units into multiple job orders of 100 units each or other specified quantities.
- **Custom Splits:** Configure varying quantities for each job order as needed to match production requirements and line capacities.

2. Operation Assignment:

- Allocate each split job order to specific production lines.
- Assign shifts and dates for each job order based on operational availability and scheduling requirements.

3. Validation Process:

- Use the "Validate" button to ensure that each split job order is feasible and that resources are available.
- The system checks if the production line, shift, and date are clear of conflicts and if the schedule adheres to all constraints.
- Positive validation allows you to save the job orders; negative validation provides error messages for required adjustments.
- Save the validated job orders.

4. Edit Schedule Functionality:

- **Editable Job Orders:** If a job order has not yet started, you can edit its details, including production line, shift, and date.
- **Revalidation:** After making changes to the job order, revalidate the schedule to ensure all adjustments are compatible and conflicts are resolved.
- **Update and Save:** Apply changes and save the updated job order schedule once revalidation is successful.

5. Error Handling and Revalidation:

- Address any validation issues by modifying the production line, shift, or date as suggested by the system.
- Revalidate after adjustments to ensure all conditions are satisfied.
- Continue this process until all job orders are successfully validated and saved.

6. Production Line Status Viewing:

- **Status Screen Access:** View the status of production line directly from the Scheduling Work Bench.
- **Scheduling Based on Status:** Make informed scheduling decisions based on the current status of production lines to avoid conflicts and optimize resource utilization.
- All actions involved in production line status can be done from the pop up screen.

- Click on **GET PL** button to see the PL records.

The screenshot shows the 'Scheduling Work Bench' interface. At the top, there are input fields for 'WorkOrder', 'Item Number', 'Description', 'Order Quantity', and 'Sales Order'. To the right are buttons for 'GET PL' (highlighted in blue), 'REFRESH', and 'ADD ROW'. Below this is a table with columns: WorkOrder, Item Number/Order Quantity, Job Order, Operation, Job Date, Planned Start Date, Planned End Date, PL, Shift, Load Qty, Setup, and Status. The table contains several rows of data. At the bottom of the table, there are buttons for 'YESTERDAY', 'TODAY' (highlighted in orange), 'TOMORROW', and 'SELECT DATE'. To the right of the table are buttons for 'Items per page' (with 'All' selected) and '1-285 of 285'. Below the table, there is a section for 'Today Schedule' with a 'Search PL #' input field and a 'GET PL SCHEDULE' button. The bottom of the interface shows navigation links for 'PL 1', 'PL 2', 'PL 3', and 'PL 4'.

- Production Line Status screen will be opened as a pop up.

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Production Line Status

Add Production Line Status

PL Line PL Status Reason Start Date & Time End Date & Time Filter Status

PL Line	Shift	PL Status	Reason	Start Time	End Time ↑	Job Order	Op	OEE	Availability	Cty	Perf	Planned Qty	Actual Qty	Actions
CUTM1	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:27:36	289093-01	10							
CUTM1	S1	Completed		25/03/2024 07:27:36	25/03/2024 07:43:12	289093-01	20							
SFSA1	S1	Completed		25/03/2024 07:43:12	25/03/2024 08:22:48	289093-01	30							
SFWH1	S1	Completed		25/03/2024 08:22:48	25/03/2024 09:32:24	289093-01	999	6469.86	9242.66	93.33	75	20	15	
CUTM3	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:55:12	289094-01	10							
CUTM3	S1	Completed		25/03/2024 07:55:12	25/03/2024 08:26:24	289094-01	20							
CUTM3	S1	Completed		25/03/2024 08:26:24	25/03/2024 10:45:36	289094-01	999	2669.64	3955.03	90	75	40	30	
CUTM4	S1	Completed		25/03/2024 07:00:00	25/03/2024 07:34:30	289084-01	10							
CUTM4	S1	In Progress		25/03/2024 07:34:30	25/03/2024 07:54:00	289084-01	20							
SFWH4	S1	Planned		12/07/2024 08:27:00	12/07/2024 09:54:00	289084-01	999							

Workflow to schedule a job order

1. Add New Schedule Entry:

- Click the **ADD ROW** "Add Row" button to create a new job order entry in the scheduling workbench.

Scheduling Work Bench											
WorkOrder :				Routing Lot :							
Work Order	Item Number/ Order Quantity	Job Order	Operation	Job Date	Planned Start Date	Planned End Date	PL	Shift	Load Qty	Setup	Status
289080	2P026885-004LF/ 1770	289080-01	140 - Electrical Testing	26/03/2024	26/03/2024 15:43:12	26/03/2024 16:34:48	SFS2A	S2	20	<input type="checkbox"/>	
289080	2P026885-004LF/ 1770	289080-01	150 - Packing	26/03/2024	26/03/2024 16:34:48	26/03/2024 17:26:24	SFSE2	S2	20	<input type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	10 - Cable Cutting	24/04/2024	24/04/2024 15:00:00	24/04/2024 15:14:35	CUTM3	S2	10	<input checked="" type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	20 - Crimping	24/04/2024	24/04/2024 15:14:35	24/04/2024 15:22:23	CUTM2	S2	10	<input type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	30 - Housing	24/04/2024	24/04/2024 23:00:00	24/04/2024 23:21:36	CUTM4	S3	10	<input checked="" type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	999 - SF Wkctr for WH	24/04/2024	24/04/2024 23:21:36	24/04/2024 23:56:24	SFSE2	S3	10	<input type="checkbox"/>	

Items per page: 1-285 of 285 | < > >>

YESTERDAY TODAY TOMORROW SELECT DATE

- New Pop up screen will be opened as below.

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Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
<input style="width: 100%; height: 30px; border: 1px solid #ccc;" type="text"/>	<input style="width: 100px; height: 30px; border: 1px solid #ccc;" type="button" value="GET DETAILS"/>						<input style="width: 150px; height: 30px; border: 1px solid #ccc;" type="text" value="Enter load Quantity"/>

Schedule Details

Job Order	Operation	Operation Desc	Run Time	Job Date	PL ↑	Shift	Planned Start Date	Planned End Date	Setup	Status
No data available										

Items per page: 0-0 of 0 | < > >>

YESTERDAY TODAY TOMORROW SELECT DATE

2. Select Work Order:

- Click the dropdown menu in the "Work Order" field.
- Choose the work order you want to schedule and click on **GET DETAILS** Get Details button. This action will automatically populate the mapped operations and their details from the backend.

The screenshot shows the 'Schedule Details' page for work order 289080. At the top, there is a header bar with the PES logo and user information: 'PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510'. Below the header, there is a summary table with the following data:

Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
289080	2P026885-004LF	1770	1590	180	64:48:00	00:21:36	0

Below the summary table is a section titled 'Schedule Details' containing a table of operations:

Job Order	Operation	Operation Desc	Run Time	Job Date	PL	Shift	Planned Start Date	Planned End Date	Setup	Status
289080-37	10	Cable Cutting/Stripping	00:01:23	18 / 08 / 2024	▼	▼				□
289080-37	10	Cable Cutting/Stripping	00:01:23	18 / 08 / 2024	▼	▼				□
289080-37	20	Crimping	00:00:47	18 / 08 / 2024	▼	▼				□
289080-37	20	Crimping	00:00:47	18 / 08 / 2024	▼	▼				□
289080-37	140	Electrical Testing	00:02:35	18 / 08 / 2024	▼	▼				□

At the bottom of the page, there are buttons for 'VALIDATE', 'SAVE', and 'CLOSE'. Below the buttons, there are date selection options: 'YESTERDAY', 'TODAY', 'TOMORROW', and 'SELECT DATE'.

3. Define Job Order Details:

- **Quantity (Qty):** Enter the quantity for the job order.
- **Production Line (PL):** Select the production line where the job order will be executed.
- **Shift:** Specify the shift during which the job order will take place.
- **Date:** Set the date for each operation associated with the job order.

- Selection of job date & Enter the load quantity

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Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
289090	2P026885-004LF	1750	327	1423	256:08:24	00:10:48	30

Schedule Details

Job Order	Operation	Operation Desc	Run Time	Job Date	PL	Shift	Planned Start Date	Planned End Date	Setup	Status
289090-10	10	Cable Cutting/Stripping	00:01:23	18 / 09 / 2024	CUTM1					
289090-10	20	Crimping	00:00:47							
289090-10	140	Electrical Testing	00:02:35							
289090-10	150	Packing	00:02:35							
289090-10	999	SF Wkctr for SA	00:03:29							

Job Date: September 2024
 Sun Mon Tue Wed Thu Fri Sat
 25 26 27 28 29 30 31
 1 2 3 4 5 6 7
 8 9 10 11 12 13 14
 15 16 17 18 19 20 21
 22 23 24 25 26 27 28
 29 30 1 2 3 4 5

Items per page: 5 | 1-5 of 5 | < > | VALIDATE | SAVE | CLOSE |

YESTERDAY TODAY TOMORROW SELECT DATE

- Selection of production line

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Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
289090	2P026885-004LF	1750	327	1423	256:08:24	00:10:48	30

Schedule Details

Job Order	Operation	Operation Desc	Run Time	Job Date	PL	Shift	Planned Start Date	Planned End Date	Setup	Status
289090-10	10	Cable Cutting/Stripping	00:01:23	18 / 09 / 2024	CUTM1					
289090-10	20	Crimping	00:00:47	18 / 09 / 2024	CUTM3					
289090-10	140	Electrical Testing	00:02:35	18 / 09 / 2024	SFS1					
289090-10	150	Packing	00:02:35	18 / 09 / 2024	SFS2					
289090-10	999	SF Wkctr for SA	00:03:29	18 / 09 / 2024	SFS4					

PL: CUTM1, CUTM3, SFS1, SFS2, SFS4, SFSE2, CUTM2, CUTM01, SFSE3

Items per page: 5 | 1-5 of 5 | < > | VALIDATE | SAVE | CLOSE |

YESTERDAY TODAY TOMORROW SELECT DATE

- Selection of Shift

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
289090	2P026885-004LF	1750	327	1423	256:08:24	00:10:48	30

Schedule Details

Job Order	Operation	Operation Desc	Run Time	Job Date	PL	Shift	Planned Start Date	Planned End Date	Setup	Status
289090-10	10	Cable Cutting/Stripping	00:01:23	18 / 09 / 2024	CUTM1	S1				
289090-10	20	Crimping	00:00:47	18 / 09 / 2024	CUTM1	S1				
289090-10	140	Electrical Testing	00:02:35	18 / 09 / 2024	SFSA1	S2				
289090-10	150	Packing	00:02:35	18 / 09 / 2024	SFSA2	S3				
289090-10	999	SF Wkctr for SA	00:03:29	18 / 09 / 2024	SFWH1					

Items per page: 5 | 1-5 of 5 | < > >>

VALIDATE SAVE CLOSE

YESTERDAY TODAY TOMORROW SELECT DATE

4. Validate Schedule:

- Click the "Validate" button to check if the schedule is feasible.
- **Planned Dates:** After validation, the system will display the planned start and end dates for the job order.
- **Status Check:** Review the validation status to determine if all scheduling conditions are met or if there are any errors.

Types of Validation messages while validate

- Message to move the operation to next Shift

The screenshot shows the PES Admin interface for a work order. At the top, it displays the work order number 289090, item number 2P026885-004LF, and various run times and remaining quantities. Below this is a table titled "Schedule Details" listing five operations (10, 20, 140, 150, 999) with their descriptions, run times, and shifts. A message box appears over the 140 operation row stating "Suggested to move this operation to next Available Shift S3". At the bottom right of the screen are buttons for VALIDATE, SAVE, and CLOSE.

- Message to move the job for next day

This screenshot shows the same PES Admin interface as the previous one, but with a different validation message. The "Schedule Details" table shows the same five operations. A message box over the 140 operation row states "Job is stretching to next day. Please re-plan." The bottom right of the screen has buttons for VALIDATE, SAVE, and CLOSE.

- Message that job scheduled on Holiday

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
289090	2P026885-004LF	1750	327	1423	256:08:24	00:10:48	10

Schedule Details

Job Order	Operation	Operation Desc	Run Time	Job Date	PL	Shift	Planned Start Date	Planned End Date	Setup	Status
289090-10	10	Cable Cutting/Stripping	00:01:23	02 / 10 / 2024	CUTM3	S1	Job order scheduled on a Holiday. Please re-plan the job order.			<input checked="" type="checkbox"/>
289090-10	20	Crimping	00:00:47	02 / 10 / 2024	CUTM3	S1				<input type="checkbox"/>
289090-10	140	Electrical Testing	00:02:35	02 / 10 / 2024	SFSA1	S1				<input type="checkbox"/>
289090-10	150	Packing	00:02:35	02 / 10 / 2024	SFSA2	S1				<input type="checkbox"/>
289090-10	999	SF Wkctr for SA	00:03:29	02 / 10 / 2024	SFWH1	S1				<input type="checkbox"/>

Items per page: 5 | 1-5 of 5 | < > >>

Today Schedule Search PL # GET PL SCHEDULE VALIDATE SAVE CLOSE

- Message that validation is successful.

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Select Work Order	Item Number	Order Quantity	Scheduled Qty	Remaining Qty	Remaining Run Time	Per Piece Run Time	Load Quantity
289090	2P026885-004LF	1750	327	1423	256:08:24	00:10:48	10

Schedule Details

Job Order	Operation	Operation Desc	Run Time	Job Date	PL	Shift	Planned Start Date	Planned End Date	Setup	Status
289090-10	10	Cable Cutting/Stripping	00:01:23	18 / 09 / 2024	CUTM1	S1	18/09/2024 07:00:00	18/09/2024 07:00:00	Validated Successfully	<input checked="" type="checkbox"/>
289090-10	20	Crimping	00:00:47	18 / 09 / 2024	CUTM1	S1	18/09/2024 07:41:24	18/09/2024 08:04:48	<input checked="" type="checkbox"/>	
289090-10	140	Electrical Testing	00:02:35	18 / 09 / 2024	SFSA1	S1	18/09/2024 08:04:48	18/09/2024 09:22:12	<input checked="" type="checkbox"/>	
289090-10	150	Packing	00:02:35	18 / 09 / 2024	SFSA2	S1	18/09/2024 09:22:12	18/09/2024 10:39:36	<input checked="" type="checkbox"/>	
289090-10	999	SF Wkctr for SA	00:03:29	18 / 09 / 2024	SFWH1	S1	18/09/2024 10:39:36	18/09/2024 12:24:00	<input checked="" type="checkbox"/>	

Items per page: 5 | 1-5 of 5 | < < > >>

YESTERDAY TODAY TOMORROW SELECT DATE VALIDATE SAVE CLOSE

5. Error Handling:

- If validation reveals errors:
 - **View Error Messages:** Examine the error messages provided by the system, which will indicate what needs to be adjusted (e.g., production line, shift, date).
 - **Modify Details:** Adjust the production line, shift, or date based on the error messages.
 - **Revalidate:** Click "Validate" again after making changes to ensure that the new details resolve the issues.
 - **Repeat:** Continue adjusting and revalidating until all errors are resolved and the schedule is validated successfully.

6. Save Schedule:

- Once validation is complete and no errors are present, check for the planned start and planned end date for all operation then save the job order schedule to finalize the entry.

This workflow ensures that job orders are accurately scheduled, taking into account the availability of production lines, shifts, and dates, while also providing mechanisms to handle and correct errors.

Production Line Status Graphical View

- Graphical Representation:** Access a graphical view that displays job and production line statuses based on shifts and selected dates.
- Normal View:** View a standard layout of job and production line statuses for a straightforward overview.
- Search Functionality:** Utilize search features to find specific job orders, production lines, or dates efficiently.
- Initially for both the production line graph will show the data of current day and can select the previous day and next day

The screenshot shows a web-based application for managing production line schedules. At the top, there is a navigation bar with four tabs: 'YESTERDAY' (highlighted in orange), 'TODAY' (white), 'TOMORROW' (white), and 'SELECT DATE' (white). To the right of the tabs is a search bar labeled 'Search PL #' and a green button labeled 'GET PL SCHEDULE'. Below the search bar, the text 'Today Schedule' is displayed. The main content area is divided into four columns: 'PL #' (Production Line Number), 'Shift 1', 'Shift 2', and 'Shift 3'. Under 'Shift 2', the message 'No data available' is shown. At the bottom of the page, there is a pagination section with 'Items per page:' dropdown set to '10', a total count of '0-0 of 0', and navigation arrows. A blue circular arrow icon is located in the bottom right corner of the main content area.

Items per page: 10 0-0 of 0 < > GET SCHEDULED DETAILS

YESTERDAY TODAY **TOMORROW** SELECT DATE

Today Schedule

PL #	Shift 1	Shift 2	Shift 3
	No data available		

Items per page: 10 0-0 of 0 < >

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- Also, if wanted to select the custom date click on **SELECT DATE** “Select Date” and select the required date.

Scheduling Work Bench

WorkOrder	Item Number/ Order Quantity	Job Order	Operation	Job Date	Planned Start Date	Planned End Date	PL	Shift	Load Qty	Setup	Status
289080	ZP026885-004LF/ 1770	289080-01	140 - Electrical Testing	26/03/2024	26/03/2024 15:43:12	26/03/2024 16:34:48	SFSA2	S2	20	<input type="checkbox"/>	
289080	ZP026885-004LF/ 1770	289080-01	150 - Packing	26/03/2024	26/03/2024 16:34:48	26/03/2024 17:26:24	SFSE2	S2	20	<input type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	10 - Cable Cutting	24/04/2024	24/04/2024 15:00:00	24/04/2024 15:14:35	CUTM3	S2	10	<input checked="" type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	20 - Crimping	24/04/2024	24/04/2024 15:22:23	24/04/2024 15:22:23	CUTM2	S2	10	<input type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	30 - Housing	24/04/2024	24/04/2024 15:21:36	24/04/2024 15:21:36	CUTM4	S3	10	<input checked="" type="checkbox"/>	
289093	0w49323CLF/ 400	289093-02	999 - SF Wkctr for WH	24/04/2024	24/04/2024 15:56:24	24/04/2024 15:56:24	SFSE2	S3	10	<input type="checkbox"/>	

Select Date X
dd / mm / yyyy

Items per page: All 1-285 of 285 < >

YESTERDAY TODAY **TOMORROW** **SELECT DATE**

PL #	Shift 1	Shift 2	Shift 3
	No data available		

- Selecting the custom date to view data.
 - Selected Date: 19/08/2024

Scheduling Work Bench

WorkOrder :	Item Number :	Description :	Order Quantity :	Sales Order :	Routing Lot :	Run Time :	Setup Time :	Test Plan :	Item Type:	GET PL	REFRESH	ADD ROW
289080	2P026885-004LF/ 1770	289080-01	140 - Electrical Testing	26/03/2024	26/03/2024 15:43:12	26/03/2024 16:34:48	SFSA2	S2	20	<input type="checkbox"/>		
289080	2P026885-004LF/ 1770	289080-01	150 - Packing	26/03/2024	26/03/2024 16:34:48	26/03/2024 17:26:24	SFSE2	S2	20	<input type="checkbox"/>		
289093	0w49323CLF/ 400	289093-02	10 - Cable Cutting	24/04/2024	24/04/2024 15:00:00	24/04/2024 15:14:35	CUTM3	S2	10	<input checked="" type="checkbox"/>		
289093	0w49323CLF/ 400	289093-02	20 - Crimping	24/04/2024	24/04/2024 15:22:23	24/04/2024 15:22:23	CUTM2	S2	10	<input type="checkbox"/>		
289093	0w49323CLF/ 400	289093-02	30 - Housing	24/04/2024	24/04/2024 15:21:36	24/04/2024 15:21:36	CUTM4	S3	10	<input checked="" type="checkbox"/>		
289093	0w49323CLF/ 400	289093-02	999 - SF Wkctr for WH	24/04/2024	24/04/2024 15:56:24	24/04/2024 15:56:24	SFSE2	S3	10	<input type="checkbox"/>		

Select Date X
19/08/2024

Items per page: All 1-285 of 285

YESTERDAY TODAY TOMORROW SELECT DATE Shift 1 Shift 2 Shift 3

No data available

- Data shown for the selected with all the Production Line and its status in graphical view.

289093	0w49323CLF/ 400	289093-02	10 - Cable Cutting	24/04/2024	24/04/2024 15:00:00	24/04/2024 15:14:35	CUTM3	S2	10	<input checked="" type="checkbox"/>
289093	0w49323CLF/ 400	289093-02	20 - Crimping	24/04/2024	24/04/2024 15:14:35	24/04/2024 15:22:23	CUTM2	S2	10	<input type="checkbox"/>
289093	0w49323CLF/ 400	289093-02	30 - Housing	24/04/2024	24/04/2024 23:00:00	24/04/2024 23:21:36	CUTM4	S3	10	<input checked="" type="checkbox"/>
289093	0w49323CLF/ 400	289093-02	999 - SF Wkctr for WH	24/04/2024	24/04/2024 23:21:36	24/04/2024 23:56:24	SFSE2	S3	10	<input type="checkbox"/>

Items per page: All 1-285 of 285

YESTERDAY TODAY TOMORROW SELECT DATE Shift 1 Shift 2 Shift 3

Cable Cutting/Stripping

CUTM1	289090-02 289090-02									
CUTM2										
CUTM3	289080-26 289080-26		289080-27 289080-27							
SFSA1	289090-02									
SFSA2	289080-26									
SFSA4			289080-27							
SFSE1										
SFSE2										
SFSE3	289080-26					289080-27				
SFSE4										

Items per page: 10 1-10 of 17

GET SCHEDULED DETAILS

- Data shown for the selected with all the Production Line and its status in table view.

				Items per page:	10	1-10 of 17	<	>	>>
				GET SCHEDULED DETAILS					
YESTERDAY	TODAY	TOMORROW	SELECT DATE						
			Shift 1	Shift 2	Shift 3				
CUTM1	289090-02 Cable Cutting/Stripping-1h 9m 289090-02 Crimping-0h 39m			No Jobs Scheduled		No Jobs Scheduled			
CUTM2	No Jobs Scheduled			No Jobs Scheduled		No Jobs Scheduled			
CUTM3	289080-26 Cable Cutting/Stripping-1h 1m 289080-26 Crimping-0h 34m		289080-27 Cable Cutting/Stripping-1h 23m 289080-27 Crimping-0h 47m			No Jobs Scheduled			
SFSA1	289090-02 Packing-2h 9m			No Jobs Scheduled		No Jobs Scheduled			

17. Job Travel Card (JTC Report)

The Job Travel Card (JTC) Report is a tool for generating and viewing detailed reports on completed job orders. Users can filter and retrieve reports based on three different criteria, with the ability to preview and download the results in PDF format.

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Job Traveller Card

Site Select PL

Work Order From Work Order To

Enter Work Order From Enter Work Order To

Job Order From Job Order To

Enter Job Order From Enter Job Order To

PREVIEW **RESET**

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Key Features

1. Report Criteria:

- **Site, Production Line, From Date, To Date:**
 - Generate a report by specifying the site, production line, and a date range (from and to dates).
- **Between From and To Work Orders:**
 - Retrieve job order details for a range of work orders, from a specified start work order to an end work order.
- **Between From and To Job Orders:**
 - Obtain job order information for a range of job orders, from a specified start job order to an end job order.

2. Report Generation:

- **Selection and Preview:**
 - Based on the selected criteria (one of the three combinations), the system will display a preview of the completed job orders report on the right side of the interface.
- **PDF Download:**
 - Users can download the displayed report as a PDF file for offline review and record-keeping.

Workflow

• Select Report Criteria:

- Choose one of the following options to filter the report:
 - **Site, Production Line, From Date, To Date:** Enter the site, production line, and date range.
 - **Between From and To Work Orders:** Enter the start and end work orders.

- **Between From and To Job Orders:** Enter the start and end job orders.
- Selection on Site, production line, from date and to date.

Job Traveller Card *i*

Site 49510	Select PL CUTM3	From Date 01 / 07 / 2024	To Date 31 / 08 / 2024
Work Order From	Work Order To		
Enter Work Order From	Enter Work Order To		
Job Order From	Job Order To		
Enter Job Order From	Enter Job Order To		
PREVIEW		RESET	

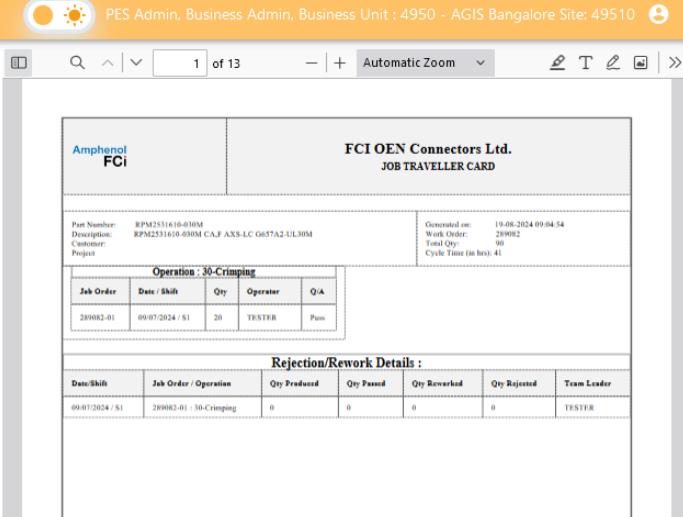
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- Preview for the selection on Site, production line, from date and to date.

PES

Job Traveller Card *i*

Site 49510	Select PL CUTM3	From Date 01 / 07 / 2024	To Date 31 / 08 / 2024
Work Order From	Work Order To		
Enter Work Order From	Enter Work Order To		
Job Order From	Job Order To		
Enter Job Order From	Enter Job Order To		
PREVIEW		RESET	



The preview window displays the following details:

**FCI OEN Connectors Ltd.
JOB TRAVELLER CARD**

Part Number: RPA25318 (0-010M)
Description: RPA25318 (0-010M) CAF AXS-LC G637A2 UL30M
Customer: Project
General on: 19-08-2024 09:04:54
Work Order: 289082
Total Qty: 90
Cycle Time (in hrs): 41

Operation : 30-Crimping				
Job Order	Date / Shift	Qty	Operator	QA
289082-01	09/07/2024 / S1	20	TESTER	Pass

Rejection/Rework Details :

Date/Shift	Job Order / Operation	Qty Produced	Qty Passed	Qty Rewarded	Qty Rejected	Team Leader
09/07/2024 / S1	289082-01 : 30-Crimping	0	0	0	0	TESTER

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- Selection for between work orders.

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Job Traveller Card

Site Select PL

Work Order From Work Order To

289090 29095

Job Order From Job Order To

Enter Job Order From Enter Job Order To

PREVIEW **RESET**

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- Preview for the selection for between work orders.

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Job Traveller Card

Site Select PL

Work Order From Work Order To

289090 29095

Job Order From Job Order To

Enter Job Order From Enter Job Order To

PREVIEW **RESET**

Amphenol FCI **FCI OEN Connectors Ltd.**
JOB TRAVELLER CARD

Part Number: 0849732CLF Description: 0849732CLF AGILIS EIO WIRE Customer: Project:	Generated on: 18.07.2024 09:06:18 Work Order: 289095 Total Qty: 400 Cycle Time (in hrs): 215					
Operation : 10-Cable Cutting						
Job Order	Date / Shift	Qty	Operator	Q/A		
289093-01	08/07/2024 / S1	20	test	Pass		
289093-03	16/07/2024 / S2	30	Tester	Pass		
289093-04	16/07/2024 / S2	30	Tester	Pass		
Operation : 20-Crimping						
Job Order	Date / Shift	Qty	Operator	Q/A		
289093-01	08/07/2024 / S1	20	test	Pass		
289093-03	16/07/2024 / S2	30	Tester	Pass		
289093-04	16/07/2024 / S2	30	Tester	Pass		
Operation : 30-Housing						
Job Order	Date / Shift	Qty	Operator	Q/A		
289093-01	08/07/2024 / S1	20	test	Pass		
289093-03	16/07/2024 / S2	30	Tester	Pass		
289093-04	16/07/2024 / S2	30	Tester	Pass		
Operation : 999-SF Wkctr for WH						
Job Order	Date / Shift	Qty	Operator	Q/A		
289093-01	08/07/2024 / S1	20	test	Pass		
289093-03	16/07/2024 / S2	30	Tester	Pass		
289093-04	16/07/2024 / S2	30	Tester	Pass		
Rejection/Rework Details :						
Date/Shift	Job Order / Operation	Qty Produced	Qty Passed	Qty Rewarded	Qty Rejected	Team Leader

- Selection for between job orders.

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Job Traveller Card

Site: Select PL

Work Order From: Enter Work Order From
289093-01

Work Order To: Enter Work Order To
289093-05

Job Order From: Job Order To
289093-01

Job Order To: 289093-05

Buttons: PREVIEW (blue), RESET (red)

- Preview for the Selection for between job orders.

PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510

Job Traveller Card

Site: Select PL

Work Order From: Enter Work Order From
289093-01

Work Order To: Enter Work Order To
289093-05

Job Order From: Job Order To
289093-01

Job Order To: 289093-05

Report Preview (Right Side):

FCI OEN Connectors Ltd. JOB TRAVELLER CARD

Part Number: 0w49323CLF
Description: 0w49323CLF AGILIS EIO WIRE
Customer: Project
Generated on: 19-08-2024 09:07:19
Work Order: 289093
Total Qty: 400
Cycle Time (in hrs): 215

Operation : 10-Cable Cutting					Operation : 20-Crimping				
Job Order	Date / Shift	Qty	Operator	Q/A	Job Order	Date / Shift	Qty	Operator	Q/A
289093-01	08/07/2024 / S1	20	test	Pass	289093-01	08/07/2024 / S1	20	test	Pass
289093-03	16/07/2024 / S2	30	Tester	Pass	289093-03	16/07/2024 / S2	30	Tester	Pass
289093-04	16/07/2024 / S2	30	Tester	Pass	289093-04	16/07/2024 / S2	30	Tester	Pass

Operation : 30-Housing					Operation : 999-SF Wkctr for WH				
Job Order	Date / Shift	Qty	Operator	Q/A	Job Order	Date / Shift	Qty	Operator	Q/A
289093-01	08/07/2024 / S1	20	test	Pass	289093-01	08/07/2024 / S1	20	test	Pass
289093-03	16/07/2024 / S2	30	Tester	Pass	289093-03	16/07/2024 / S2	30	Tester	Pass
289093-04	16/07/2024 / S2	30	Tester	Pass	289093-04	16/07/2024 / S2	30	Tester	Pass

Rejection/Rework Details :					
Date/Shift	Job Order / Operation	Qty Produced	Qty Passed	Qty Rejected	Team Leader

- Generate Report:
 - After selecting the criteria, the system will compile the relevant data.
 - The report preview will appear on the right side of the interface, reflecting the completed job orders based on the selected filters.
- Preview and Download:
 - Review the report preview to ensure it meets the desired criteria.
 - Click the download button to save the report as a PDF file.

The screenshot shows a software interface titled "Job Traveller Card". On the left, there are dropdown menus for "Site" and "Select PL". Below these are fields for "Work Order From" (with value "Enter Work Order From") and "Work Order To" (with placeholder "Enter Work Order To"). Further down are fields for "Job Order From" (value "289093-01") and "Job Order To" (value "289093-05"). At the bottom are two buttons: "PREVIEW" (blue) and "RESET" (red).

The main area displays a report titled "FCI OEN Conn JOB TRAVELLER CARD". The report header includes the company logo "Amphenol FCI" and the project name "FCI OEN Conn JOB TRAVELLER CARD". It also lists part number, description, customer, and project information.

The report contains two tables:

- Operation : 10-Cable Cutting**
- Operation : 30-Housing**

Both tables have columns for Job Order, Date / Shift, Qty, Operator, and Q/A. The data for the first table is as follows:

Job Order	Date / Shift	Qty	Operator	Q/A
289093-01	08/07/2024 / S1	20	test	Pass
289093-03	16/07/2024 / S2	30	Tester	Pass
289093-04	16/07/2024 / S2	30	Tester	Pass

The data for the second table is as follows:

Job Order	Date / Shift	Qty	Operator	Q/A
289093-01	08/07/2024 / S1	20	test	Pass
289093-03	16/07/2024 / S2	30	Tester	Pass
289093-04	16/07/2024 / S2	30	Tester	Pass

Below the tables is a "Rejection/Rework Details" section with columns for Date/Shift, Job Order / Operation, Qty Produced, Qty Passed, Qty Rewarded, Qty Rejected, and Team Leader.

On the right side of the report, there is a vertical toolbar with various icons for printing, saving, and navigating through the page.

Benefits

- Comprehensive Analysis:** Obtain detailed reports on completed job orders based on flexible filtering options.
- User-Friendly Interface:** Easily select criteria and view reports with an intuitive interface.
- Convenient Access:** Preview reports in real-time and download them in PDF format for easy sharing and record-keeping.

16. Quality Assurance - Observation and Analysis

The QA screen provides a comprehensive interface for performing Quality Assurance (QA) testing during production. It includes functionalities for managing job orders, sampling procedures, component tracking, and recording test results. The screen is designed to ensure that products meet quality standards throughout the production process by allowing users to capture and analyse relevant data efficiently.

1. Job Order Testing Procedure

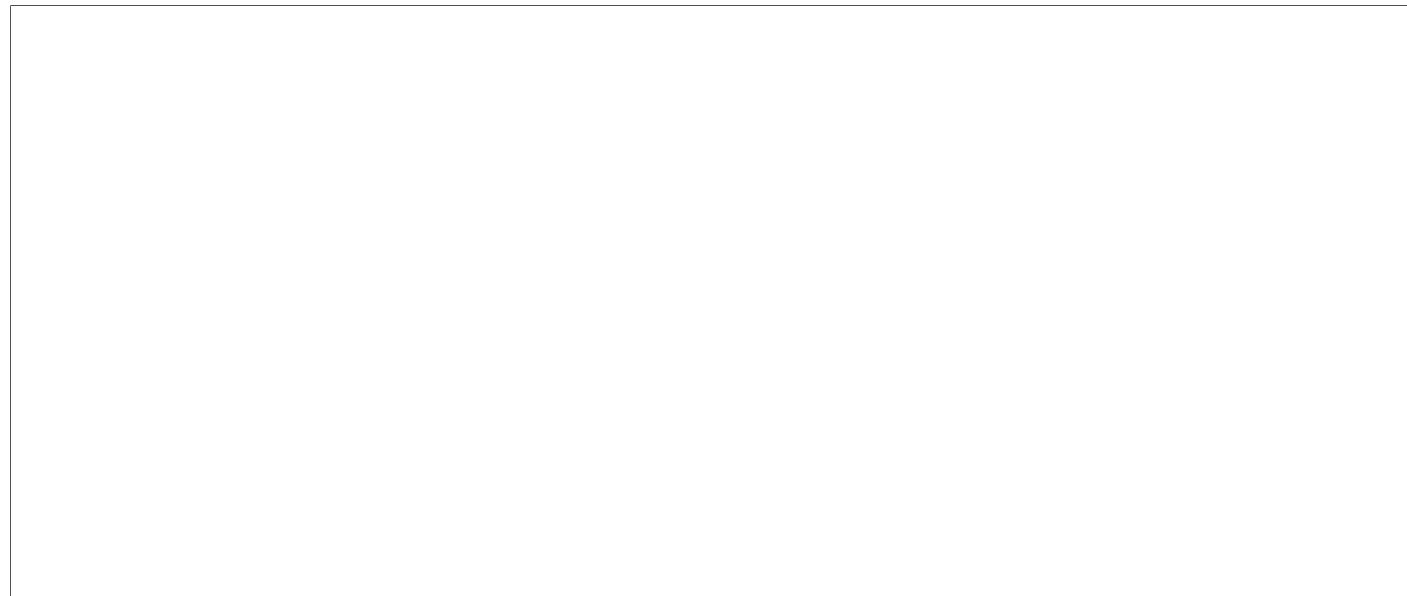
1.1. Test Samples

For each job order, testing must be performed on specific pieces to ensure quality. The following pieces should be tested:

1. **Select Job Order:** Choose the relevant job order from the dropdown menu.
2. Click on **Get Test Details** (Get Test Details) Button. The testing details and all the components will be populated.
3. **Select Test Pieces:** Click on the test pieces that need to be tested, which include:
 - **First Piece:** The first piece of the production run.
 - **Samples:** Any one of the intermediate samples (pieces 1, 2, 3, or 4).
 - **Last Piece:** The last piece of the production run.
- 4.

Mandatory Testing

- First Piece
- Last Piece
- Minimum One Sample
-



2. Component Tracking

2.1. Recording Components

For each job order, document the components used in production. The component names will be automatically populated from the backend. Please include the following details for each component used in that specific operation:

- **Lot Number:** The lot number associated with each component used.
- **Rejected Quantity:** The quantity of each component that was rejected, if applicable.

This ensures accurate tracking and reporting of the components directly involved in the current production run.

The screenshot shows a software interface for Quality Assurance. At the top, there's a header bar with the PES logo, user information (PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510), and a settings icon. Below the header, the title "Quality Assurance - Observation and Analysis" is displayed. On the left side, there are several input fields and buttons: "Job Order / Operation" dropdown set to "289080-01 / Electrical Testing", "Get Test Details" button, "Report Down Time" button, "WorkOrder: 289080", "Order Qty: 1770", "PN: 2P026885-004LF", and "Job Load Qty: 20". There's also a "Select Test Type" section with options like "First Piece", "Sample 1", "Sample 2", "Sample 3", "Sample 4", and "Last Piece". Further down are fields for "Operator Name", "Machine" (with a dropdown arrow), "Appl#No" (with a dropdown arrow), and "Enter Sample Size 0". A "Remarks" text area is also present. On the right side, a large red-bordered table lists components with their details: Component (e.g., 1 39-01-2065-P, 1-39-00-0059, 1-DF11-2428SCF, etc.), Lot (all listed as "Enter Lot"), and Rejected Quantity (all listed as 0). The table includes a "Search Component" header and pagination controls at the bottom. At the very bottom of the interface, there are buttons for "Test Plan: 2P026885-004LF", "QA Complete" (with a checkbox), "SAVE", and "REFRESH".

Components		Search Component
Component	Lot	Rejected Quantity
1 39-01-2065-P	Enter Lot	0
1-39-00-0059	Enter Lot	0
1-DF11-2428SCF	Enter Lot	0
1-DF11-24D5-2C	Enter Lot	0
1-DF11-6DS-2C	Enter Lot	0
1-DF13-2630SCFA	Enter Lot	0

2.2. Additional Information

- **Operator:** Name or ID of the operator performing the job.
- **Machine:** Machine used for production it will be a dropdown.
- **Applicator:** Applicator used it will be a dropdown.
- **Sample Size:** No of samples used for testing.
- **Remarks:** Any additional notes or comments relevant to the production or testing.

The screenshot shows a software interface for Quality Assurance. At the top, there's a header bar with the PES logo and user information: "PES Admin, Business Admin, Business Unit : 4950 - AGIS Bangalore Site: 49510". Below the header, the title "Quality Assurance - Observation and Analysis" is displayed. On the left, a sidebar includes a dropdown for "Job Order / Operation" set to "289080-01 / Electrical Testing", and buttons for "Get Test Details" and "Report Down Time". It also shows "WorkOrder: 289080", "Order Qty: 1770", "PN: 2P026885-004LF", and "Job Load Qty: 20". A section titled "Select Test Type" offers options like "First Piece", "Sample 1", "Sample 2", "Sample 3", "Sample 4", and "Last Piece". A red box highlights a group of input fields: "Operator Name", "Machine", "Appl#No", and "Enter Sample Size 0". Below these is a "Remarks" text area. To the right, a table lists components with their lot numbers and rejected quantities. The table has columns for "Components", "Lot", and "Rejected Quantity". The data includes:

Components	Lot	Rejected Quantity
1 39-01-2065-P	Enter Lot	0
1-39-00-0059	Enter Lot	0
1-DF11-2428SCF	Enter Lot	0
1-DF11-24DS-2C	Enter Lot	0
1-DF11-6DS-2C	Enter Lot	0
1-DF13-2630SCFA	Enter Lot	0

At the bottom, there are buttons for "QA Complete" (with a checkbox), "SAVE", and "REFRESH".

3. Testing Details

3.1. Test Description

Each test to be performed should will include the following details, which will be populated automatically from the test plan - work order mapping:

- **Test Description:** A brief description of what is being tested.
- **Actual Value:** The value observed or measured during testing (user entry).
- **Reference Value:** The standard value that should be met.
- **Upper Limit:** The maximum acceptable value.
- **Lower Limit:** The minimum acceptable value.
- **Attribute Name:** The specific attribute being tested.
- **Pass/Fail:** The result of the test based on whether the Actual Value falls within the specified limits.



3.2. Entering Test Results

- Actual Value:** Enter the value observed during testing.
- Automatic Population:** All other details, including Test Description, Reference Value, Upper Limit, Lower Limit, and Attribute Name, will be automatically populated based on the mapping done in the test plan - work order mapping.
- Pass/Fail Determination:** The Pass/Fail result will be automatically calculated based on the Actual Value entered and the limits specified in the test plan.

WorkOrder 289080		Order Qty: 1770		PN: 2P026885-004LF		Job Load Qty: 44																																																																																																	
Select Test Type																																																																																																							
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By entering only the Actual Value, the system will automatically fill in the remaining details and determine the Pass/Fail status, ensuring efficiency and accuracy in recording test results.

3.3. QA Completion and Record Management

3.3.1. QA Completion Checkbox

- QA Completion Checkbox:** After all, required testing for a job order is completed, the QA Completion checkbox must be checked. This action signifies that testing for the current piece is finalized and ready for review.
- Automatic Transition:** Once the QA Completion checkbox is checked and the record should be saved, then the system will automatically open next test piece in the sequence for testing.

Quality Assurance - Observation and Analysis

Job Order / Operation 289080-02 / Cable Cutting/Stripping	Get Test Details	Report Down Time																																									
WorkOrder 289080	Order Qty: 1770	PN: 2P026885-004LF	Job Load Qty: 44																																								
Select Test Type																																											
First Piece	Sample 1	Sample 2	Sample 3																																								
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QA Complete <input checked="" type="checkbox"/> SAVE REFRESH																																											

3.3.2. Data Modification Rules

- If QA is Completed and Saved:** Once the QA Completion checkbox is checked and the record is saved, the data becomes locked and cannot be modified. This ensures that finalized test results are preserved and prevents accidental changes.

Quality Assurance - Observation and Analysis

Job Order / Operation 289080-02 / Cable Cutting/Stripping	Get Test Details	Report Down Time																																																	
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QA Complete <input checked="" type="checkbox"/> SAVE REFRESH																																																			

- If QA is Not Completed:** If the QA Completion checkbox has not been checked, the data remains editable. You can continue to make changes or updates to the test results until the QA process is finalized.

Quality Assurance - Observation and Analysis

Job Order / Operation
289080-02 / Cable Cutting/Stripping

Get Test Details
Report Down Time

WorkOrder:289080
Order Qty:1770
PN:2P026885-004LF
Job Load Qty:44

Select Test Type

First Piece
Sample 1
Sample 2
Sample 3
Sample 4
Last Piece

Operator Name
Test
Machine
MACH...
App#No
#APP1_CU...
Enter Sample Size
10

Remarks
Test entry

Components	Search Component
Component 1-DF11-6DS-2C	Lot Enter Lot <input type="text"/> Rejected Quantity 0
1-DF13-26305CFA	Lot Enter Lot <input type="text"/> Rejected Quantity 0
1-DF3-24285CFC	Lot Enter Lot <input type="text"/> Rejected Quantity 0
1-DF3-4EP-2C	Lot Enter Lot <input type="text"/> Rejected Quantity 0
1-DF3-4S-2C	Lot Enter Lot <input type="text"/> Rejected Quantity 0
1-DF3-EP2428PCFA	Lot Enter Lot <input type="text"/> Rejected Quantity 0

Items per page: 10 | < < > > |

Test Plan: 2P026885-004LF

Test Desc	Actual Value	Ref Value	Upper Limit	Lower Limit	Attribute	UOM	Pass / Fail ↑
Wire gauge 28AWG	<input type="checkbox"/>				GAUGE		Fail
Wire gauge 26AWG	<input type="checkbox"/>				GAUGE		Fail
UL Type 1061	<input type="checkbox"/>				UL TYPE		Fail
UL Type 1007	<input type="checkbox"/>				UL TYPE		Fail

QA Complete

SAVE

REFRESH

By adhering to these procedures, the system maintains the integrity of the test results and facilitates a smooth transition between test pieces, while allowing flexibility during the testing phase.

3.4. Actual Time Recording

- Actual Start Time:** This timestamp is recorded only when the testing of the First Piece is completed and the QA Completion checkbox for the First Piece is checked. This marks the beginning of the production run.
- Actual End Time:** This timestamp is recorded only when the testing of the Last Piece is completed and the QA Completion checkbox for the Last Piece is checked. This marks the conclusion of the production run.

These timestamps ensure accurate tracking of the start and end times of each job order based on the completion of QA testing for the first and last pieces.

3.5 Report Downtime

From the QA screen, you can report any downtime encountered during production. Follow these steps to add downtime:

- Click on Report Downtime:** Click the Report Downtime button on the QA screen.
- Enter Downtime Details:**
 - Reason for Downtime:** Provide a brief description of the issue or reason for the downtime.
 - Start Time:** Record the time when the downtime started.
 - End Time:** Record the time when the downtime ended (if applicable).
- Save:** After entering the necessary details, save the downtime report.

Quality Assurance - Observation and Analysis

Job Order / Operation
289080-01 / Electrical Testing

Get Test Details
Report Down Time

WorkOrder:289080 Order Qty:1770 PN:2P026885-004LF Job Load Qty:20

Select Test Type

First Piece Sample 1 Sample 2 Sample 3 Sample 4

Operator Name: Sundar Machine: MACHI... Appl#No: #APPL_EL...

Reason Code: Start Date Time: End Date Time:

SAVE CANCEL

Remarks:

Components		Search Component	
Component	Lot	Rejected Quantity	
139-01-2065-P	IOT-01	0	

Items per page: 10 | 1-1 of 1 | < > >>

QA Complete SAVE REFRESH

Test Plan: 2P026885-004LF

Test Desc	Actual Value	Ref Value	Upper Limit	Lower Limit	Attribute	UOM	Pass / Fail
Length as per Board Routing	■				VERIFICATION		Pass
Labeling	■				LABELING		Pass
Cable Tie Verification as per Drawing	■				TYING		Pass
Dimension Verification as per Drawing	■				VERIFICATION		Pass

The reported downtime will be added to the production line status, helping to track and manage production interruptions effectively.

3.6 Report Production and Rejected Quantity

From the QA screen, you can report production and rejection quantity during conclusion of production when the last operation and last piece testing completed. Follow these steps to add downtime:

1. **Click on Report Quantity:** Click the "Report Downtime" button on the QA screen.
2. **Enter Downtime Details:**
 - o **Production Quantity:** Enter the total quantity produced inclusive of reworked.
 - o **Rejection Quantity:** Enter the total rejected quantity which is not reworked.
 - o **Reworked Quantity:** Enter the quantity that has been reworked after rejection.
 - o **Reason:** select the reason from the reason.
3. **Submit:** After entering the necessary details, submit the quantity.

The screenshot shows the 'Quality Assurance - Observation and Analysis' screen. On the left, there's a sidebar with 'Job Order / Operation' dropdown, 'Get Test Details' and 'Report' buttons, 'WorkOrder: 289080', 'Order Qty: 1770', 'PN: 2P026885-004LF', and a 'Select Test Type' section with buttons for 'First Piece', 'Sample 1', 'Sample 2', 'Sample 3', 'Sample 4', and 'Last Piece'. Below these are fields for 'Operator Name' (kish), 'Machine' (MACH...), 'AppNo' (#APPL_SF), and 'Remarks'. A 'Test Plan: 2P026885-004LF' section lists two items: 'Cable Tie Verification as per Drawing' and 'Dummy Pin Verification as per Drawing', both with 'Actual Value' checked. On the right, a 'Report Quantity' dialog box is open, containing four input fields: 'Production Qty' (0), 'Rejected Qty' (0), 'Reworked Qty' (0), and a 'Reason' dropdown. At the bottom of the dialog are 'SUBMIT' and 'CANCEL' buttons. To the right of the dialog, there's a 'Search Component' table with columns 'Lot' and 'Rejected Quantity', showing one row with Lot 'D-02' and Rejected Qty '0'. At the bottom right are buttons for 'QA Complete' (checkbox), 'REPORT QTY' (blue), 'SAVE' (green), and 'REFRESH' (orange). The status bar at the bottom shows 'Attribute UOM Pass / Fail' for 'TYING' (Pass) and 'VERIFICATION' (Pass).

The reported quantities will be added as the job order production and rejected quantities.

18. Shop Floor Viewer

The Shop Floor Viewer provides a comprehensive overview of the production status and performance across one or multiple shop floors. This feature allows you to monitor and analyze various metrics to ensure efficient production management. Here's how you can use the Shop Floor Viewer:

The screenshot shows the Shop Floor Viewer interface with the following key elements:

- Header:** Business Unit : 4950, Shop Floor:
- Metric Summary:** OEE (avg.)%, Performance %, Quality %, Availability %, Capacity, Utilized, Planned Production, Actual Production.
- Shifts:** SHIFT 1 (7AM-3PM), SHIFT 2 (3PM-11PM), SHIFT 3 (11PM-7AM).
- Table Headers:** PL, Work Order, Job Order, Job Perf %, PL Status, Job Progress - Planned, Output (Qty), Time (hh:mm). Sub-headers include Start Time, End Time, Planned, Actual, Setup, Prod, Down, Idle.
- Message:** No data available.
- Job Detail:** Shows a small thumbnail image of a machine.
- Product Details:** Sales Order, Customer, Job Order Op, Test Plan, Actual Start Date, Actual End Date.
- Pagination:** Items per page: 10, 0-0 of 0, navigation icons.

Features

- Completed Status:** View the status of shop floors that are currently running or have completed production.
- OEE (Overall Equipment Effectiveness):** Check the OEE metric to assess the overall efficiency of the equipment, including availability, performance, and quality.
- Availability:** Monitor the availability of shop floor equipment, showing the proportion of time the equipment is operational compared to the total available time.
- Performance:** Evaluate the performance of the shop floor, including the speed and output rates relative to expected targets.
- Quality:** Review the quality of production, including metrics such as defect rates and compliance with quality standards.
- Utilized:** Check the utilization of shop floor resources to determine how effectively they are being used.
- Planned Production:** Compare the planned production targets with the actual performance to assess if production goals are being met.
- Actual Production:** View the actual production quantities achieved on the shop floor.
- Job Order Quantity Reporting:** Report and review the quantities for specific job orders, including any adjustments or updates.

How to Use

- Select Shop Floors:** Choose one or multiple shop floors you want to view from the available options.
 - Select Date:** Specify the date or date range for which you want to view the production data.
 - View Metrics:** Access the metrics including OEE, availability, performance, quality, utilized, planned production, actual production, and job order quantities.
 - Analyze Data:** Use the displayed data to analyze production performance, identify areas for improvement, and make informed decisions.
- Click on filter button on top right of the screen

The screenshot shows the 'Shop Floor Viewer' dashboard for Business Unit : 4950. The top navigation bar includes a filter icon. Below it, various performance metrics are displayed: OEE (avg.)%, Performance %, Quality %, Availability %, Capacity, Utilized, Planned Production, and Actual Production. The dashboard is divided into three main sections: SHIFT 1 (7AM-3PM), SHIFT 2 (3PM-11PM), and SHIFT 3 (11PM-7AM). Each section has tabs for PL, Work Order, Job Order, Job Perf %, and PL Status. A central 'Filter Options' dialog box is open, showing a dropdown menu for 'Shopfloor' with the value '12SFSA, 12SFWH, 12SFSE, 12SCUT, 12SFFO, 12SFTEST'. Below this, there is a 'Select Date' field set to '19 / 08 / 2024' with a calendar icon, and 'APPLY' and 'RESET' buttons. To the right of the dialog, there is a 'Job Detail' section showing a machine icon and a 'Product Details' table with columns for Sales Order, Customer, Job Order Op, Test Plan, Actual Start Date, and Actual End Date.

- Select the shop floor and date , then click on apply. Data will be displayed.

This screenshot shows the same 'Shop Floor Viewer' interface as above, but the 'Shopfloor' dropdown now displays the selected values: '12SFSA, 12SFWH, 12SFSE, 12SCUT, 12SFFO, 12SFTEST'. The 'APPLY' button is highlighted in blue, indicating it has been clicked. The rest of the interface remains consistent with the first screenshot.

By leveraging the Shop Floor Viewer, you can gain valuable insights into production efficiency and effectively manage your shop floors.

Shop Floor Metrics Formulas

Here are the formulas used to calculate various shop floor metrics:

1. Availability

Availability measures the proportion of time the equipment or shop floor was available for production compared to the total planned time.

$$\text{Availability} = (\text{Planned Start Time} + \text{Planned End Time}) / (\text{Actual Start Time} + \text{Actual End Time}) \times 100$$

Note: The Actual Start Time, Actual End Time will be captured while reporting of test type of first piece and last piece. Planned Start Time, and Planned End Time are calculated while scheduling the job.

2. Performance

Performance measures how well the job performed relative to the planned production quantity.

$$\text{Performance} = (\text{Job Load Quantity} / \text{Job Production Quantity}) \times 100$$

Note: Job Production Quantity refers to the number of units produced, while Job Load Quantity is the number of units planned to be produced.

3. Quality

Quality measures the proportion of good units produced compared to the total production quantity.

$$\text{Good Quantity} = \text{Job Production Quantity} - \text{Rejected Quantity}$$

$$\text{Quality} = (\text{Good Quantity} / \text{Job Production Quantity}) \times 100$$

Note: Rejected Quantity is the number of units that failed quality control.

4. OEE (Overall Equipment Effectiveness)

OEE combines performance, quality, and availability into a single metric to measure overall production effectiveness.

$$\text{OEE} = (\text{Performance} / 100) \times (\text{Quality} / 100) \times (\text{Availability} / 100) \times 100$$

5. Utilized

Utilized measures whether a shop floor is being used for production based on whether a job has started running.

- If a job started running on the shop floor, it is considered a utilized production line (PL).

6. Planned Production

Planned Production is the total quantity of production planned for the shop floor.

- **Planned Production:** Total quantity planned for production in that shop floor.

7. Actual Production

Actual Production is the quantity of units that were actually completed on the shop floor.

- **Actual Production:** Total quantity of units completed in that shop floor.

By using these formulas, we are effectively monitor and analyzing the performance of the shop floors.

Data Display Overview

The selected shop floor data will be presented based on the different shifts: S1, S2, and S3. The data will be organized and displayed in a table format, providing detailed insights into the work orders and job orders for each shift. Here's how to view and interpret the data:

1. Data Display

The data shown will include the following details:

- **Work Order:** The identifier or reference for the work order.
- **Job Order:** The specific job order associated with the work order.
- **Job Performance:** Metrics or statistics related to the performance of the job.
- **Job Status:** The current status of the job (e.g., Running, Completed, Pending).
- **Job Planned Start Time:** The scheduled start time for the job.
- **Job Planned End Time:** The scheduled end time for the job.
- **Job Actual Start Time:** The actual time when the job started.
- **Job Actual End Time:** The actual time when the job ended.
- **Setup Time:** The time taken to set up for the job.
- **Run Time:** The time taken to actually run the job.

2. Viewing Data Across Shifts

- **Shift Tabs:** The data can be viewed for different shifts by switching between the shift tabs:
 - **Shift S1:** Data for the first shift.
 - **Shift S2:** Data for the second shift.
 - **Shift S3:** Data for the third shift.

To view data for a specific shift, click on the corresponding shift tab. The table will update to display the relevant data for that shift.

3. Table Layout

The table will be organized to show the following columns:

- Overall View after selection of Shop floor and Date.

Business Unit : 4950		Shop Floor Viewer										Shop Floor:12SFWH...			
OEE (avg.)%	75.00	Performance %	91.66	Quality %	6598.85	Availability %	17	Capacity	5	Utilized	60	Planned Production	45	Actual Production	
SHIFT 1 (7AM-3PM)		SHIFT 2 (3PM-11PM)		SHIFT 3 (11PM-7AM)											
PL	Work Order	Job Order	Job Perf %	PL Status	Job Progress - Planned		Output (Qty)		Time (hh:mm)						
CUTM3	289094	289094-01	0	Completed	●	25/03/2024 07:00:00	25/03/2024 07:55:12	40	0	00:1	00:55	00:00			
CUTM3	289094	289094-01	0	Completed	●	25/03/2024 07:55:12	25/03/2024 08:26:24	40	0	00:2	00:31	00:00			
CUTM3	289094	289094-01	75	Completed	●	25/03/2024 08:26:24	25/03/2024 10:45:36	40	30	00:1	2:19	00:00			
SFSA1	289093	289093-01	0	Completed	●	25/03/2024 07:43:12	25/03/2024 08:22:48	20	0	00:2	00:40	00:00			
SFWH1	289093	289093-01	75	Completed	●	25/03/2024 08:22:48	25/03/2024 09:32:24	20	15	00:1	1:10	00:00			
CUTM1	289093	289093-01	0	Completed	●	25/03/2024 07:00:00	25/03/2024 07:27:36	20	0	00:1	00:28	00:00			
CUTM1	289093	289093-01	0	Completed	●	25/03/2024 07:27:36	25/03/2024 07:43:12	20	0	00:2	00:16	00:00			
CUTM4	289084	289084-01	0	Completed	●	25/03/2024 07:00:00	25/03/2024 07:34:30	25	0	00:1	00:34	00:00			
CUTM4	289084	289084-01	0	In Progress	●	25/03/2024 07:34:30	25/03/2024 07:54:00	25		00:2	00:19	00:00			

- Job Details display based on Job order's  (i) button clicked

Business Unit : 4950		Shop Floor Viewer										Shop Floor:12SFWH...			
OEE (avg.)%	75.00	Performance %	91.66	Quality %	6598.85	Availability %	17	Capacity	5	Utilized	60	Planned Production	45	Actual Production	
SHIFT 1 (7AM-3PM)		SHIFT 2 (3PM-11PM)		SHIFT 3 (11PM-7AM)											
PL	Work Order	Job Order	Job Perf %	PL Status	Job Progress - Planned		Output (Qty)		Time (hh:mm)						
CUTM3	289094	289094-01	0	Completed	●	25/03/2024 07:00:00	25/03/2024 07:55:12	40	0	00:1	00:55	00:00			
CUTM3	289094	289094-01	0	Completed	●	25/03/2024 07:55:12	25/03/2024 08:26:24	40	0	00:2	00:31	00:00			
CUTM3	289094	289094-01	75	Completed	●	25/03/2024 08:26:24	25/03/2024 10:45:36	40	30	00:1	2:19	00:00			
SFSA1	289093	289093-01	0	Completed	●	25/03/2024 07:43:12	25/03/2024 08:22:48	20	0	00:2	00:40	00:00			
SFWH1	289093	289093-01	75	Completed	●	25/03/2024 08:22:48	25/03/2024 09:32:24	20	15	00:1	1:10	00:00			
CUTM1	289093	289093-01	0	Completed	●	25/03/2024 07:00:00	25/03/2024 07:27:36	20	0	00:1	00:28	00:00			
CUTM1	289093	289093-01	0	Completed	●	25/03/2024 07:27:36	25/03/2024 07:43:12	20	0	00:2	00:16	00:00			
CUTM4	289084	289084-01	0	Completed	●	25/03/2024 07:00:00	25/03/2024 07:34:30	25	0	00:1	00:34	00:00			
CUTM4	289084	289084-01	0	In Progress	●	25/03/2024 07:34:30	25/03/2024 07:54:00	25		00:2	00:19	00:00			

By using the shift tabs and reviewing the data table, you can effectively monitor and analyze job performance and production metrics across different shifts.