



Minor Defect Record System Work Instruction

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A web application that provides comprehensive functionality for managing and analyzing minor defects on production lines. Key features include:

- Defect Tracking: Efficiently record and monitor defects per production line.
- Data Management: Capture essential details such as date detected, car maker and model, line number, process, product number, lot number, serial number, defect category, defect details, treatment content, sequence and connector numbers, and personnel involved in repair and verification.
- Trend Analysis: Utilize recorded data to analyze trends and visualize performance metrics.
- Reporting: Generate insightful reports to aid in decision-making and quality control.

This system is designed to streamline defect management and enhance data-driven decision-making through effective tracking and analysis.

I. Viewing Page

MINOR DEFECT RECORD SYSTEM Wednesday, September 4, 2024 | 1:42:31 PM

A

Line No. Scan here Product Number Lot No. Serial No.

Date From * Date To * Process Defect Category Defect Details

2024-05-01 2024-09-04 Select Process Select Defect Category Select Defect Details Search

Note: The records displayed below are for today's date. Clear Refresh Export Add Record

B

#	Datetime Detected	Car Maker	Car Model	Line No.	Process	Group	Shift	Product Number	Lot Number	Serial Number	Defect Category	Defect
1	2024-07-10 08:30:14.000	TOYOTA	920B_INP	4128	Dimension_1	B	DS	82141-AK170C-P	59AAA8	00064	Insufficient taping (with dimension requirement)	Branch
2	2024-07-10 08:29:47.000	TOYOTA	920B_INP	4128	Dimension_1	B	DS	82141-AK140C-P	59A9W5	00049	Clamp Defect	Half locked clamp
3	2024-07-10 08:28:34.000	TOYOTA	920B_INP	4128	Dimension_1	B	DS	82141-AK140C-P	59A9W5	00049	Clamp Defect	Long clamp tail
4	2024-07-10 08:24:06.000	TOYOTA	920B_INP	4128	Dimension_1	B	DS	82141-AK170C-P	59AAA8	00068	Missing Tape	Missing spot tape
5	2024-07-10 07:56:06.000	TOYOTA	920B_INP	4128	Dimension_1	B	DS	82141-AK170C-P	59AAA8	00062	Insufficient taping (with dimension requirement)	Combine
6	2024-07-10 07:55:08.000	TOYOTA	920B_INP	4128	ECT_2	B	DS	82141-AK170C-P	59AAA7	00003	Exposed wire/junction	Junction
7	2024-07-10 05:14:08.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00062	Insufficient taping	Branch
8	2024-07-10 05:10:53.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction	Junction

Load more

C Total Record: 1043

Figure 1. Viewer Page

This page offers a comprehensive overview of the system, structured to enhance usability and efficiency:

1.A. At the top of the page, the user will find a set of search fields designed to help them quickly locate specific records. These fields allow them to filter data based on various criteria, making it easier to find relevant defect records based on above parameters. By default, the date from and date to is set to current date.

1.B. Below the search fields, the main section of the page features a detailed table displaying the defect records that match the search criteria. This table is organized to provide a clear and concise view of all added defect records. The table also includes load more to help users to navigate through large sets of records efficiently.

1.C. In the lower right of the table, it displays the total count of records. These changes based on the data shown in the table.

II. Adding of Record

Minor Defect Record

Date Detected * 2024-09-04 01:43:39 PM Car Maker * TOYOTA Car Model * 920B_INP

Line No. * 4128 Process * Dimension_1 Group * A Shift * DS

Scan QR-Code

Product Number * N463-67-010A(4)-1 Lot No. * 5998UD Serial No. * 00014

Defect Category * Foreign material Defect Details * Bandcut Treatment Content of Defect * Remove and dispose foreign material

Sequence No. * 45 Connector No. * 67 Repaired By (Pd Jr.Staff/Staff ID No.) * 13-0217 Verified By (Qa Jr.Staff/Staff ID No.) * 21-02115

Clear All Add Record

#	Datetime Detected	Car Maker	Car Model	Line No.	Process	Group	Shift	Product Number	Lot Number	Serial Number	Defect Category	Defect Details	Sequence No.	Connector No.
1	2024-07-10 08:30:14.000	TOYOTA	920B_INP	4128	ECT_2	B	DS	82141-AK170C-P	59AAA7	00008	Exposed wire/junction			
2	2024-07-10 08:29:47.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00062	Insufficient taping			
3	2024-07-10 08:28:34.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction			
4	2024-07-10 08:24:06.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction			
5	2024-07-10 07:56:08.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction			
6	2024-07-10 07:55:08.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction			
7	2024-07-10 05:14:08.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction			
8	2024-07-10 05:10:53.000	TOYOTA	920B_INP	4128	Appearance	A	NS	82141-AKF00C-P	59AAA6	00050	Exposed wire/junction			

Load more

Total Record: 1043

Figure 2. Add Record

Upon clicking the add record button [**+ Add Record**], the add record form will appear. This contains the following:

2.A. The datetime detected is auto-generated. The car maker and model are automatically fetched based on the selected line number. The list of processes is based on the processes associated with the selected line number. The shift is also automated.

2.B. When a harness is barcoded, its product name, lot number, and serial number will be fetched automatically and displayed in their designated input fields.

2.C. When a defect category is selected, the corresponding defect details will be displayed in the dropdown menu. Similarly, the treatment content for the defect will be based on the selected defect details.

III. Search Fields

MINOR DEFECT RECORD SYSTEM

Line No. 4128 Scan here Product Number Product Number Lot No. Lot No. Serial No. Serial No.

Date From * 2024-06-01 Date To * 2024-06-30 Process Select Process Defect Category Foreign material Defect Details Select Defect Details Search

Note: The records displayed below are for today's date. Clear Refresh Export + Add Record

#	Datetime Detected	Car Maker	Car Model	Line No.	Process	Group	Shift	Product Number	Lot Number	Serial Number	Defect Category	Defect Details	Sequence No.	Connector No.
1	2024-06-30 03:44:33.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	00063	Foreign material	Dust	0	547
2	2024-06-30 03:38:13.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	00045	Foreign material	Dust	0	180
3	2024-06-30 00:34:57.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	00009	Foreign material	Dust	0	547

Figure 3. Search

3.A. In the highlighted part, the user will find a range of search fields designed to help them efficiently locate specific records. These fields enable the user to filter data by various criteria, allowing them to swiftly find relevant defect records based on parameters such as line no., product name, lot no., serial

no. (these can be done manually or scan harness and it will search automatically), date from, date to, process, defect category, and defect details. By default, the date from and date to is set to current date.

IV. Export Record

MINOR DEFECT RECORD SYSTEM

Line No. 4128 Scan here Product Number Lot No. Downloads
Date From 2024-06-01 Date To 2024-06-30 Process Select Process Defect Category Foreign material Defect Details Select Defect Details Search
Note: The records displayed below are for today's date. Clear Refresh Export Add Record

Minor Defect Record Table

#	Datetime Detected	Car Maker	Car Model	Line No.	Process	Group	Shift	Product Number	Lot Number	Serial Number	Defect Category	Defect Details	Sequence No.	Connector No.
1	2024-06-30 03:44:33.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	00063	Foreign material	Dust	0	547
2	2024-06-30 03:18:13.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	00045	Foreign material	Dust	0	180
3	2024-06-30 00:34:57.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	00009	Foreign material	Dust	0	547
4	2024-06-29 20:09:58.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK170C-P	59A6ZY	00091	Foreign material	Dust	0	251
5	2024-06-29 01:40:46.000	TOYOTA	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6J0	00056	Foreign material	Dust	0	180
6	2024-06-28 21:16:53.000	TOYOTA	920B_INP	4128	Appearance	B	NS	82141-AK170C-P	59A6ZY	00087	Foreign material	Dust	32	251
7	2024-06-28 01:58:23.000	TOYOTA	920B_INP	4128	Appearance	B	NS	82141-AK140C-P	59A6ZX	00023	Foreign material	Connector scratch	179	547
8	2024-06-27 14:57:51.000	TOYOTA	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	00059	Foreign material	Fiber	91	38

Total Record: 13

Figure 4. Export

Date Detected	Time Detected	Car Model	Line No.	Process	Group	Shift	Product Number	Lot Number	Serial Number	Defect Category	Defect Details	Sequence No.	Connector No.	Treatment Content of Defect	Repaired By	Verified By
2024-06-27	9:27:30	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	16	Foreign material	Fiber	97	76	Remove and dispose foreign material	14-01715	21-06667
2024-06-27	11:44:07	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	27	Foreign material	Fiber	179	547	Remove and dispose foreign material	18-04058	21-06667
2024-06-27	12:32:04	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	31	Foreign material	Fiber	91	38	Remove and dispose foreign material	14-01715	21-06667
2024-06-27	13:04:03	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	26	Foreign material	Fiber	99	42	Remove and dispose foreign material	14-01715	21-06667
2024-06-27	14:32:49	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	57	Foreign material	Fiber	91	38	Remove and dispose foreign material	14-01715	21-06667
2024-06-27	14:57:51	920B_INP	4128	Appearance	A	DS	82141-AK140C-P	59A6J0	59	Foreign material	Fiber	91	38	Remove and dispose foreign material	14-01715	21-06667
2024-06-28	1:58:23	920B_INP	4128	Appearance	B	NS	82141-AK140C-P	59A6ZX	23	Foreign material	Connector scratch	179	547	Remove and dispose foreign material	18-04060	21-06559
2024-06-28	21:16:53	920B_INP	4128	Appearance	B	NS	82141-AK170C-P	59A6ZY	67	Foreign material	Dust	32	251	Remove and dispose foreign material	20-05063	21-06559
2024-06-29	1:40:46	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6J0	56	Foreign material	Dust	0	180	Remove and dispose foreign material	22-07671	21-06559
2024-06-29	20:09:58	920B_INP	4128	ECT_1	B	NS	82141-AK170C-P	59A6ZY	93	Foreign material	Dust	0	251	Remove and dispose foreign material	15-02716	21-06559
2024-06-30	0:34:57	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	9	Foreign material	Dust	0	547	Remove and dispose foreign material	5-02716	21-06559
2024-06-30	9:18:13	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	45	Foreign material	Dust	0	180	Remove and dispose foreign material	15-02716	21-06559
2024-06-30	9:44:33	920B_INP	4128	ECT_1	B	NS	82141-AK140C-P	59A6ZX	63	Foreign material	Dust	0	547	Remove and dispose foreign material	14-02258	21-06559

Figure 5. Exported Data

4.A. Once the user has filtered the data as needed, click the export button to download the file. The file will contain the filtered data from the table.

4.B. The downloaded file will be named based on the date of download, indicating the time it was saved.

V. Line Number / Process / QR Setting Registration (for Administrator)

5.A. Open the http://172.25.116.188:3000/pcad/pcs_page/admin/

5.B. Navigate to the PCS Masterlist page and verify if the required line number is registered.

5.C. Proceed to the Inspection Masterlist and confirm the processes registered under the specific line number.

5.D. Once done, access the http://172.25.116.188:3000/minor_defect_record_system/index_m.php

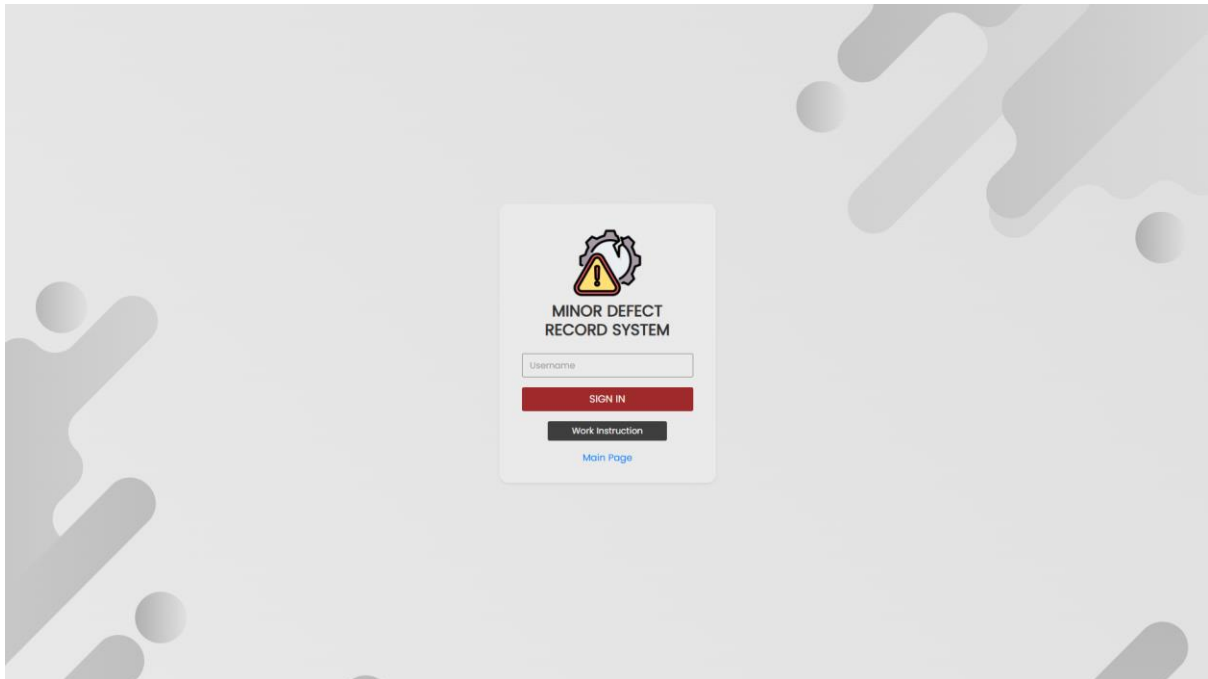


Figure 6. Administrator Login Page

5.E. Log in using your credentials, then view the QR Settings Masterlist tab.

- Check if the required car maker and car model are registered.
- If not, click on the Add Model Settings button, then input the needed details (car maker, car model setting, car value, total length, product name start and length, lot number start and length, and serial number start and length) and save the changes.

#	Car Maker	Car Model Setting	Car Value	Total Length	Product Name Start	Product Name Length	Lot No. Start	Lot No. Length	Serial No. Start	Serial No. Length
1	DAIHATSU	DOIL	2	50	10	23	33	8	41	9
2	TOYOTA	920B_RNP	4	50	10	23	33	8	41	9

Figure 7. QR Settings Page

6.F. Click on the Defect Category, Details, and Treatment Content tab to view the defect category and details.

- To add defect details, click on the Add Defect Details button. Fill-out the needed details (defect code, defect category, defect sub code, defect details, and defect treatment), then save the record.

#	Action	Defect Code	Defect Category	Defect Sub Code	Defect Details	Defect Treatment
1	Delete	AA	Exposed Wire/Junction	AA1	Junction	Add tape
2	Delete	AA	Exposed Wire/Junction	AA2	Branch	Add tape
3	Delete	BB	Missing Marking	BB1	Alignment jig	Use alignment jig to pt pass mark
4	Delete	BB	Missing Marking	BB2	Connector retainer	Put marking
5	Delete	BB	Missing Marking	BB3	Clamp/sponge	Put marking
6	Delete	BB	Missing Marking	BB4	VS	Put marking
7	Delete	BB	Missing Marking	BB5	COH	Put marking
8	Delete	BB	Missing Marking	BB6	PR	Put marking
9	Delete	BB	Missing marking	BB7	CAP	Put marking

Figure 8. Defect Category, Details, and Treatment Content Page

7.G. Click on the Account Management tab to view the list of registered accounts.

- To add account, click on the Add Account button. Fill-out the needed details (username and role), then save the record.

#	Action	Username	Role
1	Delete	ally	ADMIN

Figure 9. Account Management Page