REQUIREMENT AND INFORMATION DOCUMENT														
Objective: - The preliminary data. BOM master operator to change and save The changes causes											No.:	DE-REQ-		
- This document will be issued by concerned section.											Issue Date :		4-Jun-21	
ЈВЈЕСТ :	Infori	m ADD Spare	Polishing	544-40	2.	-	THAM		P. J	iv: Adjana	Vimin Con	APPRO	OVED:	敦
CUMENT or		Drawing	V	BOM Master		PO			Metho	d (WI)	•			
OF CHANGE		PDM	V	SAP		Produ	ction Plan		Other					
TS CODE :			1				WATCH	CODE:						
544-00230-40														
Showed of the second of the se														
	CLA	SSIFICATIO	N FOR C	HANGING:			START R	EQUIRE	PROD	UCTION MO	NTH: 10K1202	1		
Change Order			Save	Cost		Chang	e Process			Standardizatio	n		Common	
Mistake Order			Chang	ge Specification		Reduc	t for Stock			Qualitty Upgra	de		Mistake Write	
For Defective			For In	nproved		Marke	t Request		V	Other Change	Spare			
DESCRIPTION														
<reason explain=""> We'd like to request ADD spare polishing 544-00230-40 because this model process polishing return to process press</reason>														
			1100 11	7 00 11/202	Marin Tolland									
	UBJECT : CUMENT or OF CHANGE RTS CODE : 544-00230-40 Change Order Mistake Order For Defective	- Thi UBJECT : Inform CUMENT or OF CHANGE RTS CODE : 544-00230-40 CLA Change Order Mistake Order For Defective	- This document w UBJECT: Inform ADD Spare CUMENT or Drawing OF CHANGE PDM RTS CODE: 544-00230-40 CLASSIFICATIO Change Order Mistake Order For Defective CREASON Explain> We'd and of the component of the	- This document will be issu UBJECT: Inform ADD Spare Polishing CUMENT or Drawing OF CHANGE PDM ETS CODE: 544-00230-40 CLASSIFICATION FOR CO Change Order Save Mistake Order Change For Defective For In <reason explain=""> We'd like to requand comback to see and com</reason>	Objective: - The preliminary data. BOM master operary - This document will be issued by concern UBJECT: Inform ADD Spare Polishing 544-40 CUMENT OF Drawing BOM Master OF CHANGE PDM SAP RTS CODE: 544-00230-40 CLASSIFICATION FOR CHANGING: Change Order Save Cost Mistake Order Change Specification For Defective For Improved <reason explain=""> We'd like to request ADD spare and comback to process polish</reason>	Objective: - The preliminary data. BOM master operator to chan This document will be issued by concerned section. UBJECT: Inform ADD Spare Polishing 544-40 CUMENT Or Drawing BOM Master DAM SAP STS CODE: 544-00230-40 CLASSIFICATION FOR CHANGING: Change Order Save Cost Mistake Order Change Specification Serve Cost DAM Serve Cost	Objective: - The preliminary data. BOM master operator to change and - This document will be issued by concerned section. UBJECT: Inform ADD Spare Polishing 544-40 CUMENT or Drawing BOM Master PO OF CHANGE PDM SAP Product CTS CODE: 544-00230-40 CLASSIFICATION FOR CHANGING: Change Order Save Cost Change Mistake Order Change Specification Reduct For Defective For Improved Marke DESCRI <reason explain=""> We'd like to request ADD spare polishing 544-0023 and comback to process polishing finish again</reason>	Objective: - The preliminary data. BOM master operator to change and save The clarification. UBJECT: Inform ADD Spare Polishing 544-40 THORS CUMENT OR Drawing BOM Master POSAP Production Plan ETS CODE: WATCH CHANGE PDM SAP Production Plan ETS CODE: Save Cost Change Process Mistake Order Save Cost Change Process Mistake Order Change Specification Reduct for Stock For Defective For Improved Market Request DESCRIPTION CReason Explain> We'd like to request ADD spare polishing 544-00230-40 because	Objective: - The preliminary data. BOM master operator to change and save The changes of this document will be issued by concerned section. INFORM. THO FOSI. CUMENT OF Drawing BOM Master PO PO COF CHANGE PDM SAP Production Plan SAP Production Plan SAP Production Plan SAP Production Plan SAP START REQUIRES CLASSIFICATION FOR CHANGING: START REQUIRES Change Order Save Cost Change Process Mistake Order Change Specification Reduct for Stock Por Defective For Improved Market Request DESCRIPTION Reason Explain> We'd like to request ADD spare polishing 544-00230-40 because this mot and comback to process polishing finish again	Objective: - The preliminary data. BOM master operator to change and save The changes causes - This document will be issued by concerned section. UBJECT: Inform ADD Spare Polishing 544-40 UBJECT: Inform ADD Spare Polishing 544-00230-40 because this model propagation and comback to process polishing finish again	Objective: - The preliminary data. BOM master operator to change and save The changes causes - This document will be issued by concerned section. INFORMATION BY: THO HOD! FIGURE OF THIS HOD! OF CHANGE PDM BOM Master PO Method (WI) OF CHANGE PDM SAP Production Plan Other OTHER CODE: START REQUIRE PRODUCTION MO Change Order Save Cost Change Process Standardization Mistake Order Reduct for Stock Qualitty Upgra For Defective For Improved Market Request Other Change DESCRIPTION We'd like to request ADD spare polishing 544-00230-40 because this model process polishing and comback to process polishing finish again	Objective: - The preliminary data. BOM master operator to change and save The changes causes - This document will be issued by concerned section. INFORMATION BY: THO HOD! For J. Adjuster Common Co	Objective: - The preliminary data. BOM master operator to change and save The changes causes - This document will be issued by concerned section. UBJECT: Inform ADD Spare Polishing 544-40	Objective: - The preliminary data. BOM master operator to change and save The changes causes - This document will be issued by concerned section. Inform ADD Spare Polishing 544-40 Inform ADD Spare Polishing 644-40 Inform A

Inform ADD Spare Polishing

		Mat'l Nam	e	3. 经基础证券	P.Type	Trial No.		Month (Ki)	Run S	ex Ran	kPL.Cate.	Color	STATE OF THE PERSONS ASSESSMENT	
-40	544-40	DECORA	TION RING	POS	EE	91XT-J001		AC-7KI	1 1	. В	TI			
3.O.M		Draw	ing View			Information			1	Routing		E	I.O.M. Review	
Mat'l No	PTISP	Otv	Spare(%) (Init Vendor	Maker	Unit Price	Cur I	Per	Cate	a Gus		Desc	HandP	STG
1-00230-40	EE	1.000	0.000 P	CE T0001	RTC	AKS ME		II		Dec	oration Ring	g POS	N. W. B. W.	MTS
4-00230-30	EE	1.000	(0.700)P	CE T0001	RTC	V. 3123 2.53		П		Dec	oration Ring	g TNS		MTS
4-00230-30	EE	1 1 000	0.000 F	CE T0001	RTC		16231	T		Dec	oration Ring	g TNS		IMTS
4-00230-20	EE	1.000	4.500 F	CE T0001	RTC		252	TI		Dec	oration Ring	g PRS		MTS
4-00230-20	EE	1.000	0.000 F	CE T0001	RTC			T		Dec	oration Ring	g PRS		MTS
4-00230-10	EE	1.000	3.000 F	PCE T0001	RTC	1 - 1 - 10		14.00	MM.	Dec	oration Ring	g Blank		MTS
4-00230-10	EE	1.000	0.000 F	PCE T0001	RTC			14.00	MM.	Dec	oration Ring	g Blank		MTS
/TI-0016	FF	14.640	0.000 G	3 Z4VDY	AMT					Tita	nium			MTS
4444	Mati No -00230-40 -00230-30 -00230-30 -00230-20 -00230-20 -00230-10 -00230-10	Maří No PT SP -00230-40 EE -00230-30 EE -00230-30 EE -00230-20 EE -00230-20 EE -00230-10 EE -00230-10 EE	Mati No PT SP Otv -00230-40 EE 1.000 -00230-30 EE 1.000 -00230-30 EE 1.000 -00230-20 EE 1.000 -00230-20 EE 1.000 -00230-10 EE 1.000 -00230-10 EE 1.000	Mati No PT SP Oty Spare(%) -00230-40	Mati No PT SP Oty Spare(%) Unit Vendor -00230-40 EE 1.000 0.000 PCE T0001 -00230-30 EE 1.000 (0.700) PCE T0001 -00230-30 EE 1.000 0.000 PCE T0001 -00230-20 EE 1.000 4.500 PCE T0001 -00230-20 EE 1.000 0.000 PCE T0001 -00230-10 EE 1.000 3.000 PCE T0001 -00230-10 EE 1.000 0.000 PCE T0001	Mati No PT SP Oty Spare(%) Unit Vendor Maker -00230-40 EE 1.000 0.000 PCE T0001 RTC -00230-30 EE 1.000 (0.700)PCE T0001 RTC -00230-30 EE 1.000 0.000 PCE T0001 RTC -00230-20 EE 1.000 4.500 PCE T0001 RTC -00230-20 EE 1.000 0.000 PCE T0001 RTC -00230-10 EE 1.000 3.000 PCE T0001 RTC -00230-10 EE 1.000 0.000 PCE T0001 RTC	Mati No PT SP Oty Spare(%) Unit Vendor Maker Unit Price -00230-40 EE 1.000 0.000 PCE T0001 RTC -00230-30 EE 1.000 (0.700) PCE T0001 RTC -00230-30 EE 1.000 0.000 PCE T0001 RTC -00230-20 EE 1.000 4.500 PCE T0001 RTC -00230-20 EE 1.000 0.000 PCE T0001 RTC -00230-10 EE 1.000 3.000 PCE T0001 RTC -00230-10 EE 1.000 0.000 PCE T0001 RTC	Mati No PT SP Oty Spare(%) Unit Vendor Maker Unit Price Cur -00230-40 EE 1.000 0.000 PCE T0001 RTC -00230-30 EE 1.000 0.000 PCE T0001 RTC -00230-30 EE 1.000 0.000 PCE T0001 RTC -00230-20 EE 1.000 4.500 PCE T0001 RTC -00230-20 EE 1.000 0.000 PCE T0001 RTC -00230-10 EE 1.000 3.000 PCE T0001 RTC -00230-10 EE 1.000 0.000 PCE T0001 RTC	Mati No PT SP Oty Spare(%) Unit Vendor Maker Unit Price Cur Per -00230-40 EE 1.000 0.000 PCE T0001 RTC TI -00230-30 EE 1.000 (0.700) PCE T0001 RTC TI -00230-30 EE 1.000 0.000 PCE T0001 RTC TI -00230-20 EE 1.000 4.500 PCE T0001 RTC TI -00230-20 EE 1.000 0.000 PCE T0001 RTC TI -00230-10 EE 1.000 3.000 PCE T0001 RTC 14.00 -00230-10 EE 1.000 0.000 PCE T0001 RTC 14.00	Mati No PT SP Otv Spare(%) Unit Vendor Maker Unit Price Cur Per Cate -00230-40 EE 1.000 0.000 PCE T0001 RTC TI -00230-30 EE 1.000 0.000 PCE T0001 RTC TI -00230-30 EE 1.000 0.000 PCE T0001 RTC TI -00230-20 EE 1.000 0.000 PCE T0001 RTC TI -00230-20 EE 1.000 3.000 PCE T0001 RTC TI -00230-10 EE 1.000 3.000 PCE T0001 RTC 14.00 MM -00230-10 EE 1.000 0.000 PCE T0001 RTC 14.00 MM	Mati No PT SP Oty Spare(%) Unit Vendor Maker Unit Price Cur Per Cate -00230-40 EE 1.000 0.000 PCE T0001 RTC TI Dec -00230-30 EE 1.000 0.000 PCE T0001 RTC TI Dec -00230-30 EE 1.000 0.000 PCE T0001 RTC TI Dec -00230-20 EE 1.000 0.000 PCE T0001 RTC TI Dec -00230-20 EE 1.000 3.000 PCE T0001 RTC TI Dec -00230-10 EE 1.000 3.000 PCE T0001 RTC 14.00 MM Dec -00230-10 EE 1.000 0.000 PCE T0001 RTC 14.00 MM Dec	Mati No PT SP Oty Spare(%) Unit Vendor Maker Unit Price Cur Per Cate -00230-40 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring -00230-30 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring -00230-30 EE 1.000 4.500 PCE T0001 RTC TI Decoration Ring -00230-20 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring -00230-10 EE 1.000 3.000 PCE T0001 RTC TI Decoration Ring -00230-10 EE 1.000 3.000 PCE T0001 RTC TI Decoration Ring -00230-10 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring	Matrino PT SP Oty Spare(%) Unit Vendor Maker Unit Price Cur Per Cate Desc -00230-40 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring POS -00230-30 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring TNS -00230-30 EE 1.000 4.500 PCE T0001 RTC TI Decoration Ring TNS -00230-20 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring PRS -00230-20 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring PRS -00230-10 EE 1.000 3.000 PCE T0001 RTC 14.00 MM. Decoration Ring Blank -00230-10 EE 1.000 0.000 PCE T0001 RTC 14.00 MM Decoration Ring Blank	Mati No PT SP Oty Spare(%) Unit Vendor Maker Unit Price Cur Per Cate Desc HandP -00230-40 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring POS -00230-30 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring TNS -00230-30 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring TNS -00230-20 EE 1.000 0.000 PCE T0001 RTC TI Decoration Ring PRS -00230-20 EE 1.000 3.000 PCE T0001 RTC TI Decoration Ring PRS -00230-10 EE 1.000 3.000 PCE T0001 RTC 14.00 MM Decoration Ring Blank

Part Code	Old Spare	New Spare
544-00230-40	0.7	1

Remark: - Please report the cause and the result was later changed. For complete details

- Change maker of parts must have price before and after change

			PO	S PROCESS	FLOW(NE	W N	ODEL T	EAM)	T/,				
Туре	Sub Type	Trial N	lo.	Case	No.	BI	Blank No. M				Rank		
ZBL	sc	87GT-J	006	4-T023				TI					
	Bezel fix Type :	No bezel Hand pres	Construction :			Watch	No.						
_		Water resist :	Vater resist : Ba										
Specification	Top side :				Sex:								
cat	Out side :							XII	A				
cifi	ALL:									(A)	J)		
Spe	Etching: 🖙	□No								T			
0,	Resin: □/es	□No											
	TNS Code:			Qty L	ot	300							
									Time (S)		Setup		
	Description	Process name		Sub process	Machine		То	ols	Man M/C		Man(S) Setup (S)		
	HAND	Rough-SC-Ti	Top side(UB	# AE=1000)	Buffing Lathe IP-14		UB # AE=1000		85.20		70	300	
	-23/4	Middle-SC-Ti	Lower(Urethance buff (White)Toji) Out side(Urethance buff (White)Toji) Top side(Urethance buff (White)Toji)		Buffing Lathe Double Head Buffing Lathe Double Head Buffing Lathe Double Head		Urethance buff (White)Toji Urethance buff (White)Toji Urethance buff (White)Toji		73.20		60	300	
		Middle-SC-Ti											
		Middle-SC-Ti											
-		Middle-SC-Ti	Cleaning(Min	ror)(Cleaning)	Cleaning M/C		Clea	ning	12.00		10		
	Middle-SC-T		Lower(Urethance buff (White))		Buffing Lathe Double Head		Urethance buff (White)				32	300	
		Middle-SC-Ti	Out side(Ure	chance buff (White))	Buffing Lathe Doubl	e Head	Urethance	ouff (White)	39.60				
		Middle-SC-Ti	Top side(Urethance buff (White))		Buffing Lathe Doubl	e Head	Urethance buff (White)						3
		Middle-SC-Ti	Lower(Urethance buff (Pink))		Buffing Lathe Doubl	e Head	Urethance buff (Pink)				34	300	- 'A'
		Middle-SC-Ti	Out side(Urethance buff (Pink))		Buffing Lathe Double Head		Urethance buff (Pink)		42.00				
		Middle-SC-Ti	Top side(Urethance buff (Pink))		Buffing Lathe Double Head		Urethance buff (Pink)						
		Final-SC-Ti	Lower(White	Buff Kya ra ku)	Buffing Lathe Double Head		White Buff	Kya ra ku			31	300	
S		Final-SC-Ti	Outside(White Buff Kya ra ku)		Buffing Lathe Double Head		White Buff Kya ra ku		38.40				
Ses		Final-SC-Ti	Top Side(Wh	ite Buff Kya ra ku)	Buffing Lathe Double Head		White Buff Kya ra ku						
Process		Final-SC-Ti	Cleaning(Mir	or)(Cleaning)	Cleaning M/C		Cleaning		12.00		10		
_					PRS Cutting				Ц				
		Final-SC-Ti		Buff Kya ra ku)	Buffing Lathe Doubl			Kya ra ku			30	300	
		Final-SC-Ti	Outside(White Buff Kya ra ku)		Buffing Lathe Double Head		White Buff Kya ra ku White Buff Kya ra ku		37.20				
		Final-SC-Ti	Top Side(White Buff Kya ra ku) Cleaning(Mirror)(Cleaning)		Buffing Lathe Double Head Cleaning M/C		Escala in the second second						
		Final-SC-Ti	Wipe (Mirror)		Hand		Clea		12.00		10		
		Final-SC-Ti		lirror)(Hand)	Hand		Cot		9.60		8		
		1 mai-50-11	mspection (iv	into (trano)	ITIATIU		Па	nu	19.20		16		
3					1								
						-							
											311.00	6.00	
				Total					380	.40	606.5	11.7	618.15 B-Rank
Pr	epared by	Verify b	У	Approv	re by		Appr	ove by		Appro	ove by	1 1 1 1 1 1 1	
TE	CH CASE Section	TECH CA	SE Section	F15 ST RE 98 MARKET	TECH CASE Section			Polishing Section		CONCREDE NO.	Adviser		
	Mr.Worrawat	Mr.Wo	orrawat		Mr.Panus		Mr.S	Samroeng		Mr.	r.Onodera		
									1				
	8/3/2019			5					1			\neg	
Caution	ข้อควรระวัง				,					=	11.7	606	
													7.