

REQUIREMENT AND INFORMATION DOCUMENT

Objective : - The preliminary data. BOM master operator to change and save The changes causes
- This document will be issued by concerned section.

No. : DE-REQ-
Issue Date : 4-Jun-21

SUBJECT :	Inform ADD Spare Polishing 544-40	INFORMATION BY : THA MODI P. S. Adhane	APPROVED : 5-6-21 似田具敦 5 JUN 2021
DOCUMENT or DATA OF CHANGE	<input type="checkbox"/> Drawing <input type="checkbox"/> PDM	<input checked="" type="checkbox"/> BOM Master <input checked="" type="checkbox"/> SAP	<input type="checkbox"/> PO <input type="checkbox"/> Production Plan <input type="checkbox"/> Method (WI) <input type="checkbox"/> Other

PARTS CODE :

544-00230-40

WATCH CODE :

CLASSIFICATION FOR CHANGING :

START REQUIRE PRODUCTION MONTH : 10K12021

- | | | | | |
|--|---|---|--|--|
| <input type="checkbox"/> Change Order | <input type="checkbox"/> Save Cost | <input type="checkbox"/> Change Process | <input type="checkbox"/> Standardization | <input type="checkbox"/> Common |
| <input type="checkbox"/> Mistake Order | <input type="checkbox"/> Change Specification | <input type="checkbox"/> Reduct for Stock | <input type="checkbox"/> Quality Upgrade | <input type="checkbox"/> Mistake Write |
| <input type="checkbox"/> For Defective | <input type="checkbox"/> For Improved | <input type="checkbox"/> Market Request | <input checked="" type="checkbox"/> 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 and comback to process polishing finish again

プレス加工用歩留率(設定)が不足のため追加。

Inform ADD Spare Polishing

Matl No.	Matl Gp.	Matl Name	PType	Trial No.	Month (KI)	Run	Sex	Rank	PL.Cate.	Color
544-00230-40	544-40	DECORATION RING POS	EE	91XT-J001	AC-7KI	1	L	B	TI	


B.O.M		Drawing View			Information			Routing		B.O.M. Review	
Matl Gp.	Matl No.	PT	SP	Qty	Spare(%)	Unit	Vendor	Maker	Unit Price	Cur	Per
544-40	544-00230-40	EE		1.000	0.000	PCE	T0001	RTC			TI
544-30	544-00230-30	EE		1.000	0.700	PCE	T0001	RTC			TI
544-30	544-00230-30	EE		1.000	0.000	PCE	T0001	RTC			TI
544-20	544-00230-20	EE		1.000	4.500	PCE	T0001	RTC			TI
544-20	544-00230-20	EE		1.000	0.000	PCE	T0001	RTC			TI
544-10	544-00230-10	EE		1.000	3.000	PCE	T0001	RTC			14.00 MM.
544-10	544-00230-10	EE		1.000	0.000	PCE	T0001	RTC			14.00 MM.
RMTI	RMTI-0016	FF		14.640	0.000	G	Z4VDY	AMT			Titanium




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

POS PROCESS FLOW(NEW MODEL TEAM)

Type	Sub Type	Trial No.	Case No.	Blank No.	Material	Rank
ZBL	SC	87GT-J006	4-T023835		TI	B

Specification	Bezel fix Type : <input type="checkbox"/> No bezel <input type="checkbox"/> Hand press <input type="checkbox"/> Rotate			Construction : _____		Watch No.	
	<input type="checkbox"/> Welding <input type="checkbox"/> Notching			Water resist : _____ Bar			
	Top side :			Sex :			
	Out side :						
	ALL:						
	Etching : <input type="checkbox"/> Yes <input type="checkbox"/> No						
	Resin : <input type="checkbox"/> Yes <input type="checkbox"/> No						
TNS Code :			Ring		Qty Lot 300		

Description	Process name	Sub process	Machine	Tools	Time (S)		Man(S)	Setup (S)	
					Man	M/C			
  	HAND	Rough-SC-Ti	Top side(UB # AE=1000)	Buffing Lathe IP-14	UB # AE=1000	85.20		70 300	
		Middle-SC-Ti	Lower(Urethane buff (White)Toji)	Buffing Lathe Double Head	Urethane buff (White)Toji	73.20		60 300	
		Middle-SC-Ti	Out side(Urethane buff (White)Toji)	Buffing Lathe Double Head	Urethane buff (White)Toji				
		Middle-SC-Ti	Top side(Urethane buff (White)Toji)	Buffing Lathe Double Head	Urethane buff (White)Toji				
		Middle-SC-Ti	Cleaning(Mirror)(Cleaning)	Cleaning M/C	Cleaning	12.00		10	
		Middle-SC-Ti	Lower(Urethane buff (White))	Buffing Lathe Double Head	Urethane buff (White)	39.60		32 300	
		Middle-SC-Ti	Out side(Urethane buff (White))	Buffing Lathe Double Head	Urethane buff (White)				
		Middle-SC-Ti	Top side(Urethane buff (White))	Buffing Lathe Double Head	Urethane buff (White)				
		Middle-SC-Ti	Lower(Urethane buff (Pink))	Buffing Lathe Double Head	Urethane buff (Pink)	42.00		34 300	
		Middle-SC-Ti	Out side(Urethane buff (Pink))	Buffing Lathe Double Head	Urethane buff (Pink)				
		Middle-SC-Ti	Top side(Urethane buff (Pink))	Buffing Lathe Double Head	Urethane buff (Pink)				
		Final-SC-Ti	Lower(White Buff Kya ra ku)	Buffing Lathe Double Head	White Buff Kya ra ku	38.40		31 300	
		Final-SC-Ti	Outside(White Buff Kya ra ku)	Buffing Lathe Double Head	White Buff Kya ra ku				
		Final-SC-Ti	Top Side(White Buff Kya ra ku)	Buffing Lathe Double Head	White Buff Kya ra ku				
		Final-SC-Ti	Cleaning(Mirror)(Cleaning)	Cleaning M/C	Cleaning	12.00		10	
	PRS Cutting								
		Final-SC-Ti	Lower(White Buff Kya ra ku)	Buffing Lathe Double Head	White Buff Kya ra ku	37.20		30 300	
		Final-SC-Ti	Outside(White Buff Kya ra ku)	Buffing Lathe Double Head	White Buff Kya ra ku				
		Final-SC-Ti	Top Side(White Buff Kya ra ku)	Buffing Lathe Double Head	White Buff Kya ra ku				
		Final-SC-Ti	Cleaning(Mirror)(Cleaning)	Cleaning M/C	Cleaning	12.00		10	
	Final-SC-Ti	Wipe (Mirror)(Cotton)	Hand	Cotton	9.60		8		
	Final-SC-Ti	Inspection (Mirror)(Hand)	Hand	Hand	19.20		16		
Total						380.40		311.00 6.00	
						380.40		606.5 11.7 618.15 B-Rank	

Prepared by TECH CASE Section Mr.Worrawat 8/3/2019	Verify by TECH CASE Section Mr.Worrawat	Approve by TECH CASE Section Mr.Panus	Approve by Polishing Section Mr.Samroeng	Approve by Adviser Mr.Onodera
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Caution ข้อควรระวัง

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