**存储过程：**

g\_machine\_sp\_worktype

**机台上料：**ACTION-M-B



**机台换料：**ACTION-M-H



物料属性表：

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
|  | 物料屬性表 範例 | |  |  |
| 模式 | 差異HH料號 | 差異供應商料號 | 屬性備註 |  |
| 群組料號 | G1 | A1 | 90,8\*8\*1,12\*12 | 90:物料在料帶中機型點實際角度 |
| 群組料號 | G1 | A2 | \*\*\*\*\*\*\* | 8\*8\*1:物料本體長寬厚 |
| 群組料號 | G1 | A3 | \*\*\*\*\*\*\* | 12\*12:料帶間距\*寬度 |
|  |  |  |  |  |
| 一物一料 | H1 | B1 | \*\*\*\*\*\*\* |  |
| 一物一料 | H2 | B2 | \*\*\*\*\*\*\* |  |

MES1.c\_material\_vendor\_config

修改来料方向不一致的检查，加在 check\_material\_mfr\_change 这个存储过程的后面。

**新增一个存储 check\_material\_vendor\_sp,**



**新增表格：**

CREATE TABLE MES1.c\_material\_vendor\_config(

MODEL VARCHAR2(100),

hhpn VARCHAR2(100),

vendor\_partno VARCHAR2(100),

propertity VARCHAR2(200),

LASTEDITBY VARCHAR2(100),

LASTEDITDT DATE

)

存储过程:

CREATE OR REPLACE PROCEDURE MES1.check\_material\_vendor\_sp(res OUT VARCHAR2,

i\_tr\_sn IN VARCHAR2,

i\_machine IN VARCHAR2) IS

v\_count INT;

v\_hhpn VARCHAR2(100);

V\_last\_vendorpartno VARCHAR2(100);

V\_vendorpartno VARCHAR2(100);

v\_last\_propertity VARCHAR2(100);

v\_propertity VARCHAR2(100);

v\_smt\_code VARCHAR2(100);

v\_replace\_hhpn VARCHAR2(100);

v\_last\_replace\_hhpn VARCHAR2(100);

v\_work\_time R\_TR\_CODE\_DETAIL.Work\_Time%TYPE;

*--定義游標，抓取替代料*

CURSOR c\_kp\_no IS

SELECT KP\_NO, REPLACE\_KP\_NO

FROM C\_REPLACE\_KP

WHERE SMT\_CODE = v\_smt\_code

AND (KP\_NO = v\_hhpn OR REPLACE\_KP\_NO = v\_hhpn);

c\_row c\_kp\_no%rowtype;

BEGIN

BEGIN

SELECT CUST\_KP\_NO, mfr\_kp\_no

INTO v\_hhpn, V\_vendorpartno

FROM R\_TR\_SN

WHERE TR\_SN = i\_tr\_sn;

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

RAISE\_APPLICATION\_ERROR(-20000,

'ERROR:can find record,tr\_sn:' || i\_tr\_sn);

END;

DBMS\_OUTPUT.put\_line('0:v\_hhpn-->' || v\_hhpn || ',V\_vendorpartno-->' ||

V\_vendorpartno);

SELECT COUNT(1)

INTO v\_count

FROM MES1.c\_material\_vendor\_config

WHERE hhpn = v\_hhpn;

DBMS\_OUTPUT.put\_line('v\_hhpn-->' || v\_hhpn ||

',MES1.c\_material\_vendor\_config count-->' ||

v\_count);

*--HHPN是屬性表是否存在*

IF v\_count > 0 THEN

SELECT COUNT(1)

INTO v\_count

FROM R\_TR\_CODE\_DETAIL

WHERE KP\_NO = v\_hhpn

AND STATION = i\_machine

AND ROWNUM<10;

*--檢查上料記錄是否存在*

IF v\_count > 0 THEN

SELECT MFR\_KP\_NO

INTO V\_last\_vendorpartno

FROM (SELECT MFR\_KP\_NO

FROM R\_TR\_CODE\_DETAIL

WHERE KP\_NO = v\_hhpn

AND STATION = i\_machine

order by WORK\_TIME desc)

WHERE ROWNUM = 1;

DBMS\_OUTPUT.put\_line('1Y2Y:V\_last\_vendorpartno-->' ||

V\_last\_vendorpartno || ',V\_vendorpartno:' ||

V\_vendorpartno);

IF V\_vendorpartno = V\_last\_vendorpartno THEN

res := 'OK'; *--返回結果*

ELSE

BEGIN

SELECT propertity

INTO v\_last\_propertity

FROM MES1.c\_material\_vendor\_config

WHERE VENDOR\_PARTNO = V\_last\_vendorpartno

and hhpn = v\_hhpn

AND ROWNUM = 1;

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

v\_last\_propertity := '';

END;

DBMS\_OUTPUT.put\_line('1Y2Y3N:v\_last\_propertity-->' ||

v\_last\_propertity);

*--供應商料號在屬性表是否存在*

IF v\_last\_propertity IS NOT NULL THEN

BEGIN

SELECT propertity

INTO v\_propertity

FROM MES1.c\_material\_vendor\_config

WHERE hhpn = v\_hhpn

and propertity = v\_last\_propertity

and vendor\_partno = V\_vendorpartno

and rownum = 1;*--通過屬性和鴻海料號查找記錄，供應商可以不同*

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

v\_propertity := '';

END;

DBMS\_OUTPUT.put\_line('1Y2Y3N4Y:v\_hhpn-->' || v\_hhpn);

*--屬性是否相等*

IF v\_propertity IS NOT NULL THEN

res := 'OK';

ELSE

res := 'ERROR:InComing Polarity,Please call EE'; *--返回結果*

END IF;

ELSE

res := 'WARNING:First online ,please call EE'; *--返回結果*

END IF;

END IF;

ELSE

BEGIN

SELECT SMT\_CODE

INTO v\_smt\_code

FROM (SELECT SMT\_CODE

FROM MES4.R\_STATION\_WIP

WHERE STATION = i\_machine

ORDER BY WORK\_TIME DESC)

WHERE ROWNUM = 1;

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

RAISE\_APPLICATION\_ERROR(-20000, 'ERROR:SMT CODE IS NULL');

END;

v\_work\_time:=TO\_DATE('1990-1-1 00:00:00', 'YYYY-MM-DD HH24:MI:SS');

*--操作最近的替代料記錄*

FOR c\_row IN c\_kp\_no LOOP

DBMS\_OUTPUT.put\_line('1Y2N-->' || c\_row.KP\_NO || ':' ||

c\_row.REPLACE\_KP\_NO);

v\_replace\_hhpn := c\_row.KP\_NO;

IF v\_replace\_hhpn <> v\_hhpn THEN

SELECT count(1)

INTO V\_count

FROM R\_TR\_CODE\_DETAIL

WHERE KP\_NO = v\_replace\_hhpn

AND STATION = i\_machine

AND WORK\_TIME > v\_work\_time;

IF V\_count > 0 THEN

*--查找最近的一筆記錄*

SELECT WORK\_TIME, MFR\_KP\_NO, KP\_NO

INTO v\_work\_time, V\_last\_vendorpartno, v\_last\_replace\_hhpn

FROM (SELECT WORK\_TIME, MFR\_KP\_NO, KP\_NO

FROM R\_TR\_CODE\_DETAIL

WHERE KP\_NO = v\_replace\_hhpn

AND STATION = i\_machine

AND WORK\_TIME > v\_work\_time

order by WORK\_TIME desc)

WHERE ROWNUM = 1;

END IF;

END IF;

v\_replace\_hhpn := c\_row.REPLACE\_KP\_NO;

IF v\_replace\_hhpn <> v\_hhpn THEN

SELECT count(1)

INTO V\_count

FROM R\_TR\_CODE\_DETAIL

WHERE KP\_NO = v\_replace\_hhpn

AND STATION = i\_machine

AND WORK\_TIME > v\_work\_time;

IF V\_count > 0 THEN

*--查找最近的一筆記錄*

SELECT WORK\_TIME, MFR\_KP\_NO, KP\_NO

INTO v\_work\_time, V\_last\_vendorpartno, v\_last\_replace\_hhpn

FROM (SELECT WORK\_TIME, MFR\_KP\_NO, KP\_NO

FROM R\_TR\_CODE\_DETAIL

WHERE KP\_NO = v\_replace\_hhpn

AND STATION = i\_machine

AND WORK\_TIME > v\_work\_time

order by WORK\_TIME desc)

WHERE ROWNUM = 1;

END IF;

END IF;

END LOOP;

*--如果有替代料的記錄，獲取最近的掃描記錄的供應商料號*

IF v\_work\_time > TO\_DATE('1990-1-1 00:00:00', 'YYYY-MM-DD HH24:MI:SS') THEN

SELECT count(1)

INTO v\_count

FROM MES1.c\_material\_vendor\_config

WHERE hhpn = v\_last\_replace\_hhpn;

*--在屬性表是否存在*

IF v\_count > 0 THEN

SELECT COUNT(1)

INTO v\_count

FROM MES1.c\_material\_vendor\_config a,

MES1.c\_material\_vendor\_config b

WHERE a.hhpn = v\_hhpn

and b.hhpn = v\_last\_replace\_hhpn

and a.propertity = b.propertity;

IF v\_count > 0 THEN

res := 'OK'; *--返回*

ELSE

res := 'ERROR:Incoming Polarity Different ,Please Call EE!';*--返回*

END IF;

ELSE

res := 'WARNING:First on line ,Please Call EE!HHPN:' || v\_hhpn; *--返回*

END IF;

ELSE

res := 'WARNING:First on line ,Please Call EE!HHPN:' || v\_hhpn; *--返回*

END IF;

END IF;

ELSE

BEGIN

SELECT SMT\_CODE

INTO v\_smt\_code

FROM (SELECT SMT\_CODE

FROM MES4.R\_STATION\_WIP

WHERE STATION = i\_machine

ORDER BY WORK\_TIME DESC)

WHERE ROWNUM = 1;

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

v\_smt\_code := '';

END;

DBMS\_OUTPUT.put\_line('1N-->v\_smt\_code:' || v\_smt\_code);

*--查找機台的替代料的鴻海料號*

FOR c\_row IN c\_kp\_no LOOP

DBMS\_OUTPUT.put\_line('1N-->' || c\_row.KP\_NO || ':' ||

c\_row.REPLACE\_KP\_NO);

v\_replace\_hhpn := c\_row.KP\_NO;

IF v\_replace\_hhpn <> v\_hhpn THEN

BEGIN

SELECT v\_replace\_hhpn || ':' || VENDOR\_PARTNO

INTO V\_last\_vendorpartno

FROM MES1.c\_material\_vendor\_config

WHERE hhpn = v\_replace\_hhpn

and rownum = 1;

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

V\_last\_vendorpartno := '';

END;

IF V\_last\_vendorpartno IS NOT NULL THEN

EXIT;

END IF;

END IF;

v\_replace\_hhpn := c\_row.REPLACE\_KP\_NO;

IF v\_replace\_hhpn <> v\_hhpn THEN

BEGIN

SELECT v\_replace\_hhpn || ':' || VENDOR\_PARTNO

INTO V\_last\_vendorpartno

FROM MES1.c\_material\_vendor\_config

WHERE hhpn = v\_replace\_hhpn

and rownum = 1;

EXCEPTION

WHEN NO\_DATA\_FOUND THEN

V\_last\_vendorpartno := '';

END;

IF V\_last\_vendorpartno IS NOT NULL THEN

EXIT;

END IF;

END IF;

END LOOP;

*--替代料在屬性表存在*

IF V\_last\_vendorpartno IS not null THEN

res := 'First on line ,Please Call EE!HHPN:'||v\_hhpn ; *--返回*

ELSE

res := 'OK'; *--返回*

END IF;

END IF;

EXCEPTION

WHEN OTHERS THEN

res := res || ',' || SQLERRM(SQLCODE);

END;