



ACDC KITTING TEAM

組合料件 操作手冊

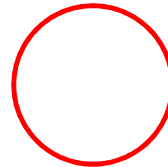
版本V1.3



標註線標準
顏色:正紅
粗細:2.25點



標註框標準
顏色:正紅
粗細:2.25點



圖片規格
邊框:無
特效:無





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版本紀錄



版本紀錄	編輯時間	編輯人	編輯敘述
V1.1	2019/7/9	Cathy Tsai	作業流程初稿。
V1.2	2019/7/9	Cathy Tsai	每個章節主要修訂的部分。
V1.3	2020/2/20	Cathy Tsai	依據實際操作後新增流程。



目錄

- 組合件生產訂單控管的工作說明
- 組合件檢貨的工作說明
- 組合件組裝的工作說明
- 檢驗組合件的工作說明
- 組合件包裝的工作說明



操作手冊指標

- 組合料件部門員工之教育訓練。
- 適用於督導審查作業流程與詳細注意事項。
- 操作手冊須於每季結束時進行重新審閱與更新。

操作手冊適用範圍

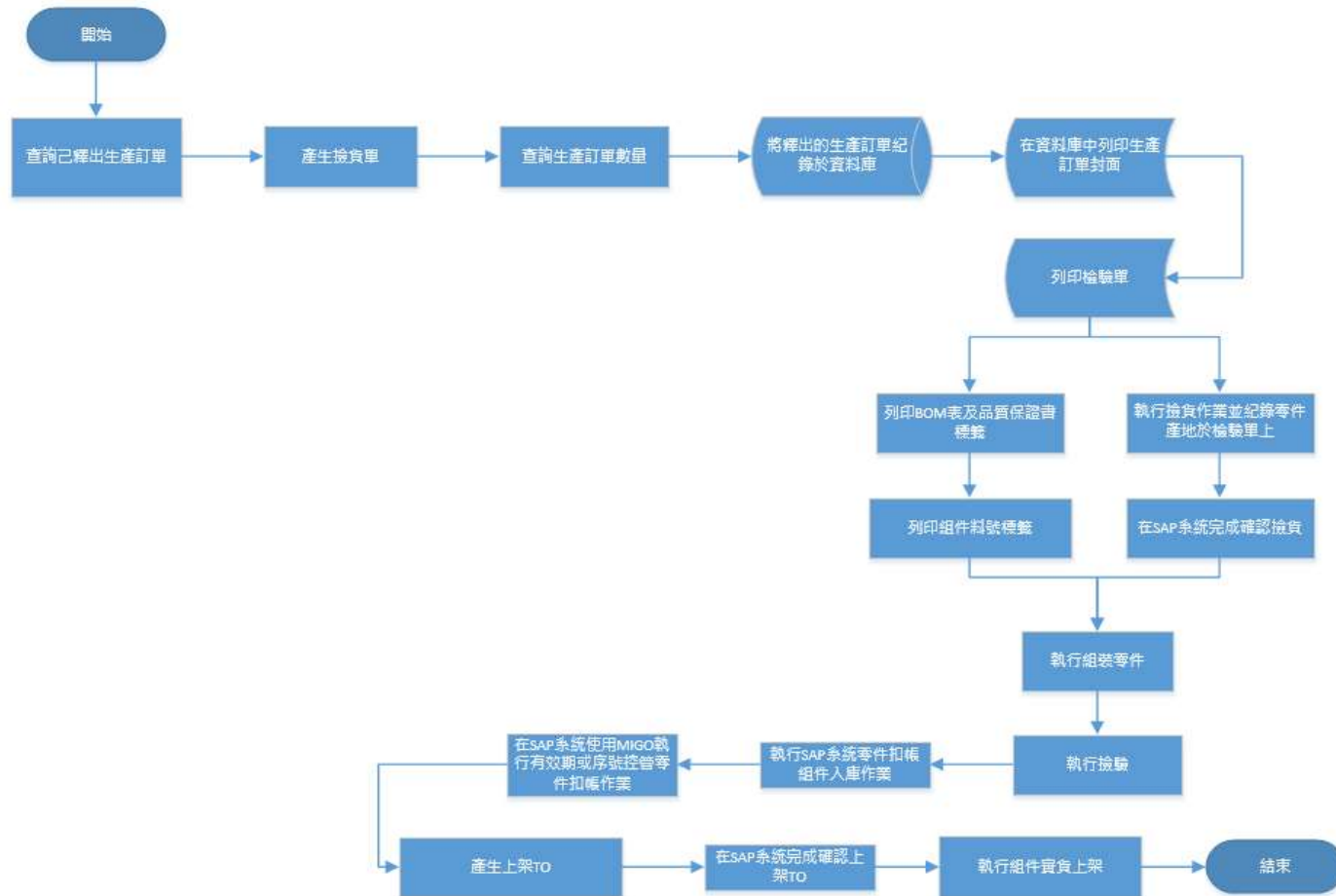


- AMAT Plant code 5402



生產訂單作業管理

- 流程圖



作業工具環境介紹

- 工具

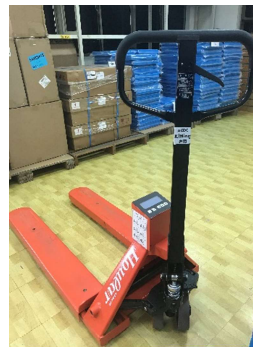
- 層檢貨車含4"儀器輪



- 桌上型封口機 (50cm)



- 油壓拖板車秤



- 電子磅稱(150kg)



- 物流搬運車 烏龜車(可供摺疊籃套用)





作業工具環境介紹

- 環境介紹

- 工作區域



- 組合料件庫存儲區



- 零件庫存儲區





生產訂單作業管理

查詢釋出的生產訂單

- 確認已釋出的生產訂單，SAP指令LB10

★ LB10 - TRs for Storage Type

- Warehouse No 544
Dest. Storage Type : PKT

Warehouse Number: 544
Source Storage Type: PKT
Dest. Storage Type: PKT
Shipment Type:

Status of Movement:
☒ Status: Open
☐ Partially Delivered
☐ Completed

General Selection Criteria:
Transfer Priority:
Execute From (Date):
Planned Time From: 00:00:00
Execute to (Date):
Planned Time To: 23:59:59

- 查詢到已釋出訂單的Prod Order 號碼(Rqmn. No.)

Display Transfer Requirement: List for Storage Type

Sl	TR Number	RS	Pr	S	My Description	Reqmt.No.	From	Dest.	Items
1	0000000002				# 219 Regim. for Production	1469106		PKT	2
2	0000000002				# 219 Regim. for Production	1466443		PKT	2

- 到SAP指令COOIS 下載生產訂單，輸入Production Plant:5402

Production Order Information System

Order: 1469106
Plant: 5402

Order Details:

Order	Plant	Order Type	Order Date	Order Status
1469106	5402	1469	2010-10-10	Released

- 輸入釋出的訂單號碼到 Production Order

Production Order Information System

Order: 1469106
Plant: 5402

Order Details:

Order	Plant	Order Type	Order Date	Order Status
1469106	5402	1469	2010-10-10	Released

- 查詢釋出生產訂單資料

Order Info System - Order Headers

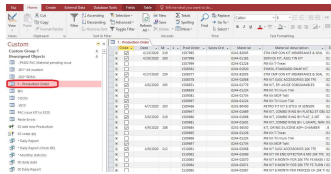
Order	Sales Ord.	Material	Material description	Rev. level	Target qty	Del. qty	System Status
1469106	0244-01688	PKT KIT, COMBO RING BH FLAT, 2.18T		02	68	68	REL. POHF. DLY.
1466443	0244-01690	PKT KIT, COMBO RING BH FLAT&2.7T GBL		02	1	1	REL. POHF. DLY.



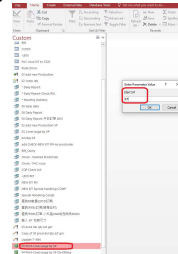
生產訂單作業管理

• 生產訂單文件列印

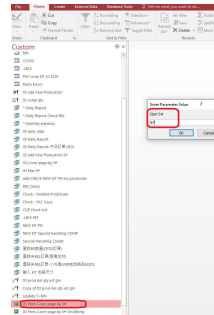
- 將生產訂單資料新增到02-KIT Prod Order的 Prod Order，並編號S#



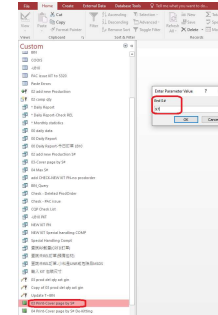
- 點 03 Print-Cover page by S# 印生產訂單封面



- Star S# 輸入 Prod Order 的 S#



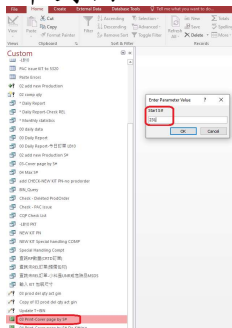
- End S# 輸入 Prod Order 的 S#



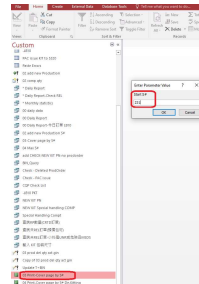
- 列印單筆生產訂單封面



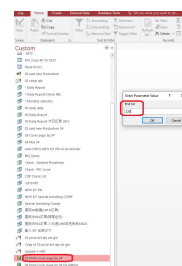
- 列印合併生產訂單封面



- Star S# 輸入起始Prod Order 的 S#



- End S# 輸入最後一筆 Prod Order 的 S#



- 列印合併生產訂單封面





生產訂單作業管理

- BOM表、品質保證標籤及組合料號標籤列印

- 列印BOM表SAP指令ZAMGR241

SAP ZAMGR241 screenshot showing the 'Logistics Label/Picklist' screen. The 'Assembly Number Selection' section is highlighted, showing 'Assembly Number' as '8244-01688' and 'Plant' as '5402'. The 'Production Number Selection' section is also highlighted, showing 'Production Number' as '0001'. The 'Label / List Selection' section is highlighted, showing 'Component Label' as 'X' and 'Pick List' as 'X'. The 'Printer Selection' section is highlighted, showing 'Printer ID' as 'TU17'.

- 列印BOM表再以無塵紙影印需求份數

Pick List screenshot showing the 'PICK LIST' screen. The 'Date' is '04.30.2019', 'Plant' is '5402', and 'Description' is 'PBA 60 VDC 50'. The 'Item Number' is '3700-0001' and 'Quantity' is '1'. The 'Unit' is 'EA' and 'Bin' is '00'. The 'Batch' is '0001' and 'Particulate' is '00'. The 'Printer ID' is 'TU17'.

- 列印組合料品質保證標籤SAP指令ZAMGR241

SAP ZAMGR241 screenshot showing the 'Logistics Label/Picklist' screen. The 'Assembly Number Selection' section is highlighted, showing 'Assembly Number' as '8244-01688' and 'Plant' as '5402'. The 'Production Number Selection' section is highlighted, showing 'Production Number' as '0001'. The 'Label / List Selection' section is highlighted, showing 'Component Label' as 'X' and 'Pick List' as 'X'. The 'Printer Selection' section is highlighted, showing 'Printer ID' as 'TU17'.

- 列印組合料的unit label SAP指令ZAMGM001

SAP ZAMGM001 screenshot showing the 'Material' screen. The 'Material' is '8244-01688', 'QTY/UGM' is '1', and 'Date' is '09.0'. The 'Batch Number' is '0001' and 'Plant' is '5402'. The 'SC' is '0001' and 'Ru' is '0001'. The 'LQty' is '2' and 'Printer' is 'TU17'. The 'Choose 1 or 2' section is highlighted, showing '1. Print without COO' and '2. Print with COO'. The 'Printer ID' is 'TU17'.

- 輸入料號數量單位、標籤張數、印表機後印出

SAP ZAMGM001 screenshot showing the 'Material' screen. The 'Material' is '8244-01688', 'QTY/UGM' is '1', and 'Date' is '09.0'. The 'Batch Number' is '0001' and 'Plant' is '5402'. The 'SC' is '0001' and 'Ru' is '0001'. The 'LQty' is '2' and 'Printer' is 'TU17'. The 'Choose 1 or 2' section is highlighted, showing '1. Print without COO' and '2. Print with COO'. The 'Printer ID' is 'TU17'.

- 列印有效期的零件unit label SAP指令ZAMGM001

SAP ZAMGM001 screenshot showing the 'Material' screen. The 'Material' is '8244-01688', 'QTY/UGM' is '1', and 'Date' is '09.0'. The 'Batch Number' is '0001' and 'Plant' is '5402'. The 'SC' is '0001' and 'Ru' is '0001'. The 'LQty' is '2' and 'Printer' is 'TU17'. The 'Choose 1 or 2' section is highlighted, showing '1. Print without COO' and '2. Print with COO'. The 'Printer ID' is 'TU17'.

生產訂單作業管理



- 列印有效期的零件 unit label

- 將有效期的零件 unit label 黏貼黃底單



- 準備組合料包材及封箱底



- 將所有標籤貼在塑膠袋及箱子外



- 產生檢貨單明細 (TO)SAP指令 LB10

- 勾選要檢貨的 Rqmn. No. 訂單號碼

Display Transfer Requirement: List for Storage Type

Warehouse: 544 ACDC PH & SUMP KIT Plant TO in Foreground (Ctrl+Shift+F8)

S	TR Number	IS	Pr	Qty	Description	R	Rqmnt.No.	From	Dest.	Items
	0000000052				a 319 Replen. for Production	P	1461440	PET		2
	0000000053				a 319 Replen. for Production	P	1461443	PET		2

- 選取 TO in Foreground

Display Transfer Requirement: List for Storage Type

Warehouse: 544 ACDC PH & SUMP KIT Plant TO in Foreground (Ctrl+Shift+F8)

S	TR Number	IS	Pr	Qty	Description	R	Rqmnt.No.	From	Dest.	Items
	0000000052				a 319 Replen. for Production	P	1461440	PET		2
	0000000053				a 319 Replen. for Production	P	1461443	PET		2

- 產生檢貨明細單 TO

生產訂單作業管理



- SAP自動列印出檢貨單明細



- 將檢貨單及檢驗單夾到檢貨車上



- 根據檢貨單明細到儲位檢貨



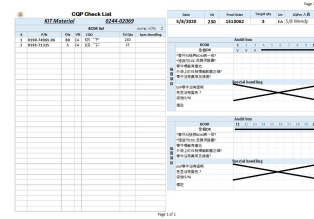
- 將檢出的零件依檢驗單順序放到檢貨車盒子裡



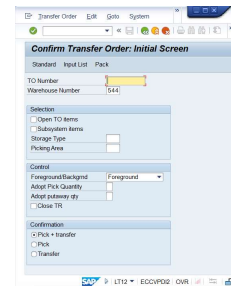
- 檢貨異常零件通知並交給專人處理



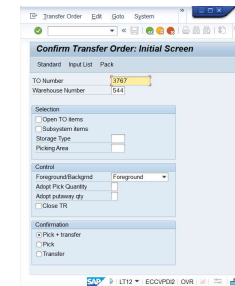
- 紀錄零件產地在檢驗單並將檢好的零件移到組裝工站



- 確認Confirm TO SAP指令LT12



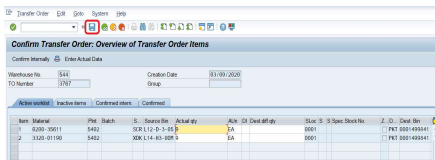
- 輸入TO No. , Enter



生產訂單作業管理



- 儲存TO



- 確認完畢

Transfer order 0000003767 confirmed

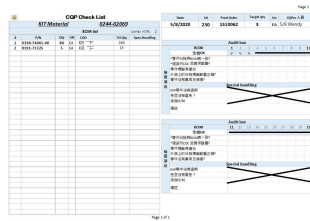
- 由組裝人員執行組裝作業



- 將成套組件移到檢驗工站執行檢驗作業



- 確認料號數量是否與檢驗單相符，且無異常後簽名加日期



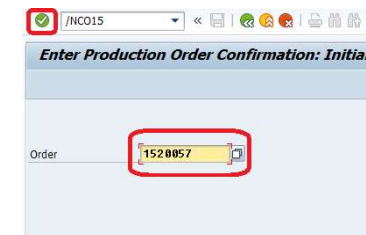
- 將檢驗好的組裝料封口封箱/袋



- 將檢好的零件在系統組成組合件
SAP指令C015



- 組裝員輸入生產訂單單號





生產訂單作業管理

- 輸入組合料數量後點選Goods Movements

- Compltd打勾後儲存

- 有控管到期日的零件需輸入到期日

- 組裝結果會顯示在底下訊息

Confirmation saved (Goods movements: 2, failed: 0)

- 組裝員組合產生 TO SAP指令LB10

- Warehouse No 544 SourceStorage Type 901

- 選取生產訂單後點 TO in Background

- 組合料上架TO產生

生產訂單作業管理



- SAP自動列印出組合料Putaway T0

Putaway
 TO number: 000004031 0001 Request: P 1499842 Datum: 03/09/2020
 0000040310001564
 Material: 0244-01224 S402/0001 PH K1C Trillion TLA1
 GR date: 03/09/2020 GR number: 4940287793
 BZC 901 003 0001499842 2 RA
 DWAT PFI 001 004-D-03 2

- 組裝員完成系統組合料上架作業指令LT12 Enter

Transfer Order Edit Data System

Confirm Transfer Order: Initial Screen

Standard Input List Pack

TO Number: 4031
 Warehouse Number: S44

Selection

☐ Open TO items
☐ Subsystem items
☐ Storage type
☐ Picking Area

Control

Foreground/Background: Foreground
☐ Adapt Pick Quantity
☐ Adapt putaway qty
☐ Close TR

Confirmation

☒ Pick + transfer
☐ Pick
☐ Transfer

SAP LT12 - ECC/PPD - OVR

- 儲存T0

Transfer Order Edit Data System

Confirm Transfer Order: Overview of Transfer Order Items

Confirm Internally: Enter Actual Date

Warehouse No.: S44 Creation Date: 03/09/2020
 TO Number: 4031 Group:

Actual transfer: Inactive items Confirmed items Confirmed

Item	Material	PH	Batch	Q	Unit	Qty	Actn	Ed	Chn	Def	Qty	Star	S	S	Open	Stock	No	Z	S	Source	Stn	It	Pk
1	0244-01224	S402	PFI	0	0	0	EA																

SAP LT12 - ECC/PPD - OVR

- 確認完畢

Transfer order 0000004031 confirmed