

# STANDARD OPERATING PROCEDURES FOR DAIFUKU HMI AND SCADA

## Section 1: MES SKU LOADING STEPS IN HMI



**Step1:** Press “PAINT MES”



**Step2:** Press “MES Loading Plan Buffer”

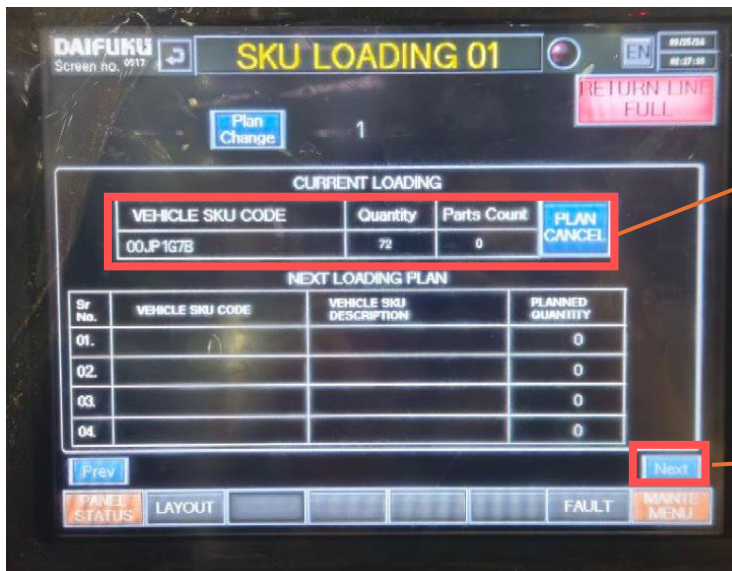


**Step3:** Long Press “REFRESH BUFFER” to get the present day’s plan

**Step4:** Select the desired loading plan

**Step5:** Long Press “Plan Select”

**Step6:** Select “SKU LOADING 01”

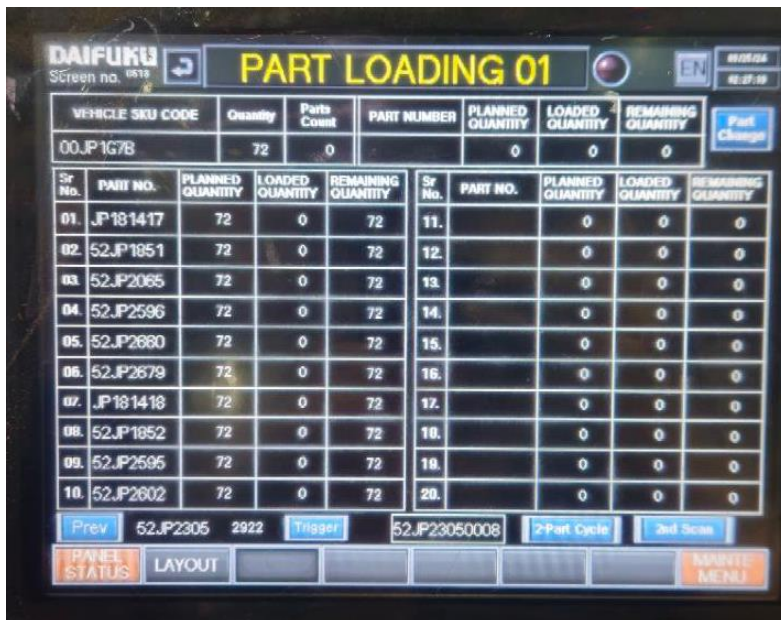


**Step7:** Check plan selected is correct

**Step8:** Press "Next"

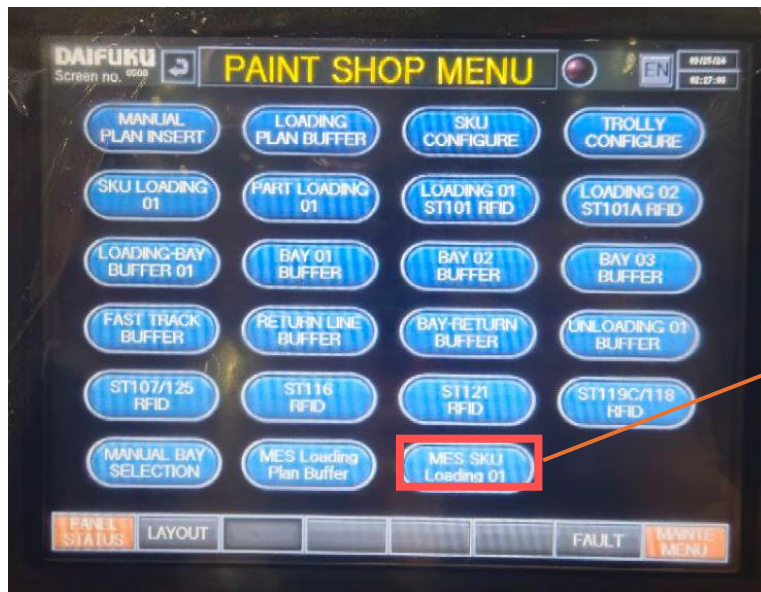
**Step9:** Push the trolley towards loading Station by the buttons present on DAIFUKU HMI module and switch the knob to manual loading.

**Step10:** Scan the Kanban card of the desired part which is going to be loaded. After scanning it will reflect on carrier section and then to change the part press "Part Change" and then the below screen will reflect with no part number in the carrier section.

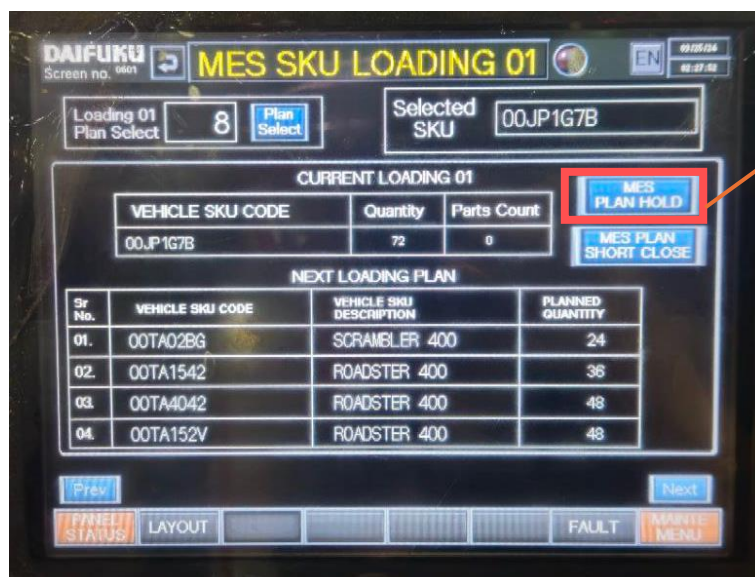




## Section 2: Changing the previously selected MES SKU plan to a new one



**Step1:** Press “MES SKU Loading 01”



**Step2:** Long Press “MES PLAN HOLD” to change the SKU code, then follow the similar steps as above to select the required plan

**NOTE:** To completely remove the Vehicle SKU Code from the plan, Press “MES PLAN SHORT CLOSE”.

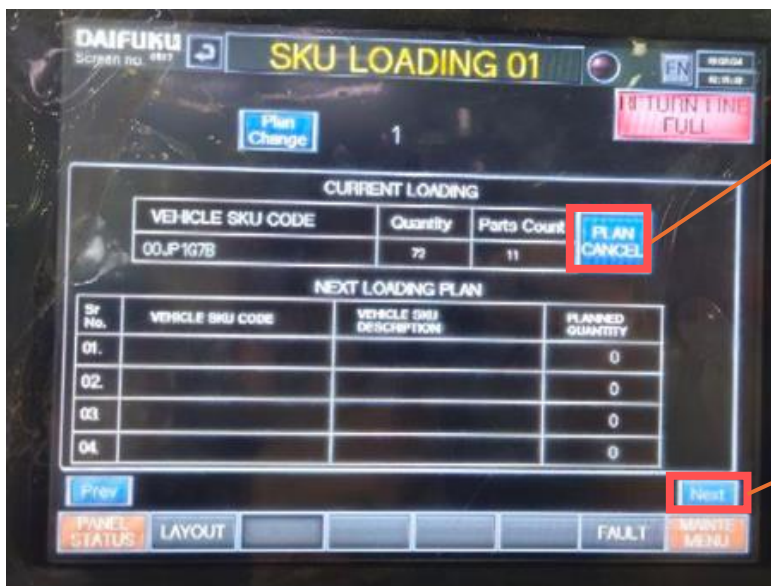
### Section 3: Switching from Manual loading to MES SKU Loading or MES to Manual loading



**Step1:** Press "PAINT MES"



**Step2:** Press "SKU LOADING 01"



**Step3:** Press "PLAN CANCEL"

**Step4:** Press "Next"



**Note:** Ensure no data is present for the current loading and carrier. Both should be zero.

DAIFUKU  
Screen no. 0010

## PART LOADING 01

VEHICLE SKU CODE	Quantity	Parts Count	PART NUMBER	PLANNED QUANTITY	LOADED QUANTITY	REMAINING QUANTITY
	0	0		0	0	0

Sr No.	PART NO.	PLANNED QUANTITY	LOADED QUANTITY	REMAINING QUANTITY
01.		0	0	0
02.		0	0	0
03.		0	0	0
04.		0	0	0
05.		0	0	0
06.		0	0	0
07.		0	0	0
08.		0	0	0
09.		0	0	0
10.		0	0	0
11.		0	0	0
12.		0	0	0
13.		0	0	0
14.		0	0	0
15.		0	0	0
16.		0	0	0
17.		0	0	0
18.		0	0	0
19.		0	0	0
20.		0	0	0

Prev 2022 Trigger 52JP23050008 2-Port Cycle 2nd Scan

PANEL STATUS LAYOUT WRITE MENU

Carrier Section

Current Loading Section

**Note:** Press MES PLAN HOLD to switch from MES to Manual loading.

DAIFUKU  
Screen no. 0001

## MES SKU LOADING 01

Loading 01 Plan Select 8 Plan Select

Selected SKU 00JP1G7B

VEHICLE SKU CODE	Quantity	Parts Count
00JP1G7B	72	0

CURRENT LOADING 01

MES PLAN HOLD

MES PLAN SHORT CLOSE

NEXT LOADING PLAN

Sr No.	VEHICLE SKU CODE	VEHICLE SKU DESCRIPTION	PLANNED QUANTITY
01.	00TA02BG	SCRAMBLER 400	24
02.	00TA1542	ROADSTER 400	36
03.	00TA4042	ROADSTER 400	48
04.	00TA152V	ROADSTER 400	48

Prev Next

PANEL STATUS LAYOUT FAULT WRITE MENU

Press "MES PLAN HOLD"

## Section 4: Loading Multiple Parts in a Single Trolley

### STEP1. Select "2-Part Cycle"

- If you need to load two parts (like seat cowl LH and RH or side cover LH and RH) in one trolley, press the "2-Part Cycle" button on the Part Loading 01 screen.

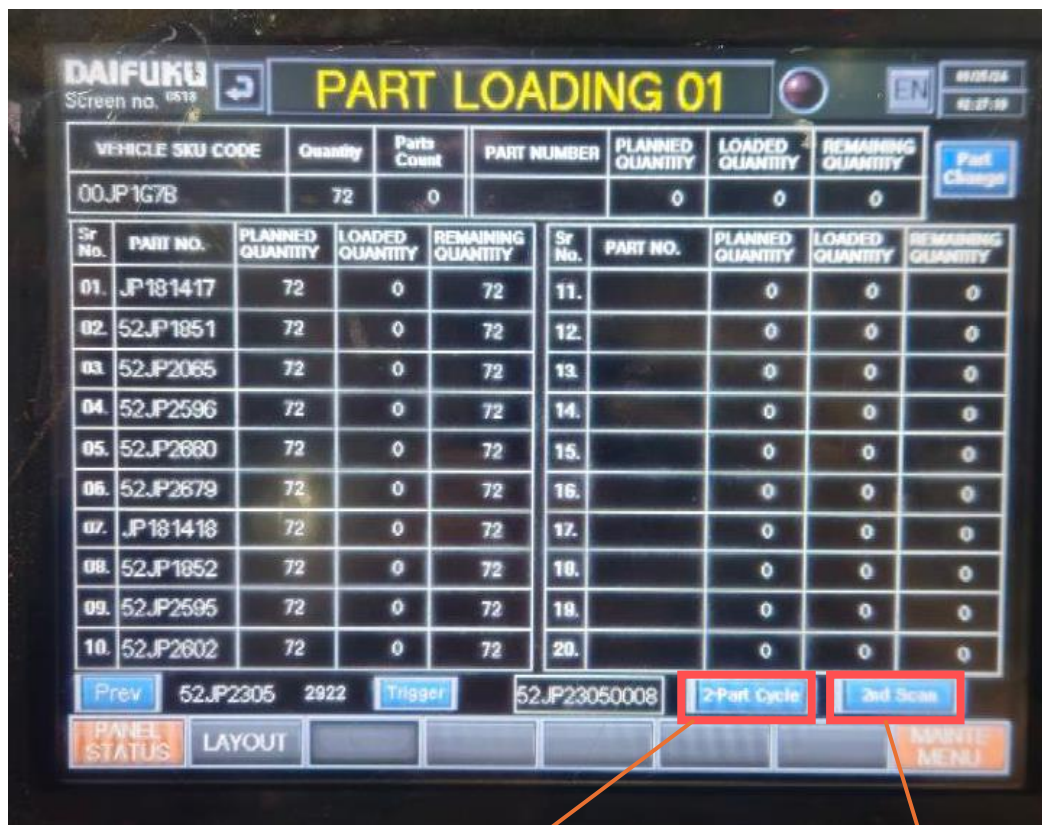
### STEP2. Scan the First Part (LH)

- Scan the first part, such as the LH part.

### STEP3. Select "2nd Scan"

- After scanning the first part, press the "2nd Scan" button.

### STEP4. Scan the Second Part (RH)



2-Part Cycle button

2nd Scan button

**Note:** This option should be selected only when multiple parts need to be sent. NEVER PRESS OTHER THAN THIS.

## **Section 5: MES SKU Loading Process and Kanban Card Handling**

### **1. Check MES SKU Plan**

- Make sure the MES SKU plan matches the day's production plan.
- If a mismatch or parts are missing, talk to the Mesmerise and Bajaj team for help.
- If that doesn't work, you may need to load parts manually as a last option.

### **2. Prepare Kanban Cards**

- Get the Kanban cards ready with the correct part number for each SKU.
- Check that the number of Kanban cards matches what is planned for the day.

### **3. Place Kanban Cards**

- Put the correct Kanban card in the trolley for painted parts.

### **4. Handling Standard Quantity Kanban Cards**

- If the Kanban cards are in standard quantities (like 8, 12, 24, or 48) and the planned quantity is different, print a Kanban card for the needed quantity.
- If print is not possible, then make a virtual Kanban card as a QR code using Microsoft Excel.

### **5. Create QR Codes if Necessary**

- If you can't create a QR code in Excel, use your mobile phone to make a QR code on [QRfy](https://qrify.com/) (https://qrify.com/) (or another similar site).
- Enter the correct text (like 52JP20140008) on the website to generate the QR code, then scan it.

### **6. Load SKUs in Order**

- Load the parts in the order of the SKU; make sure to send all parts for one SKU before starting on the next one.

### **7. Collect and Organize Kanban Cards**

- When the trolley returns from Bajaj, collect all the Kanban cards.
- Put them in the correct boxes to keep everything organised for the future.