

**PIS program modify add F1:CSV to export production data to CSV file.**

The screenshot shows the 'ProductionData' screen with a table of production data. A red box highlights the 'F1:CSV' button in the top left corner. A red arrow points from the 'F1:SEARCH' button area to the 'F1:CSV' button. The table below shows the data structure:

Index	M.Y.	Suffixcode	Lot	Unit	Line	SEQ. No.	BLOCK MODEL	B/Seq.	PROD. SEQ.	ASM No.	ISZ	OFF DATE	CONTROL CODE	Sp1	Model Type	Sp2	Sp3
1	120	E1A00	001	001	1	L000556			00010	8981022521	20110510	1211244116	0	2	2		
2	120	E1A00	001	002	1	L000557			00020	8981022521	20110510	1211244116	0	2	2		
3	120	E1A00	001	003	1	L000558			00030	8981022521	20110510	1211244116	0	2	2		
4	120	11000	010	001	1	P000010			00010	8981557990	20110510	2211244216	0	2	2		
5	120	21000	010	002	1	P000011			00020	8981022731	20110510	2113244216	0	2	2		
6	220	E1D00	010	003	1	P000012			00030	8981022532	20110510	1212244116	0	2	2		
7	120	E1D00	011	001	1	E000007			00010	8981022532	20110510	1212244116	0	2	2		
8	120	E1Z00	011	002	1	E000008			00020	8981591740	20110510	1113243116	0	2	2		
9	120	E1Z01	011	003	1	E000009			00030	8981022532	20110510	1014242116	0	2	2		
10	201	01220	001	001	1	S000006			00010	8981498790	20110510	1211244113	0	1	0		
11	201	01220	001	002	1	S000007			00020	8981499140	20110510	1314262115	0	1	0		
12	201	01220	001	003	1	S000008			00030	8981498790	20110510	1417280117	0	1	0		
13	240	E1F00	060	001	1	X000101			00010	8981342563	20110510	1211232123	0	2	0		
14	240	E1F00	060	002	1	X000102			00020	8981342563	20110510	1211232123	0	2	0		
15	240	E1F00	060	003	1	X000103			00030	8981342563	20110510	1211232123	0	2	0		
16	120	E1E00	013	001	1	C000006			00010	8981022532	20110510	1212244116	0	2	2		
17	120	E1E00	013	002	1	C000007			00020	8981591740	20110510	1113243116	0	2	2		
18	120	E1E00	013	003	1	C000008			00030	8981022532	20110510	1014242116	0	2	2		
19	120	E1A00	001	004	1	L000559			00040	8981022521	20110510	1211244116	0	2	2		
20	120	E1A00	001	005	1	L000560			00050	8981022521	20110510	1211244116	0	2	2		
21	120	E1D00	002	001	1	L000561			00060	8981498810	20110510	1212244113	0	1	2		
22	120	E1D00	002	002	1	L000562			00070	8981498810	20110510	1212244113	0	1	2		
23	120	E1D00	002	003	1	L000563			00080	8981498810	20110510	1212244113	0	1	2		

Legend: MASS (white), PILOT (purple), EMERGENCY (green), SERVICE (pink), CSO (brown), CLAIM (light blue), INSERT (yellow), LOCKED (red).

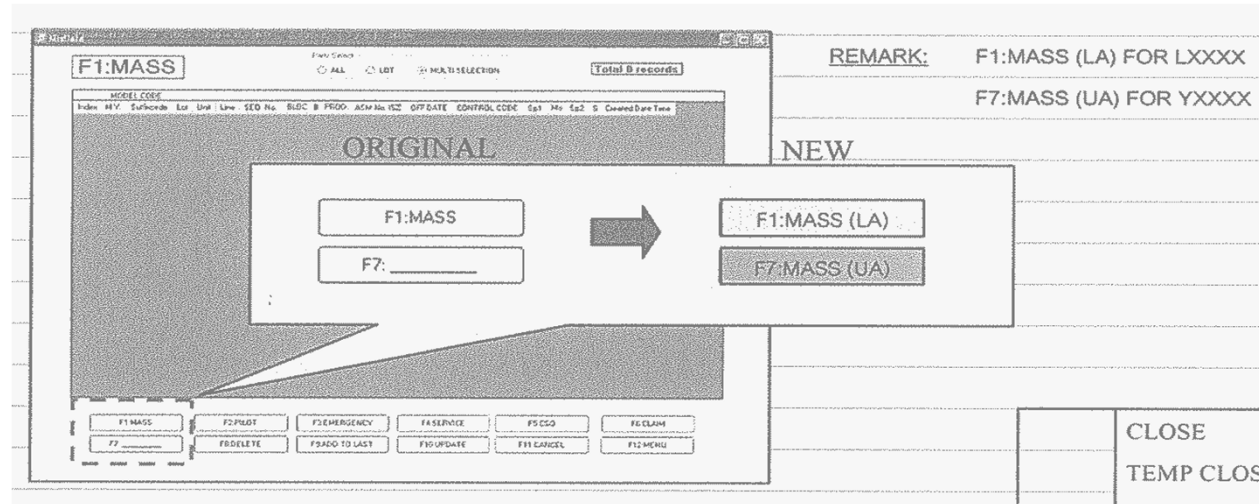
Buttons: F1:SEARCH, F2:ADDITION, F3:MAKE DATA, F4:SEARCH, F5:SKIP, F6:INSERT, F7:PREVIOUS, F8:NEXT, F9:RELOAD, F10:ADD DUMMY, F11:DELETE DUMMY, F12:MENU, Clear.

**Purpose:** Additional function F1:CSV to export data from production data screen.

**Remarks:** CSV file format see attached file CSV format.xls

**Due date:** Before 26 Sep. 2011

**PIS program modify separate mass production data.**



**F1:MASS** Total 8 records

MODEL CODE

Index	MOV	Subcode	Est	Unit	Line	SEQ No.	BLDC	B	PROD	ADM No.	SIZE	OFF DATE	CONTROL CODE	Est	Mo	Est	S	Created Date Time
ORIGINAL																		
NEW																		

**REMARK:** F1:MASS (LA) FOR LXXXX  
F7:MASS (UA) FOR YXXXX

**F1:MASS (LA)**  
**F7:MASS (UA)**

**F1:MASS** **F2:PILOT** **F3:EMERGENCY** **F4:SERVICE** **F5:CSG** **F6:CLAIM**  
**F7** **F8:DELETE** **F9:GO TO LAST** **F10:UPDATE** **F11:CANCEL** **F12:MENU**

**CLOSE**  
**TEMP CLOSE**

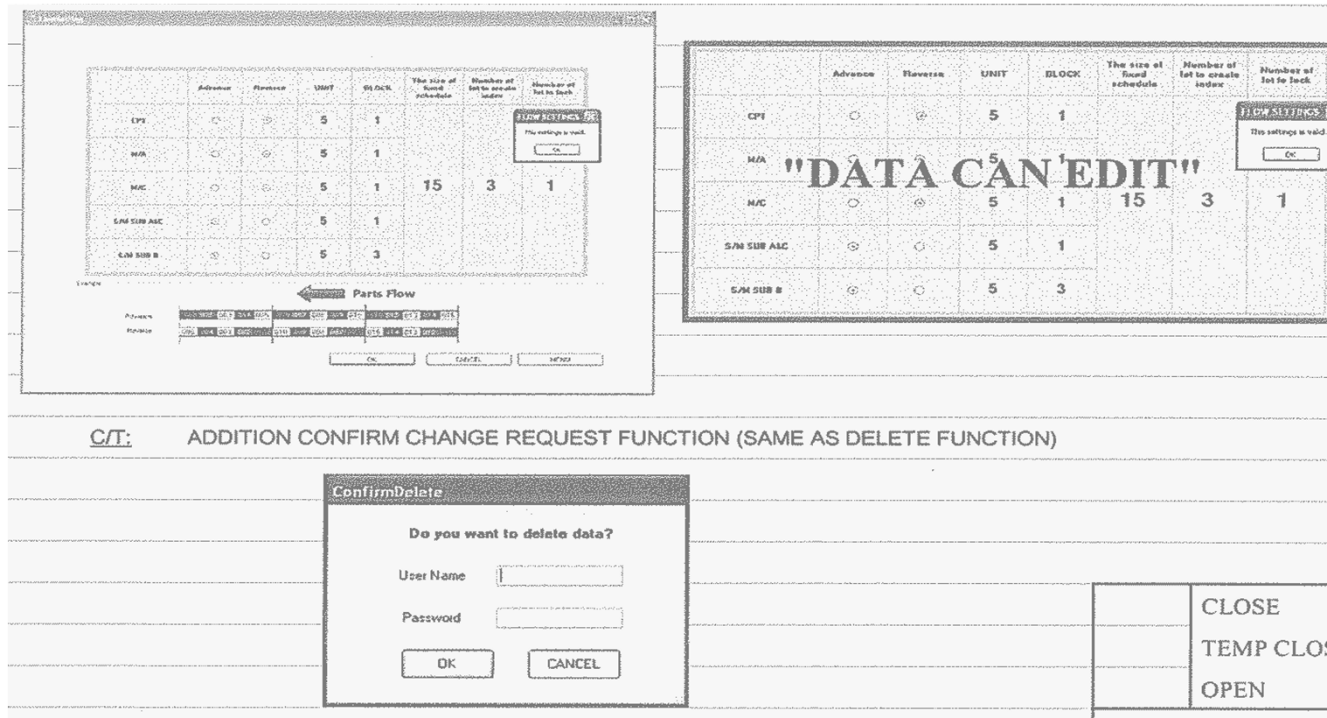
**Purpose:** Modify and add function key F1:MASS(LA) and F7:MASS(UA) to separate production data of LA line and UA line.

**Remarks:** 1.LA : seq.no. = Lxxxxxx

2.UA: seq.no. = Yxxxxxx

**Due date:** After receive PO. from client.

**PIS program modify add pop up for confirmation after edit flow setting.**



The screenshot displays the 'Parts Flow' table within the PIS program. The table has columns for Advance, Reverse, UNIT, BLOCK, The size of fixed schedule, Number of lot to create index, and Number of lot to load. The data rows are as follows:

Advance	Reverse	UNIT	BLOCK	The size of fixed schedule	Number of lot to create index	Number of lot to load
CP1	1	5	1			
M/A	1	5	1			
M/C	1	5	1	15	3	1
S/M SUB A/C	1	5	1			
S/M SUB B	1	5	3			

Below the table, there is a 'Parts Flow' section with a 'ConfirmDelete' dialog box. The dialog box contains the text 'Do you want to delete data?' and fields for 'User Name' and 'Password'. There are 'OK' and 'CANCEL' buttons at the bottom of the dialog box.

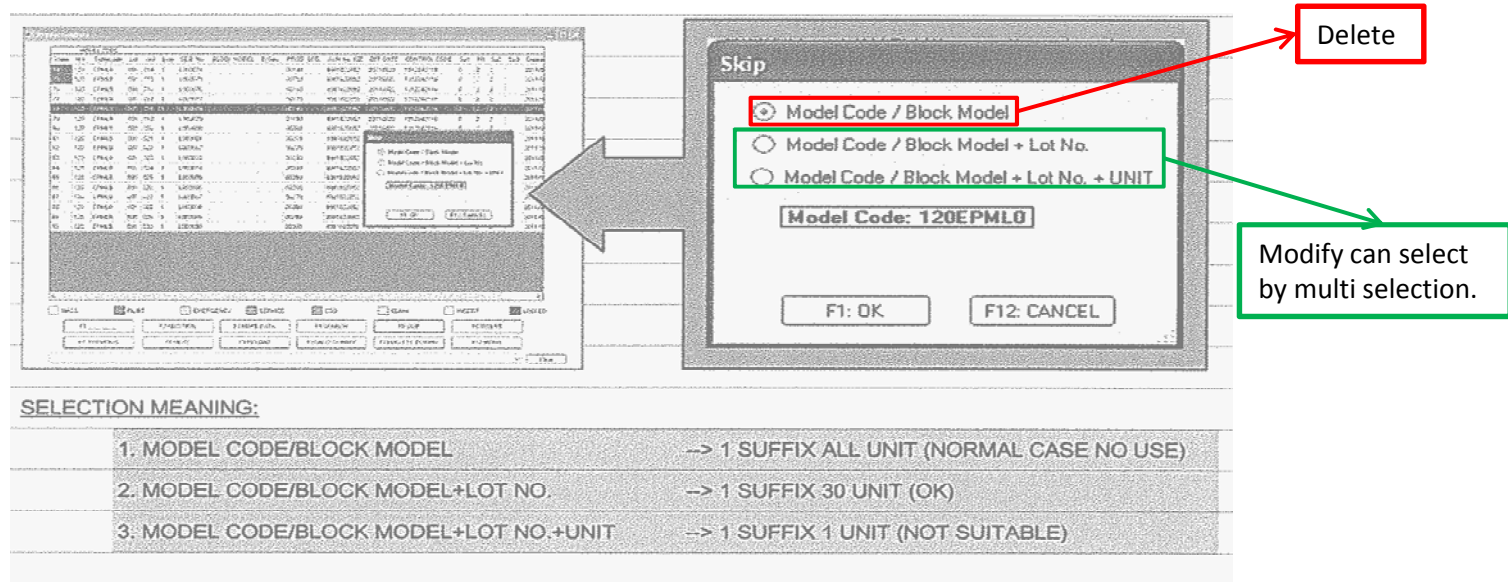
**CONFIRM:** ADDITION CONFIRM CHANGE REQUEST FUNCTION (SAME AS DELETE FUNCTION)

**Purpose:** Additional confirmation pop up after edit flow setting.

**Remarks:** 1.This function can be change the password for confirmation.  
2.Can add user name maximum 5 users.

**Due date:** After receive PO. from client.

**PIS program modify condition for select skip production data.**



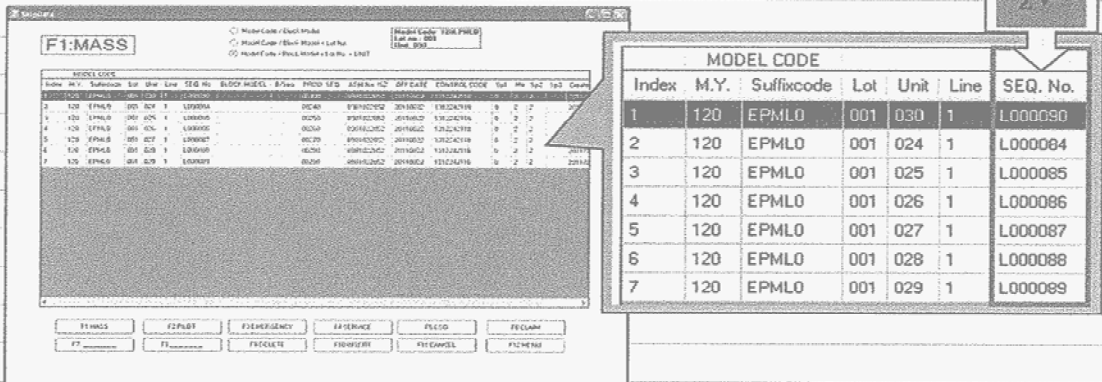
**Purpose:** 1.Delete Model Code / Block Model select function.  
2.Modify select codition of Model Code / Block Model + Lot No. and Model Code / Block Model + Lot No.+ Unit can select production data by multi selection.

**Remarks:**

**Due date:** After receive PO. from client.

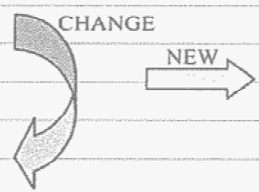
**PIS program modify sorting skip production data on skipdata screen by ascending.**

**PROBLEM3: DATA IN SKIP MODE NO SORTED ASCENDING.**



Index	M.Y.	Suffixcode	Lot	Unit	Line	SEQ. No.
1	120	EPML0	001	030	1	L000090
2	120	EPML0	001	024	1	L000084
3	120	EPML0	001	025	1	L000085
4	120	EPML0	001	026	1	L000086
5	120	EPML0	001	027	1	L000087
6	120	EPML0	001	028	1	L000088
7	120	EPML0	001	029	1	L000089

**C/T: SEQ. NO. SORTED ASCENDING (SEQ. NO --> 1,2,3,...)**



Seq. no.
L000084
L000085
L000086
L000087
L000088
L000089
L000090

**DUE DATE** 30-SEP-2011

**Buttons:** CLOSE, TEMP CLO, OPEN, COST, A

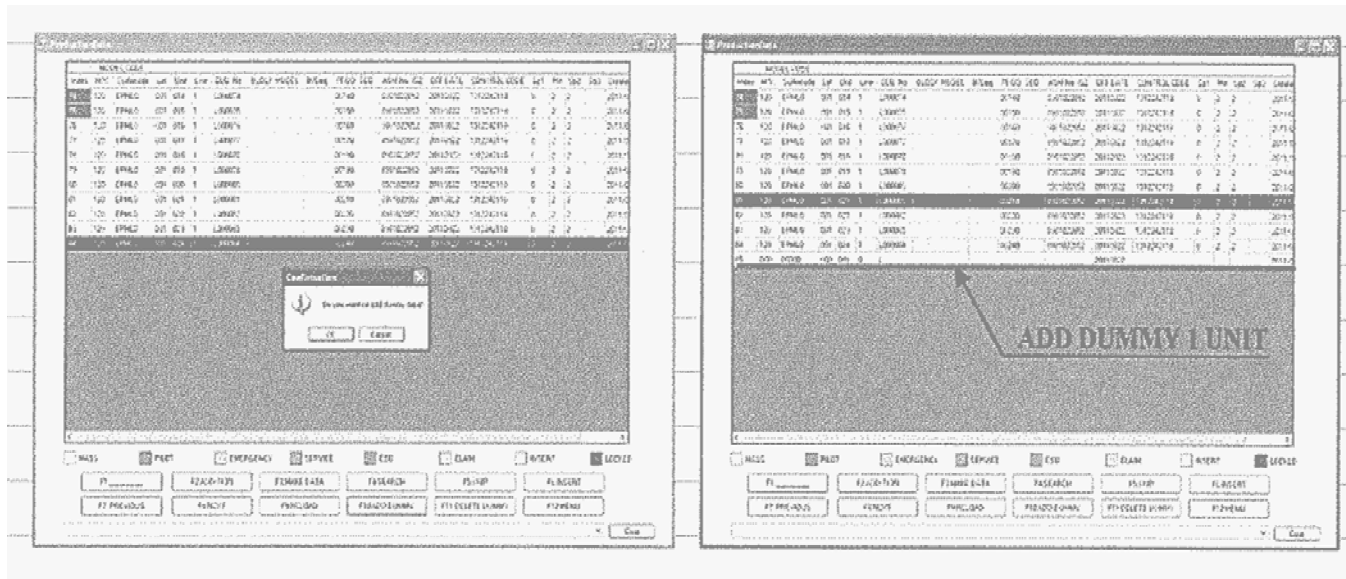
**Purpose:** Modify sorting seq.no. on skipdata screen by ascending (A-->Z and 1,2,3,...,n.)

**Remarks:**

**Due date:** After receive PO. from client.



### PIS program modify dummy data function.

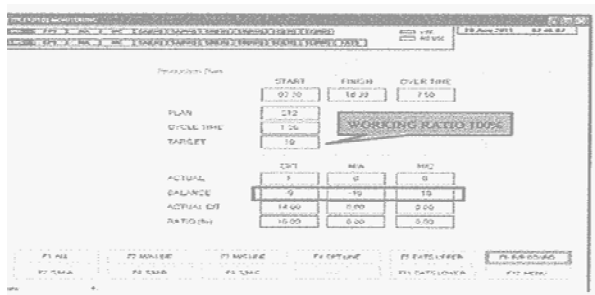


**Purpose:** 1.On production data screen modify add dummy data by automatic ( can input number of dummy data).  
2.On production data screen modify can delete dummy data by multi selection.

**Remarks:**

**Due date:** After receive PO. from client.

**LMS program modify calculate target by use working ratio from PPC plan (excel file).**



**ACTUAL TIME CALCULATE**

PERIOD	WORKING TIME		ACTUAL TIME (MIN)	REMARK
	START	FINISH		
TIME01	07.30	10.00	150	
TIME02	10.10	12.00	110	
TIME03	13.00	15.00	120	
TIME04	15.10	16.30	80	
TIME05	16.45	19.30	165	
TOTAL (MIN)				NOT OVERTIME
TOTAL (MIN)			625	OVERTIME

**Contents**

1. MODIFY PROGRAM FOR CALCULATE TARGET BY  
ADD WORKING RATIO FOLLOW PPC PLAN.

$$\text{TARGET (FEG REQUEST)} = \frac{\text{ACTUAL TIME (MIN)} - \text{LOSS TIME (MIN)}}{\text{CYCLE TIME (MIN/UNIT)} \times 100\%}$$

$$\text{TARGET (UNIT)} = \frac{\text{ACTUAL TIME (MIN)} - \text{LOSS TIME (MIN)}}{\text{CYCLE TIME (MIN/UNIT)} \times \text{WORKING RATIO (\%)}}$$

**CURRENT CONDITION:**

CYCLE TIME = 1.38 MIN/UNIT  
WORKING RATIO = 100%

∴ TARGET 1 UNIT = REAL TIME PER 1.38 MIN

UNIT OF FRAME  
RUN AS REALTIME  
BY TIME PERIOD

REMARK: WORKING TIME OF FRAME  
PRODUCTION HAVE MANY PATTERN SET  
PLEASE FOLLOW UP PLC PROGRAM.

**Need to modify PLC  
for calculate working ratio  
follow PPC plan document  
(PIS data import file).  
Not equal 100%.**

**Purpose:** 1.Modify target formular by use working ratio from PPC plan (excel file from PPC.).

**Remarks:**

**Due date:** After receive PO. from client.