

## **FG RETURN SLIP FOR PRODUCTION**

HEADER				
SR. NO.	DATA TYPE	DATA SELECTION/ PICK-UP/ENTRY	FROM	CONDITION FOR RESTRICTED ENTRY
1	DATE	PICK-UP	SYSTEM DATE	Allow change to system date - 1
2	SHIFT	SELECTION	A or B	

COLUMN NO	1	2	3	4	5	6
DATA TYPE	M/C NO	PRODUCT	BOXES AS PER PRODUCTION	QUANTITY PER BOX	NO OF BOXES RECD BY STORES	QUANTITY RECD BY STORES
DATA SELECTION / PICK UP/ ENTRY	PICK UP & DISPLAY	PICK UP & DISPLAY	PICK UP & DISPLAY	PICK UP & DISPLAY	K.B. ENTRY	CALCULATE & DISPLAY
SELECTION / PICK UP FROM	PRODUCTION DATA ENTRY FOR SELECTED DATE & SHIFT	PRODUCTION DATA ENTRY FOR SELECTED DATE & SHIFT	PRODUCTION DATA ENTRY FOR SELECTED DATE & SHIFT	FROM PACKING MATRIX ###	--	COL (4) * COL(5)
EDITING ALLOWED	NO	NO	NO	NO	YES	NO

### **### PACKING MATRIX**

PRODUCT	BOX TYPE	TYPE OF PACKING	QUANTITY PER BOX
SELECT FROM PRODUCT MASTER	SELECT FROM PRODUCT MASTER. TYPE = "CARTON" GROUP = "PACKING MATERIAL"	SELECT FROM ARRANGED/ FREE FALL/ GAYLORD	K.B. ENTRY

## HOURLY DATA ENTRY

HEADER				
SR. NO.	DATA TYPE	DATA SELECTION/ PICK-UP/ENTRY	FROM	CONDITION FOR RESTRICTED ENTRY
1	DATE	PICK-UP	SYSTEM DATE	Allow change to system date - 1
2	TIME	PICK UP	SYSTEM TIME	NONE
3	SHIFT	SELECTION	A or B	

COLUMN NO	1	2	3	4	5
DATA TYPE	M/C NO	PRODUCT	CYCLE TIME	CAVITY BLOCKS	AVERAGE WEIGHT
DATA SELECTION/ PICK UP/ ENTRY	PICK UP & DISPLAY	PICK UP & DISPLAY	K.B. ENTRY	K.B. ENTRY	K.B. ENTRY
SELECTION/ PICK UP FROM	PRODUCTION PLAN RUNNING OR CLOSED IN SELECTED DATE & SHIFT	PRODUCTION PLAN RUNNING OR CLOSED IN SELECTED DATE & SHIFT	--	--	--
EDITING ALLOWED	NO	NO	YES	YES	YES
CONDITION FOR RESTRICTED ENTRY			Match with Std Cycle Time. Variation if more than 10% , warning to reconfirm		Match with Std Weight. Variation if more than 10%, warning to reconfirm

## DAILY PRODUCTION DATA ENTRY

HEADER				
SR. NO.	DATA TYPE	DATA SELECTION/ PICK-UP/ENTRY	FROM	CONDITION FOR RESTRICTED ENTRY
1	DATE	PICK-UP	SYSTEM DATE	Allow change to system date - 1
2	SHIFT	SELECTION	A or B	
3	MEMO (COMMENTS)	K.B. ENTRY	--	<b>Necessity of this field is to be checked with users</b>

COLUMN NO	1	2	3	4	5	6	7
DATA TYPE	M/C NO	PRODUCT	END SHOT COUNTER	SHOT COUNTER DATE/ TIME	NO OF BOXES PROD	PURGING QNTY (if any)	SELECT TAB
DATA SELECTION/ PICK UP/ ENTRY	PICK UP & DISPLAY	PICK UP & DISPLAY	K.B. ENTRY	DISPLAY	K.B. ENTRY	K.B. ENTRY	
SELECTION/ PICK UP FROM	PRODN PLAN	PRODN PLAN		SYSTEM DATE/ TIME	--	--	
EDITING ALLOWED	NO	NO	YES	YES	YES	YES	
CONDITION	Only Plans with Status "Running" to be displayed		Last reading of shot counter for m/c should not be more than current	Allow change to system date – 1. Editing of Time allowed			To select M/c for entry of Rejection & Down Time

### REJECTION ENTRY FOR M/C SELECTED IN SELECT TAB (REPEATER LOOP)

COLUMN NO	1	2	3
DATA TYPE	REASON FOR REJECTION	QUANTITY	COMMENT
DATA SELECTION/ PICK UP/ ENTRY	SELECT	K.B. ENTRY	K.B. ENTRY
SELECTION/ PICK UP FROM	DEFECT MASTER	--	--
EDITING ALLOWED	NO	YES	YES
CONDITION	None	None	None

**DOWN TIME ENTRY FOR M/C SELECTED IN SELECT TAB (REPEATER LOOP)**

COLUMN NO	1	2	3	4	5	6
DATA TYPE	SUB-REASON FOR DOWN TIME	START DATE	START TIME	END DATE	END TIME	COMMENT
DATA SELECTION/ PICK UP/ ENTRY	SELECT	K.B. ENTRY	K.B. ENTRY	K.B. ENTRY	K.B. ENTRY	K.B. ENTRY
SELECTION/ PICK UP FROM	DOWN TIME MASTER	--	--	--	--	--
EDITING ALLOWED	NO	YES	YES	YES	YES	YES
CONDITION	None	None		End Date & End Time cannot be less than Start Date & Time		None

**SAMPLE DEFECT MASTER**

#	Defect	Defect Nature	Level of Criticality	Causes Cavity- Block	Defect Reason	Factory remarks
1	Short Shot	Preform	Critical	Y	Process	
2	Silver Streak	Preform	Moderate	N	Process	
3	Gate String	Preform	Moderate	Y	Process	
4	Cooling Lines	Preform	Moderate	Y	Process	
5	Shrinkage	Preform	Moderate	N	Process	
6	Flash	Preform	Moderate	Y	Process	Can be due to mold also
7	Long Gate	Preform	Moderate	Y	Process	
8	Cloudiness	Preform	Moderate	N	Process	
9	Bubbles	Preform	Moderate	N	Process	
10	Flow Marks	Preform	Moderate	Y	Process	Can be due to mold also
11	Black Spots	Preform	Moderate	N	Process	Can be due to RM also
12	Tip Crystallinity	Preform	Moderate	N	Process	
13	Color Variation	Preform	Moderate	N	Process	Color
14	Pin Hole	Preform	Critical	Y	Process	can be due to mold also
15	Neck Damage	Preform	Moderate	N	Process	can be due to mold/robot also
16	Collar Damage	Preform	Moderate	N	Process	can be due to mold/robot also
17	Degraded Material	Preform	Moderate	N	Process	
18	Water Mark	Preform	Moderate	N	Process	can be due to mold also
19	Dot Marks	Preform	Moderate	N	Process	
20	Punch Marks	Preform	Moderate	N	Process	can be due to mold also

21	Scratches	Preform	Moderate	N	Handling	
22	Cold Slug	Preform	Moderate	Y	Process	can be due to mold also
23	Wall Thickness Variation	Preform	Critical	Y	Process	can be due to mold also
24	Weight Variation	Preform	Moderate	Y	Process	can be due to mold also
25	Neck Ovality	Preform	Moderate	N	Handling	
26	Short Quantity (Supply)	Preform	Moderate	N	Handling	
27	Short Quantity (Packing)	Preform	Moderate	N	Handling	
28	Damaged Boxes	Preform	Moderate	N	Handling	
29	Unmelt	Preform	Moderate	N	Process	
30	Gate Peel off	Preform	Moderate	N	Process	
31	Crystallinity	Preform	Moderate	N	Process	
32	Gate Finish Improper	Preform	Moderate	Y	Process	can be due to mold also

<b>Defect</b>					<b>Sr. #</b>	<b>Code</b>	<b>Code Value</b>
<b>Sr. #</b>	<b>Fields</b>	<b>Example Value</b>	<b>Remarks</b>		1	<b>Level of Criticality</b>	High
<b>(#)</b>	<b>(-)</b>	<b>(-)</b>	<b>(-)</b>		2	<b>Level of Criticality</b>	Moderate
1	<b>Defect</b>	Long-Gate	Typed-In		3	<b>Defect Nature</b>	Preform
2	<b>Level of Criticality</b>	Moderate	Select from drop-down		4	<b>Defect Nature</b>	Bottle
3	<b>Causes Cavity-Block</b>	Yes	Select from drop-down		5	<b>Defect Nature</b>	Cap
					6	<b>Defect Nature</b>	Carton
<b>Sr. #</b>	<b>Defect Nature</b>	<b>Remarks</b>	<b>Defect Reason</b>	<b>Remarks</b>	7	<b>Defect Reason</b>	Process
<b>(#)</b>	<b>(-)</b>	<b>(-)</b>	<b>(-)</b>	<b>(-)</b>	8	<b>Defect Reason</b>	Raw-Material
1	<b>Preform</b>	Check-Box	<b>Process</b>	Select from drop-down	9	<b>Answer</b>	Yes
2	<b>Bottle</b>	Check-Box	<b>Raw-Material</b>	Select from drop-down	10	<b>Answer</b>	No
3	<b>Cap</b>	Check-Box					
4	<b>Carton</b>	Check-Box					

**SAMPLE DOWN TIME MASTER**

<b>Sr. #</b>	<b>Code</b>	<b>Code Value</b>	<b>Code</b>	<b>Code Value</b>
1	<b>Down Time Reason</b>	Production	<b>Down Time Sub-Reason</b>	Operations
2	<b>Down Time Reason</b>	Management	<b>Down Time Sub-Reason</b>	Mechanical Maint
3	<b>Down Time Reason</b>	Power	<b>Down Time Sub-Reason</b>	Electrical Maint
4	<b>Down Time Reason</b>	ChangeOver	<b>Down Time Sub-Reason</b>	Complete Change over
5	<b>Down Time Reason</b>	Administration	<b>Down Time Sub-Reason</b>	No Power
			<b>Down Time Sub-Reason</b>	No Plan
			<b>Down Time Sub-Reason</b>	Preventive Maint
			<b>Down Time Sub-Reason</b>	No Manpower

**REJECTION RETURN SLIP ENTRY**

HEADER				
SR. NO.	DATA TYPE	DATA SELECTION/ PICK-UP/ENTRY	FROM	CONDITION FOR RESTRICTED ENTRY
1	DATE	PICK-UP	SYSTEM DATE	Allow change to system date - 1
2	SHIFT	SELECTION	A or B	
3	REJ GENERATED FROM	SELECT	FROM EITHER "PRODN" OR "CUST REJ"	

**IF "PRODUCTION" IS SELECTED**

COLUMN NO	1	2	3
DATA TYPE	COLOUR	QUANTITY AS PER SYSTEM (Kgs)	QUANTITY RECEIVED BY STORES (Kgs)
DATA SELECTION/ PICK UP/ ENTRY	PICK-UP & DISPLAY	CALCULATE & DISPLAY	K.B. ENTRY
SELECTION/ PICK UP FROM	PRODUCT MASTER OF RUNNING PRODUCTS	SUM OF (REJECTED QUANTITY * AVG WT / 1000) FOR ALL THE M/C RUNNING WITH SAME COLOUR PRODUCT	--
EDITING ALLOWED	NO	NO	YES
CONDITION	ONE COLOUR TO BE DISPLAYED ONCE ONLY	None	

**IF "CUST REJ" IS SELECTED**

COLUMN NO	1	2	3
DATA TYPE	COLOUR	QUANTITY AS PER QC (Kgs)	QUANTITY RECEIVED BY STORES (Kgs)
DATA SELECTION/ PICK UP/ ENTRY	SELECT	K.B. ENTRY (By QC)	K.B. ENTRY
SELECTION/ PICK UP FROM	COLOUR MASTER	-	--
EDITING ALLOWED	YES	YES	YES
CONDITION	None	None	