

TCODE – QA32

Program Edit Goto System Help

Inspection Lot Selection

My default

Inspection lot selection

Selection Profile

Lot created on 17.04.2020 to 17.04.2020

Insp. start date to

End of Inspection to

Plant to

Insp.lot origin to

Material [x] 40115020251200 to

Batch to

Vendor to

Manufacturer to

Customer to

Material class Class selection

Maximum No. of Hits 100

List settings

Select all inspection lots

Select only inspection lots without a usage decision

Select only inspection lots with a usage decision

Layout 1STANDARD

Ref. field monitor 3 Degree of proc. for insp. lot

Press On Execute Button.

RESULT RECORDING

Monit...	A	Inspection Lot	Material	Batch	Plant	Lot Qty	BU	LT	ST	Start date	End Date	System Status
●○○		40005867645	40115020251200	0234720Q01	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867646	40115020251200	0234720Q02	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867647	40115020251200	0234720Q03	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867648	40115020251200	0234720Q04	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867649	40115020251200	0234720Q05	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867650	40115020251200	0234720Q06	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867651	40115020251200	0234720Q07	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867652	40115020251200	0234720Q08	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867653	40115020251200	0234720Q09	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867654	40115020251200	0234720Q10	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867655	40115020251200	0234720Q11	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867656	40115020251200	0234720Q12	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867657	40115020251200	0234720Q13	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867658	40115020251200	0234720Q14	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867659	40115020251200	0234720Q15	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ

Change data for inspection lot: Worklist for Inspection Lots

Monit...	A	Inspection Lot	Material	Batch	Plant	Lot Qty	BU	LT...	ST...	Start date	End Date	System Status
●○○		40005867645	40115020251200	0234720Q01	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867646	40115020251200	0234720Q02	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867647	40115020251200	0234720Q03	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867648	40115020251200	0234720Q04	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867649	40115020251200	0234720Q05	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867650	40115020251200	0234720Q06	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867651	40115020251200	0234720Q07	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867652	40115020251200	0234720Q08	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867653	40115020251200	0234720Q09	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867654	40115020251200	0234720Q10	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867655	40115020251200	0234720Q11	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867656	40115020251200	0234720Q12	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867657	40115020251200	0234720Q13	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867658	40115020251200	0234720Q14	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867659	40115020251200	0234720Q15	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ

Select the inspection lot and click on “Result”.

Change data for inspection lot: Worklist for Inspection Lots

Current node no. (1) 2 Entries found

Restrictions

Op...	Short text	Insp.-rel.	Work Ctr	Plnt	Seq.
0010	PHYSICAL PROPERTIES	▲			0
0020	CHEMICAL PROPERTIES	▲			0

Select “CHEMICAL PROPERTIES” and fill result.

Results Edit Goto Extras Settings Environment System Help

Record Results: Characteristic Overview

Defects... Inspection Method Control chart Histogram Run values (run chart) Results history Valuation parameter...

Material 40115020251200 Billet 150X150 4 SP 12mtr Batch 0234720Q01

Insp. Lot 40005967645

Oper./Act. 0020 CHEMICAL PROPERTIES PInt ES01

Order 200001249

General Summarized Indicators

A...	R...	S...	Short text for the l...	Specifications	Inspect	Inspected	Si...	Result	Original Va...	V...	Defect ...	Attribute	Insp.descriptn	L...	C...	Char
	2		Carbon	0.100 .. 0.250 %	1	1		0.1000	0.1							1(
	2		Manganese	0.400 .. 1.200 %	1	1		0.4000	0.4							2(
	2		Sulphur	0.001 .. 0.040 %	1	1		0.0010	0.001							3(
	2		Phosphorus	0.001 .. 0.040 %	1	1		0.0010	0.001							4(
	2		Silicon	0.100 .. 0.400 %	1	1		0.1000	0.1							5(
	2		Copper	0.001 .. 0.020 %	1	1		0.0010	0.001							6(
	2		Chromium	0.001 .. 0.100 %	1	1		0.0010	0.001							7(
	2		MOLYBDENUM	0.0001 .. 0.0010 %	1	1		0.00010	0.0001							8(
	2		VANADIUM	0.001 .. 0.010 %	1	1		0.0010	0.001							9(
	2		Nickel	0.001 .. 0.010 %	1	1		0.0010	0.001							10(
	0		Carbon Equivalent	0.280 .. 0.420 %	1	0										11(
	0		MICRO ALLOYING EL...	%	1											12(
	0		Nb	0.000 .. 0.000 %	1											13(
	2		Boron	0.0001 .. 0.0010 %	1	1		0.00010	0.0001							14(

Results Edit Goto Extras Settings Environment System Help

Record Results: Characteristic Overview

Defects... Inspection Method Control chart Histogram Run values (run chart) Results history Valuation parameter...

Material 40115020251200 Billet 150X150 4 SP 12mtr Batch 0234720Q01

Insp. Lot 40005967645

Oper./Act. 0020 CHEMICAL PROPERTIES PInt ES01

Order 200001249

General Summarized Indicators

Manual Valuation

Char. 10 Carbon

Make a decision:

Accept

Reject

A...	R...	S...	Short text for the l...	Specifications	Inspect	Inspected	Si...	Result	Original Va...	V...	Defect ...	Attribute	Insp.descriptn	L...	C...	Char
	2		Carbon	0.100 .. 0.250 %	1	1		0.1000	0.1							1(
	2		Manganese	0.400 .. 1.200 %	1	1		0.4000	0.4							2(
	2		Sulphur	0.001 .. 0.040 %	1	1		0.0010	0.001							3(
	2		Phosphorus	0.001 .. 0.040 %	1	1		0.0010	0.001							4(
	2		Silicon	0.100 .. 0.400 %	1	1		0.1000	0.1							5(
	2		Copper	0.001 .. 0.020 %	1	1		0.0010	0.001							6(
	2		Chromium	0.001 .. 0.100 %	1	1		0.0010	0.001							7(
	2		MOLYBDENUM	0.0001 .. 0.0010 %	1	1		0.00010	0.0001							8(
	2		VANADIUM	0.001 .. 0.010 %	1	1		0.0010	0.001							9(
	2		Nickel	0.001 .. 0.010 %	1	1		0.0010	0.001							10(
	0		Carbon Equivalent	0.280 .. 0.420 %	1	0										11(
	0		MICRO ALLOYING EL...	%	1											12(
	0		Nb	0.000 .. 0.000 %	1											13(
	2		Boron	0.0001 .. 0.0010 %	1	1		0.00010	0.0001							14(

Save the entries.

Select the line and press on “Usage Decision”.

Monit...	A	Inspection Lot	Material	Batch	Plant	Lot Qty	BUN	LT...	ST...	Start date	Change usage decision (Ctrl+Shift+F5)
●○○		40005867645	40115020251200	0234720Q01	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 INSP RREC SPRQ
●○○		40005867646	40115020251200	0234720Q02	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867647	40115020251200	0234720Q03	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867648	40115020251200	0234720Q04	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867649	40115020251200	0234720Q05	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867650	40115020251200	0234720Q06	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867651	40115020251200	0234720Q07	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867652	40115020251200	0234720Q08	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867653	40115020251200	0234720Q09	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867654	40115020251200	0234720Q10	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867655	40115020251200	0234720Q11	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867656	40115020251200	0234720Q12	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867657	40115020251200	0234720Q13	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867658	40115020251200	0234720Q14	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ
●○○		40005867659	40115020251200	0234720Q15	ES01	2.111	T...	0	0	17.04.2020	17.04.2020 REL CALC SPRQ

Select the UD Code (Either Accept Or Reject) accordingly.

Record Usage Decision: Characteristic Overview

Inspection Lot: 40005867645
 Material: 40115020251200 Billet 150X150 4 SP 12mtr
 Batch: 0234720Q01
 System Status: INSP RREC SPRQ
 Insp. End Date: 17.04.2020
 Rake No:
 Defects Characteristics Inspection lot stock

Usage Decision for Inspection Lot

- Decision Usage decisions
- 01 Goods receipt (Wareneingang)
- 02 Goods issue (Warenausgang)
- 03 Production
- 04 Goods receipt from production
 - A Accept
 - A1 Other batch
 - A2 Other material
 - R Rejected
 - R1 Return Delivery
 - R2 Rework
 - R3 Scrapping
 - R4 Start 100% inspection
 - RQ Reject and start Q-activity
 - X Other usage decision (see the UD text)
 - A0 Acceptance (automatic stock posting)
- 05 Goods receipt (Wareneingang)
- 07 Vendor audit (Lieferantenaudit)
- 09 Deadline monitoring (Terminüberw.)

UD code:
 Quality score: 0
 FollowUpActn:
 SLED/BBB
 From usage decision cod

Choose

Press on Inspected Lot Stock tab.

Usage decision Edit Goto Extras Environment Inspection processing System Help

Record Usage Decision: Stock

Stock posting log Material documents.. Stock Inspection Lot Change history...

Inspection Lot: 40005867645
 Material: 40115020251200 Billet 150X150 4 SP 12mtr
 Batch: 0234720Q01 SMBL
 System Status: UD ICCO SPRQ UserStatus:
 Insp. End Date: 17.04.2020
 Rake No. Vechile No.

Defects Characteristics Inspection lot stock

Insp. Lot Qty: 2.111 TON Insp. stock
 Sample size: 0.000 TON

Quantity posted

Total	0.000
To unrestricted use	0.000
To scrap	0.000
To sample usage	0.000
To blocked stock	0.000
To new material	0.000
To reserves	0.000
Return Delivery	0.000

To be posted

0.000	StLoc	Proposal
2.111	SMBL	Document
		Document
		Document
		Doc. Item
		Document
	SMBL	Material
	SMBL	Document
	0001	Document

Doc...

Save it.

After refreshing, line will be disappeared from list.

List Edit Goto Settings System Help

Change data for inspection lot: Worklist for Inspection Lots

Usage decision (UD) Defects Defec

Monit...	A	Inspection Lot	Material	Batch	Plant	Lot Qty	BUn	LT...	ST...	Start date	End Date	System Status
●○○		40005867646	40115020251200	0234720Q02	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867647	40115020251200	0234720Q03	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867648	40115020251200	0234720Q04	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
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●○○		40005867650	40115020251200	0234720Q06	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867651	40115020251200	0234720Q07	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867652	40115020251200	0234720Q08	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867653	40115020251200	0234720Q09	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867654	40115020251200	0234720Q10	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867655	40115020251200	0234720Q11	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
●○○		40005867656	40115020251200	0234720Q12	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
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●○○		40005867659	40115020251200	0234720Q15	ES01	2.111	T...	0	0	17.04.2020	17.04.2020	REL CALC SPRQ