### TCODE – QA32

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<u>P</u> rogram <u>E</u> dit <u>G</u> oto S <u>v</u> stem	Helb		
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Inspection Lot Selection			
😔 📑 🚺 My default			
nspection 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 [×]	40115020251200	to	
Batch		to	
Vendor		to	
Manufacturer		to	
Customer		to	
Material class	Class selection		
Maximum No. of Hits	100	_	
ist settings			
<ul> <li>Select all inspection lots</li> </ul>			
<ul> <li>Select only inspection lots without a unit</li> </ul>	isage decision		
<ul> <li>Select only inspection lots with a usage</li> </ul>	e decision		
Layout	1STANDARD		
Ref. field monitor	3 Degree of proc. for	insp. lot 🗸	

### Press On Execute Button.

## **RESULT RECORDING**

🔄 List	<u>E</u> dit	<u>G</u> oto <u>S</u> etti	ings S <u>y</u> stem <u>H</u> elp									
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🗊 Monit_	A	Inspection Lot	t Material	Batch	Plant	Lot Qty	BUn	LT	ST	Start date	End Date	System Status
000		40005867645	5 <u>40115020251200</u>	0234720Q01	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
000		40005867646	<u>40115020251200</u>	0234720Q02	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
000		40005867647	40115020251200	0234720Q03	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
000		40005867648	40115020251200	0234720Q04	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867649	40115020251200	0234720Q05	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867650	40115020251200	0234720Q06	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
000		40005867651	40115020251200	0234720Q07	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
000		40005867652	40115020251200	0234720Q08	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC SPRQ
000		40005867653	40115020251200	0234720Q09	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867654	40115020251200	0234720Q10		2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867655	40115020251200	0234720011	ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867656	40115020251200	0234720Q12		2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867657	40115020251200	0234720Q13	ES01	2.111	T	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867658	3 40115020251200	0234720Q14		2.111	Т	0	0	17.04.2020	17.04.2020	REL_CALC SPRQ
000		40005867659	40115020251200	0234720Q15		2.111	Τ	0	0	17.04.2020	17.04.2020	REL_CALC SPRO

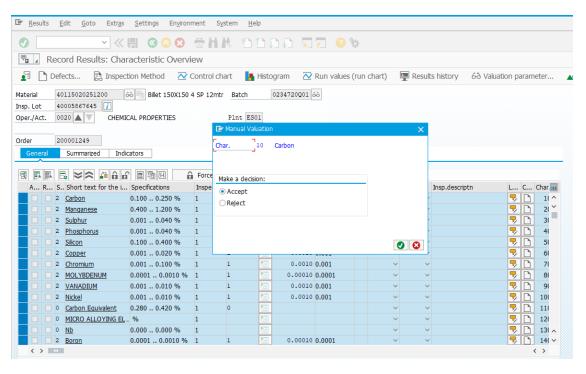
F	List E	dit	<u>G</u> oto	<u>S</u> ettin	igs Sy	ystem	<u>H</u> elp																
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63	9		R		FY		4	×	^₽ ₫	1	•	a Sa		Usage	decision	(UD)	Defe	cts 📝	Defects	💉 Resu	ults 🖌	Inspection lot	🖶 Inspect
E.	Monit A		Inspectior	n Lot	Material			Batc	h	Plant	Lot Qty	BUn l	T	ST. Sta	irt date	End Date	Syst	tem Status	5		Change i	nspection results	(Ctrl+Shift+F8)
	000	:	40005867	7645	401150	202512	00	0234	720Q01	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	) REL	CALC SP	RQ				
	000	:	40005867	7 <u>646</u>	<u>401150</u>	202512	00	<u>0234</u>	720Q02	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	) REL	CALC SP	RQ				
	000	1	40005867	7647	<u>401150</u>	202512	00	0234	720Q03	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	) REL	CALC SPI	RQ				
	000	:	40005867	7 <u>648</u>	<u>401150</u>	202512	00	0234	720Q04	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	) REL	CALC SPI	RQ				
	000	4	40005867	7 <u>649</u>	<u>401150</u>	202512	00	0234	720Q05	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	) REL	CALC SPI	RQ				
	000	4	40005867	7 <u>650</u>	<u>401150</u>	202512	00	0234	720Q06	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	) REL	CALC SP	RQ				
	000	4	40005867	7651	401150	202512	00	0234	720Q07	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	REL	CALC SP	RQ				
	000	4	40005867	7652	401150	202512	00	0234	720Q08	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	REL	CALC SP	RQ				
	000	:	40005867	7653	401150	202512	00	0234	720Q09	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	REL	CALC SP	RQ				
	000	4	40005867	7654	401150	202512	00	0234	720010	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	REL	CALC SP	RQ				
	000		40005867	7655	401150	202512	00	0234	720011	ES01	2.111	Τ	0	0 17	.04.2020	17.04.2020	REL	CALC SPI	RQ				
	000	-	40005867	7656	401150	202512	00	0234	720012	ES01	2.111	T.	0	0 17	.04.2020	17.04.2020	REL	CALC SP	RQ				
	000	4	40005867	7657	401150	202512	00	0234	720013	ES01	2.111	T	0	0 17	.04.2020	17.04.2020	REL	CALC SPI	RQ				
	000	4	40005867	7658	401150	202512	00	0234	720014	ES01	2.111	T.	0	0 17	.04.2020	17.04.2020	REL	CALC SPI	RQ				
	000		40005867	7659	401150	202512	00		720015		2.111		0	0 17	.04.2020	17.04.2020		CALC SPI	RO				

# Select the inspection lot and click on "Result".

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			-	💽 Cu	irrent node no. (	1) 2 En	tries foun					
	~		8	Re	estrictions							
Change	data for inspect	tion lot: Wor	klist fo					7	v			
🤣 😚		<b>= y Q</b>	1.	0	🛛 H 🖪 🏍	2 🖶						
~ 2		- 1 0		Op	Short text	I	nsprel.	Work Ctr Pin	nt Seq.			
🗊 Monit	A Inspection Lot	Material		0010	PHYSICAL PROP	ERTIES	<b></b>		0			
000	40005867645	401150202512	00	0020	CHEMICAL PROP	PERTIES			0			
000	40005867646	401150202512	.00									
000	40005867647	401150202512	00									
000	40005867648	401150202512	00									
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Select "CHEMICAL PROPERTIES" and fill result.

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🖥 🔺 Record Results: (	Characteristic Overv	iew											
🗈 🗋 Defects 🛃 In:	spection Method 🛛 🔀	Control cha	rt 🛛 🚹	Histogram	$\overline{\mathbf{v}}$	Run values	(run	chart)	🖳 Result	ts history	60 Valuation p	aram	eter
terial 40115020251200	68 Bilet 150X150	4 SP 12mtr	Batch	02347	20001 6	à							
p. Lot 40005867645 i													
	HEMICAL PROPERTIES		Pint ES0	1									
der 200001249													
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General Summarized	Indicators												
		Force	Furth	er details									
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	he i Specifications	Inspect	Inspected	Si Result			v	Defect		Insp.descriptr			Char.
2 <u>Carbon</u>	0.100 0.250 %	1	Inspected	2	0.1000	0.1	V	~	~			D	10
2     Carbon       2     Manganese	0.100 0.250 % 0.400 1.200 %	1	Inspected 1 1	a a	0.1000 0.4000	0.1 0.4	V	~	~		<b>7</b>		1( 2(
2     Carbon       2     Manganese       2     Sulphur	0.100 0.250 % 0.400 1.200 % 0.001 0.040 %	1 1 1	Inspected 1 1 1	a a	0.1000 0.4000 0.0010	0.1 0.4 0.001	V	~	~		7) 7) 7)		1( 2( 3(
2     Carbon       2     Manganese       2     Sulphur       2     Phosphorus	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 %	1 1 1 1 1	Inspected 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010	0.1 0.4 0.001 0.001	V	~ ~ ~	~		7) 7) 7) 7)		1( 2( 3( 4(
2     Carbon       2     Manganese       2     Sulphur	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.100 0.400 %	1 1 1	Inspected 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000	0.1 0.4 0.001 0.001 0.1	V	~	~		9 9 9 9		1( 2( 3(
2     Carbon       2     Manganese       2     Sulphur       2     Phosphorus	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 %	1 1 1 1 1	Inspected 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010	0.1 0.4 0.001 0.001 0.1	V	~ ~ ~	~		9 9 9 9 9		1( 2( 3( 4(
2     Carbon       2     Manganese       2     Sulphur       2     Phosphorus       2     Silicon	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.100 0.400 %	1 1 1 1 1	Inspected 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000	0.1 0.4 0.001 0.001 0.1 0.001	V	~ ~ ~	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~		9 9 9 9		1( 2( 3( 4( 5(
2     Carbon       2     Manganese       2     Sulphur       2     Phosphorus       2     Silicon       2     Copper	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.100 0.400 % 0.001 0.020 %	1 1 1 1 1 1 1 1	Inspected 1 1 1 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000 0.0010	0.1 0.4 0.001 0.001 0.1 0.001 0.001	V	~ ~ ~ ~			9 9 9 9 9		1( 2( 3( 4( 5( 6(
2     Carbon       2     Manganese       2     Sulphur       2     Phosphorus       2     Silicon       2     Copper       2     Chromium	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.100 0.400 % 0.001 0.020 % 0.001 0.100 %	1 1 1 1 1 1 1 1	Inspected 1 1 1 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000 0.0010 0.0010	0.1 0.4 0.001 0.001 0.1 0.001 0.001 0.001 0.0001	V	~ ~ ~ ~			9 9 9 9 9 9 9		1( 2( 3( 4( 5( 6( 7(
2     Carbon       2     Manganese       2     Subhur       2     Phosphorus       2     Silicon       2     Copper       2     Chromium       2     MOLYBDENUM	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.100 0.400 % 0.001 0.020 % 0.001 0.100 % 0.0001 0.010 %	1 1 1 1 1 1 1 1 1	Inspected 1 1 1 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000 0.0010 0.0010 .00010	0.1 0.4 0.001 0.001 0.1 0.001 0.001 0.001 0.0001 0.001	V	× × × ×			9 9 9 9 9 9 9 9 9 9 9		1( 2( 3( 4( 5( 6( 7( 8(
2     Carbon       2     Manganese       2     Subhur       2     Phosphorus       2     Silicon       2     Copper       2     Chromium       2     MOLYBDENUM       2     VANADIUM	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.100 0.400 % 0.001 0.020 % 0.001 0.010 % 0.0001 0.010 %	1 1 1 1 1 1 1 1 1 1 1	Inspected 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000 0.0010 0.0010 0.0010 0.0010	0.1 0.4 0.001 0.001 0.1 0.001 0.001 0.001 0.0001 0.001	V	× × × ×			9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9		1( 2( 3( 4( 5( 6( 7( 8( 9(
2     Carbon       2     Anganese       2     Subhur       2     Subhur       2     Silkon       2     Silkon       2     Copper       2     MolyBERUM       2     VANADUM       2     Nickel	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.001 0.040 % 0.001 0.020 % 0.001 0.000 % 0.001 0.010 % 0.001 0.010 % 0.001 0.010 % 0.001 0.010 %	1 1 1 1 1 1 1 1 1 1 1	1 1 1 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000 0.0010 0.0010 0.0010 0.0010	0.1 0.4 0.001 0.001 0.1 0.001 0.001 0.001 0.0001 0.001	V	· · · · · · · · · · · · · · · · · · ·			9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9, 9		1( 2( 3( 4( 5( 6( 7( 8( 9( 10(
2     Carbon       2     Manganese       2     Subhur       2     Phosphorus       2     Silcon       2     Copper       2     Chromium       2     MOLYBDENUM       2     Nickel       0     Carbon Equivaler	0.100 0.250 % 0.400 1.200 % 0.001 0.040 % 0.001 0.040 % 0.001 0.040 % 0.001 0.020 % 0.001 0.000 % 0.001 0.010 % 0.001 0.010 % 0.001 0.010 % 0.001 0.010 %	1 1 1 1 1 1 1 1 1 1 1	1 1 1 1 1 1 1 1 1 1 1 1 1		0.1000 0.4000 0.0010 0.0010 0.1000 0.0010 0.0010 0.0010 0.0010	0.1 0.4 0.001 0.001 0.1 0.001 0.001 0.001 0.0001 0.001	V				9 9 9 9 9 9 9 9 9 9 9 9 9 9 9 9 9 9 9		1( 2( 3( 4( 5( 6( 7( 8( 9( 9( 10( 11(



Save the entries.

Select the line and press on "Usage Decision".

	List	<u>E</u> dit	<u>G</u> oto	<u>S</u> etti		Syst		elp												
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Ch	nange	e dat	ta for ii	nspec	tion	lot:	Workli	st foi	Insp	ection	Lot	S								
69	- <del>5</del>	E		<u> </u>	Ŧ	Y	8	la 🖌	⊞ ^ <sub>B</sub>	<b>B</b>		•3			' Usa	age decision	(UD)	Defe	cts 🛛 💉 D	efect
	Monit_	А	Inspect	ion Lot	Mate	erial		В	atch	Pla	nt	Lot Qty	BUn	LT	ST	Start date C	hange usa		n (Ctrl+Shif	t+F5)
	000		400058							<u>Q01</u> ES		2.111		0		17.04.2020	17.04.20		P RREC SPRQ	_
	000		400058							<u>Q02</u> ES		2.111		0		17.04.2020	17.04.20		CALC SPRQ	
	000		400058	367647	4011	150202	251200	0	234720	<u>Q03</u> ES	01	2.111		0		17.04.2020	17.04.20		CALC SPRQ	
	000		400058	867648	4011	150202	251200	0	234720	Q04 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867649	4011	150202	251200	0	234720	Q05 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867650	4011	50202	51200	0	234720	Q06 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867651	4011	150202	251200	0	234720	Q07 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	<u>367652</u>	4011	150202	251200	0	234720	Q08 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	<u>367653</u>	4011	150202	51200	0	234720	Q09 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867654	4011	150202	251200	0	234720	Q10 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867655	4011	150202	251200	0	234720	Q11 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867656	4011	150202	251200	0	234720	012 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867657	4011	150202	51200	0	234720	Q13 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	867658	4011	150202	51200	0	234720	014 ES	01	2.111	Τ	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	
	000		400058	367659	4011	50202	51200	0	234720	Q15 ES	01	2.111	т	0	0	17.04.2020	17.04.20	20 REL	CALC SPRQ	

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

	rd Usage Decision: Cl cts 68 Inspection Lo			ive quantity Complete insp	ection Administrative data	(H) Change hist
Inspection Lot Material Batch System Status	40005867645 40115020251200 0234720Q01 SMBL INSP RREC SPRQ	Billet 150X150 4	SP 12mtr		×	
nsp. End Date take No Defects Chars Relev C V L W	Characteristics Inspectio	Vechile	<pre>&gt; Decision &gt; 01 &gt; 02 &gt; 03 &gt; 03 </pre> 04  04  04  04  04  04  04  04  04  04  04  04  04  05	Usage decisions 01 Goods receipt (Wareneingang) 02 Goods receipt (Warenausgang) 03 Production 04 Goods receipt from production Accept Other batch Other material Rejected Return Delivery Rework Scrapping Start 100% inspection Reject and start Q-activity Other usage decision (see the U Acceptance (automatic stock pu OS Goods receipt (Wareneingang)		S Data origi
Usage decision UD code Quality score FollowUpActn		SLED/BBD	> 07	07 Vendor audit (Lieferantenaudit) 09 Deadline monitoring (Terminüberw	.)	

Press on Inspected Lot Stock tab.

Usage decision	<u>E</u> dit	<u>G</u> oto	Extr <u>a</u> s	En <u>v</u> ironment	t Ins <u>p</u> ectio	n processing	S <u>y</u> stem	<u>H</u> elp	
				3 📀 🕄	**	111	) *)	★. ₹.	😯 🔅
Record	d Usage	Decis	sion: St	ock					
Stock posting	g log 🛛 🔺	尾 Mat	erial doc	uments	💦 Stock	60 Inspectio	on Lot	(H) Chan	ge history
Inspection Lot	40005867	645						66	
Material	40115020	25120	0	Billet 150	X150 4 SP 12	2mtr		68 🖷	
Batch	02347200	01	SMBL					66	
System Status	UD ICC	O SPR	Q	1	UserStatus			i	
Insp. End Date	17.04.20	20							
Rake No				<u>_</u>	Vechile No.				
Defects C	haracteristic	s I	nspection	lot stock					
Insp. Lot Qty		2.111		TON		🗸 Ins	p. stock		
Sample size		0.000		TON					
							🗢 Doc		
Quantity posted				To be	posted				
Total	0	.000		_0.000		StLoc	Pr	roposal	
To unrestricted	use 0	.000		2.111		SMBL	i i i i i i i i i i i i i i i i i i i	Document	
To scrap	0	.000					- 👯 🕻	Document	
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To blocked stoc	k 0	.000				SMBL		ocument	
To new material	0	.000				SMBL	<b>1</b>	Material	
To reserves	0	.000				0001	i i i i i i i i i i i i i i i i i i i	Document	
Return Delivery	0	.000					i i i i i i i i i i i i i i i i i i i	Document	

#### Save it.

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- 69	😒 😒			ŦŢ	9	<mark>,</mark>					Usa	ige decision	(UD)	Defects	💉 Defec
	Monit_	Α	Inspection Lo	t Material		Batch	Plant	Lot Qty	BUn	LT	ST	Start date	End Date	System Sta	tus
	000		40005867646	<u>40115020</u>	251200	0234720Q	02 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867647	40115020	251200	0234720Q	03 ES01	2.111	Т	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867648	<u>40115020</u>	251200	02347200	04 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867649	40115020	251200	0234720Q	05 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867650	40115020	251200	0234720Q	06 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867651	40115020	251200	0234720Q	07 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867652	40115020	251200	0234720Q	08 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867653	40115020	251200	0234720Q	09 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867654	40115020	251200	0234720Q	<u>10</u> ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867655	40115020	251200	0234720Q	11 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867656	40115020	251200	0234720Q	12 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867657	40115020	251200	0234720Q	13 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867658	40115020	251200	0234720Q	14 ES01	2.111	Τ	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ
	000		40005867659	40115020	251200	02347200	<u>15</u> ES01	2.111	Т	0	0	17.04.2020	17.04.2020	REL CALC	SPRQ