WRM

TCODE – QA32

<u>Program E</u> dit <u>G</u> oto S <u>v</u> stem	<u>H</u> elp		
✓ 	🔇 🛇 😋 🖶		😴 🔽 😯 🐄
Inspection Lot Selection			
🕞 📑 🚺 My Default			
Inspection Lot Selection			
Selection Profile			
Lot Created On	01.01.2020	to 18.04.2020	<u></u>
Start of Inspection		to	
End of Inspection		to	<u></u>
Plant	2000	to	
Insp. Lot Origin		to	
Material	60105578870030	<u>र</u> ।	
Batch		to	
Vendor		to	
Manufacturer		to	
Customer		to	
Materials by Class			
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 U	sage Decision		
Layout	1STANDARD		
Ref. Field Monitor	3 Degree of Proc. for	Insp. Lot 🗸	

Press On Execute Button.

RESULT RECORDING

	List	<u>E</u> di	t <u>G</u> oto	<u>Settings</u>	S <u>y</u> stem	<u>H</u> elp)									
				~ «		9 📀	🙁 音	н	44	Ŷ		D f		?	÷0	
C	hang	e D	ata for	Inspection	n Lot: W	/orklis	st for Ins	spec	tion	Lot	s					
63	è 😏	1		- - -	Y 3		× [¶] ^ _E	દ હ			•	-2 <u>6</u>	💉 Usage I	Decision	n 🦂	🖍 Res
	Monit	. A	Insp. Lot	Material		Plant	Lot Qty	BUn	LT	ST	Start	Date	End Date	System	n Stati	us
	000		400000	60105578870	0030	2000	2.020	то	0	0	19.03	.2020	19.03.2020	REL C	ALC SI	PRQ
	000		400000	60105578870	0030	2000	2.020	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.030	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.050	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.060	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.070	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.070	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.070	то	0	0	19.03	.2020	19.03.2020	REL C	ALC S	PRQ
	000		400000	60105578870	0030	2000	2.043	то	0	0	28.03	.2020	28.03.2020	LTCA (CALC	
	000		400000	60105578870	0030	2000	2.043	то	0	0	28.03	.2020	28.03.2020	LTCA (CALC	
	000		400000	60105578870	0030	2000	4	то	0	0	03.04	.2020	03.04.2020	REL C	ALC S	PRQ

	List	<u>E</u> di	t <u>G</u> oto	<u>S</u> ettings	S <u>y</u> stem	<u>H</u> elp								
				~ «		9 📀	🙁 音	-	44	Ŷ	1000		😯 🐎	
С	hange	e D	ata for	Inspection	n Lot: W	orklis/	st for In	spec	tion	Lot	S			
6	🔄 🔺			A 7	Y 3		× 🗐 ^	P c (1	1		• <u>3</u>	💉 Usage I	Decision	💉 Result
	Monit	А	Insp. Lot	Material		Plant	Lot Qt	y BUn	LT	ST	Start Date	End Date	System Sta	atus
	000		400000	6010557887	0030	2000	2.020	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.020	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.030	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.050	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.060	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.070	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.070	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.070	то	0	0	19.03.2020	19.03.2020	REL CALC	SPRQ
	000		400000	6010557887	0030	2000	2.043	то	0	0	28.03.2020	28.03.2020	LTCA CALC	:
	000		400000	6010557887	0030	2000	2.043	то	0	0	28.03.2020	28.03.2020	LTCA CALC	:
	000		400000	6010557887	0030	2000	4	то	0	0	03.04.2020	03.04.2020	REL CALC	SPRQ

Select the inspection lot and click on "Result".

	<u>L</u> ist	Edi	it <u>G</u> oto	<u>S</u> et	tings	Sys	tem	<u>H</u> elp									urrent Node No. (1)	3 Entries fo	ound		
								~	<u> </u>							F	Restrictions				
V				~			<u> </u>		•			+ 1								2	7
C	hang	e D	ata for	Inspe	ectio	n Lot	: W	orklis	t for Ir	nsp	ectio	n Lo	ots	5		0	🗵 🚹 👫 🏍 🖉	🖶 🖌			
66		h		_	=	~			I I	^B				2% E%	🖍 Usage D	Op	Short Text	Insprel.	Work Ctr	Pint	Seq.
	- 2	1			-				x=	~C	199				Je obuge b	0010) chemical analysis	<u> </u>	QUALITY	2000	0
	Monit	A	Insp. Lot	Materia	al			Plant	Lot Q	ty B	Un L1	ST		Start Date	End Date	0020	Mechanical properties	A	QUALITY	2000	0
	000	-	400000	60105	57887	0030		2000	2.020	0 T	0	0	0	19.03.2020	19.03.2020	0030	Metllurgical properties	A	QUALITY	2000	0
	000		400000	60105	57887	0030		2000	2.020	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.030	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.050	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.060	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.070	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.070	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.070	0 Т	0	0	0	19.03.2020	19.03.2020						
	000		400000	60105	57887	0030		2000	2.043	3 Т	0	0	0	28.03.2020	28.03.2020						
	000		400000	60105	57887	0030		2000	2.043	3 Т	0	0	0	28.03.2020	28.03.2020						
	000		400000	60105	57887	0030		2000	4	4 T	0	0	0	03.04.2020	03.04.2020						

Select one by one operations and fill result.

3	E	F	≅ ≍ ≈ ₽ ₽ ₽		Force	Furth	er de	tails								
	A	R	S Short text for the i	Specifications	Inspect	Inspected	Si	Result	Original Va	v	Defect	Attribute	Insp.descriptn	L	C	Char.
			2 <u>Carbon</u>	0.100 0.250 %	1	1	Ð	0.1000	0.1		~	~		- 😎		1(^
			2 Manganese	0.400 1.200 %	1	1	Ð	0.4000	0.4		~	~		- 😎		2(🎽
			2 <u>Sulphur</u>	0.001 0.040 %	1	1	Ð	0.0010	0.001		~	~		- 💎		3(
			2 Phosphorus	0.001 0.040 %	1	1	Ð	0.0010	0.001		~	~		- 😎		4(
			2 <u>Silicon</u>	0.100 0.400 %	1	1	Ð	0.1000	0.1		~	~		- 😎		50
			2 <u>Copper</u>	0.001 0.020 %	1	1	Ð	0.0010	0.001		~	~		- 😎		6(
			2 <u>Chromium</u>	0.001 0.100 %	1	1	Ð	0.0010	0.001		~	~		- 😎		7(
			2 MOLYBDENUM	0.0001 0.0010 %	1	1	Ð	0.00010	0.0001		~	~		- 😎		8(
			2 VANADIUM	0.001 0.010 %	1	1		0.0010	0.001		~	~		-		9(
			2 <u>Nickel</u>	0.001 0.010 %	1	1		0.0010	0.001		~	~		- 🍫		10(
			0 Carbon Equivalent	0.280 0.420 %	1	0					~	~		-		11(
			MICRO ALLOYING EL.	. %	1						~	~		-		12(
			0 <u>Nb</u>	0.000 0.000 %	1						~	~		-		13(🔨
			2 Boron	0.0001 0.0010 %	1	1		0.00010	0.0001		~	~		-		14(~
	1 3															< >

Order 200001249 General Summarized Indicators		Char. 10	Carbon					
	E Force	Make a decision:						
A R S Short text for the i Specificat	ions Inspe	Accest				Insp.descriptn	L C	Char.
0.1000	.250 % 1	Onder						1(^
2 Manganese 0.400 1	.200 % 1							2(🗡
2 <u>Sulphur</u> 0.0010	.040 % 1	L						3(
2 Phosphorus 0.0010	.040 % 1							4(
🔲 🔲 2 <u>Silicon</u> 0.1000	.400 % 1							5(
0.0010	.020 % 1	_		0.001				6(
🔲 🔲 2 <u>Chromium</u> 0.0010	.100 % 1	1 🔁	0.0010	0.001	~ ~			7(
□ □ 2 <u>MOLYBDENUM</u> 0.0001	0.0010 % 1	1 🔁	0.00010	0.0001	~ ~			8(
0.0010	.010 % 1	1 🔁	0.0010	0.001	~ ~			9(
0.0010	.010 % 1	1 🔁	0.0010	0.001	~ ~			10(
Carbon Equivalent 0.280 0	.420 % 1	0			~ ~		7 N	11(
D 0 MICRO ALLOYING EL %	1	2			~ ~		P D	12(
0.000 0	.000 % 1	2			~ ~		P D	13(^
0.0001	0.0010 % 1	1	0.00010	0.0001	~ ~		70	14(~
< >							<	< > 2

Save the entries.

Select the line and press on "Usage Decision".

	List	Ed	it <u>G</u> ot	o <u>S</u> et	tings	Syst	tem	<u>H</u> elp)										
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C	hang	e C	oata fo	r Inspe	ectior	l Lot	: W	orklis	st for I	nspe	ctio	n Lot	ts						
6	چ 🗧	1		<u>ــــــــــــــــــــــــــــــــــــ</u>	Ŧ	Y			, ∎	<mark>^в</mark> с (B		9 3	e a ca	💉 Usage	Decisio	n 📝 Re	esults	Create Defe
E	Monit	. A	Insp. Lot	t Materia	al			Plant	Lot Q	ty BU	n LT.	ST.	Start [Date	End Date	Sy Cha	nge Usage D	ecision	(Ctrl+Shift+F5)
	000	~	400000	60105	578870	0030		2000	2.02	0 ТО		0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000	-	400000	60105	578870	0030		2000	2.02	0 ТО		0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.03	0 ТО		0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.05	0 ТО	1	0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.06	0 ТО		0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.07	0 ТО	1	0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.07	0 ТО		0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.07	0 ТО	1	0 0	19.03.	2020	19.03.2020	REL C	ALC SPRQ		
	000		400000	60105	578870	0030		2000	2.04	з то		0 0	28.03.	2020	28.03.2020	LTCA	CALC		
	000		400000	60105	578870	0030		2000	2.04	з то		0 0	28.03.	2020	28.03.2020	LTCA	CALC		
	000		400000	60105	578870	0030		2000		4 ТО		0 0	03.04.	2020	03.04.2020	REL C	ALC SPRQ		

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

Usage Decision	n <u>E</u> dit <u>G</u> oto Ext	r <u>a</u> s En <u>v</u> ironment	Inspection Pro	cessing	S <u>y</u> stem <u>H</u> elp			
0	• « E	C 📀 🖸 🖶	HH 1	11		2 *		
Recor	d Usage Decision:	Characteristic C	verview					
🔝 🏴 Defec	ts 60 Inspection L	ot 🛛 🖳 Results His	tory De	fective	Quantity	Complete Inspection Administra	ative Data	H Change History
Inspection Lot	4000000465				🔄 Usage Decision	for Inspection Lot		×
Material	60105578870030				V Decision	Usage Decisions		^
	WIRE ROD COTI S IS 7	7887 GR 3 5 50DTA			> 01	01 Goods receipt (Wareneingang)		~
Datch	2000055002				> 02	02 Goods issue (Warenausgang)		
Bacch	2000033003 WKE	•			> 03	03 Production		
System Status	REL CALC SPRQ	Use	rStatus		V 🔽 04	04 Goods receipt from production		
End Date	19.03.2020				- 🕨 🕗 A	Accept		
Defects C	haracteristics Inspe	ction Lot Stock			- 🕨 🗸 A.	Other batch		-
					• 🕨 🕗 A:	2 Other material		
Chars Releva	ant for Usage Decision	Characteristics	0 /	0	- 🕨 🔀 R	Rejected		
C V I DE	Weighting Defect	Enacifications	Pocult	Chor	- 🕨 🔀 R.	Return Delivery		
C V L 05	weighting belett	Specificacions	Result	51101	- 🕨 😣 R.	2 Rework		
8					• 🕨 🔀 R	Scrapping		
8					· • • • • • •	Start 100% inspection		
8						2 Reject and start Q-activity	0 ++)	
						Other usage decision (see the u	D text)	
						05 Goods receipt (Warepeingang)	sung)	
					> 07	07 Vendor audit (Lieferantenaudit)		
<	>				> 09	09 Deadline monitoring (Terminüberw	.)	^
Usage Decision							.,	~
							Choose	\geq \approx \otimes
UD Code		5000 000						
ob code								
Quality Score	U	From usage decisio	n code					
FollowUpActn								

Press on Inspected Lot Stock tab.

Usage Decision	<u>E</u> dit <u>G</u> oto Extr <u>a</u> s	Environment Inspection	n Processing	S <u>y</u> stem <u>H</u> elp	
•		😣 😒 😁 H H			9¢F
Record	Usage Decision: Sto	ck			
Stock Posting) Log 💦 💦 Material Docu	iments 💦 Stock	60 Inspect	ion Lot (H) Chang	e History
Inspection Lot	4000000465			66	
Material	60105578870030			68 E	
	WIRE ROD COILS_IS 7887 G	R 3_5.50DIA			
Batch	2000055C03 WRFY			66	
System Status	UD ICCO SPRQ	UserStatus		i	
End Date	19.03.2020				
Defects Cl	haracteristics Inspection L	ot Stock			
	^				
Insp. Lot Qty	2.020	TO	Insp. S	stock 🔽	
Sample Size	0	TO			
		v - • • •		Doc	
Quantity posted		To be posted	r		
Total	0	0	StLoc	Proposal	
To Unrestricted	Use 0	2.020	WRFY	Document	
To Scrap	0			Document	
To Sample Consu	imptn 0			Document	
To Blocked Stock	k0		WRFY	Document	
To New Material	0		WRFY	📫 Material	
To Reserves	0			Document	
Return Posting	0			Document	

Save it.

After refreshing, line will be disappeared from list.

🔄 List	Ŀ	Edit <u>G</u> oto	o <u>S</u> ettings S <u>v</u> stem	n <u>H</u> elp							
•			~ ~ 🖷 🔇	3 📀	8 音	н	44	Ŷ		-	
Chan	ge	Data for	Inspection Lot: V	Vorklis	t for Ins	spec	tion	Lot	S		
6 2 4	3		🛋 🛨 🍸 🕾	! 📭	<mark>,</mark> ∰ ^8	6)			💉 Usage I	Decision 🛛 💉 Result
🗐 Mon	it	A Insp. Lot	Material	Plant	Lot Qty	BUn	LT	ST	Start Date	End Date	System Status
0	07	400000	60105578870030	2000	2.020	то	0	0	19.03.2020	19.03.2020	REL_CALC SPRQ
0	0	400000	60105578870030	2000	2.030	то	0	0	19.03.2020	19.03.2020	REL_CALC SPRQ
0	0	400000	60105578870030	2000	2.050	то	0	0	19.03.2020	19.03.2020	REL CALC SPRQ
0	0	400000	60105578870030	2000	2.060	то	0	0	19.03.2020	19.03.2020	REL_CALC SPRQ
	0	400000	60105578870030	2000	2.070	то	0	0	19.03.2020	19.03.2020	REL_CALC SPRQ
0	0	400000	60105578870030	2000	2.070	то	0	0	19.03.2020	19.03.2020	REL_CALC SPRQ
	0	400000	60105578870030	2000	2.070	то	0	0	19.03.2020	19.03.2020	REL_CALC SPRQ
0	0	400000	60105578870030	2000	2.043	то	0	0	28.03.2020	28.03.2020	LTCA CALC
	0	400000	60105578870030	2000	2.043	то	0	0	28.03.2020	28.03.2020	LTCA CALC
•0	0	400000	60105578870030	2000	4	то	0	0	03.04.2020	03.04.2020	REL_CALC_SPRQ