

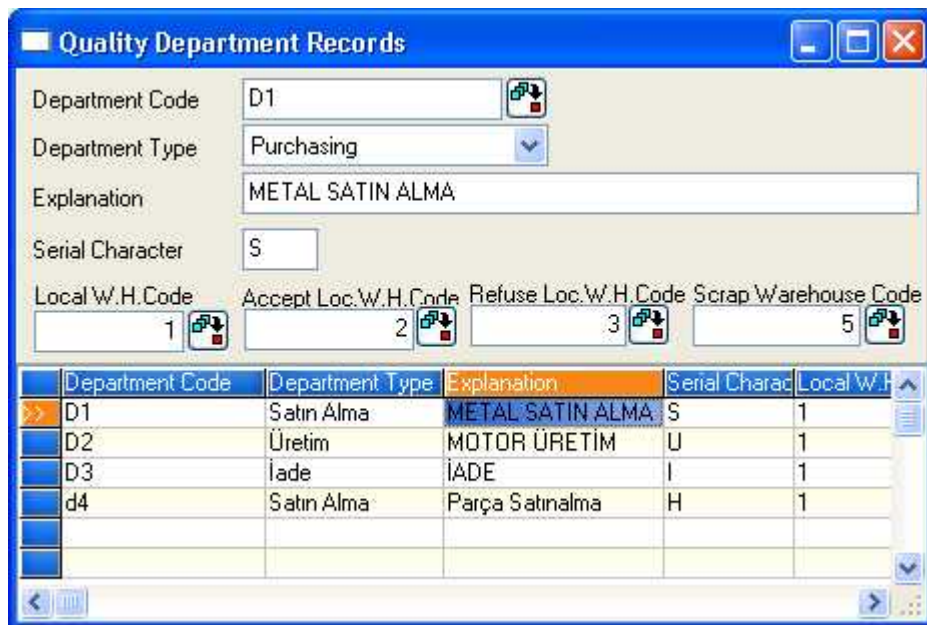
# Quality Control

# 1. Quality Control Module

The Quality Control Module is the module where the quality control records of the inventories that enter the company through purchasing, the products/semi products that are produced on work orders, and inventories that return to the inventory on purchase waybills or purchase invoices can be processed. Furthermore, in the Module, the inventories that are accepted can be transferred to the accept warehouse and those that are rejected can be transferred to the reject warehouse, finished ods records can be created for the accepted products/semi products that are produced on work orders, and the Quality Control records can be reported.

## 2. Records

### 2.1 Quality Department Records



Department Code	Department Type	Explanation	Serial Charac	Local W.H. Code
D1	Satin Alma	METAL SATIN ALMA	S	1
D2	Üretim	MOTOR ÜRETİM	U	1
D3	İade	İADE	I	1
d4	Satin Alma	Parça Satınalma	H	1

In this section you should enter the information of the department that will process the quality control operation.

**Department Code**

You should define a code for every department for which the quality control operation will be processed. These can be maximum 8-character alphanumeric codes

### **Department Type**

You can define 4 different types of departments in the quality control operation: Purchase, Production, Return and Other.

The Purchase, Production and Return department type definitions are used in quality control operations that include measurement details based on documents such as waybills, invoices or work orders, whereas the Other department type definition is used in quality control operations that do not include measurement details and for entering the control records freely as necessary. An example to the operations that can be included in the Other department would be the After Sales service records.

It is also possible to define multiple departments in a single department type. In a company that purchases metal plates and engines, for example, two different units of the purchasing department may be processing the quality control of these two products. In this case you should define two separate departments that have Purchase as their department types.

### **Explanation**

In this field you can enter an explanation about the quality control departments. Maximum 50 characters are allowed.

### **Serial Character**

In this field you should enter the characters, which the quality control number series in the departments will begin with. The quality control records will begin with the serial character that you define here. You can define 1-character numeric or alphanumeric series.

For example, if you define "S" as the serial character of the Purchase department, the quality control numbers will generate as S0000001, S0000002... and forth. You can define different series characters for every department or the same for all departments, but the field cannot be left blank.

### **Local Warehouse Code**

This is the local warehouse code in which the good enters with a purchase waybill for the quality control records of the purchase and return operation. You should also enter the receive warehouse code that is used in the finished goods records in the quality control records of the manufacture operations. If the receive warehouse code on the purchase waybill is different from the warehouse code you enter here, the programme will not be able to access the relevant records when processing the purchase and return type quality control records. *The relevant local warehouses must be previously defined in the Inventory Module/Local Warehouse Definitions section.*

### **Accept Local Warehouse Code**

This is the production/sales local warehouse code of the warehouse that will receive the goods that are accepted at the end of the quality control records. The code you enter here will be used in the "Accept Quality Control Warehouse Transfer" operation that will be discussed later in this document and enable the transfer of the accepted goods to the accept local warehouse via the local warehouse transfers operation. You can process receive

operations for different accept warehouses in terms of different departments. *The warehouse codes you enter in this section must be previously defined in the Inventory Module/Local Warehouse Definitions section.*

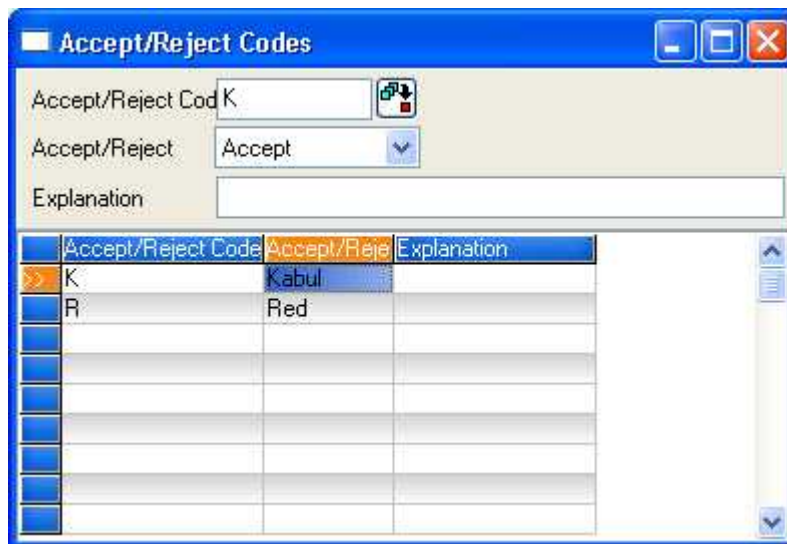
### **Reject Local Warehouse Code**

This is the scrap/return local warehouse code of the warehouse that will receive the goods that are rejected at the end of the quality control records. The code you enter here will be used in the "Reject Quality Control Warehouse Transfer" operation that will be discussed later in this document and enable the transfer of the rejected goods to the reject local warehouse via the local warehouse transfers operation. You can process reject operations for different accept warehouses in terms of different departments. *The warehouse codes you enter in this section must be previously defined in the Inventory Module/Local Warehouse Definitions section.*

### **Scrap Warehouse Code**

This is the scrap/return local warehouse code of the warehouse that will receive the goods that are identified as unusable by the tests executed on the inventories. The code you enter here will be used in the "Scrap Quality Control Warehouse Transfer" operation that will be discussed later in this document and enable the transfer of the scrapped goods to the scrap local warehouse via the local warehouse transfers operation. You can process scrap operations for different accept warehouses in terms of different departments. *The warehouse codes you enter in this section must be previously defined in the Inventory Module/Local Warehouse Definitions section.*

## **2.2 Accept/Reject Codes**



The screenshot shows a software window titled "Accept/Reject Codes". At the top, there is a text field for "Accept/Reject Cod" containing the letter "K", a dropdown menu for "Accept/Reject" set to "Accept", and an "Explanation" text field. Below these fields is a table with three columns: "Accept/Reject Code", "Accept/Reje", and "Explanation". The table contains two rows of data:

Accept/Reject Code	Accept/Reje	Explanation
K	Kabul	
R	Red	

In this section you should enter the reasons for accepting or rejecting the goods in your quality control records. You will use the Accept/Reject Codes when processing the quality control records, thus will be able to list your records according to their acceptance or rejection reasons.

### **Accept/Reject Code**

In this field you can define the 2-character numeric or alphanumeric code for the Accept/Reject state of the relevant good.

### Accept/Reject

This is the section where you can indicate whether the good defined by the indicated code is accepted or rejected.

### Explanation

In this field you can enter an explanation about the Acceptance/Rejection reasons. Maximum 50 characters are allowed.

## 2.3 Group Measurement Records

### 2.3.1 Quality Measurement Data

Code	Unit Measure	Explanation	Numeric Value	Decimal
001	HEAT		E	2
002	LENG.		E	2
003	ACID		E	0
>> 004	COLOR		H	0

In this section you will define every kind of measurement that is required in the quality control process of your company. You should define each and every measurement type regardless of the department and the controlled products, i.e., width, height, colour, temperature, humidity or voltage.

### Code

In this section you should enter maximum 8-character long code information for the measurement type.

### Unit Measure

In this section you should enter a maximum 5-character long explanation that will identify the measurement type.

### Numeric Value

You should select this parameter when the measurement is expressed in terms of numeric values. For example, measurement results such as width, height and temperature are expressed numerically. Colour measurements, on the other hand, are not expressed numerically, thus this parameter should not

be selected for such measurements. The definitions you enter in this section will determine whether or not you can enter numeric values for the relevant measurement entries in the quality control records.

### Decimal

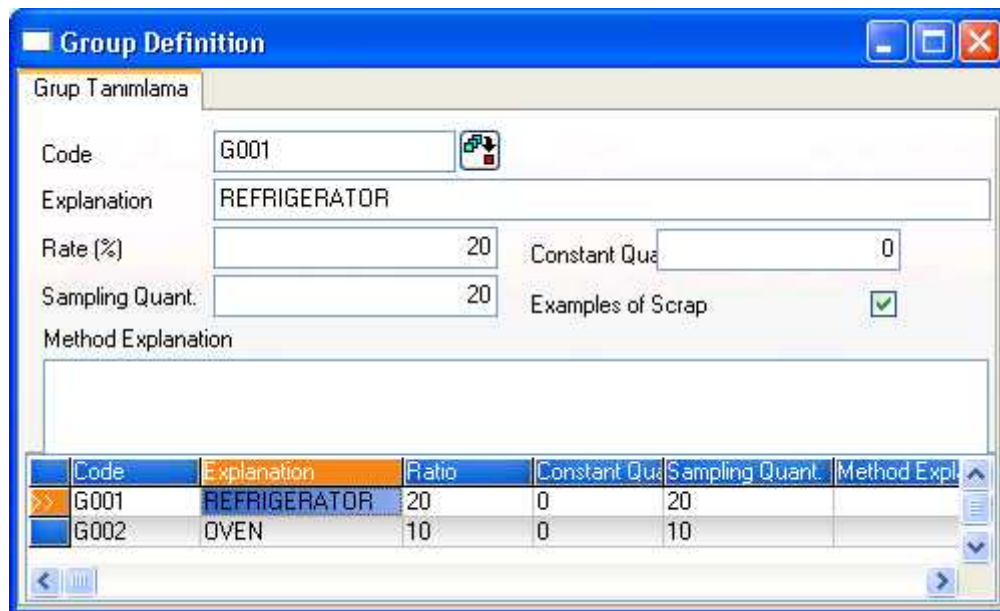
This parameter will be active when you select the Numeric Value parameter. If you will use decimal values in the measurement value, then you should here indicate the number of decimal fraction digits that you will use. E.g., 32,456 cm.

### Explanation

In this field you can enter an explanation about the measurement. Maximum 50 characters are allowed.

## 2.3.2 Quality Group Definitions

### 2.3.2.1 Group Definition



Code	Explanation	Ratio	Constant Qua	Sampling Quant.	Method Expl.
G001	REFRIGERATOR	20	0	20	
G002	OVEN	10	0	10	

In this section you will define the groups that are subject to similar quality control tests and their acceptance/rejection conditions. These can be deemed as groups of goods such as refrigerators group, ovens group.

### Code

In this section you should enter maximum 8-character long, numeric or alphanumeric code information for the quality group.

### Explanation

In this field you can enter an explanation about the Quality group. The explanation can be maximum 50 characters, numeric or alphanumeric.

### Examples of Scrap

If the samples used in testing are scrapped after the testing process, then you should select this parameter.

## Method Explanation

In this field you can enter an explanation about the selected method.

### 2.3.2.2 Inspection Interval Group Definitions

Code	Inspection Code	Beginning Quantity	Ratio	Sampling Qu.	Constant
g001	1		2	5	0
g001	1	5.001	4	5.000	0
g001	1	15.001	3	20.000	0
g001	2	1	6	2.500	0
g001	2	5.001	10	5.000	0
g001	2	15.000	12	20.000	0

Before we explain about the Sampling Quantity and Ratio fields we should discuss what sampling represents.

Observing, inspecting and examining each and every unit in the mass or pile can mostly become a difficult, time consuming and expensive task in the quality control process. Instead of examining the entire pile it would be more appropriate to inspect a sample group that represents the whole pile. The process of selecting these sample units is called "sampling."

#### Sampling Quantity

In this section you should enter the sampling quantity, which will represent the pile in terms of the quality group.

#### Ratio (%)

In this section you should enter what portion of the sampling quantity will be examined.

#### Fixed Quantity

When you will examine a fixed quantity, you should enter this quantity value in this field. If you specify a fixed quantity then you should not enter a value in the above-described Ratio field.

For example, let us assume that the metal plates in the above example are purchased by box and one box consists of 5 plates. The first measurement unit in the inventory card of this metal plate is units and the second measurement unit is parcel. You have purchased 100 boxes of metal plates; this is to say you received 500 units of metal plates with the purchase waybill. In the quality control process you take one metal plate from every box and if

the control result is positive you accept the whole box, otherwise reject the box. In this example the sampling quantity is 5 and the ratio is 20% (1/5). Let us take another example where you purchase 30 refrigerators with a waybill and the first measurement unit in the inventory card of this good is units. In the quality control process you examine each refrigerator individually and either accept or reject it.

In this case you should enter 30 in the sampling quantity field and 100% in the ratio field.

### **Inspection Code**

This field is used for specifying the sampling quantities of the quality control groups and the ratio/fixed quantity information on basis of intervals. Hence, you can specify multiple sampling quantities by quantity intervals for the quality control group. (E.g., if the quantity interval is 100-200, then the sampling quantity is 10 and the ratio is 1%; or if the quantity interval is 201-400, then the sampling quantity is 30 and the ratio is 5%.)

You can furthermore indicate multiple sampling quantities for the same quantity interval and identify which sampling quantity should be applied in the quality control record process (e.g., for the quantity interval 100-200, the sampling quantity can be identified as 10 and 15).

In order to support the above-exemplified usage of the application, the "Quality Control Sampling Intervals" definition parameter is included in the Quality Control/Parameters section. When you select this parameter, you should enter the quantity interval start and end values in the Inspection Interval Group Definitions page in the Quality Group Definitions menu, and then you will be allowed to enter multiple sampling quantity and ratio/fixed quantity information for the same quality control group. Multiple sampling quantity definitions for the same quantity interval -as mentioned above- are also supported by the inspection codes that should be defined in the Inspection Interval Group Definitions section under the Group Measurement Records menu. Different sampling quantities, ratio/fixed quantity information in terms of inspection codes for a single group and the same quantity can be entered in the Quality Group Records section. (E.g., when the quantity interval for quality group G01 is 100-200, the sampling quantity for inspection code M1 may be 10 and for inspection code M2 it may be 15.) In the quality control record the sampling quantities will be generated on basis of the inspection codes selected in the record entry process.

### **2.3.3 Measurement Group Information**

Measurement Code	Numeric Minimum	Numeric Maximum	Min Alph	Max Alph	Explanation
001	10	20			BEYAZ GRI
004	0	0			BEYAZ GRI

In this section you will define which types of measurement should be applied to the quality groups. The maximum and minimum values of the measurement results should also be defined in this section.

In an example where the refrigerator and oven groups are each defined as quality groups, while width, height, temperature and voltage measurements would be applied to the goods in the refrigerator group, only width, height, temperature measurements would be applied to the goods in the oven group.

#### Group Code

In this section you should enter the group code of the quality group, for which the measurement information will be defined, as defined in the Quality Group Definitions section.

#### Measurement Code

In this field you should enter the measurement that will be applied to the quality group. The measurement codes must be previously defined in the Quality Measurement Constant Data section.

#### Numerical

In this section you will specify whether the selected measurement's result will be entered as a numeric or alphanumeric value. Whether this parameter will be active or inactive depends on the selection made in the "Numeric Value" parameter in the Quality Measurement Constant Data section.

#### Min. Alphanumeric

You can enter information in this field only if the "Numeric Value" parameter in the Quality Measurement Constant Data section is not selected for the related measurement. You should enter the minimum value applicable for the

measurement results that cannot be expressed in numeric values, such as white, small, matte.

**Max. Alphanumeric**

You can enter information in this field only if the “Numeric Value” parameter in the Quality Measurement Constant Data section is not selected for the related measurement. You should enter the maximum value applicable for the measurement results that cannot be expressed in numeric values, such as black, large, shiny.

**Min. Value**

You can enter information in this field only if the “Numeric Value” parameter in the Quality Measurement Constant Data section is selected for the related measurement. You should enter the minimum value applicable for the measurement results that will be expressed in numeric values, such as 10 degrees, 50 cm.

**Max. Value**

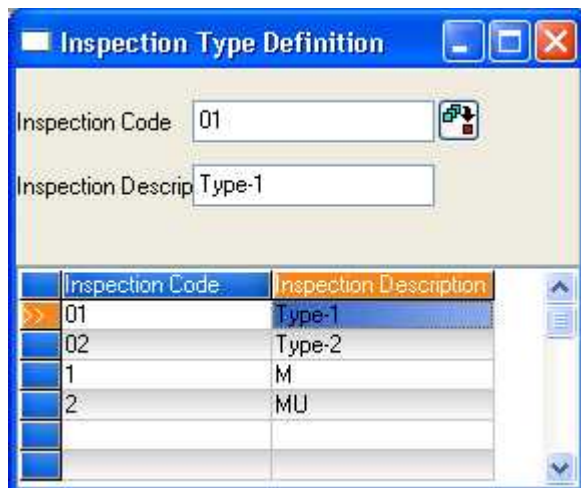
You can enter information in this field only if the “Numeric Value” parameter in the Quality Measurement Constant Data section is selected for the related measurement. You should enter the maximum value applicable for the measurement results that will be expressed in numeric values, such as 30 degrees, 65 cm.

**Explanation**

In this field you can enter an explanation about the quality control measurements. Maximum 50 characters are allowed.

**2.3.4 Inspection Type Definition**

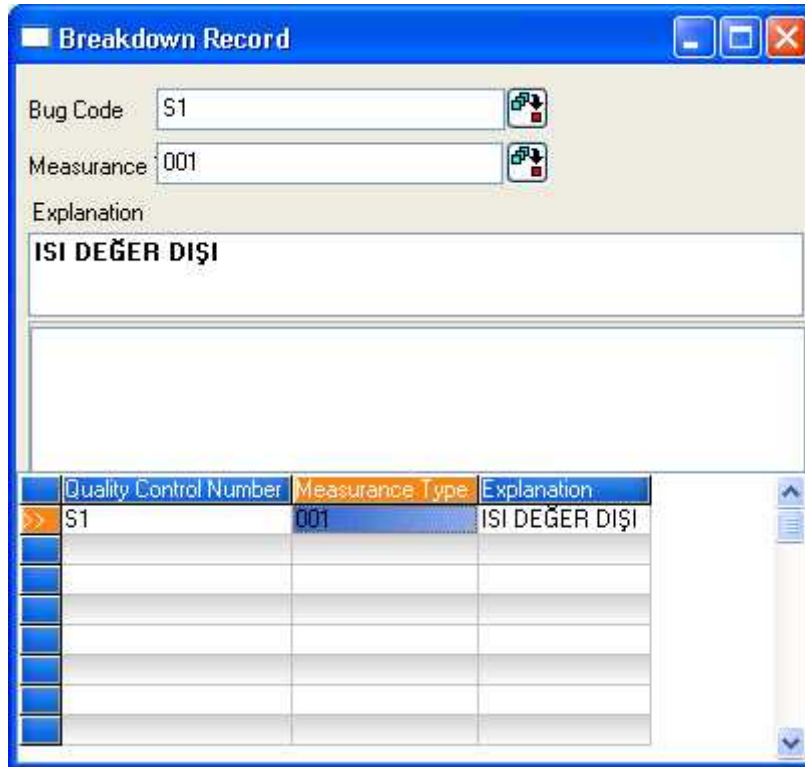
This section will be active in the Quality Control Group Measurement Records menu when the “Quality Control Sampling Intervals” parameter in the Parameters section is selected.



The inspection codes defined in this section will be queried in the Quality Group Definitions section and enable multiple sampling quantity definitions for the same quantity interval.

Inspection codes must be first defined in order to be able to specify the sampling quantities by intervals.

## 2.4 Breakdown Record



Quality Control Number	Measurance Type	Explanation
S1	001	ISI DEĞER DIŐI

In this section you will define the breakdowns, which may cause the rejection of goods as a result of the quality control operations, according to measurement types.

### **Bug Code**

In this section you should enter maximum 8-character long, numeric or alphanumeric code information for the defined breakdown.

### **Measurement Type**

In this section you will identify the type of measurement that is related with the breakdown record. The measurement types to be specified must first be recorded in the "Quality Measurement Data" section.

### **Explanation**

In this field you can enter an explanation about the Breakdown record freely as necessary.

## 2.5 Inventory/Current Account Matching

The quality groups, which the inventories will be linked to in terms of the relevant supplier or suppliers, are defined in this section. These definitions will be used in the quality control records operation and will determine the types of quality measurement that will be applied to the inventories.

### 2.5.1 Current Account-Group Matching

	Curr.Acc.Code	Department Code	Group Code	Explanation
>>	C001		G001	
	C001	D2	G003	
	C002	D1		

In this section you will specify whether or not you will run the quality control operation in terms of suppliers, if yes which quality groups the relevant suppliers belong. With this definition you will specify the quality measurements will be applied to the goods, which tests will be applied (sampling quantity, minimum value, maximum value, etc.), the conditions of accepting or rejecting.

The records you insert in the Current Account-Group Matching menu do not include product details. This means to say that you can use this menu both if you run the same type of measurements regardless of the supplier they are purchased from or if you do not require any quality control tests because the relevant supplier holds a quality certificate.

#### Current Account Code

This is the code of the supplier that will be linked to the quality group. You can define one of the suppliers defined in the Current Account Module/Current Account Master Records menu.

#### Department Code

In this section you will specify the quality department related to the definition.

#### Group Code

This is the section where you can specify the quality group to which the supplier is linked. The goods received from the indicated supplier will be

measured according to the specifications defined for the indicated quality group. The group codes you select in this section must be previously defined in the "Quality Group Definitions" menu.

### Explanation

In this field you can enter an explanation freely as necessary.

### No QC

You can select this parameter if you do not run quality control for the goods you purchase from suppliers who hold quality certification. You should leave the Group Code field blank for these types of records; otherwise you will receive a warning message, which notifies that "You should not enter a Group Code if you will not process Quality Control."

## 2.5.2 Inventory-Group Matching

Inventory Code	Department Code	Group Code	Explanation
00001	D2	G003	
M11	D2	G003	

In this section you will specify which quality control groups the goods belong. This menu is rather used for matching the produced products with quality groups.

With this definition you will specify the quality measurements will be applied to the goods, which tests will be applied (sampling quantity, minimum value, maximum value, etc.), the conditions of accepting or rejecting.

The records you insert in the Inventory-Group Matching menu do not include supplier details. This means to say that you should use the Current Account-Inventory Matching menu if you run different types of measurement tests to the goods when you purchase the same good from different suppliers.

### Inventory Code

This is the code of the commodity that will be linked to the quality group. You can define one of the inventories defined in the Inventory Module/ Inventory Master Records menu.

### Department Code

In this section you will specify the quality department related to the definition.

### Group Code

This is the section where you can specify the quality group the commodity belongs. The goods that are purchased, returned or produced will be measured according to the specifications defined for the indicated quality group. The group codes you select in this section must be previously defined in the "Quality Group Definitions" menu.

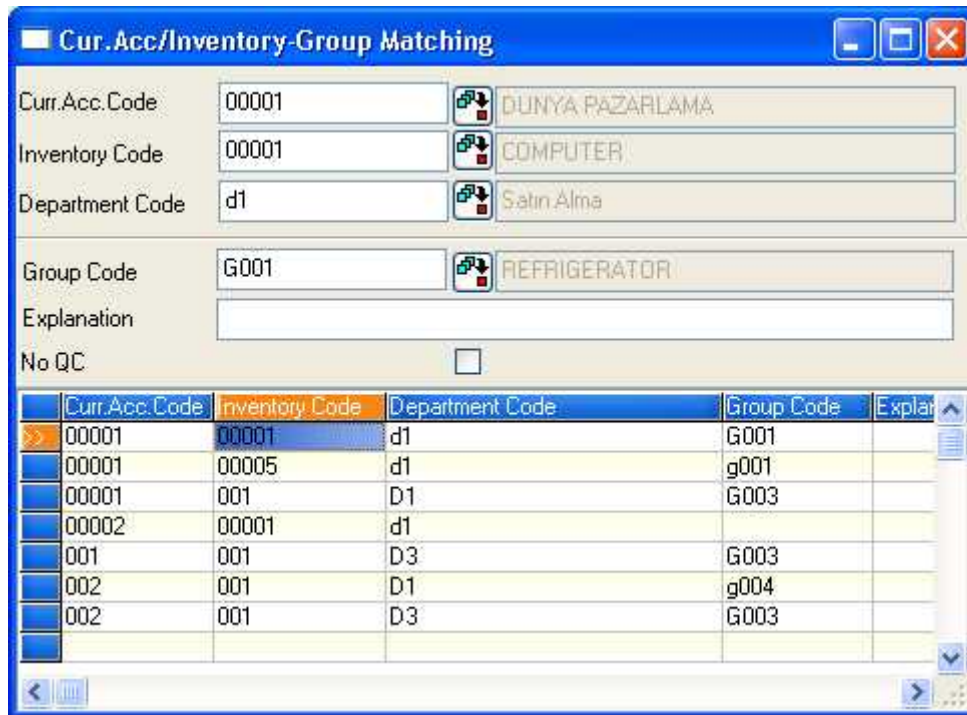
### Explanation

In this field you can enter an explanation freely as necessary.

### No QC

You can select this parameter if accept certain products without running quality control for these products. You should leave the Group Code field blank for these types of records; otherwise you will receive a warning message, which notifies that "You should not enter a Group Code if you will not process Quality Control."

## 2.5.3 Current Account/Inventory-Group Matching



Curr.Acc.Code	Inventory Code	Department Code	Group Code	Explat
00001	00001	d1	G001	
00001	00005	d1	g001	
00001	001	D1	G003	
00002	00001	d1		
001	001	D3	G003	
002	001	D1	g004	
002	001	D3	G003	

In this section you will specify which quality control groups the inventories belong according to their suppliers. Thus, you can run different test for the same product purchased from different suppliers.

### Current Account Code

This is the supplier code that will be linked to the quality group.

### Inventory Code

This is the inventory code that will be linked to the quality group.

### Department Code

In this section you will specify the quality department related to the definition.

### **Group Code**

This is the section where you can specify the quality group the inventory belongs according to the suppliers. The goods that are purchased from suppliers will be measured according to the specifications defined for the indicated quality group. The group codes you select in this section must be previously defined in the "Quality Group Definitions" menu.

### **Explanation**

In this field you can enter an explanation freely as necessary.

### **No QC**

You can select this parameter if you do not run quality control for goods you purchase from suppliers who hold quality certification. You should leave the Group Code field blank for these types of records; otherwise you will receive a warning message, which notifies that "You should not enter a Group Code if you will not process Quality Control."

When defining the quality groups of products, thus the measurement tests that are required for the products in the Quality Control Record Screen section, the process should be in the following order:

- Current Account/Inventory-Group Matching
- Current Account-Group Matching
- Inventory-Group Matching

When running quality control in purchasing operations, if there are any definitions recorded in the Current Account/Inventory-Group Matching menu of the supplier or the good itself, then the programme will first read this definition. If there are no definitions, then it will read the definition indicated in the Current Account-Group Matching section in terms of suppliers.

## **2.6 Employee Definition**

Company	Employee ID	Employee Name	Workst.Code
KAYNAK	10		
KAYNAK	13545645	ERHAN USTA	
KESİMHAN	9811122121	METİN	
MONTAJ	9811122120	ENVER	
PRESS	4556425125	BARIŞ USTA	

For detailed information about Employee Definitions, please see [MRP/Employee Definitions](#).

## 2.7 Quality Control Record Screen

The quality control records are processed in 4 different menus according to the types of the operation.

- Purchase
- Production
- Return
- Other

### 2.7.1 Purchase

This is the section where the quality control records of the goods received on purchase waybills should be inserted.

There are several important points in the quality control process of purchasing operations:

- The Quality Control in Purchase parameter in the Quality Control Parameters menu should be selected.
- The Store Invoiced Waybills parameter in the Purchase Invoice Parameters menu should be selected.

#### 2.7.1.1 Initial-Query

**Quality Control Record Screen**

You can enter Quality Control Record on this screen

Pre Query

Default Value Entrance

Personnel Code 8 MONTAJ 9811122120 ENVER

Document Restrictions

Department Code d1 METAL SATIN ALMA

Clerk Code 00001 DUNYA PAZARLAMA

Waybill Number 000000000000324

Inventory Co	Inventory Name	Quantity	Quantity2	Net Price	Total Acceptance	Total Refuse
>> 00001	COMPUTER	10	0	13.23	13.23	0

### Department Code

In this section you will indicate the code of the department that will run the receive control of the goods. The lookup in this field includes the codes of the departments that are recorded with the "purchase" department type in the Quality Department Records menu.

### Personnel Code

This is the code of the employee who will run the receive quality control. The codes you enter in this field must be previously defined in the MRP Module/Employee Definitions menu. The field cannot be left blank.

### Supplier Code

This is the code of the supplier from which the relevant goods subject to the quality control are purchased, as indicated in the purchase waybill record. The programme will read the information stored in the Current Account/Inventory Group Matching and the Current Account-Group Matching records of the related supplier respectively and generate the necessary measurement tests. The field cannot be left blank.

### Waybill Number

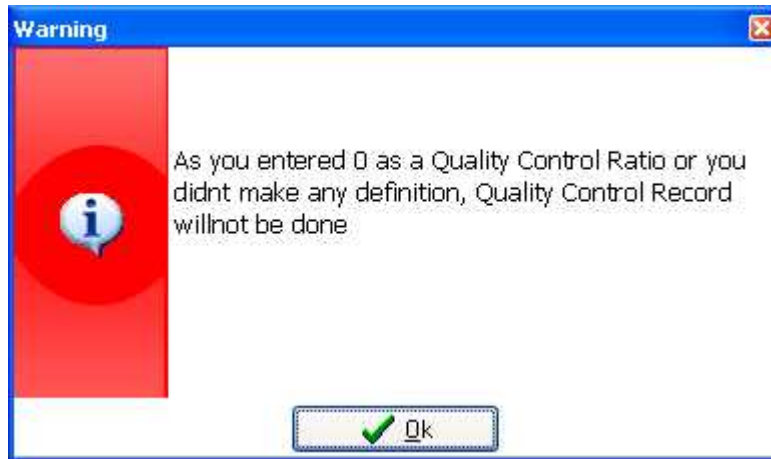
In this section you should select the purchase waybill with which the goods subject to quality control are received. The lookup in this field includes the list of the purchase waybills received from the selected supplier. When you select the appropriate waybill and press the "Tab" key, all of the inventory records listed in the waybill will be copied to the grid section.

Important points:

- In order to be able to insert the quality control record, you must have matched the goods with the relevant quality groups in either the Current Account/Inventory-Group Matching, the Current Account-Group Matching or the Inventory-Group Matching sections as necessary according to the type of the record.

- In the "Quality Control Definitions" menu, you must have recorded the Quality Control "Ratio" of the quality group to which the supplier or inventory belongs.

If either of these definitions is missing, the programme will display the below-shown warning message when you double click on the inventory record.



You can insert multiple quality control records for an inventory recorded in the same waybill. In this menu you can retrieve the list of the quality control records that were previously inserted for the related inventory and insert a new record. Hence, you can run the quality control operation first for the 90 of the 100 units that are received with the same purchase waybill, then for the remaining 10 units and transfer these to the acceptance/rejection warehouses as necessary via different vouchers.

When you double click on the waybill displayed in the Grid in the Initial Query page, you can move to the page where you will process the quality control record of the related document.

### **2.7.1.2 Quality Control Record Screen**

#### **2.7.1.2.1 Quality Control Document Information**

The screenshot displays a software window titled "Quality Control Record Screen". At the top, a message states "You can enter Quality Control Records on this form". Below this, a toolbar contains buttons for "Record Close", "Record Open", "Move Quantity Proposals to Activities", and "New Document". A left-hand navigation pane shows a tree structure with "Purchasing" selected and a "New Record" option. The main area, titled "Quality Control Document Information", contains the following fields:

Inventory Code	00001	COMPUTER
Document Number	0000000000000324	
Document Quantity	10	
Curr.Acc. Code	00001	DUNYA PAZARLAMA

When you go to the quality control record, the programme will first display the page where you can view the information related to the selected document. In this section, you can press the "+" sign in the Purchase field on the left of the window to create the new quality control document.

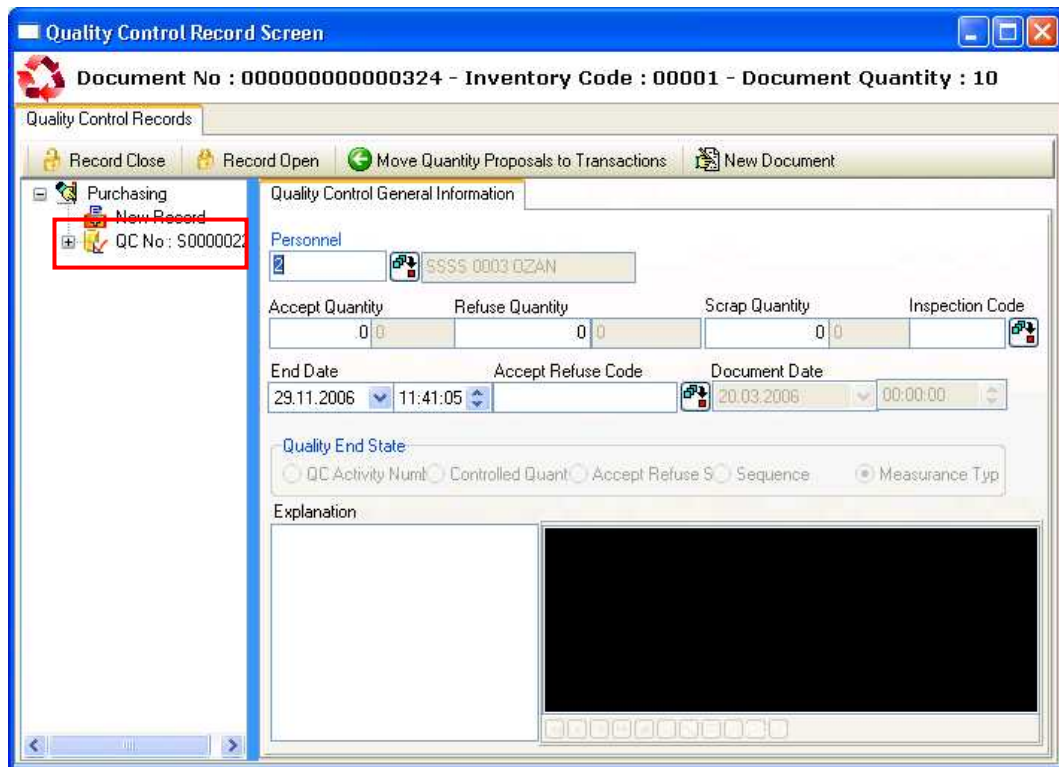
### 2.7.1.2.2 Quality Control General Information

### New Record

The New Record section can be used for creating a new quality control document. When you select the New record field, a section entitled “Quality Control General Information” section will be displayed on the left of the window. Here you can view information about the user who inserted the quality control record. When processing the quality control record entry, you can move between the fields of the Quality Control General Information section with the “Tab” key without having to enter any values. When you complete the entry in the quality control record, the programme will insert the quantities of the accepted, rejected or scrapped inventories in the relevant fields.

If, however, the Quality Control Sampling Intervals parameter in the Parameters section is selected, then the Inspection Code will be queried in this section and will not allow users to leave this field blank. In this field you will specify according to which group intervals, as defined for the inspection code, you wish to apply to the quality control record. [For detailed information about the interval definition in quality control groups, please see Quality Control/Group Measurement Records/Quality Group Definitions.](#)

When you enter the information as necessary in these fields, the programme will create the quality control document in the New Record section. In this field you can monitor the number of the created document.



### QC Number

This is the quality control number the programme generates for the quality control record. The quality control numbers will begin with the Serial Character indicated in the Quality Department Records section and the numbers will be assigned to each document in subsequent sequence. Users are not allowed to modify the assigned numbers, e.g., S0000001, S0000002, and so on.

When you press the "+" sign to the left of the field where the document number is displayed, you can enter view the quality control results for the samples that users have entered or the programme inserted.

If the "Automatic Quality Control Activities" parameter is selected in the Parameters section, the samples will be created by the programme. The sampling quantities will be as specified in the Quality Group Definitions menu. When you select the samples listed in the left section of the window, the Quality Control Detail Information section will be displayed in the right section of the window.

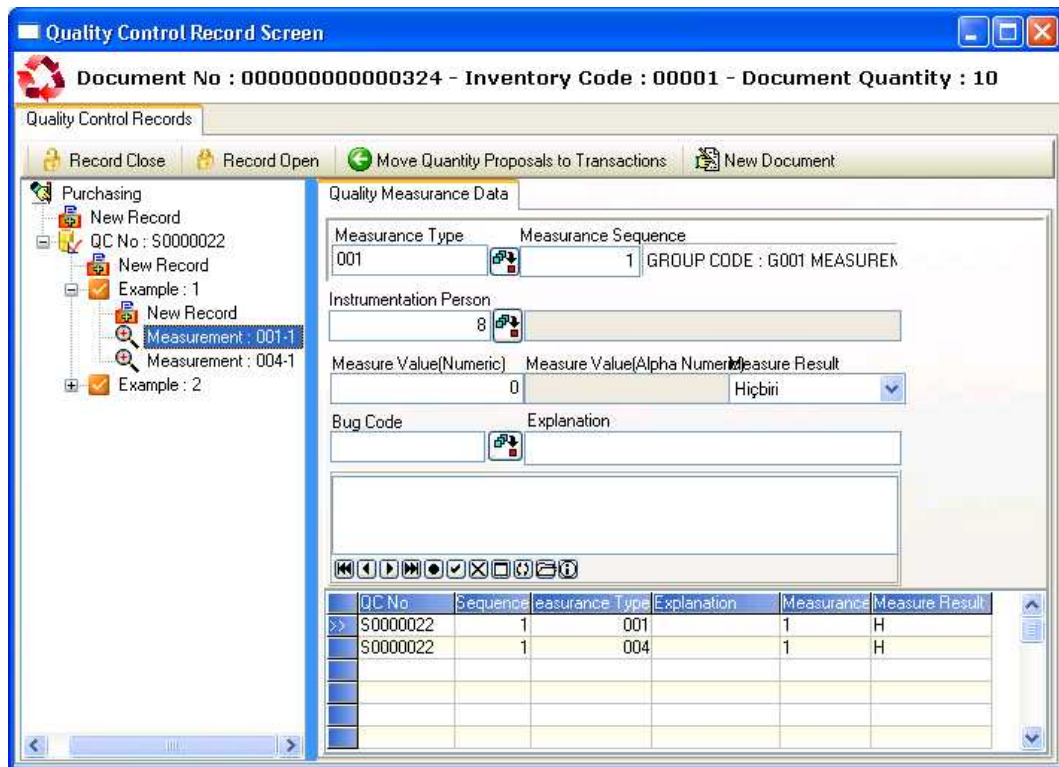
### 2.7.1.2.3 Quality Control Detail Information

In this section you can enter acceptance or rejection quantities for every sample and determine their acceptance/rejection states. In this menu, the total good quantities of the samples that will be measured are grouped according to the samples. For example, if the 50 units recorded in the purchase waybill will be tested as groups of 10, there will be 5 separate rows. In this section you can enter the acceptance/rejection states for every group of 10 units to indicate their relevant states.

The acceptance/rejection states of groups can be inserted manually in this section or they can be generated from the measurements results entered in the Quality Measurement Data section as well. In this case, the Move Quantity Proposals to Activities button can be used.

Measurement entries can be recorded for the sample if any measurement value is matched with the quality control group, which is taken as base in the quality control record. To do this you should press the "+" sign to the left of the sample field. The Quality Measurement Data section will be displayed in the right section of the window.

#### 2.7.1.2.4 Quality Measurement Data



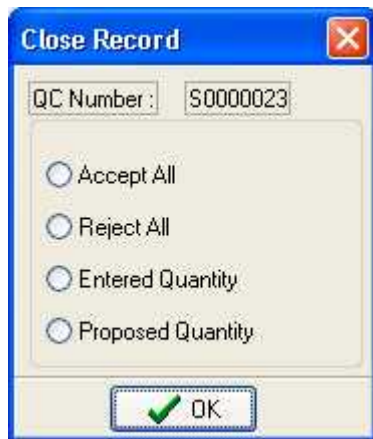
You can use this section to enter the quality control measurement results according to the samples.

The records in the Transaction/Measurement Data page can be both inserted manually or automatically by the programme. In this case, the Move Quantity Proposals to Activities button can be used. If the "Automatic Quality Control Activities" and "Automatic Quality Control Measurement" parameters are selected in the Parameters section, then the programme will automatically create the activity and measurement records. The measurement results can also be recorded by entering the acceptance/rejection quantities and acceptance/rejection states and settling the records with the "Close Record" option.

### 2.7.1.2.5 Open/Close Record

After completing the quality control records, the Record Close operation has to be processed in order to insert the finished ods records for the accepted products/semi products and to transfer the rejected goods to the rejection warehouse. This section should also be used for reopening the closed records. In order to close a quality control record or open a previously closed record you should right click on the "Quality Control Record Screen" page. Two options will be displayed, namely the "Open Record" and the "Close Record" options.

When you click on the Close Record option, another menu where you can determine the final state of the record will open.



This is the section where you can specify the final state of the products/semi products recorded in the work order after the quality control operations are completed. When you enter the quality control results in detail in the Activity/Masurement Records page, you should come back to this page and specify the final quality state to close the record. There are 5 different possible states:

**(A) ccept All**

You should select this option in order to accept all of the goods in the work order.

**(R) eject All**

You should select this option in order to reject all of the goods in the work order.

**Entered Quantity**

You should use this option to enter the relevant quantities in the accept/reject fields and thus close the record.

**Proposed Quantity**

The total of the accept/reject quantities, which you enter on basis of the samples, will be displayed as the proposed quantity in the field next to the accept/reject quantity field on the Activity/Masurement Data page. If you want to determine the proposed accept/reject quantities as the actual accept/reject quantities, then you should use this option to close the record.

### **2.7.1.2.6 Quality Control Record Deletion**

In order to delete the quality control record, you should go to the "Quality Control Record Screen" and press either F7 or the "Delete Record" button on the toolbar. This operation will also process the deletion of the measurement data linked to the record that is deleted. The delete operation cannot be realised if the related record is already closed or the production voucher has been generated.

### **2.7.2 Production**

This is the section where the quality control records of the products/semi products that are produced in connection with a work order are inserted. The Finished Ods records for the accepted products/semi products will be created

after the records are inserted in this menu, while those rejected will be transferred to the rejection warehouse. [For further information about using this menu, please see Quality Control, Quality Control Record Screen/Purchase.](#)

### 2.7.3 Return

This is the section where the quality control records of the inventories returned with a purchase waybill or purchase invoice can be inserted. [Since this process requires the same operational process as the Purchase operation, you can read the relevant detailed information in the Purchase section.](#)

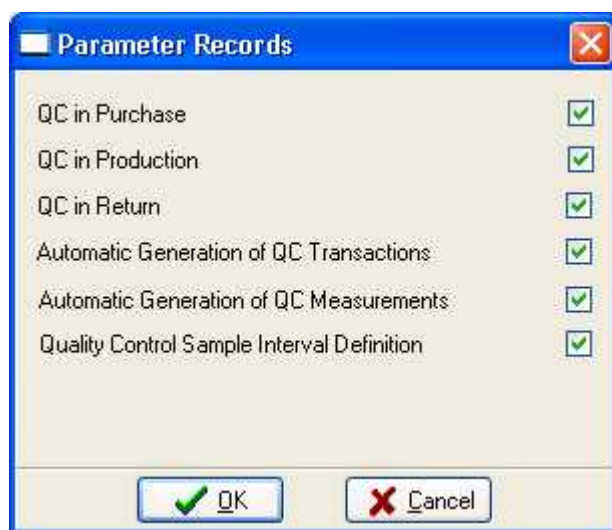
### 2.7.4 Other

This menu can be used for inserting free format quality control records; e.g., Service records after sales.

Companies that wish to store this type of records should select the following parameters in the Parameters menu.

- Quality Control in Purchase
- Quality Control Records in Production
- Quality Control Records in Return

## 2.8 Parameters



### Quality Control in Purchase

You should select this parameter if you want to run a quality control operation for the goods received by the local warehouse with a purchase waybill. You will be able to use the Purchase section in the Quality Control record Screen when you select this parameter.

### Quality Control Records in Production

You should select this parameter if you want to run a quality control operation for the products/semi products that are produced with a work order. You will

be able to use the Production section in the Quality Control record Screen when you select this parameter.

#### **Quality Control Records in Return**

You should select this parameter if you want to run a quality control operation for the goods returned and received by the local warehouse with a purchase waybill. You will be able to use the Return section in the Quality Control record Screen when you select this parameter.

#### **Automatic Quality Control Activities**

You should select this parameter if you want the programme to insert the quality control activities according to the definitions you previously recorded in the Group Measurement data and the Current Account-Inventory Matching sections.

#### **Automatic Quality Control Measurement**

This parameter will be active when you select the "Automatic Quality Control Activities" parameter described above. When processing quality control in Purchase and Production operations this parameter enables the programme to use the specified Current Account-Inventory Matching information and automatically generate the relevant measurement data. This is to say that the parameter serves to identify which measurements will be executed for the inventory and whether the related inventory will be accepted or rejected according to the measurement values. To enable this, you must fill out the complete information queried in the "Quality Measurement Date" and the "Quality Group Definitions" sections for the inventory subject to quality control. Users should enter the relevant information in the Measurement value filed in the Activity and Measurement Records section individually for all transaction entries. In this case, the programme will automatically insert the information in the Measurement Result field according to the definitions in the "Measurement Group Data" section.

## **3. Operations**

The operations in this menu will automatically process the transfers of the goods to the local acceptance, rejection or scrap warehouses according to the results of the quality control records.

### **3.1 Accept Quality Control Warehouse Transfer**

**Quality Control Warehouse Transfer**

Resource Whouse Co: 1 HAMMADDE KABUL

QC Date of Completion: 21/11/2006

Voucher date: 21/11/2006

Serial for Whouse Transfer Voucher: 0

Quality No	Department	Employee Co	Waybill No	Inventory Co	Accept Quar
50000001	D1	6	5000000000000036	001	100
50000002	D1	6	5000000000000037	001	100
50000019	d1	12	0000000000000232	00001	24250
50000020	D1	12	0000000000021312	00001	72750

QC No:                      W.H Slip No:

This section should be used for transferring the goods that are accepted as a result of the quality control operations to the acceptance warehouse with the Local Warehouse Transfer operation. Processing this operation will also generate Warehouse Transfer Slip in the Invoice Module.

**Resource Warehouse Code**

This is the code of the local warehouse which is indicated as the receive warehouse in the goods' purchase waybill. The issue operations of the goods will be processed from this warehouse in the warehouse transfers operation.

**QC Date of Completion**

This is the end date of the record, which is inserted during the quality control record process. The warehouse transfer voucher will be created for the quality control records before this date.

**Voucher Date**

This is the date on the voucher of the local warehouse transfers that will be processed.

After you enter the Resource Warehouse Code and the QC Date of Completion information, the programme will list the records that match the defined filters in the grid section. You can generate warehouse transfer vouchers for all or some of the records. To select the inventories that you wish to transfer, you should double click on the relevant entry in the grid section. The records that you select will be displayed in red. When you press the OK button, the programme will create the warehouse transfer vouchers for the selected records and display the number of the voucher.

If you have selected the Serial character option and the "Purchase Waybill" option in the Parameters section, at the end of the warehouse transfer

operation, an issue record will be created from the resource warehouse for the relevant series and a receive record will be created to the acceptance warehouse. However, after the transfer voucher to which the good is linked is deleted, you can insert a record and process modification or deletion operations.

### 3.2 Reject Quality Control Warehouse Transfer

Quality No	Department	Employee Co	Waybill No	Inventory Co	Refuse Quar
50000019	d1	12	000000000000232	00001	50000
50000020	D1	12	0000000000021312	00001	25000

This section will be used for transferring the goods that are rejected as a result of the quality control operations to the rejection warehouse and creating the relevant local warehouse transfer voucher. If desired, Return waybills can also be created in this section for the goods that will be returned.

#### Resource Warehouse Code

This is the code of the local warehouse which is indicated as the receive warehouse in the goods' purchase waybill. The issue operations of the goods will be processed from this warehouse in the warehouse transfers operation.

#### QC Date of Completion

This is the end date of the record, which is inserted during the quality control record process. The warehouse transfer voucher will be created for the quality control records before this date.

#### Voucher Date

This is the date on the voucher of the local warehouse transfers that will be processed.

After you enter the Resource Warehouse Code and the QC Date of Completion information, the programme will list the records that match the defined filters in the grid section. You can generate warehouse transfer vouchers for all or some of the records. To select the inventories that you wish to transfer, you should double click on the relevant entry in the grid section. The records that you select will be displayed in red. When you press the OK button, the programme will create the warehouse transfer vouchers for the selected records and display the number of the voucher.

If you have selected the Serial character option and the "Purchase Waybill" option in the Parameters section, at the end of the warehouse transfer operation, an issue record will be created from the resource warehouse for the relevant series and a receive record will be created to the acceptance warehouse. However, after the transfer voucher to which the good is linked is deleted, you can insert a record and process modification or deletion operations.

#### **Move Inventory to Rejection Warehouse**

You should select this parameter to transfer the rejected inventories to the rejection warehouse that is defined in the "Quality Department Records" section.

#### **Generate Return Waybill**

This parameter is for creating the return waybill in order to be able to return the rejected inventories to the related supplier.

If you have selected the Serial character option and the "Purchase Waybill" option in the Parameters section, at the end of the warehouse transfer operation, an issue record will be created from the resource warehouse for the relevant series and a receive record will be created to the rejection warehouse. Quality control records for which the warehouse transfer vouchers have been created cannot be modified or deleted. However, after the transfer voucher to which the good is linked is deleted, you can insert a record and process modification or deletion operations.

### **3.3 Scrap Quality Control Warehouse Transfer**

**Quality Control Warehouse Transfer**

Resource Whouse Co: 1 HAMMADDE KABUL

QC Date of Completion: 21/11/2006

Voucher date: 21/11/2006

Serial for Whouse Transfer Voucher: 0

Quality No	Department	Employee Co	Waybill No	Inventory Co	Scrap Quanti
50000019	d1	12	000000000000232	00001	750
50000020	D1	12	000000000021312	00001	2250
50000021	d1	2	000000000000002	00001	500

QC No:                      W.H Slip No:

This section will be used for transferring the goods that will be scrapped as a result of the quality control operations to the scrap warehouse and creating the relevant local warehouse transfer voucher.

**Resource Warehouse Code**

This is the code of the local warehouse which is indicated as the receive warehouse in the goods' purchase waybill. The issue operations of the goods will be processed from this warehouse in the warehouse transfers operation.

**QC Date of Completion**

This is the end date of the record, which is inserted during the quality control record process. The warehouse transfer voucher will be created for the quality control records before this date.

**Voucher Date**

This is the date on the voucher of the local warehouse transfers that will be processed.

After you enter the Resource Warehouse Code and the QC Date of Completion information, the programme will list the records that match the defined filters in the grid section. You can generate warehouse transfer vouchers for all or some of the records. To select the inventories that you wish to transfer, you should double click on the relevant entry in the grid section. The records that you select will be displayed in red. When you press the OK button, the programme will create the warehouse transfer vouchers for the selected records and display the number of the voucher.

If you have selected the Serial character option and the "Purchase Waybill" option in the Parameters section, at the end of the warehouse transfer operation, an issue record will be created from the resource warehouse for the relevant series and a receive record will be created to the acceptance warehouse. However, after the transfer voucher to which the good is linked is deleted, you can insert a record and process modification or deletion operations.

### 3.4 Generating Finished Ods Records

The screenshot shows a dialog box titled "Generating Finished Ods Records". It contains the following fields and options:

- Text: "Tokens are made one by one based on work order"
- Field: "Man.Ord. No Interval" (empty)
- Field: "End Date for Records of Quality Control" (29.11.2006)
- Field: "Record Date for Created Tokens" (29.11.2006)
- Field: "Token No Serial" (K)
- Checkbox: "Created Tokens are produced automatically" (unchecked)
- Section: "Balance"
  - Radio button: "Current Warehouse" (selected)
  - Radio button: "All Warehouse" (unchecked)
- Field: "Use from Inventory for Automatic Semiproductions" (checked)
- Buttons: "OK" and "Cancel"

This section is used for creating the finished ods records of the goods that are accepted or rejected as a result of the quality control records processed in the Production menu and, if desired, for reflecting the productions to the inventory transactions.

In the case that Loss application is used, the rejected products will be evaluated as loss in the finished ods records. The finished ods records will be generated individually on basis of the work orders entered in the Quality Control Records section.

**In order to create the Finished Ods records, you should,**

- Close the Quality Control record,
- The "Finished Goods Receipt Place" in the Inventory Planning Records menu of the inventory recorded in the Quality Control Record should be specified as Quality Control.

**Manufacture Order No Interval**

This is the section where you will select the work orders for the finished ods record that you will create.

**End Date for Quality Control Records**

The quality control records that are inserted before this date will be controlled. Finished ods records will be created for the records for which finished ods records are not created.

**Record Date for Created Tokens**

The date you insert in this field will be the date of the finished ods vouchers. The programme will automatically insert the current date and the system time.

**Token No Serial**

In this field you will specify the series of the finished ods record numbers.

**Created Token are Produced Automatically**

When you select this parameter the below described queries will be active. Additionally, when this parameter is selected, the finished ods records will be inserted in the inventory transactions of the finished ods records. Otherwise, in order to be able to create the generated finished ods records, you should retrieve these vouchers in the Production Module/Finished Ods Records section and insert the vouchers into the records.

**Balance (Current Warehouse /All Warehouses)**

When the production phases are defined on local warehouses bases and the local warehouses used in the production operation is specified in the Production Module, this parameter queries whether the onhand control should be run in the single warehouse where the production is made or in all of the local warehouses that are involved in the production operation.

If you select the all warehouses option, the system considers the material onhand quantities that exist in all of the warehouses that are defined in the Production parameters. In the current warehouse option, the system considers the onhand quantities that exist in the local warehouse where the production is made, as indicated in the Finished Ods Warehouse Code field.

**Use from Inventory for Automatic Semi products**

In the BoMs defined for the semi products in the Manufacture Bill of Materials section, the "Auto Production" parameter is selected to enable the automatic production of the semi products in the production of the products in which these semi products are used. In this case, the system automatically produces the related semi products during the production of the products. In this kind of a production operation, the system does not consider whether or not there is sufficient inventory onhand of the semi product required for the production, assuming there are no onhands, produces the semi product in the quantities required for production. Thus, this parameter can be used in the Finished Ods Records.

When you select this parameter, the system will check the inventory onhands of the semi products and not produce the semi product if sufficient onhand for the production exists. The system will produce the required semi product if the onhand quantity of the related semi product is not sufficient for production.

## 4. Reports

### 4.1 Quality Activity Report

Quality Activity Report

General Restrictions | Filter | Sort | Scaling | Printer Options

Date Interval: 01/01/2006 | 31/12/2006

QC Number Inter: | |

Report | Read | Save | Help | Cancel

The Quality Activity Report will enable you to list your quality control records by defining a specific date and quality control interval.

For detailed information about the fields in the Filter, Sort, Scaling and Printer Options pages and general information on how to use the report, please see Introduction/Standard Reports.

Quality Activity Report

Measure No	Worker	QC Date	Control Quantity	Accept/Refuse Quantity	Accept/Refuse	Serial No	Explanat
2		3 28.04.2006	5	50	R		
1		3 28.04.2006	5	50	K		
2		2 28.04.2006	5	50	R		
1		2 28.04.2006	5	50	K		

Completed. - Time 00:00:01

## 4.2 Clerk Performance Report

**Clerk Performance Report**

General Restrictions | **Quality Restrictions** | Filter | Scaling | Printer Options

Date Interval: 01/01/2006 to 31/12/2006

Undetailed  Detailed

Include Branch Trans.   
 Project Code Subtotal   
 Project Code Interval: [ ] [ ]

Report | Read | Save | Help | Cancel

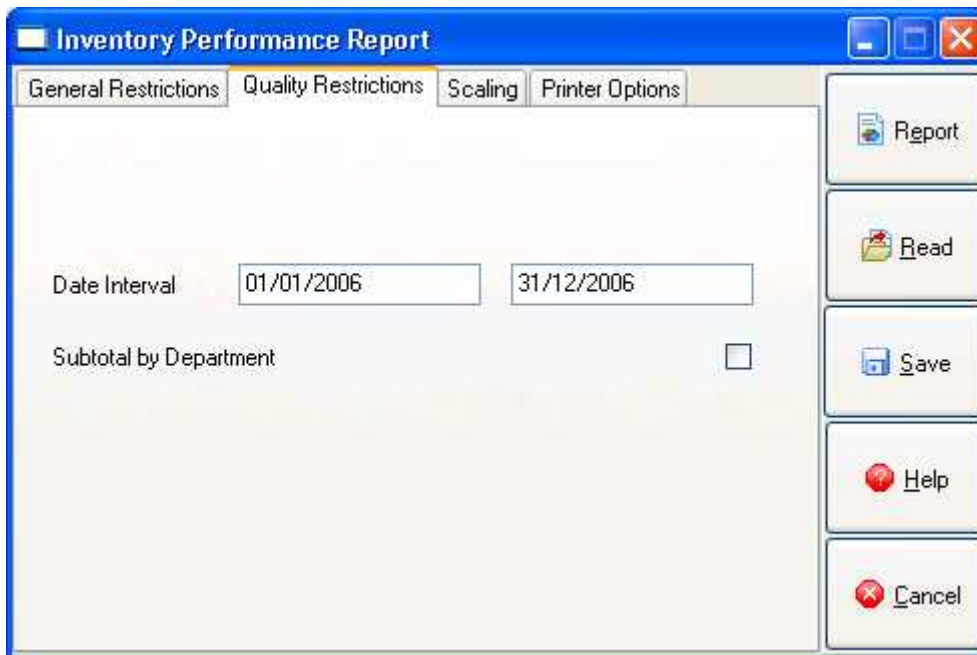
This is the report in which you can monitor your suppliers' performances within a specific date interval, with or without details as necessary. The report will list the total receive quantities purchased from the related supplier, the relevant accept and reject quantities and their ratios.

For detailed information about the fields in the Filter, Sort, Scaling and Printer Options pages and general information on how to use the report, please see Introduction/Standard Reports.

	A	B	C	D	E	F	G
1	Curr.Acc.Code	Inventory Code	Total Quality Warehouse Entrance	Total Acceptance	Total Refuse	Accept Ratio (%)	Refuse Ratio (%)
2	00001	00001	210,000	101,500	80,000	48.33	38.1
3			210,000	101,500	80,000	48.33	38
4							
5							

Completed. - Time 00:00:00

## 4.3 Inventory Performance Report



This is the report with which you can monitor the performance of your inventory within a specific date interval. The report will list the total receive quantities of the related inventories, their accept and reject quantities and their ratios.

For detailed information about the fields in the Filter, Sort, Scaling and Printer Options pages and general information on how to use the report, please see [Introduction/Standard Reports](#).

	A	B	C	D	E	F
	Inventory Code	Total Quality Warehouse Entrance	Total Acceptance	Total Refuse	Accept Ratio (%)	Refuse Ratio (%)
2	00001	210,000	101,500	80,000	48.33	38.1
3	M11	300	200	100	66.67	33.33
4						
5						
6						

#### 4.4 Work Order-Quality-Manufacture Report

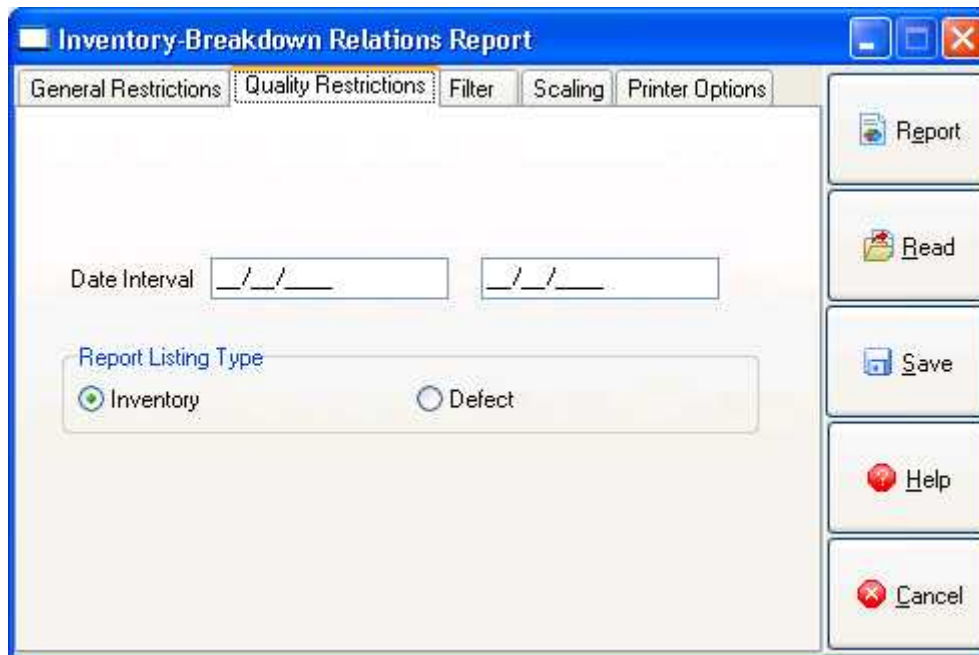
With this report you can list your Quality Control records related to Production by defining a specific date interval and work order number range, either according to the work orders or the inventories.

For detailed information about the fields in the Filter, Sort, Scaling and Printer Options pages and general information on how to use the report, please see Introduction/Standard Reports.

	A	B	C	D	E	F	G
	Work Order Code	Inventory Code	Work Order Quan	Quality Control Accept	Quality Control Refuse	Qu:Produced	Quantity Accepted
1							
2	000000000000021	M11	20	50	50	100	100
3	000000000000022	M11	80	50	50	100	100
4	s000000000000001	M11	100		100	0	100
5							

This report will list the work order quantities, the quality control accept quantities and reject quantities related to the work orders, produced quantity, accepted quantity and remainder quantity on basis of inventories. The Accepted Quantity field displays the total of the accept/reject quantities recorded in the "Transaction/Measurement Data" page in the related quality control records.

## 4.5 Inventory-Breakdown Relations Report



This report provides you the list of the breakdown cases, which you entered for the rejected samples in the quality control records, for a specific date interval. The report will also list the breakdown repeat count either on inventory basis or breakdown basis, as desired.

[For detailed information about the fields in the Filter, Sort, Scaling and Printer Options pages and general information on how to use the report, please see Introduction/Standard Reports.](#)