

KnowledgeBase Article 2053

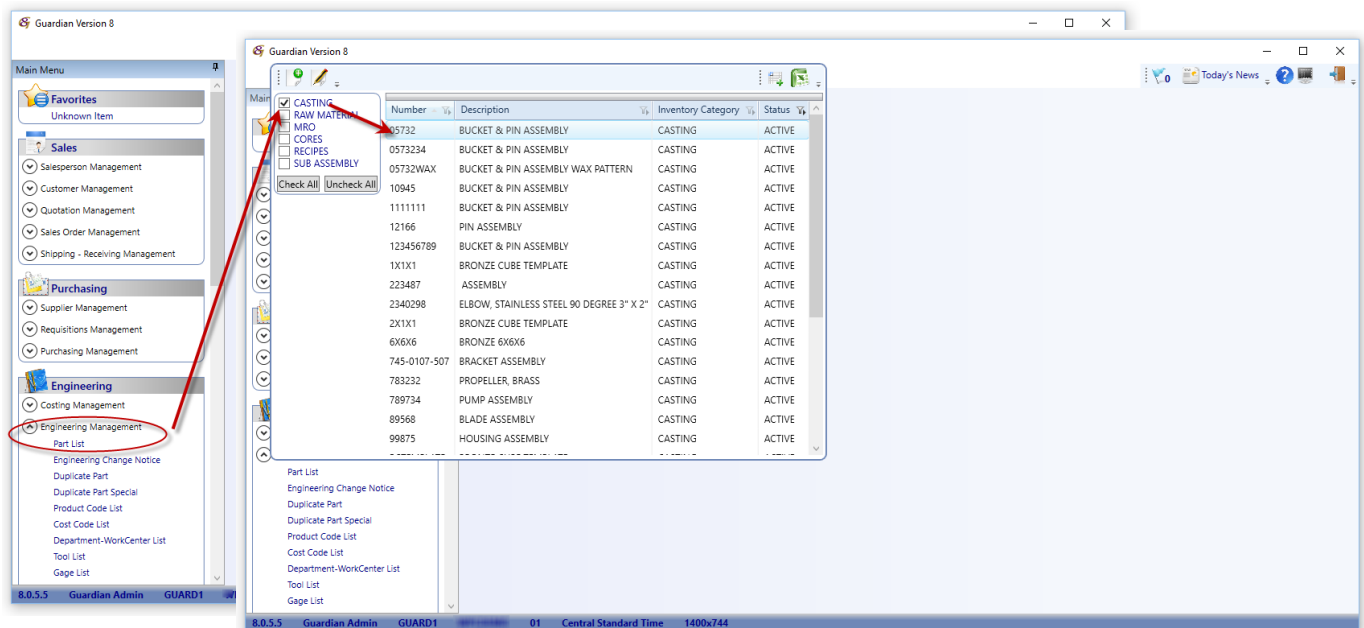
Quality Master

The Quality Master is a powerful tool forcing quality checks of various types upon the MES Touch user while performing their duties in the manufacturing process. Quality attributes may be "Qualitative", requiring pass / fail information, or "Quantitative", requiring specific readings and measurements. Quality checks can be forced upon a certain percentage of the pieces completed or a very specific number of pieces, (IE every piece, or every tenth piece, etc.) When the user reaches the quantity specified, the MES system will not permit further entry of parts until the user completes the required quality check.

Setup of the Quality Master is dependent upon complete part information. In addition, the Quality Master is assigned to a specific routing sequence. The Quality Master may be assigned to any or as many routing sequences as required. Further, multiple quality masters may be assigned to any given sequence.

To create a Quality Master:

1. Navigate to Engineering Management > Part List and select (double-click) the part desired



2. Open the Routing and select (double-click) the routing sequence desired

Guardian Version 8

Main Menu

- Favorites
 - Unknown Item
- Sales
 - Salesperson Management
 - Customer Management
 - Quotation Management
 - Sales Order Management
 - Shipping - Receiving Management
- Purchasing
 - Supplier Management
 - Requisitions Management
 - Purchasing Management
- Engineering
 - Costing Management
 - Engineering Management
 - Part List
 - Engineering Change Notice
 - Duplicate Part
 - Duplicate Part Special
 - Product Code List
 - Cost Code List
 - Department-WorkCenter List
 - Tool List
 - Gage List

Casting 05732

Number 05732 Alloy M00967: METAL-A356.2 -ALUMINUM

Description BUCKET & PIN ASSEMBLY

Replaced By

Inventory Category CASTING

Change Enabled

Status Active

Weight 6.74320

Cost

Lot Size 100

Source MANUFACTURED

Surcharge Weight 11.00000

Product Code AEROSPACE

Pattern/Die BUCKET & PIN ASSEMBLY

Unit Of Measure EACH

Pieces Per Mold 2

Planner ENGINEER

Engineer ENGINEER

Specification ALUMINUM 356.2 Certification

Drawing 05732 Revision D Date 10/31/2012

Process Rev.

Sample Date Select a date

Supplemental Rev.

Analysis Codes

USER FIELD 1 1234567890123 USER FIELD 2 1234567890123 USER FIELD 3 1234567890123 USER FIELD 4 1234567890123

Requires

- ☐ SDS
- ☐ Approved Suppliers
- ☐ Heat
- ☐ Serial Number
- ☐ Last Serial Number Used 16265

Test Bars

Export Controlled

Routing

Sequence	Type	Cost Code	Description	Outside Cost	Supplier Number	Skip Audit	Alternate	Overlap	Crew	Studied Date	No Print	Work Center	Operation C
0001	Inside	0100	INJECTION			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	1	10/31/2012	<input type="checkbox"/>	0105	0030
0200	Inside	0120	ASSEMBLY			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	1	11/01/2012	<input type="checkbox"/>	0150A	0120

Full Access

8.0.5.5 Guardian Admin GUARD1 01 Central Standard Time 1400x744

3. Open the Quality Master and click the "Add New" button to create a new Quality Master for this routing sequence.

Guardian Version 8

Main Menu

- Favorites
 - Unknown Item
- Sales
 - Salesperson Management
 - Customer Management
 - Quotation Management
 - Sales Order Management
 - Shipping - Receiving Management
- Purchasing
 - Supplier Management
 - Requisitions Management
 - Purchasing Management
- Engineering
 - Costing Management
 - Engineering Management
 - Part List
 - Engineering Change Notice
 - Duplicate Part
 - Duplicate Part Special
 - Product Code List
 - Cost Code List
 - Department-WorkCenter List
 - Tool List
 - Gage List

Casting 05732

Routing

Sequence 0700 Type Inside Description POUR

Work Center POUR REGULAR Department POURING DEPARTMENT

Operation Code

Minutes Per Piece 4.28502 Setup Hours 0.000

Cost Code POUR

Crew Size 1 Lead Time 0

Pattern/Die/Corebox

Drawing Number Drawing Revision Revision Date Select a date

☐ Overlap Prior Sequence ☐ Alternate Sequence ☐ Skip Audit ☐ Rework Operation ☐ Cost Only ☐ No Print

Sequence Standard

☐ Estimated ☒ Studied Studied Date 11/1/2012

Revision

Revision 3 Revision Date 12/21/2015

Tools

Specifications

Gages

Process Instructions





Narrative

Quality Master

Image Maintenance

Full Access

8.0.5.5 Guardian Admin GUARD1 01 Central Standard Time 1400x744

- 




Quality

Number

Name

Type

Status

Check Percent Or Check every of pieces

Revision ECN Number Date

Replaced By

Specification

Added By Date Added Changed By Date Changed

Invalid Entry File Not Saved Full Access

-
- Quality**
- Name Number
- Type **Qualitative** Status
- Check Percent Or Check every of pieces
- Revision ECN Number Date
- Replaced By
- Specification
- Added By Date Added Changed By Date Changed
- Invalid Entry File Not Saved Full Access

6. If the Quality check is "Quantitative", select the Type and complete the Minimum, Alert Minimum, Target, Alert Maximum and Maximum fields.
 - a. The system can calculate the Target value automatically by checking the "Calculate Target" checkbox, however, the Minimum and Maximum must be entered first.

The screenshot shows the 'Quality' configuration window. The 'Type' is set to 'Quantitative'. The 'Status' is set to 'Alert'. The 'Minimum', 'Alert Minimum', 'Target', 'Alert Maximum', and 'Maximum' fields are all set to '0.00000'. The 'Calculate Target' checkbox is checked. The 'Check Percent' is set to '0' and 'Check every' is set to '0'. The 'Revision', 'ECN Number', 'Date', 'Replaced By', and 'Specification' fields are also present. The bottom status bar shows 'Invalid Entry', 'File Not Saved', and 'Full Access'.

7. Complete the "Check Percent" or "Check every _ of _ pieces". Save.