

เอกสารอ้างอิง

ภาษาไทย

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ภาคผนวก ก

ตัวอย่างรายงานการประมวลผลการวางแผนการผลิต

ศูนย์วิทยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย

PS REPORT : ITEM MASTER. AT December 6, 1991 -10:22:30
 CONSTRAINTS : ITEM NUMBER : A TO Z

ITEM NUMBER	ITEM DESCRIPTION	U/M	ITEM-TYPE	FL	DR-F	S-FAC	MAXOR-QTY	MINOR-QTY	MULOR-QTY	FEQ-IS-QTY	AVG-USE-QTY	ONHAND-QTY	ALLOC-QTY	ORDER-QTY	W.I.P-QTY	RUN-OUT	STD-COST	PUR-PRICE	VENDOR	ID	WDATE
0	ผ้าดิบ T/Cเนื้อท100%	YD	RAW MATERIAL	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	290.0	0.0	-200.0	*****	0.00	0.00	NK	MPS	24/12/1991
0-C/1	BURN OUT COLOR PASS KE	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	21/08/1991
0-C/2	BURN OUT COLOR PASS JIGGER	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	21/08/1991
0-CL-JG	100% สี เครื่องผ่านจิกเกอร์	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	31/10/1991
0-CL-KE	100% สี เครื่องผ่านหม้อต้ม	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	26/11/1991
0-CL-LB	ผ้าT/C100% สี เครื่องผ่านL-BOX	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	31/10/1991
0-CL-OUT	ผ้าT/C100% สี จ้างเครื่องภายนอก	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	31/10/1991
0-W/1	BURN OUT WHITE PASS KE	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	03/08/1991
0-W/2	BURN OUT WHITE PASS JIGGER	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	31/10/1991
0-WH-JG	100% ขาว เครื่องผ่านจิกเกอร์	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	09/12/1991
0-WH-KE	100% ขาว เครื่องผ่านหม้อต้ม	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	24/12/1991
0-WH-LB	ผ้าT/C100% ขาว เครื่องผ่านL-BOX	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	31/10/1991
0-WH-OUT	ผ้าT/C100% ขาว จ้างเครื่องภายนอก	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	27/12/1991
1-13	HYDROGEN	KG	PURCHASED	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	06/12/1991
1-23	SOD. SILIGATE	KG	PURCHASED	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	27/12/1991
1-27	SANDOPAN DTC	KG	PURCHASED	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	6.9	0.0	*****	0.00	0.00	NK	MPS	06/12/1991
2-15	LEONIL EB-LU	KG	PURCHASED	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	6.9	0.0	*****	0.00	0.00	NK	MPS	06/12/1991
2-17	MARCUPAN HK	KG	PURCHASED	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	17.4	0.0	*****	0.00	0.00	NK	MPS	06/12/1991
4-07	PALANIL WHITE R	KG	PURCHASED	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	31/10/1991
0Y	ผ้าดิบสำหรับย้อม	YD	RAW MATERIAL	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	31/10/1991
0Y-CP/1	COTTON RAYON DYEING BY CO-PAD	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	23/07/1991
0Y-CP/2	T/C RAYON DYEING BY CO-PAD	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	21/08/1991
0Y-CP/3	RAYON DYEING BY CO-PAD	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	31/10/1991
0Y-CT-CP	ย้อมผ้าCOTTON โผCO-PAD	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00		MPS	31/10/1991
0Y-CT-JG	ย้อมผ้าCOTTON โผจิกเกอร์	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	21/08/1991
0Y-JG/1	COTTON DYEING BY JIGGER	YD	ASSEMBLY	Y		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	06/08/1991
0Y-JG/2	T/C DYEING BY JIGGER	YD	ASSEMBLY	N		1.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	*****	0.00	0.00	NK	MPS	06/08/1991

ตัวอย่างรายงานรายละเอียดของวัสดุ

MPS REPORT : ITEM ROUTING MASTER. AT December 6, 1991 -11:04:51

PAGE 1

CONSTRAINTS : ITEM NUMBER : ST-WH-KE TO ST-WH-LB / W/C GROUP : A TO A

END ITEM-NO	ITEM DESCRIPTION	W/C GROUP	MFG-TYPE	SEQ.	OPERATION	WORK CENTER	SETUP-TIME	STD-TIME	CUM-TIME	ID	MDATE
ST-WH-KE	สีรุ้ง ขาว เครื่องผ่านหม้อต้ม	A	Flow shop	0002	เขียนหัวผ้า	WH	300.0	60.0	60.0	MPS	31/10/1991
				0004	ต่อหัวผ้า	SW	300.0	60.0	120.0	MPS	31/10/1991
				0010	ทอขน กัดขนบึง	SI-1	600.0	60.0	180.0	MPS	21/01/1992
				0020	หมักขนบึง	AG-1	28800.0	1.0	181.0	MPS	31/10/1991
				0030	ล่อนผ้า (SCOURING)	KE-1	0.0	90.0	271.0	MPS	31/10/1991
				0040	ล้างผ้าจากหม้อล่อน	BL-1	300.0	40.0	311.0	MPS	21/01/1992
				0050	อบผ้าจากหม้อก่อนทอขาว	DR-1	300.0	100.0	411.0	MPS	21/01/1992
				0060	ทอขาว	RS-2	600.0	60.0	471.0	MPS	21/01/1992
				0070	กัดสลาย	PR-2	1800.0	100.0	571.0	MPS	21/01/1992
				0072	ล้างผ้าหลังจากกัดสลาย	BL-1	300.0	40.0	611.0	MPS	21/01/1992
				0080	หมักขาวและล้างน้ำสะอาด	WN-A	0.0	65.0	676.0	MPS	31/10/1991
				0090	อบผ้าหลังจากหมัก	DR-2	300.0	67.0	743.0	MPS	21/01/1992
				0100	ทอผ้าสำเร็จ	RS-1	600.0	100.0	843.0	MPS	21/01/1992
ST-WH-LB	สีรุ้ง ขาว เครื่องผ่านL-BOX	A	Flow shop	0002	เขียนหัวผ้า	WH	300.0	60.0	60.0	MPS	31/10/1991
				0004	ต่อหัวผ้า	SW	300.0	60.0	120.0	MPS	31/10/1991
				0010	ทอขน และกัดขนบึง	SI-1	300.0	60.0	180.0	MPS	21/01/1992
				0030	ล้าง และหมักผ้า (SCABL)	L-BOX	900.0	60.0	240.0	MPS	21/01/1992
				0060	ทอขาว	RS-2	900.0	60.0	300.0	MPS	21/01/1992
				0070	กัดสลาย	PR-2	1800.0	80.0	380.0	MPS	31/10/1991
				0072	ล้างผ้าจากเครื่องพิมพ์	BL-1	300.0	40.0	420.0	MPS	21/01/1992
				0080	หมักขาว และล้างน้ำสะอาด	WN-A	0.0	65.0	485.0	MPS	31/10/1991
				0090	อบผ้าจากโรงขึ้น	DR-2	600.0	67.0	552.0	MPS	21/01/1992
				0100	ทอผ้าสำเร็จ เร็ว	RS-1	900.0	100.0	652.0	MPS	21/01/1992

--END OF REPORT --

ตัวอย่างรายงานขั้นตอนการผลิต

DYEING CO.,LTD

MPS REPORT : WORK CENTER MASTER. AT December 6, 1991 -11:03:04

PAGE 1

CONSTRAINTS : WORK CENTER : A TO Z

WORK CENTER	WC-DESCRIPTION	DEPARTMENT	SHIFT	HRS/DAY	DAY/WEEK	ID	WDATE
AG-1	บ่อหมักก้นบึ้ง 1	PRE-1	2	8.0	6	MPS	31/10/1991
AG-2	บ่อหมัก 2	PRE-1	2	8.0	6	MPS	31/10/1991
BA-1	อบความร้อน 1	PRE-1	2	8.0	6	MPS	31/10/1991
BL-1	หมักโรค 1	PRE-1	2	8.0	6	MPS	31/10/1991
BL-2	หมักโรค 2	PRE-1	2	8.0	6	MPS	31/10/1991
BL-3	หมักโรค 3	PRE-1	2	8.0	6	MPS	31/10/1991
BL-4	หมักโรค 4	PRE-1	2	8.0	6	MPS	31/10/1991
BO-1	เครื่องสกัดโรค 1	PRE-1	2	8.0	6	MPS	31/10/1991
BOX	ถังหมักก้นบึ้ง	PRE-2	2	8.0	6	MPS	31/10/1991
CA-1	รีดมัน 1	FHS	2	8.0	6	MPS	31/10/1991
CA-2	รีดมัน 2	FHS	2	8.0	6	MPS	31/10/1991
CP-1	ข้อม CO-PAD 1	DYE	1	8.0	6	MPS	31/10/1991
CP-2	ข้อม CO-PAD 2	DYE	1	8.0	6	MPS	31/10/1991
CT-1	สลักน้ำ 1	PRE-1	2	8.0	6	MPS	31/10/1991
DE-1	ก้นบึ้ง 1	PRE-1	2	8.0	6	MPS	31/10/1991
DR-1	อบ 1	PRE-1	2	8.0	6	MPS	31/10/1991
DR-2	อบ 2	PRE-2	2	8.0	6	MPS	31/10/1991
DR-3	อบ 3	PRE-2	2	8.0	6	MPS	31/10/1991
IN-1	ตรวจผ้าดิบ 1	WH	1	8.0	6	MPS	31/10/1991
IR-1	ม้วนผลา 1	IY	2	8.0	6	MPS	31/10/1991
IR-2	ม้วนผลา 2	IY	2	8.0	6	MPS	31/10/1991
IR-3	ม้วนผลา 3	IY	2	8.0	6	MPS	31/10/1991
IY-1	ม้วนผลาแบบทอ 1	IY	2	8.0	6	MPS	31/10/1991
IY-2	ม้วนผลาแบบทอ 2	IY	2	8.0	6	MPS	31/10/1991
JG-1	จิกเกอร์ 1	DYE	2	8.0	6	MPS	31/10/1991
KE-1	หม้อต้ม 1	PRE-1	1	8.0	6	MPS	31/10/1991
KE-2	หม้อต้ม 2	PRE-1	1	8.0	6	MPS	31/10/1991
L-BOX	เครื่อง L-BOX	PRE-2	2	8.0	6	MPS	31/10/1991
ME-1	มอเตอร์เซอร์โรซ์	PRE-2	1	8.0	6	MPS	31/10/1991
PR-1	พิมพ์ 1	PRN	1	8.0	6	MPS	31/10/1991
PR-2	พิมพ์ 2	PRN	1	8.0	6	MPS	31/10/1991
PS-1	PAD STEAM NO#1	DYE	1	8.0	6	MPS	01/08/1991
RA-1	ชุดย้อม 1	PRE-2	2	8.0	6	MPS	31/10/1991
RA-2	ชุดย้อม 2	PRE-2	2	8.0	6	MPS	31/10/1991
RA-3	ชุดย้อม 3	PRE-2	2	8.0	6	MPS	31/10/1991
RA-4	ชุดย้อม 4	PRE-2	2	8.0	6	MPS	31/10/1991

ตัวอย่างรายงานข้อมูลสถานะการผลิต

MPS REPORT : ORDER MASTER. AT December 6, 1991 -10:28:12

CONSTRAINTS : ORDER NUMBER : A TO Z /ID : MPS

ORDER-NO	ORDER STATUS	ORDER DUE	PLAN START	MFG DUE	COMPT DATE	RELSE DATE	ITEM NUMBER	ITEM DESCRIPTION	ITEM-TYPE	U/M	ORDER-QTY	RECEIVED-QTY	ORDER-NOTE	RUN-OUT	CR-RATIO	ID	MDATE
AT26	RELEASED.	20/12/1991	29/11/1991	11/12/1991	/ /	02/12/1991	ST-CL-KE	จักร สี เครื่องทอผ้า	ASSEMBLY	YD	210.00	0.00	P578 TC144 จักร#547 3สี REM *****	1.15	MPS	02/12/1991	
DM10	RELEASED.	28/12/1991	13/12/1991	24/12/1991	/ /	06/12/1991	ST-WH-KE	จักร ขาว เครื่องทอผ้า	ASSEMBLY	YD	348.00	0.00	P554 47"TC186 จักร7810 REM *****	1.92	MPS	06/12/1991	
DV35	RELEASED.	13/12/1991	03/12/1991	12/12/1991	/ /	09/12/1991	BO-WH-KE	100% ขาว เครื่องทอผ้า	ASSEMBLY	YD	100.00	0.00	D1031 TC DOBBY#1,2 BO 3สี REM. *****	0.80	MPS	09/12/1991	
DV35/1	RELEASED.	13/12/1991	03/12/1991	12/12/1991	/ /	09/12/1991	BO-WH-KE	100% ขาว เครื่องทอผ้า	ASSEMBLY	YD	100.00	0.00	D1031 TC DOBBY#1,2 BO3สี REM. *****	0.80	MPS	09/12/1991	
DV36	RELEASED.	13/12/1991	03/12/1991	12/12/1991	/ /	09/12/1991	BO-WH-KE	100% ขาว เครื่องทอผ้า	ASSEMBLY	YD	40.02	0.00	D1064 TC DOBBY#1,2 BOขาว REM. *****	0.80	MPS	09/12/1991	
FL4	RELEASED.	20/12/1991	29/11/1991	11/12/1991	/ /	02/12/1991	ST-WH-KE	จักร ขาว เครื่องทอผ้า	ASSEMBLY	YD	500.00	0.00	P574 TC144จักรขาว 10810 *****	1.15	MPS	02/12/1991	
FL4/1	RELEASED.	18/12/1991	02/12/1991	13/12/1991	/ /	02/12/1991	ST-WH-KE	จักร ขาว เครื่องทอผ้า	ASSEMBLY	YD	500.00	0.00	P575 TC144 จักรขาว 10810 *****	1.08	MPS	02/12/1991	
GS50	RELEASED.	13/12/1991	03/12/1991	12/12/1991	/ /	09/12/1991	BO-WH-KE	100% ขาว เครื่องทอผ้า	ASSEMBLY	YD	50.00	0.00	D1066 TC152 หรือ100%ขาว REM. *****	0.80	MPS	09/12/1991	
NL95	BEING ENTER.	28/12/1991	14/12/1991	20/12/1991	/ /	/ /	BO-WH-LB	ผ้าT/C100% ขาว เครื่องทอผ้า-BOX	ASSEMBLY	YD	80.00	0.00	D1083 TC144 100%ขาว REMจริง *****	3.29	MPS	24/12/1991	
PON10	RELEASED.	13/12/1991	06/12/1991	09/12/1991	/ /	09/12/1991	ST-WH-KE	จักร ขาว เครื่องทอผ้า	ASSEMBLY	YD	28.01	0.00	P582 TC152ขาว จักรขาว#413 REM *****	2.00	MPS	09/12/1991	
ST18/1A	RELEASED.	18/12/1991	04/12/1991	12/12/1991	/ /	09/12/1991	ST-WH-KE	จักร ขาว เครื่องทอผ้า	ASSEMBLY	YD	280.00	0.00	P581 TC144 จักรขาว2081080691Y *****	1.44	MPS	09/12/1991	
ST18/1B	RELEASED.	18/12/1991	06/12/1991	16/12/1991	/ /	09/12/1991	ST-WH-KE	จักร ขาว เครื่องทอผ้า	ASSEMBLY	YD	400.00	0.00	P581 TC144จักรขาว 2081080691Y *****	1.18	MPS	09/12/1991	
ST18/1C	PLANNED	18/12/1991	09/12/1991	13/12/1991	/ /	/ /	ST-WH-LB	จักร ขาว เครื่องทอผ้า-BOX	ASSEMBLY	YD	120.00	0.00	P581 TC144 จักรขาว 20810 *****	2.60	MPS	09/12/1991	

---END OF REPORT ---

ศูนย์วิทยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย
ตัวอย่างรายงานรายละเอียดของใบสิ่งผลิต

MPS REPORT : INDENT BILL OF MATERIAL. AT December 6, 1991 -11:05:52

CONSTRAINTS : ITEM NUMBER : ST-WH-KE TO ST-WH-LB

END ITEM-NO	ITEM DESCRIPTION	ITEM-TYPE	BASE-QTY	U/M	LEVEL	ITEM NUMBER	ITEM DESCRIPTION	ITEM TYPE	QTY-IN-ASSY	U/M	UPDATE-DATE	ID
ST-WH-KE	ซีทรู ขาว เครื่องทำนพื่อคั้น	ASSEMBLY	1.0	YD	*1	C1-23	SOD. SILIGATE	PURCHASED	0.03	KG	27/12/1991	MPS
					*1	C2-15	LEONIL EB-LU	PURCHASED	0.02	KG	06/12/1991	MPS
					*1	C2-17	MARCUPAN HK	PURCHASED	0.02	KG	06/12/1991	MPS
					*1	C4-07	PALANIL WHITE R	PURCHASED	0.05	KG	27/12/1991	MPS
					*1	ST	ผ้าดิบ ซีทรู	RAW MATERIAL	1.00	YD	31/10/1991	MPS
ST-WH-LB	ซีทรู ขาว เครื่องทำนพื่อคั้น-BOX	ASSEMBLY	1.0	YD	*1	C1-23	SOD. SILIGATE	PURCHASED	0.03	KG	27/12/1991	MPS
					*1	C2-15	LEONIL EB-LU	PURCHASED	0.04	KG	27/12/1991	MPS
					*1	C2-17	MARCUPAN HK	PURCHASED	0.25	KG	27/12/1991	MPS
					*1	C4-07	PALANIL WHITE R	PURCHASED	0.05	KG	27/12/1991	MPS
					*1	ST	ผ้าดิบ ซีทรู	RAW MATERIAL	1.00	YD	27/12/1991	MPS

--END OF REPORT --

ตัวอย่างรายงานข้อมูลโครงสร้างผลิตภัณฑ์.

ศูนย์วิทยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย

WPS REPORT : SHOP ORDER SCHEDULE . AT December 6, 1991 -15:01:48
 CONSTRAINTS : ORDER NUMBER : DW10 TO DW10 / ID : WPS

ORDER-NO	ORDER STATUS	PLAN START	DUE DATE	COMPLT DATE	END ITEM-NO	ITEM DESCRIPTION	U/M	ORDER-QTY	RECEIVED-QTY	SEQ	ITEM NUMBER	WC	OPERATION	REQ-YDS	REQ-HRS	DATE	ID
DW10	BEING ENTER.	13/12/1991	28/12/1991	/ /	ST-WH-KE	ยีนู ขาว เดร้อน	YD	348.00	0.0	0010	ST-WH-KE	WH	เขียนหัวผ้า	348.00	5.9	13/12/1991	MPS
										0020	ST-WH-KE	SW	ค้อนหัวผ้า	348.00	5.9	13/12/1991	MPS
										0030	ST-WH-KE	SI-1	เขวชน ถักนึ่ง	348.00	6.0	14/12/1991	MPS
										0040	ST-WH-KE	AG-1	หมักนึ่ง	87.21	2.0	14/12/1991	MPS
										0050	ST-WH-KE	AG-1	หมักนึ่ง	260.79	6.1	16/12/1991	MPS
										0060	ST-WH-KE	KE-1	คั้นผ้า (SCOURING)	348.00	8.7	16/12/1991	MPS
										0070	ST-WH-KE	BL-1	ล้างผ้าจากหมักคั้น	348.00	4.0	17/12/1991	MPS
										0080	ST-WH-KE	DR-1	อบผ้าจากหมักก่อนล้าง	348.00	9.8	17/12/1991	MPS
										0090	ST-WH-KE	RS-2	ล้างขาว	134.07	2.3	17/12/1991	MPS
										0100	ST-WH-KE	RS-2	ล้างขาว	213.93	3.7	18/12/1991	MPS
										0110	ST-WH-KE	PR-2	ถักคลาย	273.75	8.0	19/12/1991	MPS
										0120	ST-WH-KE	PR-2	ถักคลาย	74.25	2.2	20/12/1991	MPS
										0130	ST-WH-KE	BL-1	ล้างผ้าหลังจากถักคลาย	348.00	4.0	20/12/1991	MPS
										0140	ST-WH-KE	WN-A	พอกขาวอะไหล่ผ้าสะอาด	104.18	1.9	20/12/1991	MPS
										0150	ST-WH-KE	WN-A	พอกขาวอะไหล่ผ้าสะอาด	243.82	4.4	21/12/1991	MPS
										0160	ST-WH-KE	DR-2	อบผ้าหลังจากพอก	348.00	6.6	23/12/1991	MPS
										0170	ST-WH-KE	RS-1	พม่าสำเร็จ	334.19	9.4	23/12/1991	MPS
										0180	ST-WH-KE	RS-1	พม่าสำเร็จ	13.81	0.4	24/12/1991	MPS

-----END OF REPORT -----

ตัวอย่างรายงานตารางการผลิตของแต่ละใบสั่ง

DYEING CO.,LTD

MPS REPORT : CAPACITY AVAILABILITY. AT December 6, 1991 -10:41:53

PAGE 1

CONSTRAINTS : WORK CENTER : JG-1 TO PR-2

WORK CENTER	WC DESCRIPTION	DATE	HRS/DAY	OVERTIME	ONHAND-HRS	ALLOC-HRS	AVAIL-HRS	SHORT-HRS	PLAN REQ-HRS
JG-1	จักรเย็บผ้า 1	07/12/1991	16.0	0.0	16.0	16.0	0.0	0.0	0.0
		09/12/1991	16.0	0.0	16.0	16.0	0.0	0.0	0.0
KE-1	หม้อต้ม 1	02/12/1991	8.0	0.0	8.0	5.3	2.7		0.0
		03/12/1991	8.0	0.0	8.0	6.5	1.5		0.0
		04/12/1991	8.0	0.0	8.0	6.3	1.7		0.0
		06/12/1991	8.0	0.0	8.0	7.3	0.7		0.0
		07/12/1991	8.0	0.0	8.0	7.0	1.0		0.0
		09/12/1991	8.0	0.0	8.0	10.0	0.0	2.0	0.0
		16/12/1991	8.0	0.0	8.0	8.7	0.0	0.7	0.0
KE-2	หม้อต้ม 2	03/12/1991	8.0	0.0	8.0	6.5	1.5		0.0
		04/12/1991	8.0	0.0	8.0	6.3	1.7		0.0
L-BOX	เครื่อง L-BOX	10/12/1991	16.0	0.0	16.0	0.0	16.0		1.9
PR-2	พิมพ์ 2	04/12/1991	8.0	0.0	8.0	5.2	2.8		0.0
		06/12/1991	8.0	0.0	8.0	1.1	6.9		0.0
		07/12/1991	8.0	0.0	8.0	11.6	0.0	3.6	0.0
		09/12/1991	8.0	0.0	8.0	6.0	2.0		0.0
		10/12/1991	8.0	0.0	8.0	12.7	0.0	4.7	0.0
		11/12/1991	8.0	0.0	8.0	0.0	8.0		3.2
		12/12/1991	8.0	0.0	8.0	6.0	2.0		0.0
		13/12/1991	8.0	0.0	8.0	6.0	2.0		0.0
		19/12/1991	8.0	0.0	8.0	8.0	0.0	0.0	0.0
		20/12/1991	8.0	0.0	8.0	2.2	5.8		0.0

-----END OF REPORT -----

ตัวอย่างรายงานความสามารถในการผลิต

DYEING CO.,LTD

[SCHEDULING] : WORK CENTER SCHEDULE. AT December 6, 1991 -11:20:52

PAGE 1

CONSTRAINTS : / WORK CENTER : AG-1 TO WN-B / FROM DATE : 10/12/1991 TO 24/12/1991

DEPARTMENT : DYE

WORK CENTER	WC DESCRIPTION	DATE	OPERATION	REQ-HRS	REQ-YDS	ITEM NUMBER	ORDER-NO	ORDER STATUS
UN-1	ชุด 1	10/12/1991	ต้มสี	16.0	70.00	ST-CL-KE	AT26	RELEASED.
WN-A	วันที่ ชุด 1	10/12/1991	ฟอกขาวและน้ำยาด่าง	1.8	100.00	BO-WH-KE	DV35	RELEASED.
		10/12/1991	ฟอกขาวและน้ำยาด่าง	1.8	100.00	BO-WH-KE	DV35/1	RELEASED.
		10/12/1991	ฟอกขาวและน้ำยาด่าง	0.7	40.02	BO-WH-KE	DV36	RELEASED.
		10/12/1991	ฟอกขาวและน้ำยาด่าง	0.9	50.00	BO-WH-KE	GS50	RELEASED.
		11/12/1991	ฟอกขาวและน้ำยาด่าง	9.0	500.00	ST-WH-KE	PL4/1	RELEASED.
		11/12/1991	ฟอกขาวและน้ำยาด่าง	5.1	280.00	ST-WH-KE	ST18/1A	RELEASED.
		13/12/1991	ฟอกขาวและน้ำยาด่าง	3.5	200.00	ST-WH-KE	ST18/1B	RELEASED.
		14/12/1991	ฟอกขาวและน้ำยาด่าง	3.5	200.00	ST-WH-KE	ST18/1B	RELEASED.
		20/12/1991	ฟอกขาวและน้ำยาด่าง	1.9	104.18	ST-WH-KE	DM10	RELEASED.
		21/12/1991	ฟอกขาวและน้ำยาด่าง	4.4	243.82	ST-WH-KE	DM10	RELEASED.

-----END OF REPORT -----

ตัวอย่างรายงานตารางการผลิตของแต่ละสถานีงาน

DYEING CO.,LTD

PAGE 1

MPS REPORT : SHOP CALENDAR. AT December 6, 1991 -10:20:07

[J O B O R D E R]

ORDER NUMBER : DW10 ORDER NOTE : P554 47*TC186 จีทูวาย เร็ม DUE DATE : 28/12/1991 PLAN START DATE : 13/12/1991
 ITEM NUMBER : ST-WH-KE DESCRIPTION : จีทูวาย เครื่องทำหม้อต้ม ORDER-QTY : 348.00 YD

ITEM NUMBER	WC	DEPARTMENT	SEQ-NO	OPERATION	REQ-YDS	REQ-HRS	SHOP-DATE	REMARK
ST-WH-KE	WH	FHS	0010	เขียนผ้าดำ	348.00	5.90	13/12/1991	
ST-WH-KE	SW	FHS	0020	ล่อนผ้าดำ	348.00	5.90	13/12/1991	
ST-WH-KE	S1-1	FHS	0030	เพาจน ถักนึ่ง	348.00	6.00	14/12/1991	
ST-WH-KE	AG-1	FHS	0040	หมักนึ่ง	87.21	2.00	14/12/1991	
ST-WH-KE	AG-1	FHS	0050	หมักนึ่ง	260.79	6.10	16/12/1991	
ST-WH-KE	KE-1	FHS	0060	คั้นผ้า (SCOURING)	348.00	8.70	16/12/1991	
ST-WH-KE	BL-1	FHS	0070	ล้างผ้าจากหม้อต้ม	348.00	4.00	17/12/1991	
ST-WH-KE	DR-1	FHS	0080	อบผ้าจากบ่อก่อนทอขาว	348.00	9.80	17/12/1991	
ST-WH-KE	RS-2	FHS	0090	ทอขาว	134.07	2.30	17/12/1991	
ST-WH-KE	RS-2	FHS	0100	ทอขาว	213.93	3.70	18/12/1991	
ST-WH-KE	PR-2	FHS	0110	ถักด้าย	273.75	8.00	19/12/1991	
ST-WH-KE	PR-2	FHS	0120	ถักด้าย	74.25	2.20	20/12/1991	
ST-WH-KE	BL-1	FHS	0130	ล้างผ้าหลังจากถักด้าย	348.00	4.00	20/12/1991	
ST-WH-KE	WN-A	FHS	0140	พอกขาวและล้างผ้าสะอาด	104.18	1.90	20/12/1991	
ST-WH-KE	WN-A	FHS	0150	พอกขาวและล้างผ้าสะอาด	243.82	4.40	21/12/1991	
ST-WH-KE	DR-2	FHS	0160	อบผ้าหลังจากพอก	348.00	6.60	23/12/1991	
ST-WH-KE	RS-1	FHS	0170	ทอผ้าสำเร็จ	334.19	9.40	23/12/1991	
ST-WH-KE	RS-1	FHS	0180	ทอผ้าสำเร็จ	13.81	0.40	24/12/1991	

-----END OF ORDER -----

ตัวอย่างรายงานใบสั่งงานการผลิต

DYEING CO.,LTD

PAGE 1

MPS REPORT : MATERIAL ORDER REQUIREMENT. AT December 6, 1991 -10:29:50
CONSTRAINTS : ORDER NUMBER : DM10 TO DM10 / ID : MPS

ORDER-NO	ORDER STATUS	PLAN START DATE	DUE DATE	COMPLT DATE	END	ITEM-NO	ITEM DESCRIPTION	U/M	ORDER-QTY	RECEIVED-QTY	ITEM NUMBER	ITEM DESCRIPTION	ITEM-TYPE	U/M	DUE DATE	REQUI-QTY	ISSUE-QTY	SCRAP-QTY	ID
DM10	RELEASED.	13/12/1991	28/12/1991	/ /		ST-WH-KE	สีทอขาว เครื่อง YD		348.00	0.0	C1-23	SOD. SILIGATE	PURCHASED	KG	12/12/1991	10.4	0.0	0.0	MPS
											C2-15	LEONIL EB-LU	PURCHASED	KG	12/12/1991	6.9	0.0	0.0	MPS
											C2-17	MARCUPAN HK	PURCHASED	KG	12/12/1991	6.9	0.0	0.0	MPS
											C4-07	PALANIL WHITE R	PURCHASED	KG	12/12/1991	17.4	0.0	0.0	MPS
											ST	ผ้าดิบ สีทอ	RAW MATERIAL	YD	12/12/1991	348.0	0.0	0.0	MPS

-----END OF REPORT -----

ศูนย์วิจัยและพัฒนาการ
ตัวอย่างรายงานความต้องการวัสดุในการผลิต
จุฬาลงกรณ์มหาวิทยาลัย

MPS REPORT : ORDER/REQUIRE FOR ITEM. AT December 6, 1991 -10:37:04

CONSTRAINTS : ITEM NUMBER : ST-WH-JG TO ST-WH-OT

ITEM NUMBER	ITEM DESCRIPTION	U/M	ORDER-QTY	ALLOC-QTY	W.I.P-QTY	FL	ORDR DUE DATE	ORDER-MO	ORDER-STATUS	PLAN-START	DUE DATE	ORDER-QTY	RECEIVE-QTY	REQUI-QTY	ISSUE-QTY	SCRAP-QTY	ID
ST-WH-KE	จักร ๖๖ เครื่องทอผ้า	YD	2056.0	0.0	0.0	N	13/12/1991	PON10	RELEASED.	06/12/1991	13/12/1991	28.01	0.00	0.00	0.00	0.00	MPS
							18/12/1991	FL4/1	RELEASED.	02/12/1991	18/12/1991	500.00	0.00	0.00	0.00	0.00	MPS
							18/12/1991	ST18/1A	RELEASED.	04/12/1991	18/12/1991	280.00	0.00	0.00	0.00	0.00	MPS
							18/12/1991	ST18/1B	RELEASED.	06/12/1991	18/12/1991	400.00	0.00	0.00	0.00	0.00	MPS
							20/12/1991	FL4	RELEASED.	29/11/1991	20/12/1991	500.00	0.00	0.00	0.00	0.00	MPS
							28/12/1991	DW10	RELEASED.	13/12/1991	28/12/1991	348.00	0.00	0.00	0.00	0.00	MPS
ST-WH-LB	จักร ๖๖ เครื่องทอผ้า-BOX	YD	0.0	0.0	0.0	N	18/12/1991	ST18/1C	PLANNED	09/12/1991	18/12/1991	120.00	0.00	0.00	0.00	0.00	MPS

--END OF REPORT--

ศูนย์วิทยพัทยากร
ตัวอย่างรายงานแสดงวัสดุที่ถูก ไปใช้กับใบสั่งผลิตต่าง ๆ
จุฬาลงกรณ์มหาวิทยาลัย

DYEING CO.,LTD

MPS REPORT : UNIT OF MEASURE. AT December 6, 1991 -11:09:36

PAGE 1

CONSTRAINTS : CODE NUMBER : A TO Z

UNIT CODE	UNIT DESCRIPTION
KG	KILOGRAM
LT	LITRE
YD	YARD

-----END OF REPORT --

ตัวอย่างรายงานหน่วยวัดของวัสดุในระบบ

DYEING CO.,LTD

MPS REPORT : PLANNER CODE. AT December 6, 1991 -11:16:15

PAGE 1

CONSTRAINTS : NONE.

PLANNER CODE	NAME
0001	PITIPONG
1234	SJ
6814	MON
PPC	CHATREE

-----END OF REPORT --

ตัวอย่างรายงานรหัสผู้ผลิตที่ใช้ระบบ

DYEING CO.,LTD

MPS REPORT : DEPARTMENT CODE. AT December 6, 1991 -11:16:57

PAGE 1

CONSTRAINTS : CODE NUMBER : A TO Z

DEPARTMENT	DEPARTMENT NAME
DYE	DYEING DEPARTMENT
FHS	RASIN FINISHING DEPT
IY	INSPECT YARD DEPT.
PRE-1	PREPARING NO#1
PRE-2	PREPARING NO#2
PRN	PRINTING DEPARTMENT
WH	WHAREHOUSE DEPT.

--END OF REPORT --

ตัวอย่างรายงานรหัสแผนกต่าง ๆ ในระบบ

DYEING CO.,LTD

MPS REPORT : HOLIDAYS. AT December 6, 1991 -11:17:58

PAGE 1

CONSTRAINTS : FROM DATE : 01/01/1991 TO 31/12/1991

DATE	HOLIDAY
12/04/1991	SONGKARN DAY
13/04/1991	SONGKARN DAY
14/04/1991	SONGKARN DAY
15/04/1991	SONGKARN DAY
01/05/1991	LABOR DAY
12/08/1991	QUEEN BIRTHDAY
24/08/1991	CHINESE DAY
23/10/1991	5TH KING OF THAILAND
05/12/1991	KING BIRTHDAY
31/12/1991	THE END OF YEAR

--END OF REPORT --

ตัวอย่างรายงานวันหยุดของโรงงาน

MPS REPORT : ACTUAL PRODUCTION DATA MASTER. AT December 6, 1991 -12:52:55

CONSTRAINTS : ORDER NUMBER: DM10 TO DM10

ORDER-NO	MARKT-NO	SEQN	OPERATION	WORK	CENT	ST-BEG	ST-END	OP-BEG	OP-END	T-TIME	WAIT	SHIFT	WORK-DATE	DEPARTMENT	SPEED	TMP&PRS	COLOR	PATTERN	TOTAL YARD	PROD. YARD	CH-NO	CH-WGT	REMARKS
DM10	P554	10	SI ฟ่านน้ำ	SI-2	0.00	0.00	9.00	13.35	4.35	0	A	11/12/1991	PRE		0.00	2.00		TC	34800.00	11456.00	0044	0.00	
		20	BOIL,BL,SC	L-BOX	0.00	0.00	8.00	16.00	8.00		A	11/12/1991	PRE-2		0.00	100.00		TC	34800.00	11598.00		0.00	
		30	SC	L-BOX	0.00	0.00	16.00	19.30	3.30		B	11/12/1991	PRE-2		90.00	0.00		TC	12000.00	8482.00	0035	0.00	
		40	SI	SI-2	0.00	0.00	17.30	22.10	4.40	0	B	12/12/1991	PRE-1		0.00	0.00		CT	23000.00	17621.00		0.00	
		50	DDR	DR-1	0.00	0.00	16.00	24.00	8.00	0	B	12/12/1991	PRE-1		180.00	67.00	WHITE		0.00	3190.00		0.00	
		60	PR	PR-1	8.00	8.30	8.30	9.30	1.30		A	17/12/1991	PR		400.00	25.00	BLACK	#564	34800.00	1720.00		0.00	
		70	RS	RS-1	0.00	0.00	10.05	11.55	1.50		A	17/12/1991	PR		50.00	170.00		TC	0.00	5068.00	0039	0.00	
		80	พิมพ์สี	PR-1	10.10	10.45	10.45	13.05	2.55		A	17/12/1991	PR		400.00	25.00	ดำ ม่วง	#568	34800.00	1730.00		0.00	
		90	พิมพ์สี	PR-1	10.10	10.45	10.45	13.05	2.55		A	17/12/1991	PR		400.00	25.00	ดำ เขียว	#569	34800.00	1730.00		0.00	
		100	พิมพ์สี	PR-1	0.00	0.00	13.10	14.05	0.55		A	17/12/1991	PR		400.00	25.00	ดำ ม่วง	#569	34800.00	1645.00		0.00	
		110	พิมพ์สี	PR-1	0.00	0.00	14.10	15.05	0.55		A	17/12/1991	PR		400.00	25.00	ดำ เทา	#569	34800.00	1690.00		0.00	
		120	JG	JG-1	0.00	0.00	16.00	24.00	8.00		B	17/12/1991	D		98.00	0.00	WHITE		0.00	1466.00	0009	16.16	
		130	RS	RS-2	0.00	0.00	16.50	17.40	0.50			17/12/1991	PR		50.00	170.00		CT	0.00	2645.00	0040	300.00	
		140	PR	PR-2	8.00	9.20	9.20	10.25	2.25	0	A	19/12/1991	PR		25.00	400.00	เขียว	#565	34800.00	1682.00		0.00	
		150	SI + OE	SI-2	0.00	0.00	10.40	11.00	0.20	0	A	19/12/1991	PRE2		0.00	5.00	TC		840.00	845.00		0.00	
		160	PR	PR-2	0.00	0.00	10.50	12.30	1.40	0	A	19/12/1991	PR		25.00	400.00	ฟ้า	#565	34800.00	1654.00		0.00	
		170	PR	PR-2	0.00	0.00	12.30	14.00	1.30	0	A	19/12/1991	PR		25.00	400.00	เทา	#565	34800.00	1660.00		0.00	
		180	DDR	DR-2	0.00	0.00	16.00	24.00	8.00	0	B	19/12/1991	PRE2		150.00	57.00	WHITE		0.00	8362.00		0.00	
		190	PR	PR-2	8.00	8.55	8.55	10.50	2.50	0	A	20/12/1991	PRE1		300.00	22.00	ม่วง,ดำ	#568	34800.00	1665.00		0.00	
		200	RS	RS-1	0.00	0.00	8.00	12.10	4.10		A	20/12/1991	PRE2		50.00	170.00		พิมพ์	0.00	7356.00	0042	450.00	
		210	PR	PR-2	0.00	0.00	10.55	12.50	1.55	0	A	20/12/1991	PRE1		300.00	22.00	เขียว,ดำ	#568	34800.00	1764.00		0.00	
		220	PR	PR-2	0.00	0.00	12.55	14.05	1.10	0	A	20/12/1991	PRE1		300.00	22.00	น้ำเงิน,ดำ	#568	34800.00	1656.00		0.00	

-----WAITING CODE: 1)FABRIC 2)CHEMICAL 3)MAN 4)CHEMICAL 5)MACHINE 6)CLEANING ----- END OF REPORT

ตัวอย่างรายงานแสดงกระบวนการผลิตจริง

DYEING CO.,LTD

MPS REPORT : ACTUAL PRODUCTION DATA MASTER. AT December 6, 1991 -12:30:03

CONSTRAINTS : ORDER NUMBER: AA8 TO HB68

ORDER-NO	MARKT-NO	SEQN	OPERATION	WORK	CENT	ST-BEG	ST-END	OP-BEG	OP-END	T-TIME	WAIT	SHIFT	WORK-DATE	DEPARTMENT	SPEED	TMP	PAPRS	COLOR	PATTERN	TOTAL YARD	PROD. YARD	CH-NO	CH-WGT	REMARKS
AA8	D911	20	RS	RS-2	0.00	0.00	18.58	19.30	0.32	6	B	11/12/1991	PR		50.00	160.00			CT	0.00	1400.00	0014	150.00	
AM3	P577	50	RS	RS-2	0.00	0.00	16.00	18.26	2.26	6	B	11/12/1991	PR		40.00	160.00			CT	8044.00	5931.00	0013	300.00	
AM4	P587	30	RS	RS-2	0.00	0.00	13.55	15.10	1.15	0	A	11/12/1991	PR		40.00	160.00			CT	2781.00	2554.00	0013	600.00	
AT25	P572	340	RS	RS-2	0.00	0.00	22.20	24.00	1.40	0	B	06/12/1991	D		80.00	180.00	WHITE	ST	0.00	7490.00	0086	1500.00		
AT26	P578	180	DDR	DR-1	0.00	0.00	9.20	10.00	0.40	0	A	12/12/1991	PRE-2		70.00	0.00	BLACK	ST	0.00	2720.00		0.00		
BGK5	P591	20	HS	RS-1	0.00	0.00	22.35	22.50	0.15		B	20/12/1991	PRE2		50.00	160.00	น้ำตา	TC	0.00	800.00		0.00		
BS57/1	D989	70	RS	RS-2	0.00	0.00	18.26	18.58	0.32	6	B	11/12/1991	PR		60.00	180.00	BLACK	TC	0.00	1087.00	0017	100.00		
BS64	D1062	70	RS	RS-2	0.00	0.00	10.36	10.51	0.15	0	A	20/12/1991	PRE1		50.00	160.00		CT	0.00	767.00	0050	1000.00		
BS65	D1069	110	RS	RS-2	0.00	0.00	20.30	21.15	0.45	0	B	20/12/1991	PRE1		50.00	160.00	เขียว	CT	0.00	1217.00	0055	500.00		
BS67	P1081	40	พนักใช้โครเชม	SI-2	0.00	0.00	9.30	13.30	4.00		A	20/12/1991	PRE		0.00	0.00		CT	0.00	8820.00		0.00	ใช้โครเชม 3 ชุด	
DM10	P554	220	PR	PR-2	0.00	0.00	12.55	14.05	1.10	0	A	20/12/1991	PRE1		300.00	22.00	น้ำเงิน,ดำ #568			34800.00	1656.00		0.00	
DM11	P490	40	RS	RS-2	0.00	0.00	17.50	18.45	0.55			17/12/1991	PR		45.00	160.00	BLACK	SPUN	0.00	2688.00	0041	450.00		
DM9	D480	20	RS	RS-1	0.00	0.00	17.55	18.45	0.50	0	B	02/12/1991	PR		40.00	170.00	RED	SPUN	0.00	2020.00	0075	900.00		
DV35	D1031	90	DDR	DR-1	0.00	0.00	11.00	12.30	1.30	0	A	12/12/1991	PRE-2		70.00	0.00	WHITE	BO	0.00	3540.00		0.00		
DV35/1	D1032	60	DDR	DR-1	0.00	0.00	10.10	11.00	0.50	0	A	12/12/1991	PRE-2		70.00	0.00	WHITE	BO	0.00	3625.00		0.00		
DV36	D1064	90	DDR	DR-1	0.00	0.00	12.30	13.25	0.55	0	A	12/12/1991	PRE-2		70.00	0.00	WHITE	BO	0.00	3885.00		0.00		
DV37	D1070	20	DDR	DR-2	0.00	0.00	22.10	22.15	0.05		B	11/12/1991	PRE-2		140.00	91.00	WHITE	BO	0.00	10.00		0.00		
FG12	D1050	140	CA	CA-1	0.00	0.00	8.00	16.00	8.00	0	A	09/12/1991	PRE		0.00	0.00	ขาว ดำ			1853.00	1853.00		0.00	
FG13	D1058	110	RS	RS-2	0.00	0.00	16.20	16.50	0.30			17/12/1991	PR		40.00	160.00		CT	0.00	1010.00		0.00		
FG21	ซ่อม	10	สังรีค สังพลา	CA-1	0.00	0.00	16.00	24.00	8.00		B	03/12/1991	PR		0.00	0.00	ดำ	CT	490.00	490.00		0.00		
FL4	P574	280	RS	RS-1	0.00	0.00	22.10	23.15	1.05		B	11/12/1991	PR		70.00	180.00	WHITE	ST	50000.00	3642.00	0020	1100.00		
FL4/1	P575	310	SC	KE-1	0.00	0.00	8.00	16.00	8.00	0	A	12/12/1991	PRE-1		0.00	0.00	WHITE	ST	0.00	2150.00		0.00	อ้างน้ำ 1 รบ	
FR25	P569	190	RS	RS-2	0.00	0.00	9.00	9.40	0.40		A	11/12/1991	PR		65.00	180.00	BLACK		0.00	2220.00	0012	200.00		
GD7	D1057	30	DRS	RS-2	0.00	0.00	12.15	14.20	2.05	0	A	09/12/1991	PRE		40.00	220.00	น้ำเงิน	CT	3384.00	3205.00	0001	800.00		
GS30/2	P525	190	DDR	DR-1	0.00	0.00	8.40	9.20	0.40	6	A	12/12/1991	PRE-2		70.00	0.00	BLACK	ST	0.00	2165.00		0.00		
GS50	D1066	40	SC	KE-1	0.00	0.00	8.00	16.00	8.00	0	A	12/12/1991	PRE-1		0.00	0.00	WHITE	BO	0.00	4649.00		0.00	อ้างน้ำ 2 รบ	
HB68	D1027	70	PAD	CP-1	0.00	0.00	13.50	14.10	0.20	6	A	20/12/1991	D		40.00	0.00	#3			610.00	0.00		0.00	

-----WAITING CODE: 1)FABRIC 2)CHEMICAL 3)MAN 4)CHEMICAL 5)MACHINE 6)CLEANING ----- END OF REPORT --

ตัวอย่างรายงานแสดงใบสั่งไประหว่างการผลิต

DYEING CO., LTD

MPS REPORT : ANALYSIS JOB ON WORK CENTER. AT December 6, 1991 -14:48:33
 CONSTRAINTS : WORK CENTER : BL-1 TO WN-B

WORK-CENT	ORDER-NO	MARKT-NO	SEQN	OPERATION	ST-BEG	ST-END	OP-BEG	OP-END	T-TIME	WAIT	SHIFT	WORK-DATE	DEPARTMENT	SPEED	TMP&PRS	COLOR	PATTERN	TOTAL YARD	PROD. YARD	CH-NO	CH-WGT	REMARKS
BL-1	ST18/1		230	SC	0.00	0.00	16.00	24.00	8.00	0	B	12/12/1991	PRE-1	0.00	0.00	WHITE	ST	0.00	12000.00		0.00	
CA-1	FG12	D1050	140	CA	0.00	0.00	8.00	16.00	8.00	0	A	09/12/1991	PRE	0.00	0.00	น้ำ ฟ้า		1853.00	1853.00		0.00	
	FG21	1.8M	10	สี.น้ำ.ฟ้า.น้ำ.ฟ้า	0.00	0.00	16.00	24.00	8.00		B	03/12/1991	PR	0.00	0.00	น้ำ	CT	490.00	490.00		0.00	
CP-1	HB68	D1027	70	PAD	0.00	0.00	13.50	14.10	0.20	6	A	20/12/1991	D	40.00	0.00	#3		610.00	0.00		0.00	
	PN69		30	PAD	0.00	0.00	14.50	15.30	0.40	6	A	20/12/1991	D	40.00	0.00	#1		2648.00	0.00		0.00	
DR-1	AT26	P578	180	DDR	0.00	0.00	9.20	10.00	0.40	0	A	12/12/1991	PRE-2	70.00	0.00	BLACK	ST	0.00	2720.00		0.00	
	DV35	D1031	90	DDR	0.00	0.00	11.00	12.30	1.30	0	A	12/12/1991	PRE-2	70.00	0.00	WHITE	BO	0.00	3540.00		0.00	
	DV35/1	D1032	60	DDR	0.00	0.00	10.10	11.00	0.50	0	A	12/12/1991	PRE-2	70.00	0.00	WHITE	BO	0.00	3625.00		0.00	
	DV36	D1064	90	DDR	0.00	0.00	12.30	13.25	0.55	0	A	12/12/1991	PRE-2	70.00	0.00	WHITE	BO	0.00	3885.00		0.00	
	GS30/2	P525	190	DDR	0.00	0.00	8.40	9.20	0.40	6	A	12/12/1991	PRE-2	70.00	0.00	BLACK	ST	0.00	2165.00		0.00	
DR-2	DV37,	D1070	20	DDR	0.00	0.00	22.10	22.15	0.05		B	11/12/1991	PRE-2	140.00	91.00	WHITE	BO	0.00	10.00		0.00	
	NL95	D1083	80	DDR	0.00	0.00	8.30	10.15	1.45		A	20/12/1991	PRE1	140.00	91.00	WHITE	BO	0.00	4725.00		0.00	
JG-1	HB70/1	P588	40	JG	0.00	0.00	16.00	24.00	8.00	0	B	20/12/1991	D	98.00	0.00	น้ำ.น้ำ.ฟ้า	ST	0.00	790.00	0021	9.00	
	HB71	D1073	240	JG	0.00	0.00	16.00	24.00	8.00	0	B	20/12/1991	D	98.00	0.00	CREAM	SPUN	0.00	1285.00	0022	10.00	
KE-1	FL4/1	P575	310	SC	0.00	0.00	8.00	16.00	8.00	0	A	12/12/1991	PRE-1	0.00	0.00	WHITE	ST	0.00	2150.00		0.00	น้ำ.น้ำ.ฟ้า 1 50M
	GS50	D1066	40	SC	0.00	0.00	8.00	16.00	8.00	0	A	12/12/1991	PRE-1	0.00	0.00	WHITE	BO	0.00	4649.00		0.00	น้ำ.น้ำ.ฟ้า 2 50M
L-BOX	NL90/1		40	BOIL,SC	0.00	0.00	16.00	24.00	8.00		B	20/12/1991	PRE2	74.00	0.00		น้ำ.น้ำ.ฟ้า	12290.00	4562.00		0.00	
	NL96		30	BL,SC	0.00	0.00	16.00	24.00	8.00		B	20/12/1991	PRE2	74.00	0.00	WHITE	CT	3443.00	3408.00		0.00	
	PN65		40	SC	0.00	0.00	16.00	24.00	8.00		B	17/12/1991	PRE-2	74.00	0.00	น้ำ.น้ำ.ฟ้า	CT	1800.00	1929.00		0.00	
ME-1	PN63		50	ME	0.00	0.00	13.00	15.15	2.15	0	A	12/12/1991	PRE-2	0.00	28.00		CT	0.00	6520.00		0.00	
PR-1	PN67	P568	40	PR	0.00	0.00	14.40	15.10	0.30		A	03/12/1991	PR	600.36	36.00	น้ำ.น้ำ.ฟ้า.น้ำ	#25	4031.00	1032.00		0.00	
	SKB14		60	PR	11.25	11.30	12.30	13.15	0.50		A	03/12/1991	PR	0.00	0.00	น้ำ.น้ำ.ฟ้า.น้ำ	#391	1981.00	2021.00		0.00	
	TR41	P573	10	PR	10.20	10.25	10.25	11.15	0.55		A	03/12/1991	PR	120.00	67.00	WHITE	#385	10900.00	3355.00		0.00	
PR-2	DM10	P554	220	PR	0.00	0.00	12.55	14.05	1.10	0	A	20/12/1991	PRE1	300.00	22.00	น้ำ.น้ำ.ฟ้า.น้ำ.ฟ้า	#568	34800.00	1656.00		0.00	
RA-1	I35	D1061	10	น้ำ.น้ำ.ฟ้า 1 น้ำ.น้ำ.ฟ้า	13.30	13.45	13.50	14.20	0.45		A	04/12/1991	PRE-2	0.00	0.00		Y/D	4.00	0.00		0.00	
RA-2	NL94		80	RA	0.00	0.00	13.30	14.35	1.05	0	A	19/12/1991	PRE-2	0.00	0.00	WHITE	น้ำ.น้ำ.ฟ้า	4600.00	0.00		0.00	

ตัวอย่างรายงานผลส่ง ไปสิ่งผลิตแยกตามสถานีงาน



ภาคผนวก ๗

โปรแกรมระบบควบคุมการผลิต

ศูนย์วิทยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย

โปรแกรมชุดที่ 1 การป้อนข้อมูล

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D:\MPS\PRG>type prd001.prg
SELE PRODUCTION
SET ORDER TO 1
set rela to wct INTO workmas
set rela to ord_no INTO ordermas
PRIVATE choice.fn,msg,y,start,fkeyuse,keychars,KEY
DIMENSION fn(4),msg(4)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F2 =Edit"
msg(2) = "Edit enter data."
fn(3) = "F3 =Finish"
msg(3) = "Confirm enter data."
fn(4) = "Esc =Cancel"
msg(4) = "Cancel enter data."
y = '09,19,29,41'
fkeyuse = 'F01,F02,F03,esc'
start = 3
PRIVATE PROGRAM,menuoption
*-----*
STORE 0 TO;
  mt_time,mst_sta,mp_yard,mch_wt,mtemp
STORE 0 TO;
  mst_end,mop_sta,mop_end,mt_yard
mspeed = 0
mord_no = SPACE(7)
mmkt_no = SPACE(7)
mshift = SPACE(1)
mst_code = SPACE(1)
mwct = SPACE(6)
mch_no = SPACE(6)
mopr = SPACE(20)
mremark = SPACE(30)
mdte = CTOD(' / / ')
mcolor = SPACE(10)
mprint = SPACE(10)
mdep = SPACE(10)
mseq = '0010'
*-----*
KEY = 0
CLEAR
ischange = .F.
DO WHILE .T.
  fkeys = 'FKEYS : F1 =Help Esc =Exit'
  PROGRAM = 'PRD001'
  menuoption = 'PRODUCTION DATA PROCESSING - ADD ACTUAL DATA'
  DO prompbar
  DO fkey_say WITH fkeys
  @ 5,1 SAY 'WORK CENTER :GET mwct PICTURE '@!'
  READ
  KEY = IIF(READ() >=256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    EXIT
  CASE KEY = helpkey
    DO syshelp WITH 'PRD001'
  CASE '' = TRIM(mwct)
    DO say_stat WITH 'WORK CENTER REQUIRED.'
  OTHER
    SELE workmas

```

```

IF .NOT. FOUND()
DO say_stat WITH 'WORK CENTER DOES NOT EXIST IN SYSTEM.'
ELSE
SET COLOR TO &promptatr
@ 5,17 SAY mwct
@ 5,30 SAY 'WC DESCRIPTION : '
@ 5,47 SAY workmas->wc_desc
SET COLOR TO &screenatr
fkeys = 'FKEYS : F1 =Help Esc =Cancel'
SEEK mwct
@ 6, 1 SAY "WORK DATE      :" GET mdte PICT "@E"
@ 6,30 SAY "SHIFT:" GET mshift PICT "@!"
@ 6.40 SAY "DEPT.:" GET mdep PICT "@!"
READ
DO DASH WITH 7
IF ' / / ' = DTOC(mdte)
DO say_stat WITH 'WORKING DATE REQUIRED.'
ENDIF
more = .T.
DO WHILE more
DO fkey_say WITH fkeys
@ 8, 1 SAY "ORDER NUMBER : " GET mord_no PICT "@!"
READ
KEY = IIF(READ() >=256,READ()-256,READ())
DO CASE
CASE KEY = escapekey
@ 8,0 CLEAR TO 20,79
more = .F.
CASE KEY = helpkey
DO syshelp WITH 'PRD001'
CASE ' ' = TRIM(mord_no)
DO say_stat WITH 'ORDER NUMBER REQUIRED.'
OTHER
* pitipong 02-05-1991
***
SELE ordermas
SEEK mord_no
***
IF .NOT. FOUND()
DO say_stat WITH 'ORDER NUMBER DOES NOT EXIST IN SYSTEM.'
***
ELSE
SET COLOR TO &promptatr
@ 8.18 SAY mord_no
@ 8.30 SAY "ORDER DESC:"
***
@ 8.42 SAY ordermas->note
SET COLOR TO &screenatr
SELE production
@ 10, 1 SAY "MARKET NO.:" GET mmkt_no PICT "@!"
@ 10,30 SAY "COLOR      :" GET mcolor PICT "@!"
@ 10,55 SAY "PATTERN   :" GET mprint PICT "@!"
@ 12, 1 SAY "TOTAL YARD:" GET mt_yard PICT "9999999.99"
@ 12,30 SAY "OPERATION:" GET mopr PICT "@!"
@ 14, 1 SAY "SPEED     :" GET mspeed PICT "999.99"
@ 14,21 SAY "YD/MIN"
@ 14,30 SAY "PRESS,TEMP:" GET mtemp PICT "999.99"
@ 14,55 SAY "WAITING-NO:" GET mst_code PICT "@!"
@ 16, 1 SAY "SET-UP BEG:" GET mst_sta PICT "99.99"
@ 16,19 SAY "END:"      GET mst_end PICT "99.99"
@ 16,30 SAY "OPTIME BEG:" GET mop_sta PICT "99.99"
@ 16,49 SAY "END:"      GET mop_end PICT "99.99"
@ 18, 1 SAY "PROD YARD :" GET mp_yard PICT "99999999.99"
@ 18,30 SAY "CHEM CODE  :" GET mch_no PICT "@!"
@ 18,55 SAY "CHEMWEIGHT:" GET mch_wt PICT "9999.99"
@ 20, 1 SAY "REMARKS   :" GET mremark PICT "@!"
READ
STORE 0 to mt1,mt2
IF mst_end < mst_sta

```



```

        mt1 = mst_end + 24.00
ELSE
        mt1 = mst_end
ENDIF
IF mop_end < mop_sta
        mt2 = mop_end + 24.00
ELSE
        mt2 = mop_end
ENDIF
v1 = (mt1 - int(mt1)) - (mst_sta - int(mst_sta))
IF v1 >= 0
        z1 = mt1 - mst_sta
ELSE
        z1 = INT(mt1) - INT(mst_sta) - 1 + v1 + 0.60
ENDIF
v2 = (mt2 - int(mt2)) - (mop_sta - int(mop_sta))
IF v2 >= 0
        z2 = mt2 - mop_sta
ELSE
        z2 = INT(mt2) - INT(mop_sta) - 1 + v2 + 0.60
ENDIF
z = z1 - INT(z1) + z2 - INT(z2)
IF z < 0.60
        z = z1 + z2
ELSE
        z = INT(z1) + INT(z2) + 1 + z - 0.60
ENDIF
mt_time = z
@ 20,55 SAY "TOTAL TIME: "
@ 20,68 SAY mt_time PICT '999.99'
@ 20,75 SAY "HRS"
KEY = IIF(READ() >= 256, READ() - 256, READ())
DO CASE
CASE KEY = escapekey
        @ 8,0 CLEAR TO 20,79
        more = .F.
CASE KEY = helpkey
        DO syshelp WITH 'PRD001'
CASE STR(KEY,1,0) $ '0145'
        LOOP
CASE 0 = mst_sta
        DO say_stat WITH 'SET-UP TIME START REQUIRED.'
CASE 0 = mst_end
        DO say_stat WITH 'SET-UP TIME END REQUIRED.'
CASE 0 = mop_sta
        DO say_stat WITH 'OPER. TIME START REQUIRED.'
CASE 0 = mop_end
        DO say_stat WITH 'OPER. TIME END REQUIRED.'
OTHER
        @ 22,0 CLEAR TO 22,79
        choice = 'H'
DO WHILE choice = 'H'
        keychars = 'HEF'+esckey
        choice = SPACE(1)
        DO barmenu WITH LEN(keychars), choice, keychars
        DO CASE
CASE choice = "H"
                DO syshelp WITH 'PRD001'
CASE choice $ "F"
                ischange = .T.
                ?? CHR(7)

```

*-----

```

APPEND Blank
REPL ord_no WITH mord_no
REPL mkt_no WITH mmkt_no
REPL dep WITH mdep

```

```

REPL wct          WITH mwct
REPL shift        WITH mshift
REPL dtc          WITH mdte
REPL opr          WITH mopr
REPL st_sta       WITH mst_sta
REPL st_end       WITH mst_end
REPL op_sta       WITH mop_sta
REPL op_end       WITH mop_end
REPL t_time       WITH mt_time
REPL t_yard       WITH mt_yard
REPL p_yard       WITH mp_yard
REPL temp         WITH mtemp
REPL st_code      WITH mst_code
REPL ch_no        WITH mch_no
REPL ch_wt        WITH mch_wt
REPL speed        WITH mspeed
REPL remark       WITH mremark
REPL color        WITH mcolor
REPL print        WITH mprint

```

```

*-----
                ENDCASE
                ENDDO
                IF choice S 'F'+esckey
                    more = .T.
                ENDIF
                ENDCASE
***            ENDIF
                ENDCASE
                ENDDO
            ENDIF
        ENDCASE
    ENDDO
    IF ischange
        @'24,15 SAY "Please Wait ! [Order is generating sequence.]"
        RUN del production.idx
        SELE production
        SET order TO 1
        index on ord_no+DTC(dtc)+shift+STR(op_end,6,2) TO production
        USE production INDEX production,prod1 ALIAS production
        SELE production
        SET order TO 1
        GO TOP
        DO WHILE .NOT.EOF()
            mseq = 0010
            mord_no = ord_no
            DO WHILE ord_no = mord_no .AND..NOT.EOF()
                REPL seq WITH STR(mseq,4)
                mseq = mseq + 0010
                SKIP + 1
            ENDDO
        ENDDO
    ENDIF
    SELE production
    SET ORDER TO 1
    RETURN

```

D:\MPS\PRG>


```

D:\MPS\PRG>type prd002.prgtype prd002.prg
SELE production
set order to 2
SET RELA TO ord_no INTO ordermas
SET RELA TO wct INTO workmas ADDI
PRIVATE choice,fn,msg,y,start,fkeyuse,keychars,KEY
DIMENSION fn(4),msg(4)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F2 =Edit"
msg(2) = "Edit entry data."
fn(3) = "F3 =Finish"
msg(3) = "Save production data."
fn(4) = "Esc =Cancel"
msg(4) = "Cancel this data entry"
y = '09,19,29,41'
fkeyuse = 'F01,F02,F03,esc'
start = 3
PRIVATE PROGRAM,menuoption
KEY = 0
CLEAR
PROGRAM = 'PRD002'
menuoption = 'PRODUCTION DATA PROCESSING - CHANGE ACTUAL DATA.'
*-----*
STORE 0 TO;
    mt_time,mst_sta,mp_yard,mtemp,mch_wt,;
    mst_end,mop_sta,mop_end,mt_yard,mspeed.
mord_no = SPACE(7)
mshift = SPACE(1)
mwct = SPACE(6)
mopr = SPACE(20)
mremark = SPACE(30)
mdte = CTOD(' / / ')
mcolor = SPACE(10)
mprint = SPACE(10)
mseq = ' 10'
choice = SPACE(1)
mmkt_no = SPACE(07)
mdep = SPACE(10)
mst_code = SPACE(1)
mch_no = SPACE(6)
*-----*
ischange = .F.
DO prompbar
DO WHILE .T.
    fkeys = 'FKEYS : F1 =Help Esc =Exit'
    DO fkey_say WITH fkeys
    SELE production
    @ 4,1 SAY 'ORDER NUMBER:' GET mord_no PICT '@!'
    READ
    KEY = IIF(READ()>=256,READ()-256,READ())
    DO CASE
    CASE KEY = escapekey
        EXIT
    CASE KEY = helpkey
        DO syshelp = 'PRD002'
    CASE '' = TRIM(mord_no)
        DO say_stat WITH 'ORDER NUMBER REQUIRED.'
    OTHER
        SEEK mord_no
        IF .NOT. FOUND()

```

DO say_stat WITH 'ORDER NUMBER DOES NOT EXIST.'

LOOP

ENDIF

@ 7,0

@ 4,38 SAY 'DESCRIP :'

SET COLOR TO &promptatr

@ 4.15 SAY mord_no

@ 4,48 SAY ordermas->note

SET FILTER TO ord_no = mord_no

SET COLOR TO &hiliteatr

@ 5,1 SAY 'SEQ.'

@ 5,8 SAY 'OPERATION

@ 5,29 SAY 'WC

@ 5,37 SAY 'ST-STA'

@ 5,44 SAY 'ST-END'

@ 5,51 SAY 'OP-STA'

@ 5,58 SAY 'OP-END'

@ 5,65 SAY 'DATE

DO dash WITH 6

DO dash WITH 15

mseq = ' 10'

recnumtop = RECNO()

pagepaint = .T.

DO WHILE .T.

fkeys = 'FKEYS : F1 =Help Esc =Cancel PgUp =Prev PgDn =Next'

DO fkey_say WITH fkeys

IF pagepaint

GO recnumtop

@ 7,0 CLEAR TO 14,79

@ 6,0 SAY ''

LIST OFF NEXT 8 seq." ",opr,"",wct,"",STR(st_sta,5,2),"",;

STR(st_end,5,2),"",STR(op_sta,5,2),"",STR(op_end,5,2),;

dte

pagepaint = .F.

ENDIF

@ 16,1 SAY 'SEQUENCE:' GET mseq PICT '@!'

READ

KEY = IIF(READ()>=256,READ()-256,READ())

DO CASE

CASE KEY = escapekey

@ 4,38 CLEAR TO 4,79

@ 5,0 CLEAR TO 20,79

EXIT

CASE STR(KEY.1.0) S '01+5'

LOOP

CASE KEY = helpkey

DO syshelp WITH 'PRD002'

CASE STR(KEY,1,0) \$ '2367'

DO readkeyc WITH .F.,8

CASE mseq = '0000' .OR. '' = TRIM(mseq)

DO say_stat WITH 'SEQUENCE OF OPERATION REQUIRED.'

OTHER

SELE production

SEEK mord_no+mseq

IF .NOT. FOUND()

DO say_stat WITH 'INVALID SEQUENCE NUMBER.'

LOOP

ENDIF

SET COLOR TO &promptatr

SET COLOR TO &screenatr

mord_no = ord_no

mwct = wct

mshift = shift

mdte = dte

mopr = opr

mst_sta = st_sta


```

mst_end = st_end
mop_sta = op_sta
mop_end = op_end
mt_time = t_time
mt_yard = t_yard
mspeed = speed
mremark = remark
mcolor = color
mprint = print
mdep = dep
mmkt_no = mkt_no
mp_yard = p_yard
mtemp = temp
mst_code = st_code
mch_no = ch_no
mch_wt = ch_wt
fkeys = 'FKEYS : F1 =Help Esc =Cancel'
DO WHILE .T.
  DO fkey_say WITH fkeys
    @ 16,16 SAY "MKT NO:" GET mmkt_no PICT "@!"
    @ 16,32 SAY "OPERATION:" GET mopr PICT "@!"
    @ 16,63 SAY "WORK CENT:" GET mwct PICT "@!"
    @ 17, 1 SAY "T-YARD:" GET mt_yard PICT "9999999.99"
    @ 17,20 SAY "SPEED:" GET mspeed PICT "999.99"
    @ 17,34 SAY "YD/MIN"
    @ 17,41 SAY "COLOR:" GET mcolor PICT "@!"
    @ 17,60 SAY "PATTERN :" GET mprint PICT "@!"
    @ 18, 1 SAY "SET-UP:" GET mst_sta PICT "99.99"
    @ 18,16 SAY "TO" GET mst_end PICT "99.99"
    @ 18,25 SAY "OPER-TIME:" GET mop_sta PICT "99.99"
    @ 18,43 SAY "TO" GET mop_end PICT "99.99"
    @ 18,53 SAY "SHIFT:" GET mshift PICT "@!"
    @ 18,63 SAY "DATE :" GET mdte PICT "@E"
    @ 19, 1 SAY "P-YARD:" GET mp_yard PICT "9999999.99"
    @ 19,20 SAY "WAITING NO:" GET mst_code PICT "@!"
    @ 19,35 SAY "TMP,PRS:" GET mtemp PICT "999.99"
    @ 19,51 SAY "CH-NO:" GET mch_no PICT "@!"
    @ 19,65 SAY "CH-WGT:" GET mch_wt PICT "9999.99"
    @ 20, 1 SAY "DEPT:" GET mdep PICT "@!"
    @ 20,17 SAY "REMARKS:" GET mremark PICT "@!"
  READ
  STORE 0 to mt1,mt2
  IF mst_end < mst_sta
    mt1 = mst_end + 24.00
  ELSE
    mt1 = mst_end
  ENDIF
  IF mop_end < mop_sta
    mt2 = mop_end + 24.00
  ELSE
    mt2 = mop_end
  ENDIF
  v1 = (mt1 - int(mt1)) - (mst_sta - int(mst_sta))
  IF v1 >= 0
    z1 = mt1 - mst_sta
  ELSE
    z1 = INT(mt1) - INT(mst_sta) - 1 + v1 + 0.60
  ENDIF
  v2 = (mt2 - int(mt2)) - (mop_sta - int(mop_sta))
  IF v2 >= 0
    z2 = mt2 - mop_sta
  ELSE
    z2 = INT(mt2) - INT(mop_sta) - 1 + v2 + 0.60
  ENDIF
  z = z1 - INT(z1) + z2 - INT(z2)
  IF z < 0.60

```

```

      z = z1 + z2
ELSE
  z = INT(z1) + INT(z2) + 1 + z - 0.60
ENDIF
mt_time = z
@ 20,57 SAY "TOTAL TIME:"
@ 20,68 SAY mt_time PICT '999.99'
@ 20,75 SAY "HRS"
KEY = IIF(READ()>=256.READ()-256.READ())
DO CASE
CASE KEY = escapekey
  @ 16,0 CLEAR TO 20,79
  EXIT
CASE STR(KEY,1,0) S '0145'
  LOOP
CASE KEY = helpkey
  DO syshelp WITH 'PRD002'
CASE 0 = mst_sta
  DO say_stat WITH 'SET-UP TIME START REQUIRED.'
CASE 0 = mst_end
  DO say_stat WITH 'SET-UP TIME END REQUIRED.'
CASE 0 = mop_sta
  DO say_stat WITH 'OPER. TIME START REQUIRED.'
CASE 0 = mop_end
  DO say_stat WITH 'OPER. TIME END REQUIRED.'
CASE '' = TRIM(mwct)
  DO say_stat WITH 'WORK CENTER NUMBER REQUIRED.'
CASE '' = TRIM(mopr)
  DO say_stat WITH 'OPERATION DESCRIPTION REQUIRED.'
OTHER
  SELE workmas
  SEEK mwct
  IF .NOT. FOUND()
    DO say_stat WITH 'WORK CENTER DOES NOT EXIST IN SYSTEM.'
    choice = ''
  ELSE
    choice = 'H'
  ENDIF
  SELE production
  IF choice = 'H'
    SEEK mord_no+mseq
    @ 22,0 CLEAR TO 22,79
    choice = 'H'
    keychars = 'HEF'+esckey
    DO WHILE choice = 'H'
      choice = ''
      DO barmenu WITH LEN(keychars),choice,keychars
      DO CASE
      CASE choice = 'H'
        DO syshelp WITH 'PRD002'
      CASE choice = "F"
        ischange = .T.
        ??CHR(7)
      REPL ord_no WITH mord_no
      REPL wct WITH mwct
      REPL shift WITH mshift
      REPL dte WITH mdte
      REPL opr WITH mopr
      REPL st_sta WITH mst_sta
      REPL st_end WITH mst_end
      REPL op_sta WITH mop_sta
      REPL op_end WITH mop_end
      REPL t_time WITH mt_time
      REPL t_yard WITH mt_yard
      REPL speed WITH mspeed
      REPL remark WITH mremark

```



```

REPL color      WITH mcolor
REPL print      WITH mprint
REPL dep        WITH mdep
REPL mkt_no     WITH mmkt_no
REPL p_yard     WITH mp_yard
REPL temp       WITH mtemp
REPL st_code    WITH mst_code
REPL ch_no      WITH mch_no
REPL ch_wt      WITH mch_wt

```

```

*-----
                SELE production
                pagepaint = .T.
*****21/03/1991  SKIP -6
                   recnumtop = RECNO()
                   CASE choice = 'E'
                   @ 17,45
                   ENDCASE
                ENDDO
                ENDIF
                IF choice $ esckey+'F'
                @ 16,0 CLEAR TO 20,79
                EXIT
                ENDIF
                ENDCASE
            ENDDO
        ENDCASE
    ENDDO
    SET FILTER TO
ENDCASE
ENDDO
SELE production
SET ORDER TO 1
SET RELA TO
RETURN

```

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```

D:\MPS\PRG>type prd003.prg
SELE production
set order to 2
SET RELA TO ord_no INTO ordermas
SET RELA TO wct INTO workmas ADDI
PRIVATE choice,fn,msg,y,start,fkeyuse,keychars,KEY
DIMENSION fn(3),msg(3)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F3 =Delete"
msg(2) = "Delete current data."
fn(3) = "Esc =Cancel"
msg(3) = "Cancel deletion"
y = '09,19,31'
fkeyuse = 'F01,F03,esc'
start = 3
PRIVATE PROGRAM,menuoption
KEY = 0
CLEAR
PROGRAM = 'PRD003'
menuoption = 'PRODUCTION DATA PROCESSING - DELETE ACTUAL DATA.'
*-----*
mord_no = SPACE(7)
*-----*
ischange = .F.
DO promptbar
DO WHILE .T.
  fkeys = 'FKEYS : F1 =Help Esc =Exit'
  DO fkey_say WITH fkeys
  SELE production
  @ 4.1 SAY 'ORDER NUMBER:' GET mord_no PICT '@!'
  READ
  KEY = IIF(READ()>=256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    EXIT
  CASE KEY = helpkey
    DO syshelp = 'PRD003'
  CASE '' = TRIM(mord_no)
    DO say_stat WITH 'ORDER NUMBER REQUIRED.'
  OTHER
    SEEK mord_no
    IF .NOT. FOUND()
      DO say_stat WITH 'ORDER NUMBER DOES NOT EXIST.'
    LOOP
  ENDIF
  @ 6,0
  @ 4,38 SAY 'DESCRIP :'
  SET COLOR TO &promptatr
  @ 4,15 SAY mord_no
  @ 4,48 SAY ordermas->note
  SET FILTER TO ord_no = mord_no
  SET COLOR TO &hiliteatr
  @ 5,1 SAY 'SEQ.'
  @ 5,8 SAY 'OPERATION'
  @ 5,29 SAY 'WC'
  @ 5,37 SAY 'ST-STA'
  @ 5,44 SAY 'ST-END'

```



```

@ 5.51 SAY 'OP-STA'
@ 5.58 SAY 'OP-END'
@ 5.65 SAY 'DATE'
DO dash WITH 6
DO dash WITH 15
mseq = ' 10'
recnumtop = RECNO()
pagepaint = .T.
more = .T.
DO WHILE more
  fkeys = 'FKEYS : F1 =Help  Esc =Cancel  PgUp =Prev  PgDn =Next'
  DO fkey_say WITH fkeys
  IF pagepaint
    GO recnumtop
    @ 7,0 CLEAR TO 14,79
    @ 6,0 SAY ''
    LIST OFF NEXT 8 seq," ",opr,"",wct,"",STR(st_sta,5,2),"",;
      STR(st_end,5,2),"",STR(op_sta,5,2),"",STR(op_end,5,2),;
      dte
    pagepaint = .F.
  ENDIF
  @ 16,1 SAY 'SEQUENCE:' GET mseq PICT '@!'
  READ
  KEY = IIF(READ()>=256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    @ 4,38 CLEAR TO 4,79
    @ 5,0 CLEAR TO 20,79
    EXIT
  CASE STR(KEY,1,0) $ '0145'
    LOOP
  CASE KEY = helpkey
    DO syshelp WITH 'PRD003'
  CASE STR(KEY,1,0) $ '2367'
    DO readkeyc WITH .F.,8
  CASE mseq = '0000' .OR. '' = TRIM(mseq)
    DO say_stat WITH 'SEQUENCE OF OPERATION REQUIRED.'
  OTHER
    SELE production
    SEEK mord_no+mseq
    IF .NOT. FOUND()
      DO say_stat WITH 'INVALID SEQUENCE NUMBER.'
    ELSE
      @ 16, 1 SAY "SEQUENCE:"
      @ 16,16 SAY "MKT NO:"
      @ 16,32 SAY "OPERATION:"
      @ 16,63 SAY "WORK CENT:"
      @ 17, 1 SAY "T-YARD:"
      @ 17,20 SAY "SPEED:"
      @ 17,34 SAY "YD/MIN"
      @ 17,41 SAY "COLOR:"
      @ 17,60 SAY "PATTERN :"
      @ 18, 1 SAY "SET-UP: "
      @ 18,16 SAY "TO"
      @ 18,25 SAY "OPER-TIME:"
      @ 18,43 SAY "TO"

```

```

@ 18.53 SAY "SHIFT:"
@ 18.63 SAY "DATE :"
@ 19, 1 SAY "P-YARD:"
@ 19.20 SAY "WAITING NO:"
@ 19.35 SAY "TMP,PRS:"
@ 19.51 SAY "CH-NO:"
@ 19.65 SAY "CH-WGT:"
@ 20. 1 SAY "DEPT:"
@ 20.17 SAY "REMARKS:"
@ 20.57 SAY "TOTAL TIME:"
@ 20.75 SAY "HRS"
SET COLOR TO &promptatr
@ 17,11 SAY seq
@ 16,24 SAY mkt_no
@ 16,43 SAY opr
@ 16,74 SAY wct
@ 17, 9 SAY t_yard
@ 17,27 SAY speed
@ 17,48 SAY color
@ 17,70 SAY print
@ 18,10 SAY st_sta
@ 18,19 SAY st_end
@ 18,36 SAY op_sta
@ 18,46 SAY op_end
@ 18,60 SAY shift
@ 18,70 SAY dte
@ 19, 9 SAY p_yard
@ 19,32 SAY st_code
@ 19,44 SAY temp
@ 19,58 SAY ch_no
@ 19.73 SAY ch_wt
@ 20, 7 SAY dep
@ 20,26 SAY remark
@ 20,68 SAY t_time PICT '999.99'
SET COLOR TO &screenatr
@ 22.0
choice = 'H'
keychars = 'HD'+esckey
DO WHILE choice = 'H'
  choice = ' '
  DO barmenu WITH LEN(keychars),choice,keychars
  DO CASE
  CASE choice = 'H'
    DO syshelp WITH 'PRD003'
  CASE choice = "D"
    ??CHR(7)
    ischange = .T.
  DELE
  SKIP -1
  IF ' ' # TRIM(ord_no)
    recnumtop = RECNO()
    pagepaint = .T.

```



```

ELSE
    DO say_stat WITH 'NOW! ORDER HAVE NO DATA'
    @ 4,36
    @ 5,0 CLEAR TO 20,79
    more = .F.
ENDIF
ENDCASE
ENDDO
IF choice S 'D'+esckey
    @ 16,0 CLEAR TO 20,79
ENDIF
ENDIF
ENDCASE
ENDDO
IF ischange
    SELE production
    SEEK mord_no
    mseq = 0010
    mord_no = ord_no
    DO WHILE ord_no = mord_no .AND. .NOT.EOF()
        REPL seq WITH STR(mseq,4)
        mseq = mseq + 0010
        SKIP + 1
    ENDDO
    ischange = .F.
ENDIF
SET FILTER TO
ENDCASE
ENDDO
SELE production
SET ORDER TO 1
SET RELA TO
RETURN

```

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```

SELE production
set order to 2
PRIVATE choice.fn,msg,y.start.fkeyuse.keychars.KEY
DIMENSION fn(3);msg(3)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F3 =Purge"
msg(2) = "Purge current order master."
fn(3) = "Esc =Cancel"
msg(3) = "Cancel this purge order master"
y = '09,19,30'
fkeyuse = 'F01,F03,esc'
start = 3
PRIVATE PROGRAM.menuoption
KEY = 0
morder_no = SPACE(7)
CLEAR
fkeys = 'FKEYS : F1 =Help Esc =Exit'
PROGRAM = 'PRD006'
menuoption = 'PRODUCTION PROCESSING - PURGE ACTUAL ORDER.'
DO prompbar
DO WHILE .T.
  DO fkey_say WITH fkeys
  SELE production
  @ 5,1 SAY 'ORDER NUMBER:' GET morder_no PICT '@!'
  READ
  KEY = IIF(READ() >=256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    EXIT
  CASE KEY = helpkey
    DO syshelp WITH 'PRD006'
  CASE '' = TRIM(morder_no)
    DO say_stat WITH 'ORDER NUMBER REQUIRED.'
  OTHER
    SEEK morder_no
    DO CASE
    CASE .NOT. FOUND()
      DO say_stat WITH "ORDER DOES NOT EXISTS IN ACTUAL ORDER."
    OTHER
      choice = 'H'
      keychars = 'HP'+esckey
      DO WHILE choice = 'H'
        choice = ' '
        DO barmenu WITH LEN(keychars),choice,keychars
        DO CASE
        CASE choice = "H"
          DO syshelp WITH 'PMM004'
        CASE choice = "P"
          *-----
          SELE production
          SEEK morder_no
          DO WHILE ord_no = morder_no .AND..NOT.EOF()
            DELE
            SEEK morder_no
          ENDDO
          *-----
        ENDCASE
      ENDDO
      IF choice <> 'H'
        @ 5,34
        @ 6.0 CLEAR TO 20,79
      ENDIF
    ENDCASE
  ENDDO
SELE production
set order to 1

```


โปรแกรมชุดที่ 3 การแสดงผลและการพิมพ์รายงาน

```

D:\MPS\PRG>type prd005.prg
SELE PRODUCTION
set order to 2
SET RELA TO ord_no INTO ordermas
SET RELA TO wct INTO workmas ADDI
PRIVATE pancol,panmax,panlast,recnumtop,recnumlast,skiprecs
PRIVATE home,endkey,uparrow,downarrow,leftarrow,rightarrow
PRIVATE ROW,rowtop,rowbottom,rowprompt,keystrokes,pagepaint
PRIVATE recnumlast.pgup,pgdn
home = CHR(1)
endkey = CHR(6)
uparrow = CHR(5)
downarrow = CHR(24)
leftarrow = CHR(19)
rightarrow = CHR(4)
pgdn = CHR(3)
pgup = CHR(18)
keystrokes = "FMBT"+uparrow+downarrow+home+leftarrow+
  rightarrow+endkey+pgdn+pgup+returnkey+esckey
*-----
mord_no = space(7)
rowtop = 9
rowbottom = 19
rowprompt = rowbottom + 3
skiprecs = rowbottom - rowtop + 1
ROW = rowtop
recnum = RECNO()
recnumtop = recnum
pagepaint = .T.
pancol = 1
panlast = 1
panmax = 4
SET COLOR TO &screenatr
CLEAR
menuoption = 'PRODUCTION INQUIRY - DISPLAY ACTUAL PRODUCTION DATA.'
PROGRAM = 'PRD005'
fkeys = "FKEYS : F1 =Help Esc =Exit"
DO prompbar
DO fkey_say WITH fkeys
SET COLOR TO &hiliteatr
SET COLOR TO &screenatr
DO WHILE .T.
  SELE production
  @ 5,1 SAY 'ORDER NUMBER:' GET mord_no PICT '@!'
  READ
  KEY = IIF(READ()>=256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    EXIT
  CASE KEY = helpkey
    DO syshelp = 'PRD005'
  CASE '' = TRIM(mord_no)
    DO say_stat WITH 'ORDER NUMBER REQUIRED.'
  OTHER
    SEEK mord_no
    recnum = RECNO().

```

```

recnumtop = recnum
IF .NOT. FOUND()
  DO say_stat WITH 'ORDER NUMBER DOES NOT EXIST.'
  LOOP
ENDIF
@ 7,0
@ 5.38 SAY 'DESCRIP :'
SET COLOR TO &promptatr
@ 5,15 SAY mord_no
@ 5,48 SAY ordermas->note
SAVE SCREEN TO scrprd1
pagepaint = .T.
pancol = 1
panlast = 1
SET FILTER TO ord_no = mord_no

*-----
mord_no = ord_no
DO WHILE .T.
  ?? SYS(2002)
  mord_no = ord_no
  IF pagepaint
    RESTORE SCREEN FROM scrprd1
    recnum = RECNO()
    GOTO recnumtop
    DO prd501 WITH (rowtop),skiprecs
    GOTO recnum
    IF pancol = panlast
      ROW = rowtop
    ENDIF
    panlast = pancol
    pagepaint = .F.
  ENDIF
  @ ROW,0 SAY CHR(16)
  choice = ' '
  DO getkey WITH choice,keystrokes,'29'
  DO WHILE choice $ uparrow+downarrow
    @ ROW,0 SAY " "
    IF choice = uparrow
      SKIP -1
    DO CASE
    CASE BOF()
      GOTO TOP
    CASE ROW > rowtop
      ROW = ROW - 1
    OTHERWISE
      recnumtop = RECNO()
      Scroll rowtop,0,rowbottom,79,-1
      DO prd501 WITH ROW,1
    ENDCASE
  ENDWHILE

```



```

ELSE
  SKIP
  DO CASE
  CASE EOF()
    GOTO BOTTOM
  CASE ROW < rowbottom
    ROW = ROW + 1
  OTHERWISE
    recnum = RECNO()
    GOTO recnumtop
  SKIP
    recnumtop = RECNO()
    GOTO recnum
    Scroll rowtop,0,rowbottom,79,1
    DO prd501 WITH ROW,1
  ENDCASE
  ...ENDIF
  @ ROW,0 SAY CHR(16)
  DO getkey WITH choice,keystrokes,'29'
ENDDO
DO CASE
CASE choice = esckey
  @ 6,0 CLEAR TO 19,79
  ?? SYS(2002,1)
  inq_choice = SPACE(1)
  EXIT
CASE choice = 'H'
  DO syshelp WITH 'PRD005'
CASE choice $ pgdn+pgup+home+endkey+rightarrow+leftarrow
  DO inkeyctl WITH .F..skiprecs
ENDCASE
ENDDO
ENDCASE
ENDDO
SELE MASTER
?? SYS(2002,1)
RETURN

```

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```

D:\MPS\PRG>type prd501.prg
PARAMETER ROW,listrecs
counter = 0
IF listrecs > 1
  DO dash WITH rowtop-1
  SET COLOR TO &hilitetr
  DO CASE
  CASE pancol = 1
    @ rowtop-2,1 SAY 'SEQ.'
    @ rowtop-2,7 SAY 'OPERATION'
    @ rowtop-2,28 SAY 'MKT-NO'
    @ rowtop-2,36 SAY 'COLOR'
    @ rowtop-2,47 SAY 'PATTERN'
    @ rowtop-2,58 SAY 'TOTAL YARD'
    @ rowtop-2,69 SAY 'PROD. YARD'
  CASE pancol = 2
    @ rowtop-2,1 SAY 'SEQ.'
    @ rowtop-2,7 SAY 'OPERATION'
    @ rowtop-2,28 SAY 'WC'
    @ rowtop-2,35 SAY 'ST-STA'
    @ rowtop-2,42 SAY 'ST-END'
    @ rowtop-2,49 SAY 'OP-STA'
    @ rowtop-2,56 SAY 'OP-END'
    @ rowtop-2,63 SAY 'T-TIME'
    @ rowtop-2,70 SAY '*-WAITING*'
    @ 22,01 SAY 'WAITING CODE:1)FABRIC 2)CHEMICAL 3)MAN 4)ELECTRIC'
    @ 22,50 SAY '5)MACHINE 6)CLEANING'
  CASE pancol = 3
    @ rowtop-2,1 SAY 'SEQ.'
    @ rowtop-2,7 SAY 'OPERATION'
    @ rowtop-2,28 SAY 'DATE'
    @ rowtop-2,39 SAY 'SHIFT'
    @ rowtop-2,45 SAY 'DEPARTMENT'
    @ rowtop-2,56 SAY 'SPEED'
    @ rowtop-2,63 SAY 'TEMP,PRESS'
  CASE pancol = 4
    @ rowtop-2,1 SAY 'SEQ.'
    @ rowtop-2,7 SAY 'OPERATION'
    @ rowtop-2,28 SAY 'CHEM-NO'
    @ rowtop-2,36 SAY 'CHEM-WT'
    @ rowtop-2,45 SAY 'REMARKS'
  ENDCASE
  SET COLOR TO &screenatr
  Scroll rowtop,0,rowbottom+1,79,rowbottom+1-rowtop
ENDIF
SET COLOR TO &screenatr
@ ROW-1,0 SAY ' '
DO CASE
CASE pancol = 1
  LIST OFF NEXT listrecs seq,"";opr,mkt_no;
  color,print,STR(t_var,10,2),STR(p_yard,10,2)
CASE pancol = 2
  LIST OFF NEXT listrecs seq,"",opr,wct,STR(st_sta,5,2),"";
  STR(st_end,5,2),"",STR(op_sta,5,2),"",STR(op_end,5,2),"";
  STR(t_time,6,2),"",st_code
CASE pancol = 3
  LIST OFF NEXT listrecs seq,"",opr,dte,"",shift,"";
  dep,STR(speed,6,2),STR(temp,6,2)
CASE pancol = 4
  LIST OFF NEXT listrecs seq,"",opr,ch_no,"",STR(ch_wt,7,2),"",remark
ENDCASE
RETURN

```



```

D:\MPS\PRG>type prdr01.prg
SELE production
SET ORDER to 2
SET RELA TO ord_no INTO ORDERMAS
SET RELA TO wct INTO WORKMAS
PRIVATE choice.fn.msg.y.start.fkeyuse,keychars,KEY
DIMENSION fn(+),msg(4)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F2 =Edit"
msg(2) = "Edit entry data."
fn(3) = "F3 =Finish"
msg(3) = "Confirm to print report"
fn(4) = "Esc =Exit"
msg(4) = "Return to menu."
y = '09,19,29,41'
fkeyuse = 'F01,F02,F03,esc'
start = 3
PRIVATE PROGRAM,menuoption
KEY = 0
mord1 = SPACE(07)
mord2 = SPACE(07)
copy_no = 1
PROGRAM = 'PRDR01'
menuoption = 'PRODUCT DATA REPORT - ACTUAL PRODUCTION DATA MASTER.'
CLEAR
fkeys = 'FKEYS : F1 =Help Esc =Exit'
DO prompbar
DO WHILE .T.
  choice = ','
  mcond1 = ':'
  expr = ''
  copy_no = 1
  DO fkey_say WITH fkeys
  @ 5,38 SAY 'FROM' TO'
  @ 6,1 SAY 'ENTER RANGE OF END ORDER-NO' :
  @ 6,35 GET mord1 PICT '@!'
  @ 6,53 GET mord2 PICT '@!'
  @ 16,1 SAY 'NUMBER OF COPIES' :
  @ 16,35 GET copy_no PICT '99'
  READ
  KEY = IIF(READ() >= 256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    EXIT
  CASE KEY = helpkey
    DO syshelp WITH 'PRDR01'
  OTHER
    expr1 = mord1
    DO criteria WITH " ' ' # TRIM(mord1)",;
      "UPPER(ord_no)>= mord1 .AND.",;
      "ORDER NUMBER:",expr1
    expr1 = mord2
    DO criteria WITH " ' ' # TRIM(mord2)",;
      "UPPER(ord_no)<= mord2 .AND.",;
      "TO",expr1
    DO condchk WITH " mord1 > mord2 .AND. ' ' # TRIM(mord2)",;
      "START ORDER NUMBER > END ORDER NUMBER",choice
    IF LEN(mcond1) > 0
      mcond1 = SUBSTR(mcond1,1,LEN(mcond1)-5)
    ELSE
      expr = 'NONE.'
    ENDIF
    choice = IIF(AT('*'.choice) = 0.'H'.' ')

```

```

@ 22,0 CLEAR TO 22,79
keychars = 'HEF'+esckey
DO WHILE choice = 'H'
  choice = ' '
  DO barmenu WITH LEN(keychars),choice,keychars
  DO CASE
  CASE choice = "H"
    DO syshelp WITH 'PRDR01'
  CASE choice = 'F'
    SET FILTER TO &mcond1
    GO TOP
    IF EOF()
      DO say_stat WITH 'NO ORDER ACTIVE FOR SELECTION CRITERIA.'
    EXIT
  ENDIF
  Isprint = .T.
  DO prn_on
  mloop = 1
  DO WHILE mloop <= copy_no .AND. Isprint
    GO TOP
    DO prdr11
    mloop = mloop+1
    SELE production
  ENDDO
  @ 5,0 CLEAR TO 20,79
  DO prn_off
  ENDCASE
ENDDO
IF choice = esckey
  EXIT
ENDIF
ENDCASE
ENDDO
SELE production
SET RELA TO
SET FILTER TO
SET ORDER to 1
SELE ORDERMAS
RETURN

```

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```

D:\MPS\PRG>type prdr02.prg
SELE production
SET ORDER to 2
SET RELA TO ord_no INTO ORDERMAS
SET RELA TO wct INTO WORKMAS
PRIVATE choice,fn,msg,y,start,fkeyuse,keychars.KEY
DIMENSION fn(4),msg(4)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F2 =Edit"
msg(2) = "Edit entry data."
fn(3) = "F3 =Finish"
msg(3) = "Confirm to print report"
fn(4) = "Esc =Exit"
msg(4) = "Return to menu."
y = '09,19,29,41'
fkeyuse = 'F01,F02,F03,esc'
start = 3
PRIVATE PROGRAM,menuoption
KEY = 0
mord1 = SPACE(07)
mord2 = SPACE(07)
copy_no = 1
PROGRAM = 'PRDR02'
menuoption = 'PRODUCT DATA REPORT - ANALYSIS ACTUAL PRODUCTION.'
CLEAR
fkeys = 'FKEYS : F1 =Help Esc =Exit'
DO prompbar
DO WHILE .T.
  choice = ' '
  mcond1 = ''
  expr = ''
  copy_no = 1
  DO fkey_say WITH fkeys
  @ 5,38 SAY 'FROM' TO'
  @ 6.1 SAY 'ENTER RANGE OF END ORDER-NO : '
  @ 6.35 GET mord1 PICT '@!'
  @ 6.53 GET mord2 PICT '@!'
  @ 16,1 SAY 'NUMBER OF COPIES : '
  @ 16,35 GET copy_no PICT '99'
  READ
  KEY = IIF(READ() >= 256,READ()-256,READ())
  DO CASE
  CASE KEY = escapekey
    EXIT
  CASE KEY = helpkey
    DO syshelp WITH 'PRDR02'
  OTHER
    expr1 = mord1
    DO criteria WITH " ' ' # TRIM(mord1)",;
      "UPPER(ord_no)>= mord1 .AND.",;
      "ORDER NUMBER:",expr1
    expr1 = mord2
    DO criteria WITH " ' ' # TRIM(mord2)",;
      "UPPER(ord_no)<= mord2 .AND.",;
      "TO",expr1

```

```

DO condchk WITH " mord1 > mord2 .AND. '' = TRIM(mord2)",;
"START ORDER NUMBER > END ORDER NUMBER".choice
IF LEN(mcond1) > 0
  mcond1 = SUBSTR(mcond1,1,LEN(mcond1)-5)
ELSE
  expr = 'NONE.'
ENDIF
choice = IIF(AT('*'.choice) = 0.'H',')
@ 22,0 CLEAR TO 22,79
keychars = 'HEF'+esckey
DO WHILE choice = 'H'
  choice = ' '
  DO barmenu WITH LEN(keychars),choice,keychars
  DO CASE
  CASE choice = "H"
    DO syshelp WITH 'PRDR02'
  CASE choice = 'F'
    SET FILTER TO &mcond1
    GO TOP
    IF EOF()
      DO say_stat WITH 'NO ORDER ACTIVE FOR SELECTION CRITERIA.'
      EXIT
    ENDIF
    Isprint = .T.
    DO prn_on
    mloop = 1
    DO WHILE mloop <= copy_no .AND. Isprint
      GO TOP
      DO prdr21
      mloop = mloop+1
      SELE production
    ENDDO
    @ 5,0 CLEAR TO 20,79
    DO prn_off
  ENDCASE
ENDDO
IF choice = esckey
  EXIT
ENDIF
ENDCASE
ENDDO
SELE production
SET RELA TO
SET FILTER TO
SET ORDER to 1
SELE ORDERMAS
RETURN

```



```

D:\MPS\PRG>type prdr11.prg
ON ESCAPE DO ponkey
mpage = 1
mline = inst_ln
*mst_time = st_time
isfirst = .T.
mord_no = ord_no
SET DEVICE TO PRINT
SET ESCA ON
DO WHILE .NOT. EOF()
  IF mline > inst_ln - 2
    @ 1,(232-LEN(TRIM(sys_comp)))/2 SAY TRIM(sys_comp)
    @ 2,0 SAY 'MPS REPORT : ACTUAL PRDOCTION DATA MASTER. AT '+';
      sysdate +' -'+TIME()
    @ 2,232-8 SAY 'PAGE '+STR(mpage,3)
    @ 3,0 SAY 'CONSTRAINTS : '+expr
    @ 4,0 SAY REPLI('-',232)
  @ 5,0 SAY 'ORDER-NO MARKT-NO SEQN OPERATION WORK '+';
    'CENT ST-BEG ST-END OP-BEG OP-END T-TIME WAIT SHIFT '+';
    'WORK-DATE DEPARTMENT SPEED TMP&PRS COLOR PATTERN '+';
    ' TOTAL YARD PROD. YARD CH-NO CH-WGT REMARKS'
  @ 6,0 SAY '----- '+';
    '----- '+';
    '----- '+';
    '----- '+';
  @ 6,202 SAY '----- '+';
    mpage = mpage+1
    mline = 7
  ENDIF
  IF isfirst
    @ mline,0 SAY ord_no
    @ mline,10 SAY mkt_no
    ***** @ mline,10 SAY ordermas->note
    isfirst = .F.
  ENDIF
  @ mline,18 SAY seq
  @ mline,23 SAY opr
  @ mline,44 SAY wct
  @ mline,55 SAY STR(st_sta,5,2)
  @ mline,62 SAY STR(st_end,5,2)
  @ mline,69 SAY STR(op_sta,5,2)
  @ mline,76 SAY STR(op_end,5,2)
  @ mline,84 SAY STR(t_time,6,2)
  @ mline,93 SAY st_code
  @ mline,98 SAY shift
  @ mline,102 SAY dte
  @ mline,113 SAY dep
  @ mline,125 SAY STR(speed,6,2)
  @ mline,133 SAY STR(temp,6,2)
  @ mline,140 SAY color
  @ mline,151 SAY print
  @ mline,163 SAY STR(t_yard,10,2)

```

```

@ mline,175 SAY STR(p_yard,10,2)
@ mline,186 SAY ch_no
@ mline,194 SAY STR(ch_wt,7,2)
@ mline,202 SAY remark
mline = mline+1
SKIP
IF ord_no # mord_no
  isfirst = .T.
  mord_no = ord_no
*   mst_time = st_time
  mline = mline+1
ELSE
*   mst_time = st_time + mst_time
ENDIF
DO CASE
CASE .NOT. Isprint
  GO BOTTOM
  SKIP
CASE Isprint .AND. mline = inst_ln
  EJECT
ENDCASE
ENDDO
IF Isprint
  @ mline,0 SAY REPLI('-',232-94) +'WAITING CODE: 1)FABRIC'+;
  ' 2)CHEMICAL 3)MAN 4)CHEMICAL 5)MACHINE 6)CLEANING'+;
  ' ----- END OF REPORT --'
ENDIF
EJECT
SET DEVICE TO SCREEN
@ 24,0 CLEAR
SET ESCA OFF
ON ESCAPE
RETURN

```

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```

D:\MPS\PRG>type prdr21.prg
ON ESCAPE DO ponkey
mpage = 1
mline = inst_ln
*mst_time = st_time
isfirst = .T.
mord_no = ord_no
SET DEVICE TO PRINT
SET ESCA ON
DO WHILE .NOT. EOF()
  IF mline > inst_ln - 2
    @ 1,(232-LEN(TRIM(sys_comp)))/2 SAY TRIM(sys_comp)
    @ 2,0 SAY 'MPS REPORT : ANALYSIS ACTUAL PRODUCTION. AT '+';
      sysdate + ' -'+TIME()
    @ 2,232-8 SAY 'PAGE '+STR(mpage,3)
    @ 3,0 SAY 'CONSTRAINTS : '+expr
    @ 4,0 SAY REPLI('-',232)
  @ 5,0 SAY 'ORDER-NO MARKT-NO SEQN OPERATION                WORK '+';
    'CENT ST-BEG ST-END OP-BEG OP-END T-TIME WAIT SHIFT '+';
    'WORK-DATE DEPARTMENT SPEED  TMP&PRS COLOR  PATTERN'+';
    '  TOTAL YARD PROD. YARD CH-NO CH-WGT  REMARKS'
  @ 6,0 SAY '-----';
    '-----';
    '-----';
    '-----';
  @ 6,202 SAY '-----';
    mpage = mpage+1
    mline = 7
  ENDIF
  IF isfirst
    @ mline,0 SAY ord_no
    @ mline,10 SAY mkt_no
    ***** @ mline,10 SAY ordermas->note
    isfirst = .F.
  ENDIF
  IF ord_no ≠ mord_no
    isfirst = .T.
    skip -1
    @ mline,18 SAY seq
    @ mline,23 SAY opr
    @ mline,44 SAY wct
    @ mline,55 SAY STR(st_sta,5,2)
    @ mline,62 SAY STR(st_end,5,2)
    @ mline,69 SAY STR(op_sta,5,2)
    @ mline,76 SAY STR(op_end,5,2)
    @ mline,84 SAY STR(t_time,6,2)
    @ mline,93 SAY st_code
    @ mline,98 SAY shift
    @ mline,102 SAY dte
    @ mline,113 SAY dep
    @ mline,125 SAY STR(speed,6,2)
    @ mline,133 SAY STR(temp,6,2)
    @ mline,140 SAY color
    @ mline,151 SAY print
    @ mline,163 SAY STR(t_yard,10,2)

```

```

@ mline,175 SAY STR(p_yard,10,2)
@ mline,186 SAY ch_no
@ mline,194 SAY STR(ch_wt,7,2)
@ mline,202 SAY remark
mline = mline+1
skip
mord_no = ord_no
ELSE
  SKIP
ENDIF
DO CASE
CASE .NOT. Isprint
  GO BOTTOM
  SKIP
CASE Isprint .AND. mline = inst_ln
  EJECT
ENDCASE
ENDDO

mline = mline+1
skip -1
@ mline,18 SAY seq
@ mline,23 SAY opr
@ mline,44 SAY wct
@ mline,55 SAY STR(st_sta,5,2)
@ mline,62 SAY STR(st_end,5,2)
@ mline,69 SAY STR(op_sta,5,2)
@ mline,76 SAY STR(op_end,5,2)
@ mline,84 SAY STR(t_time,6,2)
@ mline,93 SAY st_code
@ mline,98 SAY shift
@ mline,102 SAY dte
@ mline,113 SAY dep
@ mline,125 SAY STR(speed,6,2)
@ mline,133 SAY STR(temp,6,2)
@ mline,140 SAY color
@ mline,151 SAY print
@ mline,163 SAY STR(t_yard,10,2)
@ mline,175 SAY STR(p_yard,10,2)
@ mline,186 SAY ch_no
@ mline,194 SAY STR(ch_wt,7,2)
@ mline,202 SAY remark

IF Isprint
  @ mline,0 SAY REPLI('-',232-94) +'WAITING CODE: 1)FABRIC'+;
  ' 2)CHEMICAL 3)MAN 4)CHEMICAL 5)MACHINE 6)CLEANING'+;
  ' ----- END OF REPORT --'
ENDIF
EJECT
SET DEVICE TO SCREEN
@ 24,0 CLEAR
SET ESCA OFF
ON ESCAPE
RETURN↑

```



```

D:\MPS\PRG>type prdr03.prg
SELE production
SET ORDER to 2
SET RELA TO ord_no INTO ORDERMAS
SET RELA TO wct INTO WORKMAS
PRIVATE choice,fn,msg,y,start,fkeyuse,keychars,KEY
DIMENSION fn(4),msg(4)
fn(1) = "F1 =Help"
msg(1) = "Display relevent help screen"
fn(2) = "F2 =Edit"
msg(2) = "Edit entry data."
fn(3) = "F3 =Finish"
msg(3) = "Confirm to print report"
fn(4) = "Esc =Exit"
msg(4) = "Return to menu."
y = '09,19,29,41'
fkeyuse = 'F01,F02,F03,esc'
start = 3
PRIVATE PROGRAM,menuoption
KEY = 0
mwkc1 = SPACE(07)
mwkc2 = SPACE(07)
copy_no = 1
PROGRAM = 'PRDR03'
menuoption = 'PRODUCT DATA REPORT - ANALYSIS JOB ON WORKCENTER.'
CLEAR
fkeys = 'FKEYS : F1 =Help Esc =Exit'
DO prompbar
DO WHILE .T.
  choice = ' '
  mcond1 = ''
  expr = ''
  copy_no = 1
  DO fkey_say WITH fkeys
    @ 5,38 SAY 'FROM' TO'
    @ 6,1 SAY 'ENTER RANGE OF END WORKCENT. : '
    @ 6.35 GET mwkc1 PICT '@!'
    @ 6.53 GET mwkc2 PICT '@!'
    @ 16.1 SAY 'NUMBER OF COPIES : '
    @ 16,35 GET copy_no PICT '99'
  READ
  KEY = IIF(READ() >= 256,READ()-256,READ())
  DO CASE
    CASE KEY = escapekey
      EXIT
    CASE KEY = helpkey
      DO syshelp WITH 'PRDR03'
    OTHER
      expr1 = mwkc1
      DO criteria WITH " ' ' # TRIM(mwkc1)",;
        "UPPER(wkc_no)>= mwkc1 .AND.",;
        "WORK CENTER :",expr1
      expr1 = mwkc2
      DO criteria WITH " ' ' # TRIM(mwkc2)",;
        "UPPER(wkc_no)<= mwkc2 .AND.",;
        "TO",expr1
  
```

```

DO condchk WITH " mwkc1 > mwkc2 .AND. '' # TRIM(mwkc2)":;
"START WORK CENTER > END WORK CENTER ",choice
IF LEN(mcond1) > 0
mcond1 = SUBSTR(mcond1,1,LEN(mcond1)-5)
ELSE
expr = 'NONE.'
ENDIF
choice = IIF(AT('*',choice) = 0,'H',' ')
@ 22,0 CLEAR TO 22,79
keychars = 'HEF'+esckey
DO WHILE choice = 'H'
choice = ' '
DO barmenu WITH LEN(keychars),choice,keychars
DO CASE
CASE choice = "H"
DO syshelp WITH 'PRDR03'
CASE choice = 'F'
*-----
@ 24,15 SAY "Please Wait ! [Order is generating.]"
DO prdr32
SELE prdwct
index on wct+ord_no+DTC(dte)+shift+STR(op_end,6,2) TO prdwct
SELE prdwct
*-----
*
SET FILTER TO &mcond1
GO TOP
IF EOF()
DO say_stat WITH 'NO WCT ACTIVE FOR SELECTION CRITERIA.'
EXIT
ENDIF
Isprint = .T.
DO prn_on
mloop = 1
DO WHILE mloop <= copy_no .AND. Isprint
GO TOP
DO prdr31
mloop = mloop+1
ENDDO
@ 5,0 CLEAR TO 20,79
DO prn_off
ENDCASE
ENDDO
IF choice = esckey
EXIT
ENDIF
ENDCASE
ENDDO
SELE production
SET REL TO
SET FILTER TO
SET ORDER TO 1
SELE ORDERMAS
RETURN

```



```

D:\MPS\PRG>type prdr31.prg
ON ESCAPE DO ponkey
mpage = 1
mline = inst_ln
isfirst = .T.
mord_no = ord_no
mwct = wct
SET DEVICE TO PRINT
SET ESCA ON
DO WHILE .NOT. EOF()
  IF mline > inst_ln - 2
    @ 1,(232-LEN(TRIM(sys_comp)))/2 SAY TRIM(sys_comp)
    @ 2,0 SAY 'MPS REPORT : ANALYSIS JOB ON WORK CENTER. AT '+';
      sysdate +' -'+TIME()
    @ 2,232-8 SAY 'PAGE '+STR(mpage,3)
    @ 3,0 SAY 'CONSTRAINTS : '+expr
    @ 4.0 SAY REPLI('-',232)
  @ 5,0 SAY 'WORK-CENT ORDER-NO MARKT-NO SEQN OPERATION '+';
    ' ST-BEG ST-END OP-BEG OP-END T-TIME WAIT SHIFT '+';
    ' WORK-DATE DEPARTMENT SPEED TMP&PRS COLOR PATTERN '+';
    ' TOTAL YARD PROD. YARD CH-NO CH-WGT REMARKS' '+';
  @ 6,0 SAY '----- '+';
    '----- '+';
    '----- '+';
    '----- '+';
  @ 6,202 SAY '----- '+';
    mpage = mpage+1
    mline = 7
  ENDIF
  IF isfirst
    @ mline.0 SAY wct
    isfirst = .F.
  ENDIF
  @ mline,11 SAY ord_no
  @ mline,20 SAY mkt_no
  @ mline,29 SAY seq
  @ mline,34 SAY opr
  @ mline,55 SAY STR(st_sta,5,2)
  @ mline,62 SAY STR(st_end,5,2)
  @ mline,69 SAY STR(op_sta,5,2)
  @ mline,76 SAY STR(op_end,5,2)
  @ mline,84 SAY STR(t_time,6,2)
  @ mline,93 SAY st_code
  @ mline,98 SAY shift
  @ mline,102 SAY dte
  @ mline,113 SAY dep
  @ mline,125 SAY STR(speed,6,2)
  @ mline,133 SAY STR(temp,6,2)
  @ mline,140 SAY color
  @ mline,151 SAY print
  @ mline,163 SAY STR(t_yard,10,2)

```

```
@ mline,175 SAY STR(p_yard,10,2)
@ mline,186 SAY ch_no
@ mline,194 SAY STR(ch_wt,7,2)
@ mline,202 SAY remark
mline = mline+1
SKIP
IF wct      # mwct
  isfirst = .T.
  mwct    = wct
  mline = mline+1
ENDIF
DO CASE
CASE .NOT. Isprint
  GO BOTTOM
  SKIP
CASE Isprint .AND. mline = inst_ln
  EJECT
ENDCASE
ENDDO
IF Isprint
  @ mline,0 SAY REPLI('-',232-94) +'WAITING CODE: 1)FABRIC'+;
  ' 2)CHEMICAL 3)MAN 4)CHEMICAL 5)MACHINE 6)CLEANING'+;
  ' ----- END OF REPORT --'
ENDIF
EJECT
SET DEVICE TO SCREEN
@ 24,0 CLEAR
SET ESCA OFF
ON ESCAPE
RETURN†
```

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```

D:\MPS\PRG>type prdr32.prg
isfirst = .T.
SET ESCA ON
SET talk off
SET echo off
SELE prdwct
RUN del prdwct.idx
dele all
pack
SELE production
GO TOP
mord_no = ord_no
DO WHILE .NOT. EOF()
  IF isfirst
    SELE prdwct
    APPEND BLANK
    REPL prdwct->ord_no WITH production->ord_no
    REPL prdwct->mkt_no WITH production->mkt_no
    isfirst = .F.
  ENDIF
  IF ord_no # mord_no
    isfirst = .T.
    SELE production
    skip -1
    SELE prdwct.
    REPL prdwct->seq WITH production->seq
    REPL prdwct->wct WITH production->wct
    REPL prdwct->shift WITH production->shift
    REPL prdwct->dte WITH production->dte
    REPL prdwct->opr WITH production->opr
    REPL prdwct->st_sta WITH production->st_sta
    REPL prdwct->st_end WITH production->st_end
    REPL prdwct->op_sta WITH production->op_sta
    REPL prdwct->op_end WITH production->op_end
    REPL prdwct->t_time WITH production->t_time
    REPL prdwct->t_yard WITH production->t_yard
    REPL prdwct->speed WITH production->speed
    REPL prdwct->remark WITH production->remark
    REPL prdwct->color WITH production->color
    REPL prdwct->print WITH production->print
    REPL prdwct->dep WITH production->dep
    REPL prdwct->p_yard WITH production->p_yard
    REPL prdwct->temp WITH production->temp
    REPL prdwct->st_code WITH production->st_code
    REPL prdwct->ch_no WITH production->ch_no
    REPL prdwct->ch_wt WITH production->ch_wt
  *-----
  SELE production
  skip
  mord_no = ord_no
  ELSE
    SELE production
    SKIP
  ENDIF
ENDDO

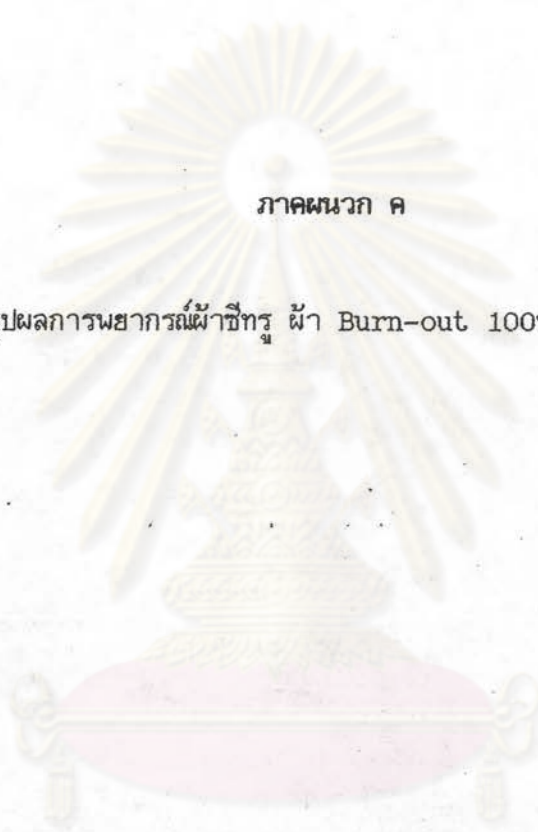
```

```
SELE production
skip -1
SELE prdwct
REPL prdwct->seq      WITH production->seq
REPL prdwct->wct      WITH production->wct
REPL prdwct->shift    WITH production->shift
REPL prdwct->dte      WITH production->dte
REPL prdwct->opr      WITH production->opr
REPL prdwct->st_sta   WITH production->st_sta
REPL prdwct->st_end   WITH production->st_end
REPL prdwct->op_sta   WITH production->op_sta
REPL prdwct->op_end   WITH production->op_end
REPL prdwct->t_time   WITH production->t_time
REPL prdwct->t_yard   WITH production->t_yard
REPL prdwct->speed    WITH production->speed
REPL prdwct->remark   WITH production->remark
REPL prdwct->color    WITH production->color
REPL prdwct->print    WITH production->print
REPL prdwct->dep      WITH production->dep
REPL prdwct->mkt_no   WITH production->mkt_no
REPL prdwct->p_yard   WITH production->p_yard
REPL prdwct->temp     WITH production->temp
REPL prdwct->st_code  WITH production->st_code
REPL prdwct->ch_no    WITH production->ch_no
REPL prdwct->ch_wt    WITH production->ch_wt
SELE production
```

```
@ 24,0 CLEAR
SET ESCA OFF
ON ESCAPE
RETURN↑
```

```
D:\MPS\PRG>
```

ศูนย์วิทยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย



ภาคผนวก ค

สรุปผลการพยากรณ์ผ้าชีทรี ผ้า Burn-out 100% และผ้าสำลี

ศูนย์วิจัยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย

TIME SERIES : SEE-THROUGH PRODUCT FORECASTING

OBSN	1	220528
OBSN	2	238002
OBSN	3	237976
OBSN	4	179647
OBSN	5	344001
OBSN	6	402531
OBSN	7	218490
OBSN	8	141594
OBSN	9	62526
OBSN	10	61097
OBSN	11	67768
OBSN	12	160124
OBSN	13	152083
OBSN	14	243973
OBSN	15	256369
OBSN	16	89469
OBSN	17	402531
OBSN	18	327438
OBSN	19	299524
OBSN	20	153046
OBSN	21	84429
OBSN	22	95296
OBSN	23	64197
OBSN	24	163150
OBSN	25	120000
OBSN	26	350000
OBSN	27	400000
OBSN	28	158000
OBSN	29	880000
OBSN	30	950000
OBSN	31	920000
OBSN	32	700000
OBSN	33	550000
OBSN	34	280000
OBSN	35	520000

MINIMUM = 61097
 MAXIMUM = 950000
 MEAN = 299822.5
 STD DEV = 242906.2

WINTERS - WINTERS 3-PARAMETERS LINEAR EXPO. SMOOTH.

TIME SERIES : SEE-THROUGH PRODUCT FORECASTING

ALPHA = .1

BETA = .1

GAMMA = .1

INITIAL ESTIMATE OF INTERCEPT = 194649.1

INITIAL ESTIMATE OF SLOPE = -19.29948

LAST PERIOD ESTIMATE OF INTERCEPT = 709319.1

LAST PERIOD ESTIMATE OF SLOPE = 41233.66

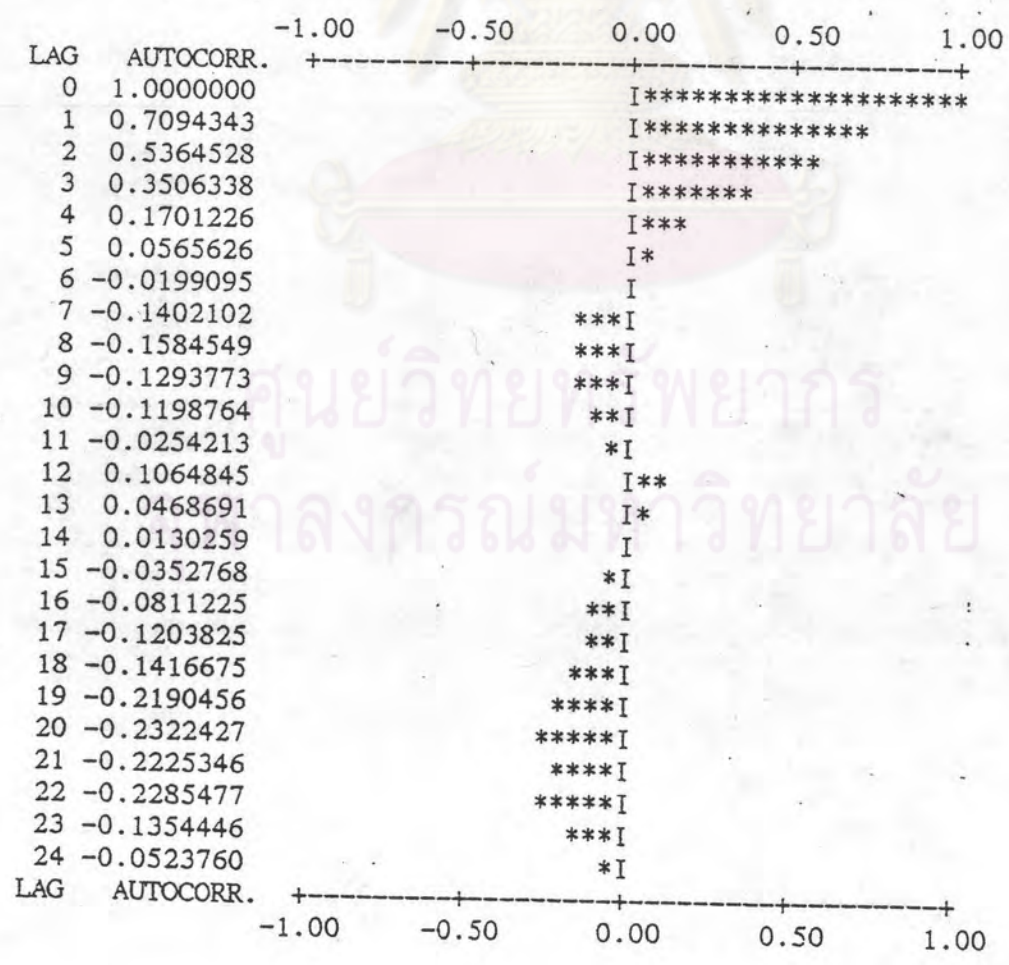
SEASONAL FACTOR	INITIAL EST.	FINAL EST.
1	0.957779	0.863279
2	1.239162	1.207952
3	1.271110	1.248424
4	0.691894	0.648338
5	1.919987	1.963722
6	1.877373	1.911532
7	1.332594	1.400818
8	0.757985	0.811035
9	0.378116	0.421807
10	0.402457	0.387417
11	0.339578	0.358494
12	0.831964	0.777184

PERIOD	ACTUAL	FORECAST	ERROR	%ERROR
1	220528.00	186412.42	34115.58	15.47
2	238002.00	245691.95	-7689.95	3.23
3	237976.00	251659.77	-13683.77	5.75
4	179647.00	136425.63	43221.38	24.06
5	344001.00	391467.81	-47466.81	13.80
6	402531.00	379827.41	22703.59	5.64
7	218490.00	271878.88	-53388.88	24.44
8	141594.00	152113.19	-10519.19	7.43
9	62526.00	75433.30	-12907.30	20.64
10	61097.00	78867.55	-17770.55	29.09
11	67768.00	64868.14	2899.86	4.28
12	160124.00	159142.56	981.44	0.61
13	152083.00	185734.55	-33651.55	22.13
14	243973.00	230726.78	13246.22	5.43
15	256369.00	236396.28	19972.72	7.79
16	89469.00	133445.78	-43976.78	49.15
17	402531.00	342856.56	59674.44	14.82
18	327438.00	344105.03	-16667.03	5.09
19	299524.00	236227.39	63296.61	21.13
20	153046.00	138848.27	14197.73	9.28
21	84429.00	69135.91	15293.09	18.11
22	95296.00	74800.67	20495.33	21.51
23	64197.00	66624.27	-2427.27	3.78
24	163150.00	162505.33	644.67	0.40
25	120000.00	187399.52	-67399.52	56.17
26	350000.00	234817.63	115182.38	32.91
27	400000.00	252586.75	147413.25	36.85
28	158000.00	145110.00	12890.00	8.16
29	880000.00	413324.88	466675.12	53.03
30	950000.00	450207.59	499792.41	52.61

31	920000.00	361004.16	558995.88	60.76
32	700000.00	241944.11	458055.88	65.44
33	550000.00	148824.94	401175.06	72.94
34	280000.00	210837.95	69162.05	24.70
35	520000.00	193044.08	326955.94	62.88
36		583317.31		
37		683532.81		
38		1006248.25		
39		1091439.25		
40		593545.69		
41		1878733.88		
42		1907622.38		
43		1455713.25		
44		876259.50		
45		473121.69		
46		450523.09		
47		431670.75		
48		967870.81		

NUMBER OF ERROR OBSNS 35
 MEAN % ERROR OR BIAS 10.80334
 MEAN ABSOLUTE %ERROR 24.55709
 MEAN SQUARED ERROR (MSE) 3.782997E+10
 MEAN ABSOLUTE ERROR 105559.7

TIME SERIES : SEE-THROUGH PRODUCT FORECASTING.



PERIOD	ACTUAL	FORECAST					
1	220528.00	186412.42	-	+			
2	238002.00	245691.95	-	+			
3	237976.00	251659.77	-	+			
4	179647.00	136425.63	-	*0			
5	344001.00	391467.81	-		O*		
6	402531.00	379827.41	-		+		
7	218490.00	271878.88	-		O*		
8	141594.00	152113.19	-	+			
9	62526.00	75433.30	-	O*			
10	61097.00	78867.55	-	O*			
11	67768.00	64868.14	-	+			
12	160124.00	159142.56	-	+			
13	152083.00	185734.55	-	O*			
14	243973.00	230726.78	-	+			
15	256369.00	236396.28	-	+			
16	89469.00	133445.78	-	O*			
17	402531.00	342856.56	-		*O		
18	327438.00	344105.03	-	+			
19	299524.00	236227.39	-		*O		
20	153046.00	138848.27	-	+			
21	84429.00	69135.91	-	*O			
22	95296.00	74800.67	-	*O			
23	64197.00	66624.27	-	+			
24	163150.00	162505.33	-	+			
25	120000.00	187399.52	-	O*			
26	350000.00	234817.63	-		* O		
27	400000.00	252586.75	-		* O		
28	158000.00	145110.00	-	+			
29	880000.00	413324.88	-		*		O
30	950000.00	450207.59	-		*		O
31	920000.00	361004.16	-		*		O
32	700000.00	241944.11	-		*		O
33	550000.00	148824.94	-		*		O
34	280000.00	210837.95	-		* O		
35	520000.00	193044.08	-		*		O
36		583317.31	-		*		
37		683532.81	-		*		
38		1006248.25	-		*		
39		1091439.25	-		*		
40		593545.69	-		*		
41		1878733.88	-		*		*
42		1907622.38	-		*		*
43		1455713.25	-		*		
44		876259.50	-		*		
45		473121.69	-		*		
46		450523.09	-		*		
47		431670.75	-		*		
48		967870.81	-		*		



TIME SERIES : BURN-OUT PRODUCT FORECASTING

OBSN	1	103270
OBSN	2	41799
OBSN	3	94502
OBSN	4	229309
OBSN	5	188698
OBSN	6	245733
OBSN	7	110188
OBSN	8	157935
OBSN	9	139827
OBSN	10	122425
OBSN	11	149417
OBSN	12	93240
OBSN	13	96725
OBSN	14	90000
OBSN	15	100891
OBSN	16	189507
OBSN	17	322813
OBSN	18	222625
OBSN	19	176327
OBSN	20	184899
OBSN	21	122221
OBSN	22	138338
OBSN	23	178579
OBSN	24	160000
OBSN	25	130000
OBSN	26	300000
OBSN	27	270000
OBSN	28	610000
OBSN	29	580000
OBSN	30	850000
OBSN	31	570000
OBSN	32	480000
OBSN	33	457000
OBSN	34	543900
OBSN	35	612300

MINIMUM = 41799

MAXIMUM = 850000

MEAN = 258927.7

STD DEV = 198959.5

WINTERS - WINTERS 3-PARAMETERS LINEAR EXPO. SMOOTH.
 TIME SERIES : BURN-OUT PRODUCT FORECASTING
 ALPHA = .2
 BETA = .1
 GAMMA = .1
 INITIAL ESTIMATE OF INTERCEPT = 125856.5
 INITIAL ESTIMATE OF SLOPE = 2129.042
 LAST PERIOD ESTIMATE OF INTERCEPT = 595916.9
 LAST PERIOD ESTIMATE OF SLOPE = 26358.86

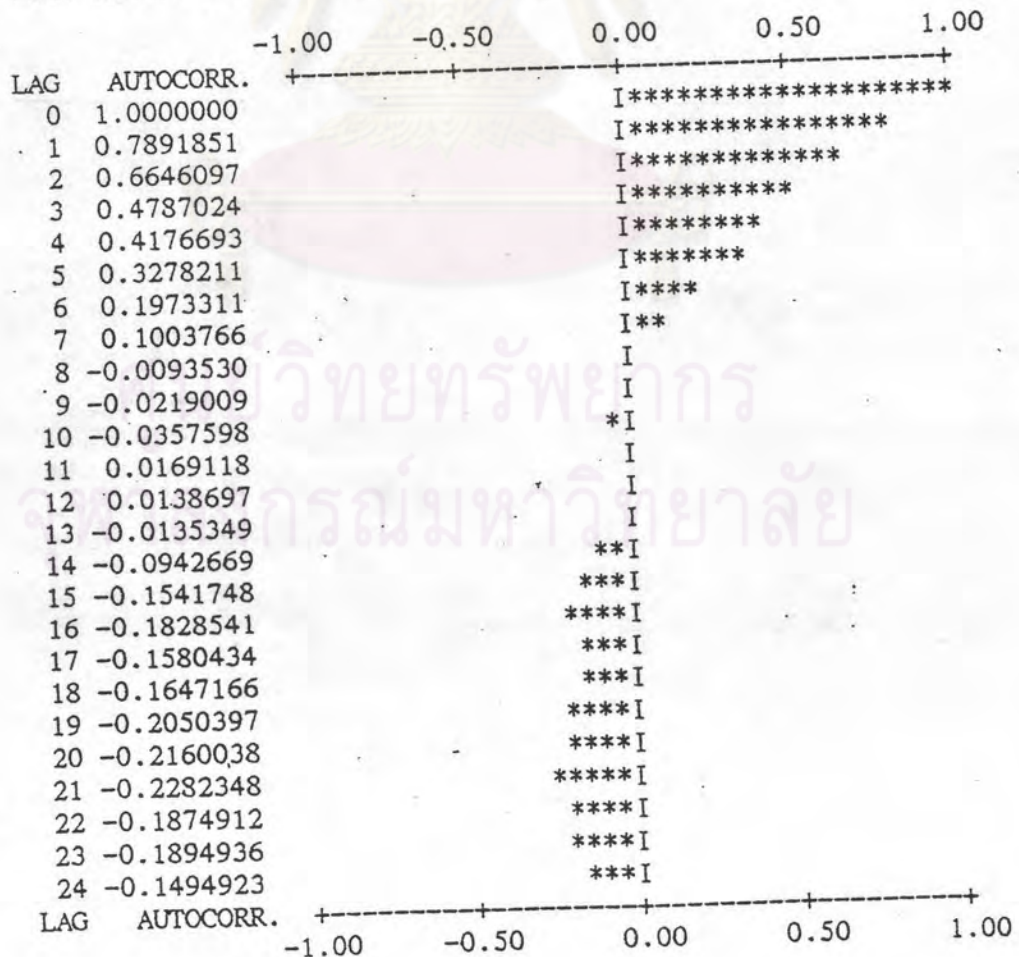
SEASONAL FACTOR	INITIAL EST.	FINAL EST.
1	0.718824	0.706102
2	0.449951	0.503641
3	0.677361	0.684356
4	1.446534	1.451692
5	1.688125	1.655738
6	1.565118	1.588797
7	0.922019	0.937671
8	1.102106	1.074663
9	0.840833	0.831702
10	0.816959	0.819197
11	1.011752	0.998432
12	0.760419	0.748006

PERIOD	ACTUAL	FORECAST	ERROR	%ERROR
1	103270.00	91999.09	11270.91	10.91
2	41799.00	60062.82	-18263.82	43.69
3	94502.00	86107.70	8394.30	8.88
4	229309.00	190107.58	39201.42	17.10
5	188698.00	234645.09	-45947.09	24.35
6	245733.00	212442.42	33290.58	13.55
7	110188.00	130986.89	-20798.89	18.88
8	157935.00	153787.98	4147.02	2.63
9	139827.00	119556.14	20270.86	14.50
10	122425.00	121953.31	471.69	0.39
11	149417.00	153587.59	-4170.59	2.79
12	93240.00	116601.98	-23361.98	25.06
13	96725.00	108180.13	-11455.13	11.84
14	90000.00	64602.15	25397.86	28.22
15	100891.00	110145.18	-9254.18	9.17
16	189507.00	236603.95	-47096.95	24.85
17	322813.00	260004.39	62808.61	19.46
18	222625.00	263160.47	-40535.47	18.21
19	176327.00	148471.25	27855.75	15.80
20	184899.00	189538.38	-4639.38	2.51
21	122221.00	147561.09	-25340.09	20.73
22	138338.00	138328.34	9.66	0.01
23	178579.00	172731.25	5847.75	3.27
24	160000.00	130224.13	29775.88	18.61
25	130000.00	132850.83	-2850.83	2.19
26	300000.00	84147.25	215852.75	71.95
27	270000.00	198609.75	71390.25	26.44
28	610000.00	473739.44	136260.56	22.34
29	580000.00	612021.06	-32021.06	5.52
30	850000.00	584987.75	265012.25	31.18

31	570000.00	392506.16	177493.84	31.14
32	480000.00	534970.75	-54970.75	11.45
33	457000.00	417815.56	39184.44	8.57
34	543900.00	432624.38	111275.63	20.46
35	612300.00	588468.62	23831.38	3.89
36		465466.25		
37		458002.06		
38		339954.53		
39		479974.81		
40		1056412.38		
41		1248542.62		
42		1239943.12		
43		756501.31		
44		895352.12		
45		714852.81		
46		725697.06		
47		910793.19		
48		702065.38		

NUMBER OF ERROR OBSNS 35
 MEAN % ERROR OR BIAS 4.229565
 MEAN ABSOLUTE %ERROR 16.87246
 MEAN SQUARED ERROR (MSE) 5.950633E+09
 MEAN ABSOLUTE ERROR 47135.7

TIME SERIES : BURN-OUT PRODUCT FORECASTING



PERIOD	ACTUAL	FORECAST		0.00	400000.00	800000.00	%1200000.00	%1600000.00
1	103270.00	91999.09	-	*O				
2	41799.00	60062.82	-	O*				
3	94502.00	86107.70	-	+				
4	229309.00	190107.58	-	*O				
5	188698.00	234645.09	-	O*				
6	245733.00	212442.42	-	*O				
7	110188.00	130986.89	-	+				
8	157935.00	153787.98	-	+				
9	139827.00	119556.14	-	+				
10	122425.00	121953.31	-	+				
11	149417.00	153587.59	-	+				
12	93240.00	116601.98	-	O*				
13	96725.00	108180.13	-	O*				
14	90000.00	64602.15	-	+				
15	100891.00	110145.18	-	+				
16	189507.00	236603.95	-	O*				
17	322813.00	260004.39	-	*O				
18	222625.00	263160.47	-	O*				
19	176327.00	148471.25	-	+				
20	184899.00	189538.38	-	+				
21	122221.00	147561.09	-	O*				
22	138338.00	138328.34	-	+				
23	178579.00	172731.25	-	+				
24	160000.00	130224.13	-	*O				
25	130000.00	132850.83	-	+				
26	300000.00	84147.25	-	* O				
27	270000.00	198609.75	-	* O				
28	610000.00	473739.44	-		* O			
29	580000.00	612021.06	-		+			
30	850000.00	584987.75	-		* O			O
31	570000.00	392506.16	-		* O			
32	480000.00	534970.75	-		O*			
33	457000.00	417815.56	-		*O			
34	543900.00	432624.38	-		* O			
35	612300.00	588468.62	-		+			
36		465466.25	-		*			
37		458002.06	-		*			
38		339954.53	-		*			
39		479974.81	-		*			
40		1056412.38	-				*	
41		1248542.62	-				*	*
42		1239943.12	-				*	*
43		756501.31	-			*		
44		895352.12	-			*		
45		714852.81	-			*		
46		725697.06	-			*		
47		910793.19	-			*		
48		702065.38	-			*		

วิทยาลัยพยาบาล
 จุฬาลงกรณ์มหาวิทยาลัย

TIME SERIES : SUMLEE PRODUCT FORECASTING

OBSN	1	182301
OBSN	2	190000
OBSN	3	208022
OBSN	4	256980
OBSN	5	195000
OBSN	6	177464
OBSN	7	184450
OBSN	8	135899
OBSN	9	155386
OBSN	10	88045
OBSN	11	52829
OBSN	12	85391
OBSN	13	133051
OBSN	14	119799
OBSN	15	212898
OBSN	16	272188
OBSN	17	197588
OBSN	18	111945
OBSN	19	79774
OBSN	20	76046
OBSN	21	67050
OBSN	22	65125
OBSN	23	54340
OBSN	24	120043
OBSN	25	181203
OBSN	26	185930
OBSN	27	210340
OBSN	28	380400
OBSN	29	260020
OBSN	30	200000
OBSN	31	120350
OBSN	32	67843
OBSN	33	70368
OBSN	34	60125
OBSN	35	59725

MINIMUM = 52829
 MAXIMUM = 380400
 MEAN = 149083.4
 STD DEV = 76925.73

WINTERS - WINTERS 3-PARAMETERS LINEAR EXPO. SMOOTH.

TIME SERIES : SUMLEE PRODUCT FORECASTING

ALPHA = .2

BETA = .1

GAMMA = .1

INITIAL ESTIMATE OF INTERCEPT = 177456.1

INITIAL ESTIMATE OF SLOPE = -2791.111

LAST PERIOD ESTIMATE OF INTERCEPT = 134656.6

LAST PERIOD ESTIMATE OF SLOPE = -729.077

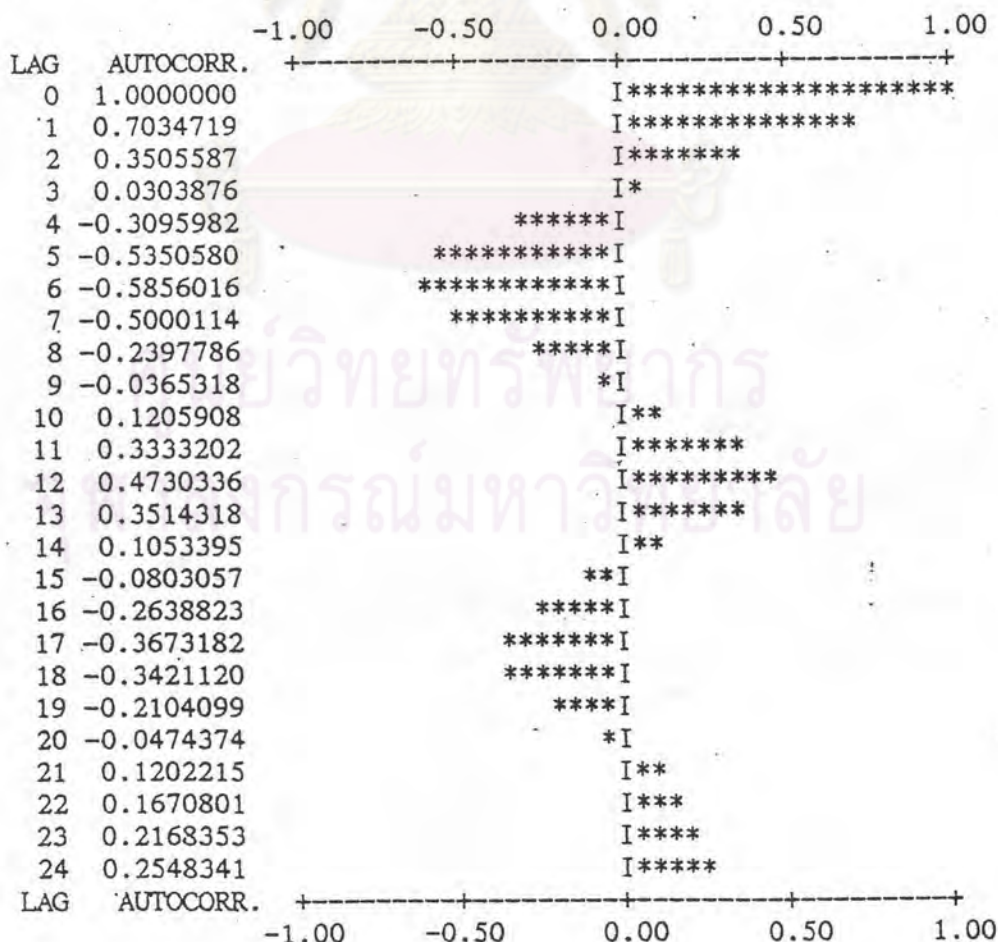
SEASONAL FACTOR	INITIAL EST.	FINAL EST.
1	1.009346	1.046592
2	1.001718	1.029560
3	1.423142	1.423000
4	1.826906	1.878677
5	1.378430	1.389798
6	1.008339	1.014795
7	0.919376	0.888311
8	0.762908	0.723120
9	0.805066	0.763849
10	0.584370	0.567753
11	0.426751	0.426856
12	0.853647	0.847687

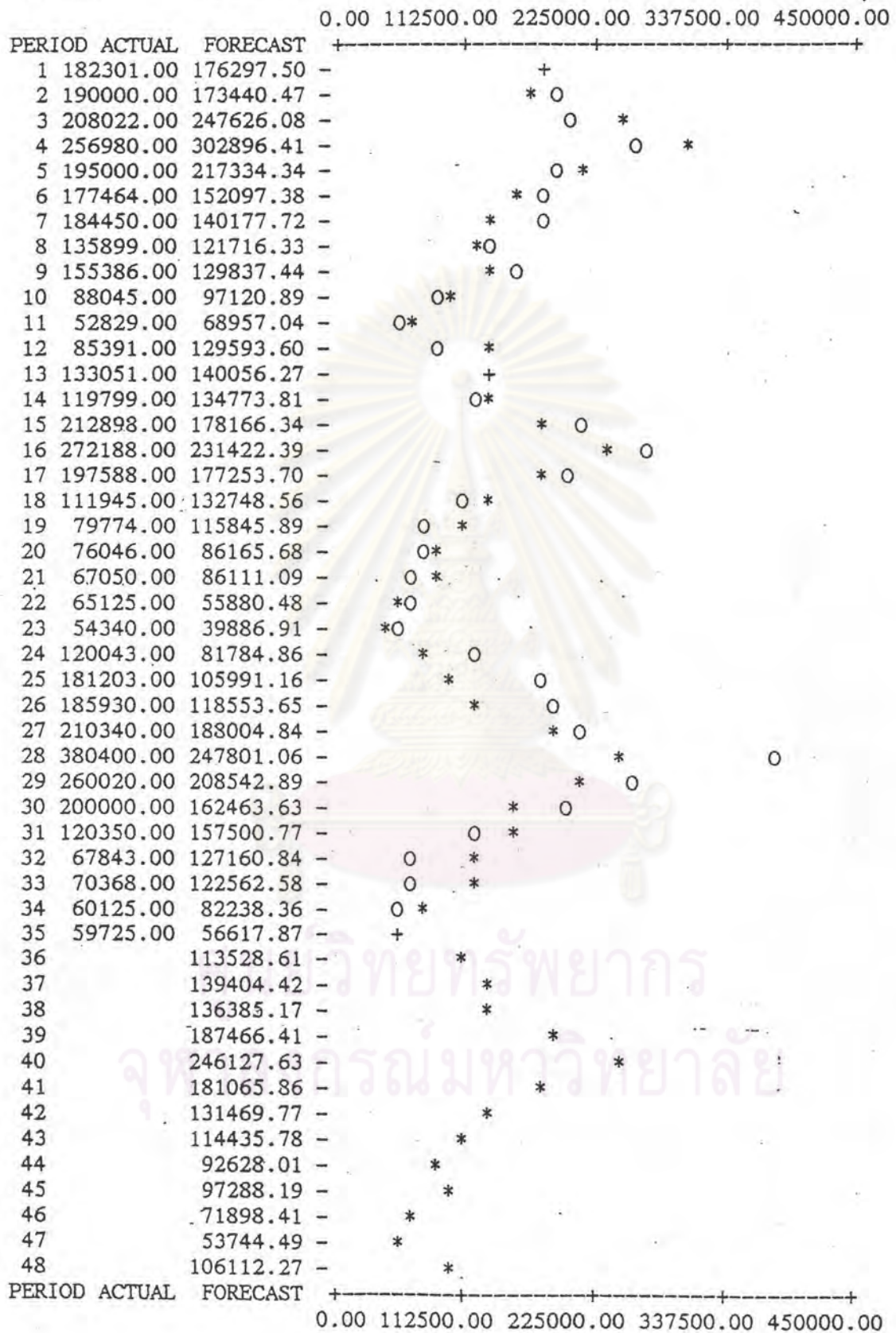
PERIOD	ACTUAL	FORECAST	ERROR	%ERROR
1	182301.00	176297.50	6003.50	3.29
2	190000.00	173440.47	16559.53	8.72
3	208022.00	247626.08	-39604.08	19.04
4	256980.00	302896.41	-45916.41	17.87
5	195000.00	217334.34	-22334.34	11.45
6	177464.00	152097.38	25366.63	14.29
7	184450.00	140177.72	44272.28	24.00
8	135899.00	121716.33	14182.67	10.44
9	155386.00	129837.44	25548.56	16.44
10	88045.00	97120.89	-9075.89	10.31
11	52829.00	68957.04	-16128.04	30.53
12	85391.00	129593.60	-44202.60	51.76
13	133051.00	140056.27	-7005.27	5.27
14	119799.00	134773.81	-14974.81	12.50
15	212898.00	178166.34	34731.66	16.31
16	272188.00	231422.39	40765.61	14.98
17	197588.00	177253.70	20334.30	10.29
18	111945.00	132748.56	-20803.56	18.58
19	79774.00	115845.89	-36071.89	45.22
20	76046.00	86165.68	-10119.68	13.31
21	67050.00	86111.09	-19061.09	28.43
22	65125.00	55880.48	9244.52	14.20
23	54340.00	39886.91	14453.09	26.60
24	120043.00	81784.86	38258.14	31.87
25	181203.00	105991.16	75211.84	41.51
26	185930.00	118553.65	67376.35	36.24
27	210340.00	188004.84	22335.16	10.62
28	380400.00	247801.06	132598.94	34.86
29	260020.00	208542.89	51477.11	19.80
30	200000.00	162463.63	37536.38	18.77

31	120350.00	157500.77	-37150.77	30.87
32	67843.00	127160.84	-59317.84	87.43
33	70368.00	122562.58	-52194.58	74.17
34	60125.00	82238.36	-22113.36	36.78
35	59725.00	56617.87	3107.13	5.20
36		113528.61		
37		139404.42		
38		136385.17		
39		187466.41		
40		246127.63		
41		181065.86		
42		131469.77		
43		114435.78		
44		92628.01		
45		97288.19		
46		71898.41		
47		53744.49		
48		106112.27		

NUMBER OF ERROR OBSNS 35
 MEAN % ERROR OR BIAS -3.860064
 MEAN ABSOLUTE %ERROR 24.34103
 MEAN SQUARED ERROR (MSE) 1.66316E+09
 MEAN ABSOLUTE ERROR 32441.07

TIME SERIES : SUMLEE PRODUCT FORECASTING







ประวัติผู้เขียน

นายปดิพงษ์ เหล่าตระกูลงาม เกิดวันที่ 10 มกราคม พ.ศ. 2510 ที่อำเภอ ยานดาขาว จังหวัดตรัง ได้รับความศึกษาในคณะวิทยาศาสตร์ มหาวิทยาลัยสงขลานครินทร์ วิทยาเขตหาดใหญ่ เมื่อปี พ.ศ. 2527 และสำเร็จการศึกษา วิทยาศาสตร์บัณฑิต สาขา คณิตศาสตร์และคอมพิวเตอร์ในปี พ.ศ. 2531 ประสบการณ์การทำงานตำแหน่ง ผู้ช่วยวิเคราะห์ ระบบงานคอมพิวเตอร์ แผนกระบบงานด้านโรงงาน บริษัทตาต้าแมท จำกัด



ศูนย์วิทยทรัพยากร
จุฬาลงกรณ์มหาวิทยาลัย