



# SAP QM – The Basics and Beyond

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# QM 101 – The Basics and Beyond

- QM 101 - The Basics
  - What is QM?
    - Using QM at varying levels of complexity
  - QM Integration Points
    - Inspection Types
  - QM Master Data
    - Inspection Methods
    - Master Inspection Characteristics
    - Inspection Plan
    - QM View of Material Master
  - A Working Example

# QM 101 – The Basics and Beyond

- QM 101 - And Beyond
  - The Bells and Whistles of QM
    - SPC Charting
    - Dynamic Modification
    - Lot Copy/Inheritance
    - Calibration

# QM 101 – The Basics and Beyond

- What is QM?
  - Complete integrated quality management solution that provides Quality Assurance and Quality Control through integration
- QM Process
  - Quality Planning
  - Quality Inspection
    - Inspection Lot Creation and Sample Determination
    - Results Recording
    - Defects Recording
    - Usage Decision
  - Evaluations (Reporting)

## Why QM?

- Why?
  - ✓ Improve Quality of your Products
  - ✓ Integrate Quality functions within your business
  - ✓ Better Quality Metrics
    - ✓ If you can't measure it, you can't manage it
  - ✓ Support Six Sigma and Black Belt Initiatives
  - ✓ Increase visibility across Supply Chain
    - ✓ Everybody can't be on the shop floor

# Project Drivers

- Sample Drivers for Implementing SAP QM
  - » Re-calls / Returns of failed product
  - » Difficulty in calculating Quality metrics (KPI)
  - » Meet regulatory requirements (i.e. FDA)
    - » Officers/Directors can be liable
  - » Improve traceability of products
  - » Integrate Quality into ERP system
  - » Save on separate licensing/support costs
  - » Eliminate paper forms, spreadsheets, local syst.
  - » Standardize and automate QM Process across Plants & Divisions

# QM – Flexible and Powerful

- Using QM at varying levels of complexity
  - Generic QM
    - Post to QI bucket (Can be used without using QM module)
  - Easy QM
    - Some control via posting to QI via an Inspection Lot
    - No results recording, stock managed via inspection lot and usage decision
  - Standard QM
    - Post to QI via an Inspection Lot using an Inspection Plan for specifications
    - Requires Characteristic Recording
    - COA Generation
  - Complex QM
    - Pos to QI via an Inspection Lot with an Inspection Plan using Sample Maganement, Sample Calculation, SPC, Dynamic Modification, Defects Recording, etc, etc, etc

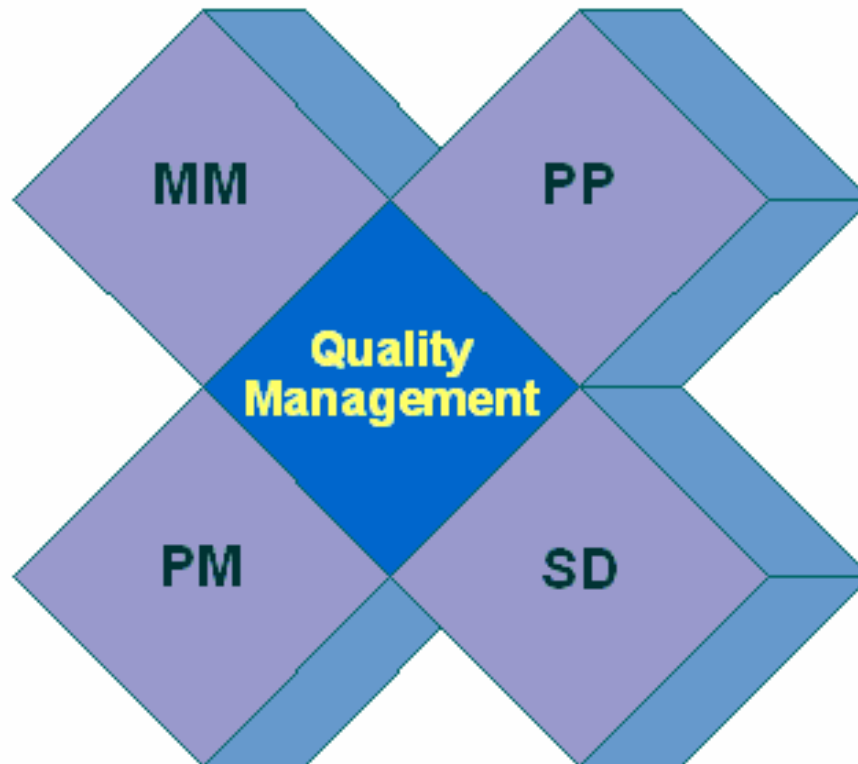


## QM – Where does it fit in SAP?

- Integrated throughout Logistics supply chain
- Inventory Management (stock status, blocking)
- Purchasing - Vendor Eval., Audits, Incoming Certs.
- Receiving Inspection
- Production - In Process data collection, defects
- Sales & Distribution - Ship QA, outgoing Certs.
- Accounting - costs due to scrap, inspection, etc.
- Plant Maintenance - gauge calibration / control
- Central Functions - Document Management, Batch Management, Classification

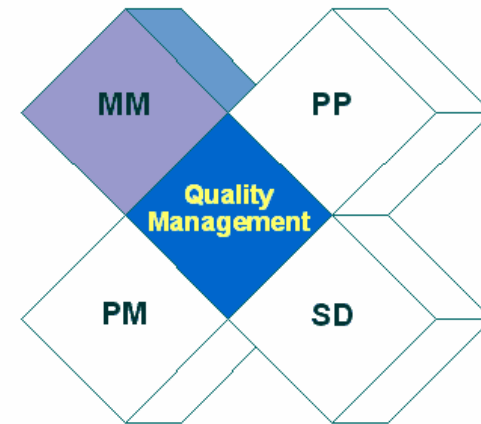
# QM – Integration Points

- QM Integration Points



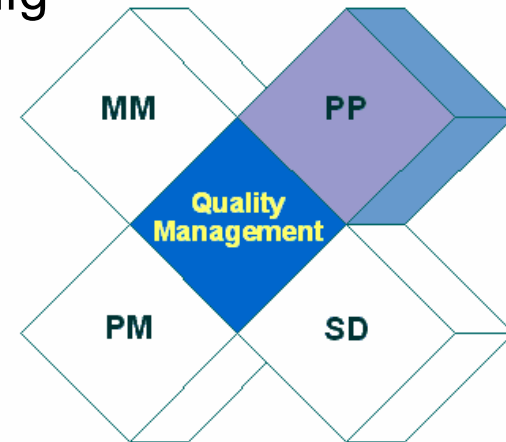
# QM – Integration Points

- QM Inspection Types – MM
  - 01 – Goods receipt insp. for purchase order
  - 0101 - Model inspection at GR for purch. Order
  - 0130 - GR inspection from external processing
  - 07 - Audit inspection for a vendor
  - 08 - Stock transfer inspection
  - 0800 - Insp. lot with insp. stock at QM actvtn
  - 09 - Recurring inspection of batches



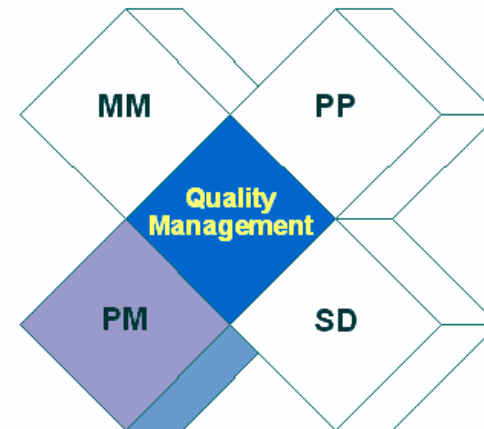
# QM – Integration Points

- QM Inspection Types – PP
  - 02 - Goods issue inspection
  - 03 - In-process insp. for manufacturing order
  - 04 - Goods receipt inspection from production
  - 05 - Inspection for other goods receipt
  - 13 - In-process insp. for repetitive mfg
  - 89 - Other inspection



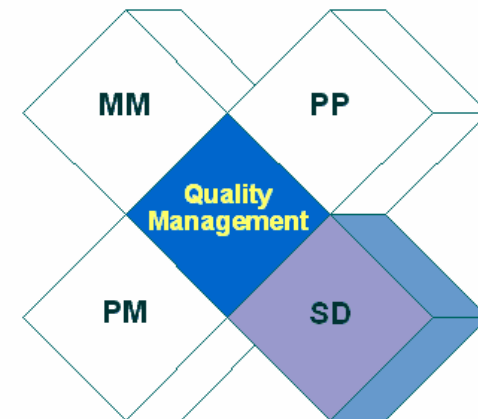
# QM – Integration Points

- QM Inspection Types – PM
  - 14 - Inspection in Plant Maintenance
  - 16 - Inspection for Storage Condition (Stabi)
  - 1601 - Initial Test (Stability Studies)
  - 1602 - Manual Insp. Lot for Storage Cond (Stab)



# QM – Integration Points

- QM Inspection Types – SD
  - 06 – Customer Returns
  - 10 - Insp. for delivery to cust. (w/ order)
  - 11 - Insp. for delivery to cust. (w/o order)
  - 12 - Inspection for delivery in general



## Master Data – Inspection Methods

- Used to define how the inspection is to be performed for an inspection characteristic
- Typically is used as a reference to a procedure
- Can be used with DMS to physically link to the actual document
  - Documents from a file server
  - Documents from a web address
- Defined at the plant level although a standard plant is typically used

# Master Data – Master Inspection Characteristics

- An inspection characteristic that has been defined for frequent use (standardization) or reporting across inspection plans (global reporting)
- Can be Quantitative or Qualitative
- Control Indicators are the “Attributes” of the characteristic
  - Recording Level
  - Scope
  - Required/Optional
- Can be assigned to one or more Inspection Methods
- Defined at the plant level although a standard plant is typically used

# Master Data – Inspection Plans

- Used to describe how a quality inspection should be performed, specifically what tests at what specification
  - Basically its where everything comes together
- Can be created and assigned to one or more materials
- A material can have multiple inspection plans for use in different processes (defined by Usage)
  - Inspection Types are assigned a task list usage in customizing
- Inspection Plans are task lists, so you have the option to use all functionality of a task list including costing, finite scheduling, and capacity planning

# Master Data – QM View of Material Master

- QM Specific data is maintained at the Plant Level
- Post to QI flag start Generic QM
- Inspection Setup defines if and where the material is to be inspected
- Once a stock relevant inspection type is activated, the material must be managed via QM if stock is to be put into QI (All or nothing)
- Flexibility to activate different inspection types at different plants for the same material
- QA08 can be used to Mass Activate materials

# QM 101 – The Basics and Beyond

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  - The Bells and Whistles of QM
    - SPC Charting
    - Dynamic Modification
    - Lot Copy/Inheritance
    - COA Generation
    - Calibration
  - A working Example

# QM 101 – The Bells and Whistles of QM

- Most implementations focus on Take, Make, Ship, Bill
  - Typical QM focus is on Finish Goods testing and COA generation
- Tight time lines, and master data conversion typically take time away from “extras”
- User base initially is shocked with just running QM
- Industry best practice is to implement QM, get stable, and then think about adding value added extras to the QM system



## QM 101 – SPC Charting

- Offered by SAP in early releases
- Driven off of the Sampling Procedure & whether or not the inspection characteristic is SPC relevant or not
- Multiple “Standard” charts available including X & Y bar chars, Shewart, etc
- Ability to customize new control charts, and incorporate custom function modules to do the calculations
- Can be viewed in a stand alone transaction, or as part of the results recording screen

# Results Recording – SPC Chart



**Record Results for 3150292-006 000007: Single Values for Characteris**

Defects... Control chart Histogram Run values (run chart) Results history Inspection point... Valuation parameter...

Inspector Insp. start time 00/00/0000 00...

Char. filter Open required characteri

- 20000271474 - 3150292-006 - 485-
  - 0026 EM0 / Sample 1 - FET The
    - Employee # : CDUNLAP /
      - 0010 FET Thermal G
        - Further inspection
          - 0027 EM0 / Sample 2 - Torque v
            - 0030 EM1 / OMS work center R6
              - 0040 EM2 / OMS work center R6
                - 0050 EM3 / OMS work center R6
                  - 0110 OPEN BOX TQC PG 1170t
                    - 0170 FINAL ASSY TQC PG 127C

| No | Measured ... | V... | Defect cl... | Attribute | Insp. unit no. | Insp. de |
|----|--------------|------|--------------|-----------|----------------|----------|
| 1  | 0.075        | ✓    |              |           | 413975         |          |

Specs: Fixed Insp. Scope

|            |   |        |    |
|------------|---|--------|----|
| Inspect    | 1 | * 1.00 | EA |
| Upper lim. |   | 0.115  | oz |
| Trgt value |   | 0.080  | oz |
| Lower lmt. |   | 0.050  | oz |

Shewhart chart for X bar / r FET Thermal Grease [ New ]

The chart displays two data series: Mean values (top) and Range (bottom). The X-axis represents time in MM/DD/YYYY format. The Y-axis for Mean values ranges from 0.06 to 0.12, and for Range from 0.1 to 0.5. Control lines are shown in red (center and 3-sigma limits) and green (2-sigma limits).

| Date           | Mean Value |
|----------------|------------|
| 2000027 1470/M | 0.095      |
| 2000027 1471/M | 0.065      |
| 2000027 1471/2 | 0.090      |
| 2000027 1472/1 | 0.095      |
| 2000027 1472/2 | 0.110      |
| 2000027 1472/3 | 0.095      |
| 2000027 1472/4 | 0.098      |
| 2000027 1473/M | 0.085      |
| 2000027 1474/M | 0.082      |
| 2000027 1474/2 | 0.090      |
| 2000027 1474/3 | 0.088      |
| 2000027 1474/4 | 0.090      |
| 2000027 1474/5 | 0.110      |
| 2000027 1474/6 | 0.118      |
| 2000027 1474/7 | 0.075      |

| Date           | Range |
|----------------|-------|
| 20000271 470/M | 0.35  |
| 20000271 471/M | 0.32  |
| 20000271 471/2 | 0.32  |
| 20000271 472/1 | 0.32  |
| 20000271 472/2 | 0.32  |
| 20000271 472/3 | 0.32  |
| 20000271 472/4 | 0.32  |
| 20000271 473/M | 0.32  |
| 20000271 474/M | 0.32  |
| 20000271 474/2 | 0.32  |
| 20000271 474/3 | 0.32  |
| 20000271 474/4 | 0.32  |
| 20000271 474/5 | 0.32  |
| 20000271 474/6 | 0.32  |

# QM Reports w/o SPC

Results history

**Master insp.charac.** VR Voltage - Red Wire  
**Version** Cross-version evaluation  
**Selection criteria** Material ICN132MC35M ELE BALLAST (1) F32T8 120-277V  
**Evaluation period** From 10/10/2004 To 10/10/2005

| Valuation | Inspection Lot | Sample | S | Valuation | MsmtUn | TargVal. | Upper lim. | Lower tol. | Mean value | Std... | Inspted | Nonconf | No. def. | No. |
|-----------|----------------|--------|---|-----------|--------|----------|------------|------------|------------|--------|---------|---------|----------|-----|
| ○○○       | 40000000058    | 1      | 5 | Accepted  | V      |          | 7.000      | 1.000      | 2.000      |        | 100     | 0       | 0        |     |
| ○○○       | 40000000057    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 2.000      |        | 100     | 0       | 0        |     |
| ○○○       | 40000000056    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 2.000      |        | 775     | 0       | 0        |     |
| ○○○       | 40000000055    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 2.000      |        | 500     | 0       | 0        |     |
| ○○○       | 40000000054    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 3.798      |        | 500     | 0       | 0        |     |
| ○○○       | 40000000070    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 3.000      |        | 1,000   | 0       | 0        |     |
| ○○○       | 40000000067    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 5.000      |        | 500     | 0       | 0        |     |
| ○○○       | 40000000065    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 1.000      |        | 1,000   | 0       | 0        |     |
| ○○○       | 40000000063    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 2.000      |        | 1,000   | 0       | 0        |     |
| ○○○       | 40000000062    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 2.000      |        | 100     | 0       | 0        |     |
| ○○○       | 40000000061    |        | 5 | Accepted  | V      |          | 7.000      | 1.000      | 1.000      |        | 100     | 0       | 0        |     |

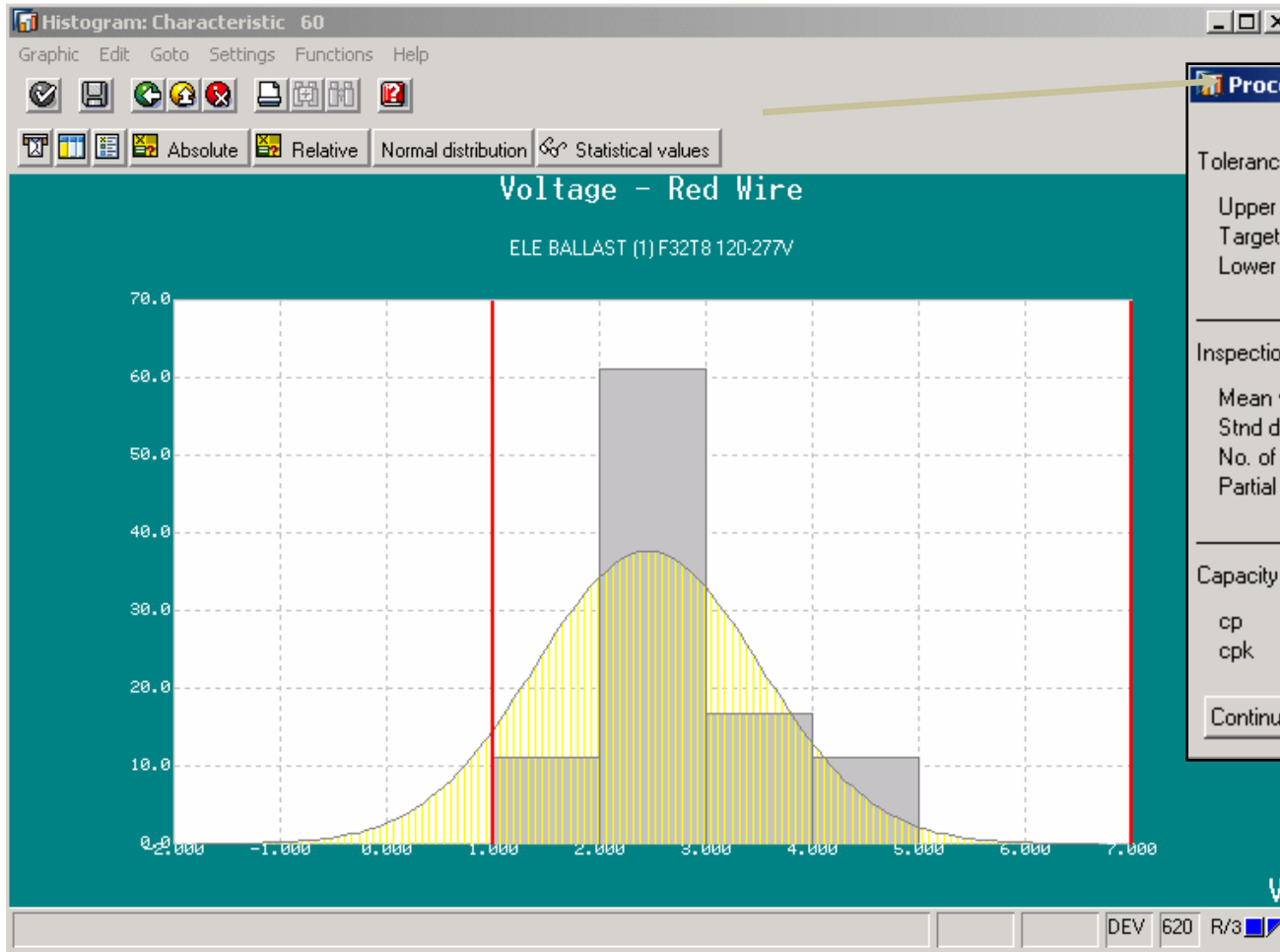
Download to Excel | Histogram | Run Chart | Single values | Single values | Single values | Inspection lot

Download to Excel

Run Chart

Histogram

# QMIS – Histogram & Statistics



### Process Capability

|                 |       |
|-----------------|-------|
| Tolerance value |       |
| Upper Limit     | 7.000 |
| Target value    |       |
| Lower spec. lmt | 1.000 |

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|                    |         |
|--------------------|---------|
| Inspection Results |         |
| Mean value         | 2.4531  |
| Std deviation      | 1.05951 |
| No. of values      | 18      |
| Partial samples    | 1       |

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|          |      |
|----------|------|
| Capacity |      |
| cp       | 0.94 |
| cpk      | 0.46 |

Continue



## QM 101 – Dynamic Modification

- Typically referred to as “Skip lot” processing
- Can be at the Inspection Lot or Inspection Characteristic level
- Uses “Quality Levels” to maintain history on skip and inspection statuses
- Special statuses assigned when it is a Skip
- Standard functionality exists to print Skipped characteristic on the COA
- Characteristic Filter on Results Recording screens can be used to not display Skip characteristics

# QM 101 – Dynamic Modification

Results Edit Goto Extras Settings Environment System Help

Record Results: Characteristic Overview

Defects... Insp. method Control chart Histogram Run values (run chart) Results history Valuation parameter...

Material: 410401106 KRYSTAR® 300 50 LB Bag Batch LK7H2724  
 Insp. Lot: 80000012381  
 Activity: 0010 KRYSTAR® 300 FCC P1nt 0385

General Summarized Indicators

| Ac                       | R                        | S | Short text for the inspection char... | Specifications | In | Result |
|--------------------------|--------------------------|---|---------------------------------------|----------------|----|--------|
| <input type="checkbox"/> | <input type="checkbox"/> | 1 | COL SPK                               | <= 3.00 /QT    |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 1 | MET FLK                               | <= 1000        |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 1 | COL-FILT KRY                          | <= 2.00        |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 1 | FILTSPKK                              | <= 6.0 #/200g  |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 1 | ODOR SD CRY5                          | Pass or Fail   |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 1 | FLAVOR SD                             | Pass or Fail   |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | ASH SYRUP                             | <= 250.000 %   |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | +MG CF                                | <= 50.0 PPM    |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | SO2                                   | <= 9 PPM       |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | HMF 5500                              | <= 50.0 PPM    |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | CHLORIDE CFR                          | <= 180.0 PPM   |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | ARSENIC                               | <= 1.0 PPM     |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | SULFATE CFR                           | <= 250.0 PPM   |    |        |
| <input type="checkbox"/> | <input type="checkbox"/> | 4 | HEAVY METALS                          | <= 5.0 PPM     |    |        |

Force Further details...

Results Record Status (1) 11 Entries found

Restrictions

Short text

- 0 Can be processed
- 1 Must be processed
- 2 Processed
- 3 Valuated
- 4 Skip
- 5 Processing is completed
- 6 Transfer Characteristic to Subsystem
- 7 Fixed (cannot be processed)
- 9 Blocked for evaluations
- A Rqd char.when controlling char.accepted
- B Rqd.char.when controlling char.rejected

11 Entries found

SP1 (1) 090 TLASAPP4 INS

# QM 101 – Dynamic Modification

SAP

List Edit Goto Settings System Help

Q-Level Evaluation: Q-Level Dynamic Modification History

Administration Inspection lots Time Inspection lot UD Characteristics Q-level Rule

Plant 2243  
 Material 00000000410401106 KRYSTAR® 300 50 LB Bag  
 Task list Q TN41 0401 01 01  
 Dynamic modification Characteristic  
 Dynamic modification 1:M Tested Once per Month  
 Time of dyn. modif Lot creation  
 Operation/Char. 0010 0200 ASH SYRUP

| Created on | Inspection Lot | Insp. type | LO | Insp. lot quantity | U.. | Sample size | S | S  | Sta... | Text Insp.stage | Se... | Dyn. valu: |
|------------|----------------|------------|----|--------------------|-----|-------------|---|----|--------|-----------------|-------|------------|
| 04/09/2007 | 80000005210    | 08         | 08 | 22,500.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/10/2007 | 80000005405    | 08         | 08 | 13,500.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/12/2007 | 80000005477    | 08         | 08 | 2,250.000          | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
|            | 80000005480    | 08         | 08 | 2,250.000          | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/14/2007 | 80000005260    | 08         | 08 | 20,250.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/15/2007 | 80000005261    | 08         | 08 | 38,250.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/16/2007 | 80000005412    | 08         | 08 | 1.000              | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
|            | 80000005551    | 08         | 08 | 27,000.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/17/2007 | 80000005263    | 08         | 08 | 1.000              | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
|            | 80000005267    | 08         | 08 | 6,750.000          | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/18/2007 | 80000005269    | 08         | 08 | 31,500.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/19/2007 | 80000005801    | 08         | 08 | 33,750.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
|            | 80000005804    | 08         | 08 | 38,250.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/20/2007 | 80000005952    | 08         | 08 | 36,000.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/21/2007 | 80000005955    | 08         | 08 | 33,750.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/23/2007 | 80000005915    | 08         | 08 | 2,250.000          | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
|            | 80000006054    | 08         | 08 | 20,250.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |
| 04/24/2007 | 80000006004    | 08         | 08 | 13,500.000         | LB  | 1.000       | X | 10 | Skip   |                 |       | Accepted   |

SP1 (2) 090 TLASAPP4 INS

## QM 101 – Lot Copy/Inheritance

- Functionality exists to inherit test results from a previous inspection lot to the current one
- BADI QC\_LOT\_COPY provided as of SAP release 4.7 SR2.
- New configuration activity provided to allow lot copy to be turned on for a plant/inspection type combination
- Lot copy functionality can be manual or automatic at time of lot creation or results recording
- Custom code can be added to find inspection lots, or map the characteristics from one lot to another

# QM 101 – Lot Copy/Inheritance

Table View Edit Goto Selection Utilities(M) System Help

Display View "Settings for Copy Inspection Results Function": Overview

| Inspecti... | Plant | Close                               | Origin TL | DatOrig.RR | Selection | Mapping | Del.Days |
|-------------|-------|-------------------------------------|-----------|------------|-----------|---------|----------|
| 01          | 43    | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 01          | 2248  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 01          | 4260  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 01          | F001  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 01          | F002  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 01          | F003  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 01          | F004  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 0102        | 2240  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 0102        | 2246  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 05          | 0001  | <input checked="" type="checkbox"/> | 02        | 02         | 300       | i 200   | i 0      |
| 05          | 0185  | <input checked="" type="checkbox"/> | 02        | 02         | 300       | i 200   | i 0      |
| 05          | 0385  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 05          | 0485  | <input checked="" type="checkbox"/> | 02        | 02         | 300       | i 200   | i 0      |
| 05          | 4239  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 05          | 4243  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 08          | 2243  | <input checked="" type="checkbox"/> |           | 02         | 910       | i 200   | i 0      |
| 08          | 2251  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 08          | 8686  | <input checked="" type="checkbox"/> |           | 02         | 300       | i 200   | i 0      |
| 10          | 1181  | <input checked="" type="checkbox"/> | 02        | 02         | 300       | i 200   | i 0      |
| 89          | 0485  | <input checked="" type="checkbox"/> | 02        | 02         | 900       | i 200   | i 0      |

Position... Entry 1 of 21

SP1 (2) 090 TLASAPP4 INS

# QM 101 – Lot Copy/Inheritance

The screenshot shows the SAP QM101 'Copy Results from Batch' dialog box. The background window displays a list of inspection characteristics for material '50 LB Bag Batch' (batch 'LK7H2724'). The dialog box has a 'Batch' field and a 'Copy' button. The list of characteristics includes:

| Ac. | R. | S | Short text for the inspection char... | Value | Unit               | Copy |
|-----|----|---|---------------------------------------|-------|--------------------|------|
|     |    | 1 | MOIST KF FRU                          |       |                    |      |
|     |    | 4 | Color Jas                             |       |                    |      |
|     |    | 1 | CLR NSDA BH                           | <=    | 30.0 RBU           |      |
|     |    | 1 | SAC DIST DEX                          | <=    | 0.50 %             |      |
|     |    | 1 | SAC DIST FRU                          | >=    | 99.50 %            |      |
|     |    | 1 | DENS KRSTAR                           |       | 0.80 .. 0.88 g/cm3 |      |
|     |    | 1 | SCR ON 20                             | <=    | 0.30 %             |      |
|     |    | 1 | SCR ON 30                             | <=    | 1.00 %             |      |
|     |    | 1 | SCR ON 40                             | <=    | 20.00 %            |      |
|     |    | 1 | SCR ON 60                             |       | 45.00 .. 75.00 %   |      |
|     |    | 1 | SCR ON 100                            |       | 0.00 .. 100.00 %   |      |
|     |    | 1 | SCR THRU 100                          | <=    | 6.00 %             |      |
|     |    | 1 | COL SPK                               | <=    | 3.00 /GT           |      |
|     |    | 1 | MET FLK                               | <=    | 1000               |      |

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- Lot copy functionality can be manual or automatic at time of lot creation or results recording
- Custom code can be added to find inspection lots, or map the characteristics from one lot to another

## QM 101 – Calibration

- Plant Maintenance integration drives calibration functionality
- Inspections done on Equipment or Functional Locations
- Inspection points used to capture results (inspection lot is created via the PM work order, like an in-process inspection)
- Multiple ways to capture As Found and As Left results
- Forward/Reverse traceability report available
- Tough tolerance limits possible like plus/minus, % of range, and % of standard (custom solution)



Thank you for participating.  
Please remember to complete  
and return your evaluation form  
following this session.

Session Code:  
**22284 & 22370**

