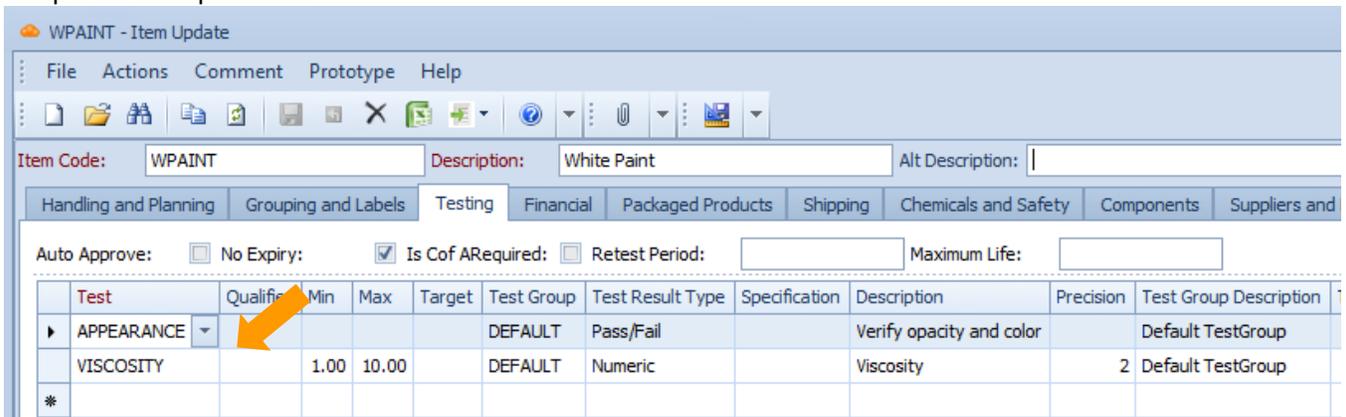


# How perform Final In-Process Test in Batch Execution

## Configuring FIPT for the product

1. Go to the Item Update form and open the Intermediate Item (product). On the Testing tab, specify the tests. It will automatically insert the requirement to draw a sample and do these tests at the end of any batch for this product. The tests listed here will be considered final in-process-tests and they will be inserted as the last step in the procedure of the batching recipe for this product:



WPAINT - Item Update

File Actions Comment Prototype Help

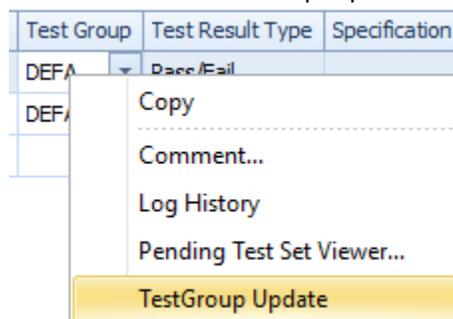
Item Code: WPAINT Description: White Paint Alt Description:

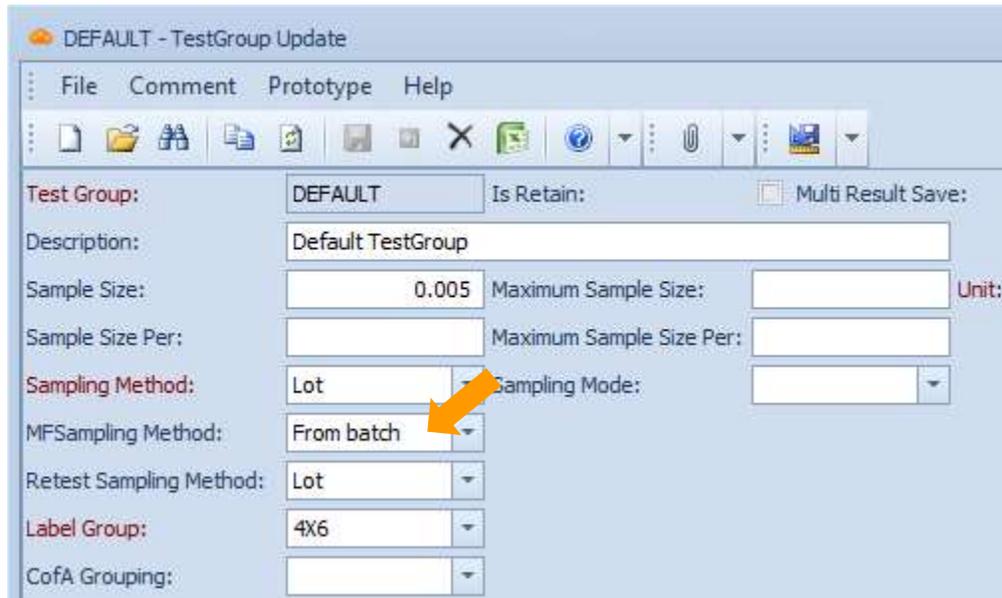
Handling and Planning Grouping and Labels **Testing** Financial Packaged Products Shipping Chemicals and Safety Components Suppliers and

Auto Approve:  No Expiry:   Is CoF A Required:  Retest Period: Maximum Life:

Test	Qualification	Min	Max	Target	Test Group	Test Result Type	Specification	Description	Precision	Test Group Description
▶ APPEARANCE					DEFAULT	Pass/Fail		Verify opacity and color		Default TestGroup
VISCOSITY		1.00	10.00		DEFAULT	Numeric		Viscosity	2	Default TestGroup
*										

2. Make sure that MFSampling Method of the Test Group is 'From Batch'. Right-click the Test Group field on the test line and select the TestGroup Update:





DEFAULT - TestGroup Update

File Comment Prototype Help

Test Group: DEFAULT Is Retain:  Multi Result Save:

Description: Default TestGroup

Sample Size: 0.005 Maximum Sample Size: Unit:

Sample Size Per: Maximum Sample Size Per:

Sampling Method: Lot Sampling Mode:

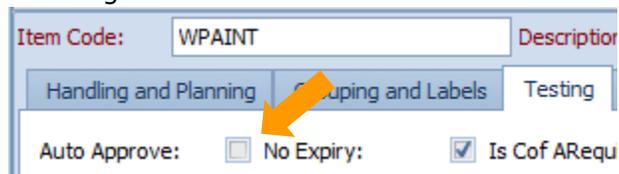
MFSampling Method: From batch

Retest Sampling Method: Lot

Label Group: 4X6

CofA Grouping:

3. Uncheck the 'Auto Approve' flag:



Item Code: WPAINT Description:

Handling and Planning Grouping and Labels Testing

Auto Approve:  No Expiry:  Is Cof A Requ:

## Performing FIPT for the product

On Batch Execution, the 'Specification Test' step appears at the end of the procedure. The required tests are listed on the right. Select the step and hit 'Execute Procedure Step' button to indicate that you are ready to take a sample for these tests:

Context	Phase	Status	Vessel	Comment	Start Log	Sanitize Log	Date S
▶	PHASE	STD	V00007E		12842	12841	2021-0

Context	Status	Item Code	Description	Log	Start Time
▶	CMP	YR005	Titanium Dioxide	12845	2021-01-05 4:40 PM
▶	CMP	YR007	Turpentine	12848	2021-01-05 4:41 PM
▶	CMP	YR006	Linseed Oil	12849	2021-01-05 4:41 PM
▶	NST		Specification Test		

Container	Test	Description	Test Result ...	Qualifier	Target
▶	APPEARANCE	Verify opaci...	Pass/Fail		
	VISCOSITY	Viscosity	Numeric		

Hit 'Save' to generate samples:

Test	Description	Test Result Type	Qualifier	Target	Min	Max	Comment	Line	Lot
▶ APPEARANCE	Verify opacity and color	Pass/Fail						1	
VISCOSITY	Viscosity	Numeric			1.00	10.00		2	

The sample label(s) will be printed. This allows you to label sample containers:

 <b>T00003R</b>	<b>QA Sample</b>	Sample Type	Default TestGroup
	Item:	White Paint	
	RM Code:	WPAINT	Lot Number
	Manufacturer:	Self	Manufacturer Lot
	GROSS WT	TARE WT	NET WT
	SAMPLER	DATE	
	Source Container(s)	V00007E	

Right-click the sample container code and select Enter Test Results, or go to Enter Test Results form under Transactions >>Testing >> Enter Test Results.

Hit the 'Find' button and pick the sample, or scan the sample label:

Location	Sample	Test Group	Test Group Description	Sampled By	Sample Date
=	=	=	Micro TestGroup	=	=
BRECEIVE	T00003K	MICRO	Micro TestGroup	vvilor@mar-kov.com	2020-12
BRECEIVE	T00003L	DEFAULT	Default TestGroup	vvilor@mar-kov.com	2020-12
BRECEIVE	T00003M	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12
BRECEIVE	T00003N	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12
BRECEIVE	T00003P	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12
BRECEIVE	T00003Q	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12
BRECEIVE	T00003R	DEFAULT	Default TestGroup	vvilor@mar-kov.com	2021-01

Enter the results and/or set the status of the tests as Pass/Failed:

T00003R - Enter Test Results

File Report Comment Help

Sample: T00003R Sampled By: vvilor@mar-kov.com Sample Date: 2021-01-05

Item: WPAINT White Paint

Test Group: DEFAULT Received Date: Manf Date:

Sublot: 215001 Manf Lot: 215001 Sup Lot:

Manufacturer: SELF Supplier:

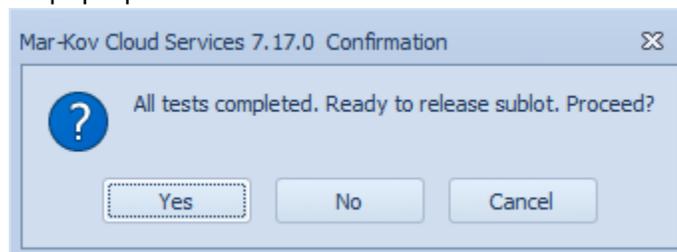
Order: 1836 Reference: Recipe Number: WPAINT.03

PO Receipt: Sampled:  CofA Grouping:

Tests Source Containers

Test	Description	Test Result Type	Min	Max	Target	Result	Status	Unit	Bypass Test	P
APPEARANCE	Verify opacity and color	Pass/Fail					Passed		<input type="checkbox"/>	
VISCOSITY	Viscosity	Numeric	1.00	10.00		2.00	Passed		<input type="checkbox"/>	

Hit 'Save'. The window will pop up:



Hit 'Yes' to bring up the lot release form. If entering test results and releasing lot are two steps, you can launch the disposition subplot form later under Transactions >> Testing >> Disposition Sublot.

On the Disposition Sublot form, approve or reject the lot by hitting the respective buttons at the top:

215001 - Disposition Sheet

File Actions Comment Help

Sublot: 215001 Status: Quar Is Sublot At Risk:

Item: WPAINT White Paint

Retest:

Manufacturer: SELF Manf Lot: 215001 Manf Date:

Manufacturer Name: Self

Supplier: Sup Lot: Received Date:

Supplier Name:

Order: 1836 Recipe Number: WPAINT.03 Reference:

Phase: PHASE

Purity: Expiry Date: Destruct Date:

Release Date: Released By:

Tests Affected Containers Containers To Reject

Sample	Superseded By	Test	Description	Precision	Test Result Type	Qualifier	Min	Max	Target	Test Group	Result	Status	CofA
▶ T00003R		APPEARANCE	Verify opacity and color		Pass/Fail					DEFAULT		Passed	
T00003R		VISCOSITY	Viscosity	2	Numeric		1.00	10.00		DEFAULT	2.00	Passed	

Record 1 of 2

If you approve the lot, go back to the Batch Execution form and hit the 'Refresh' button. The status of the test will be set to CMP (completed), and you can proceed with packing out the product:

1836 - Batch Execution

File Actions Report Comm

Refresh (F5)

Context	Status	Item Code	Description	Lo
▶	CMP	YR005	Titanium Dioxide	9
	CMP	YR007	Turpentine	9
	CMP	YR006	Linseed Oil	9
	CMP		Specification Test	9

## Fixing failed FIPT

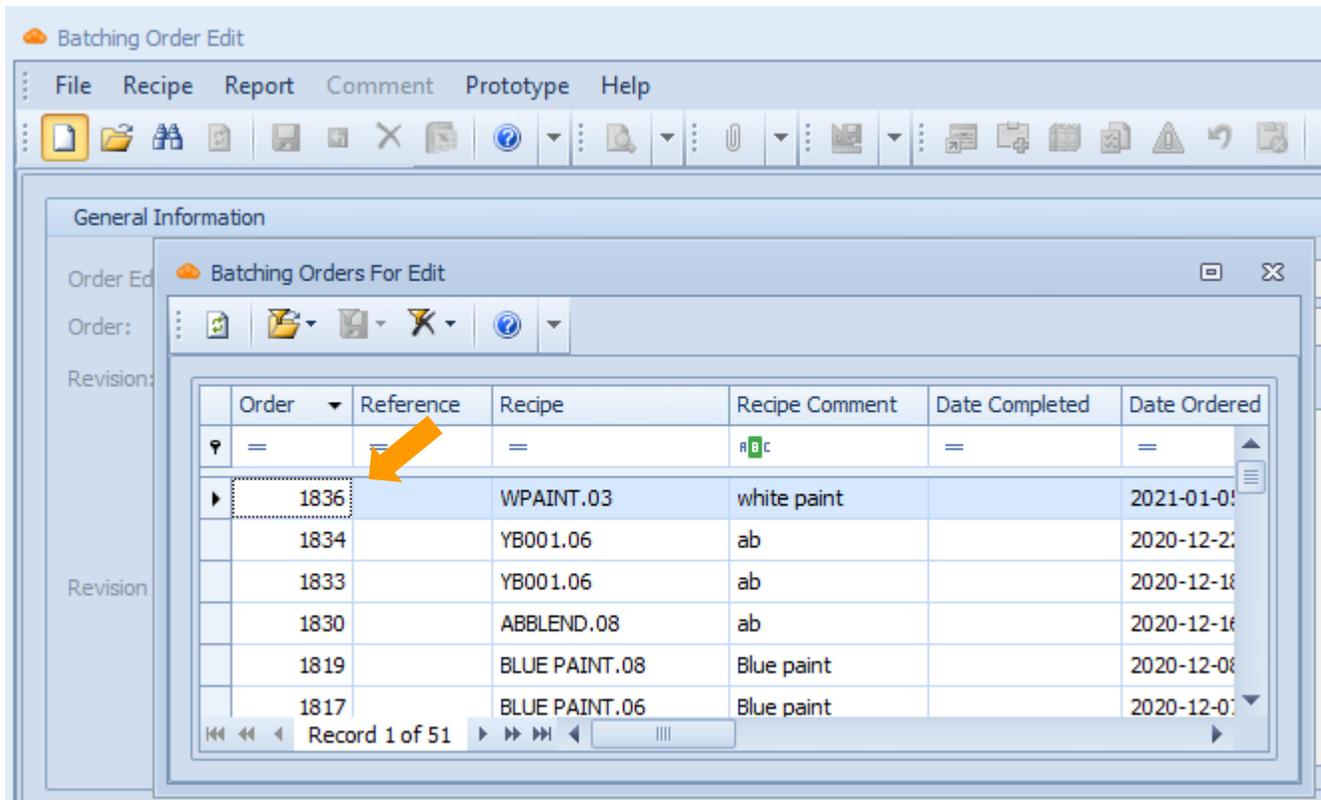
If you reject the lot, the status of the Specification Test step will remain STD, and you will not be able to proceed. At this point there are four ways to fix it.

### *Setting new acceptable values for the FIPT*

On Batch Execution form, de-select the order:



Go to the Batching Order Edit form under Order Entry >> Batching Order Edit. Click 'New' and select the order from the list:



Go to the 'Final IPT' tab. Modify the acceptable values of the test and, optionally, change the description:

Header	Ingredients	Components	Procedure	Final IPT		
Description:	Specification Test Edited					
Qualifier:	F	Number Of Samples:				
Comment:						
Final Inprocess Tests						
Test	Qualifier	Min	Max	Target	Test Group	Commer
APPEARANCE					DEFAULT	
VISCOSITY		1.00	8.00		DEFAULT	
*						

Enter the Revision Comment.  
Save and Publish the edit record:

329 - Batching Order Edit

File Recipe Report **Comment** Prototype Help

General Information

Order Edit: 329 Edit Status: STD Order Status: STD Lot:

Order: 1836 Recipe Number: WPAINT.03 Placed By: vvilor@mar-kov.com Sec

Revision: 1

Final IPT Edit

Revision Comment:



Go back to the Batch Execution form and refresh it. The existing Specification Test will be set to CMP, and a new one will be added to the procedure:

1836 - Batch Execution

File Actions Report Comment Help

General Preweigh Resources Procedure Packaging Container Reserved

Context	Phase	Status	Vessel	Comment	Start Log	Sanitize Log	Date S
	PHASE	STD	V00007E		12842	12841	2021-0

Context	Status	Item Code	Description	Log	Start Time
	CMP	YR005	Titanium Dioxide	12845	2021-01-05 4:4
	CMP	YR007	Turpentine	12848	2021-01-05 4:4
	CMP	YR006	Linseed Oil	12851	2021-01-05 4:4
	CMP		Specification Test	128	2021-01-05 4:4
	NST		Specification Test Edited		

You can now perform another testing by highlighting the row and hitting the 'Execute Procedure Step' button.

### *Adding more ingredients to the batch*

Create new Batching Order Edit record for the order and go to the Ingredients tab. Add a new row for the ingredient you wish to add to the batch:

\* - Batching Order Edit

File Recipe Report Comment Prototype Help

Order Edit: \* Edit Status: STD Order Status: STD Lot:

Order: 1836 Recipe Number: WPAINT.03 Placed By: vvilor@mar-kov.com Security:

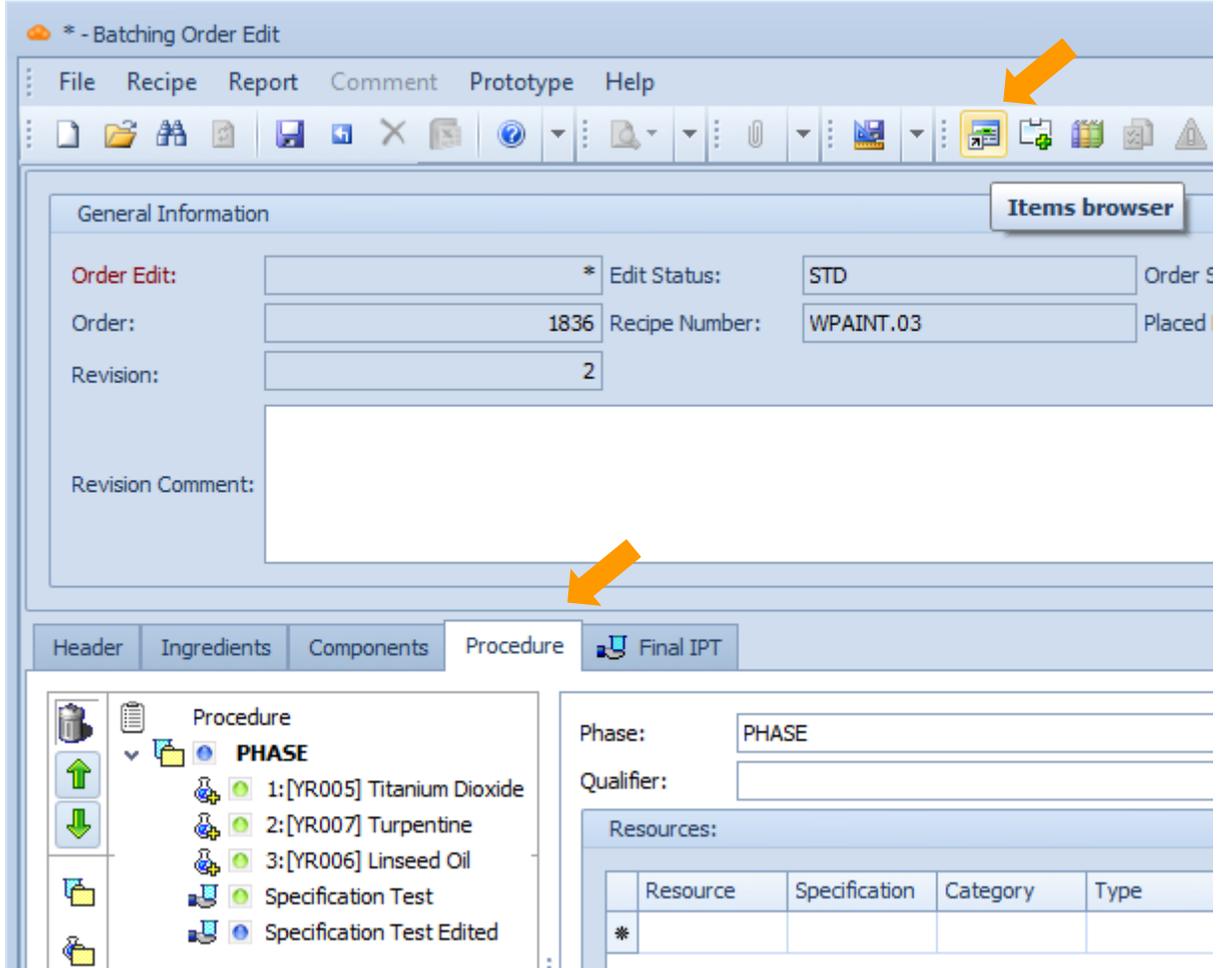
Revision: 2

Revision Comment:

Header Ingredients Components Procedure Final IPT

Line	Item	Description	Qty Required	Weight	Volume	Status	Hold Allowed	AltDescription	Add Method	% Stock Conc	M
1	YR005	Titanium Dioxide	1.000 lb	0.454 kg	0.454 l	CMP	<input type="checkbox"/>		Commingle		
2	YR007	Turpentine	1.000 lb	0.454 kg	0.454 l	CMP	<input type="checkbox"/>		Commingle		
3	YR006	Linseed Oil	1.000 lb	0.907 kg	0.907 l	CMP	<input type="checkbox"/>		Commingle		
▶	4	YR005	Titanium Dioxide	0.220 lb	0.100 kg	NST	<input type="checkbox"/>		Commingle	100.0%	
*							<input type="checkbox"/>				

Hit 'Save' and go to the Procedure tab. Select the 'Items Browser' button:



Drag the Item onto the recipe (you can drop it on the word Phase). The Item should go below the Specification Test:

General Information

Order Edit:  \*

Order:  1836

Revision:  2

Revision Comment:

Items/phases browser

Line	Item	Description	AltDescription
1	YR005	Titanium Dioxide	
2	YR007	Turpentine	
3	YR006	Linseed Oil	
4	YR005	Titanium Dioxide	

Procedure

- PHASE
  - 1:[YR005] Titanium Dioxide
  - 2:[YR007] Turpentine
  - 3:[YR006] Linseed Oil
  - Specification Test
  - Specification Test Edited

General Information

Order Edit:  \*

Order:  1836

Revision:  2

Revision Comment:

Items/phases browser

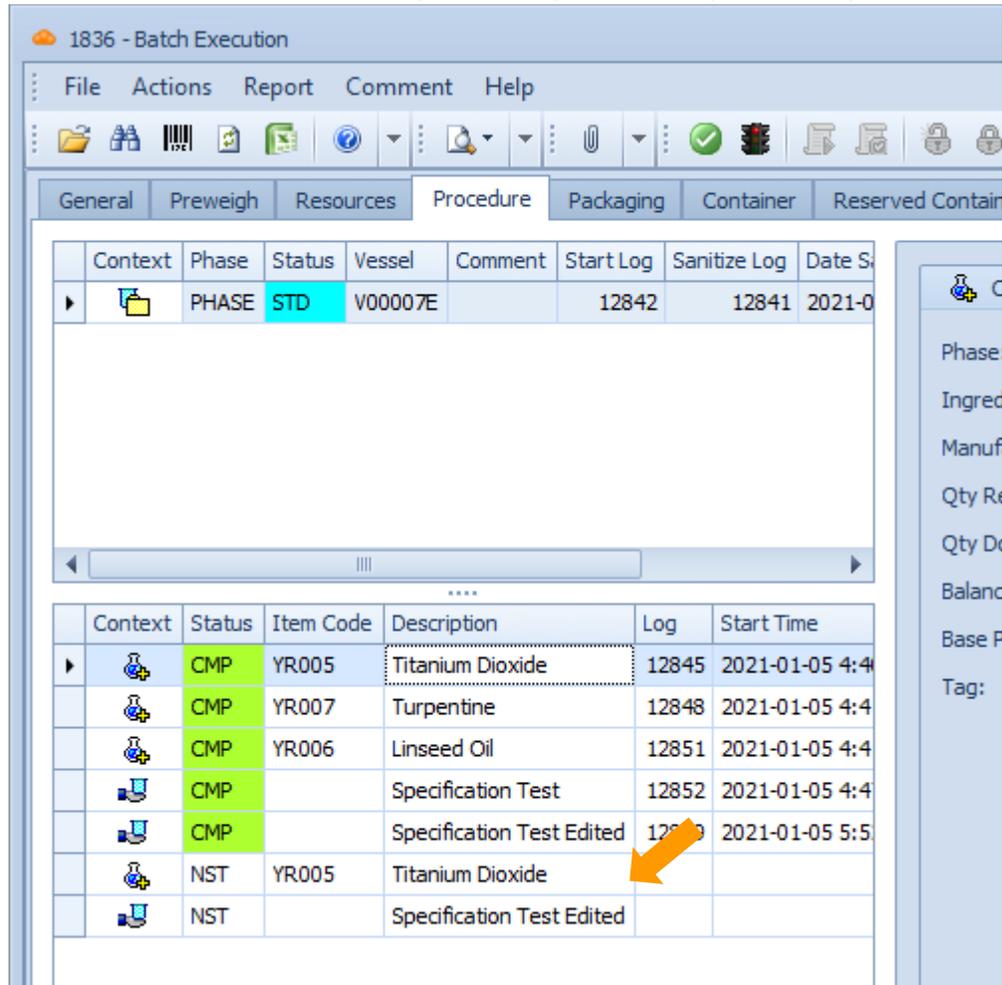
Line	Item	Description
1	YR005	Titanium Dioxide
2	YR007	Turpentine
3	YR006	Linseed Oil
4	YR005	Titanium Dioxide

Procedure

- PHASE
  - 1:[YR005] Titanium Dioxide
  - 2:[YR007] Turpentine
  - 3:[YR006] Linseed Oil
  - Specification Test
  - Specification Test Edited
  - 4:[YR005] Titanium D...

Enter a Revision Comment. Hit 'Save' and 'Publish'.

Go back to the Batch Execution. Add the ingredient again, and repeat the Specification Test.



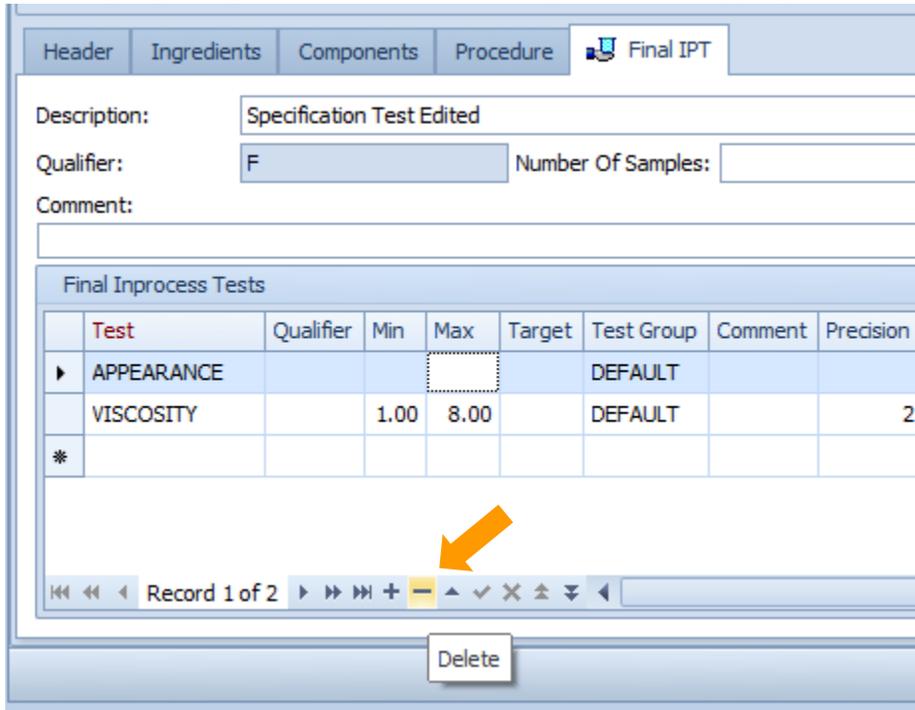
Context	Phase	Status	Vessel	Comment	Start Log	Sanitize Log	Date S
	PHASE	STD	V00007E		12842	12841	2021-0

Context	Status	Item Code	Description	Log	Start Time
	CMP	YR005	Titanium Dioxide	12845	2021-01-05 4:4
	CMP	YR007	Turpentine	12848	2021-01-05 4:4
	CMP	YR006	Linseed Oil	12851	2021-01-05 4:4
	CMP		Specification Test	12852	2021-01-05 4:4
	CMP		Specification Test Edited	12853	2021-01-05 5:5
	NST	YR005	Titanium Dioxide		
	NST		Specification Test Edited		

## Removing FIPT from the procedure

Create new Batching Order Edit record for the Order and go to the 'Final IPT' tab. Remove the tests by highlighting the test line and hitting the minus (-) sign:



The screenshot shows the 'Final IPT' tab with the following details:

- Header: Final IPT
- Description: Specification Test Edited
- Qualifier: F
- Number Of Samples: (empty)
- Comment: (empty)

Test	Qualifier	Min	Max	Target	Test Group	Comment	Precision
▶ APPEARANCE					DEFAULT		
VISCOSITY		1.00	8.00		DEFAULT		2
*							

Navigation: Record 1 of 2, +, -, ▲, ▼, X, ▲, ▼

Buttons: Delete

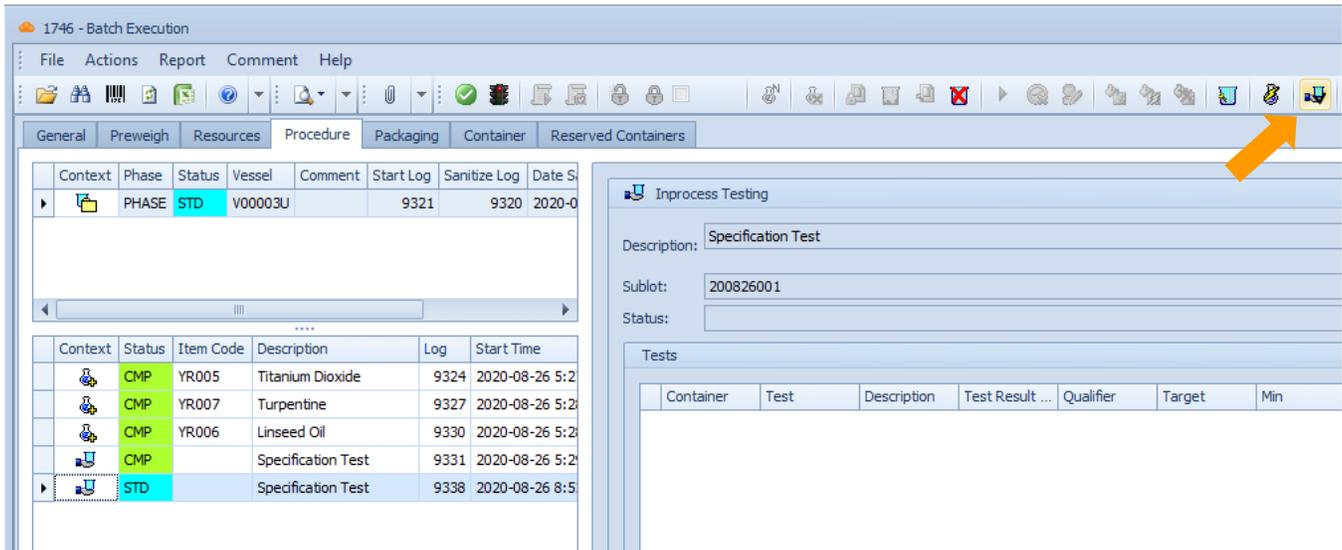
Enter the Revision Comment. Save and Publish the Edit record.

On the Batch Execution form, the Specification Test step will be removed from the procedure, so that you can proceed to the packaging.

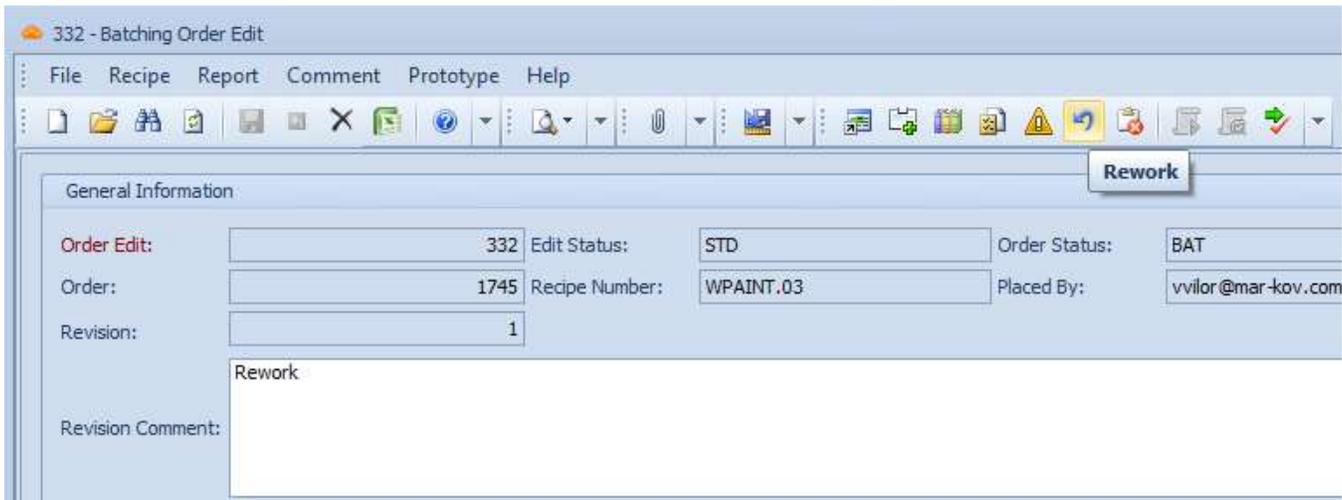
## Reworking inventory after Packout

On occasion you may need to rework inventory after it has been packed out. For example, you may pack out the product in order to free up your equipment and then send a sample to a customer for approval. After the customer responds, you pour the product back into another vessel to perform some further processing and then packout again.

On the Batch Execution form, select 'Mark FIPT Complete' button. The status of the Specification Test will be changed to CMP:

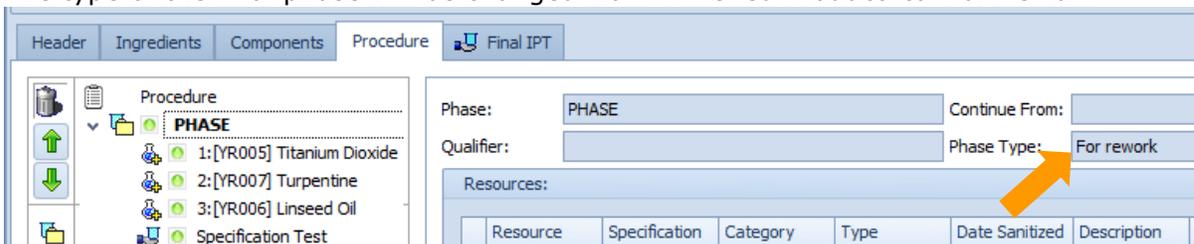


Go to the Packaging tab and pack out the product.  
 When you are ready to rework the batch, create a new edit record in Batching Order Edit form.  
 Enter a Revision comment and save the record.  
 Hit the 'Rework' button:

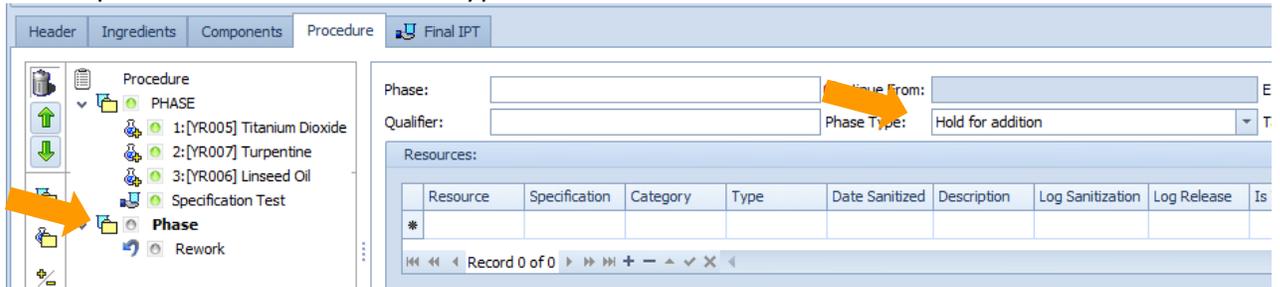


The following will happen:

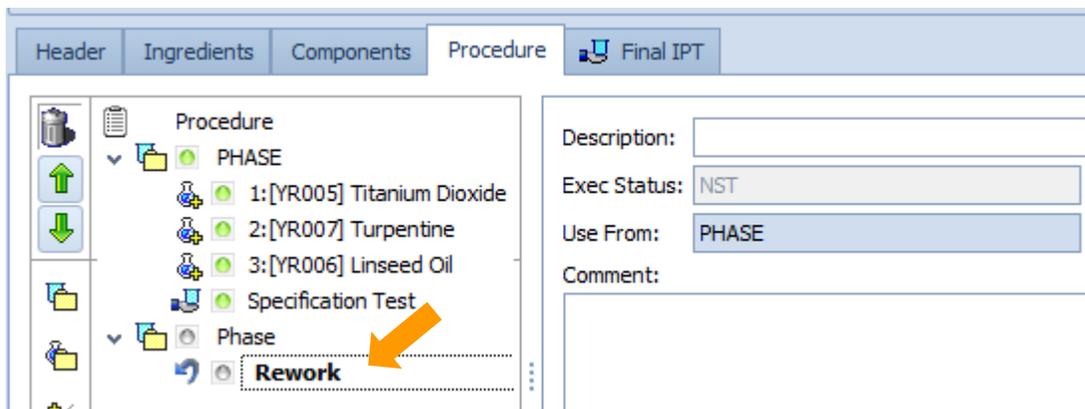
- The type of the final phase will be changed from 'Finished Product' to 'For Rework'



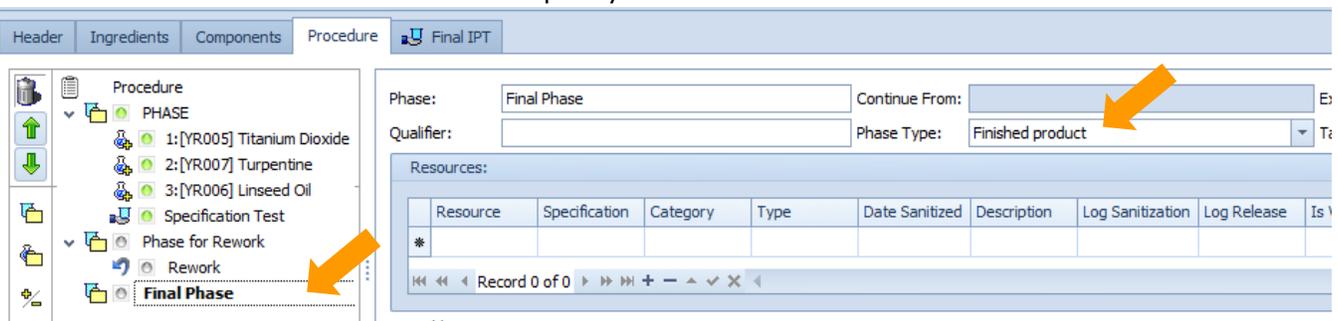
- A new phase will be created with type Hold for Addition



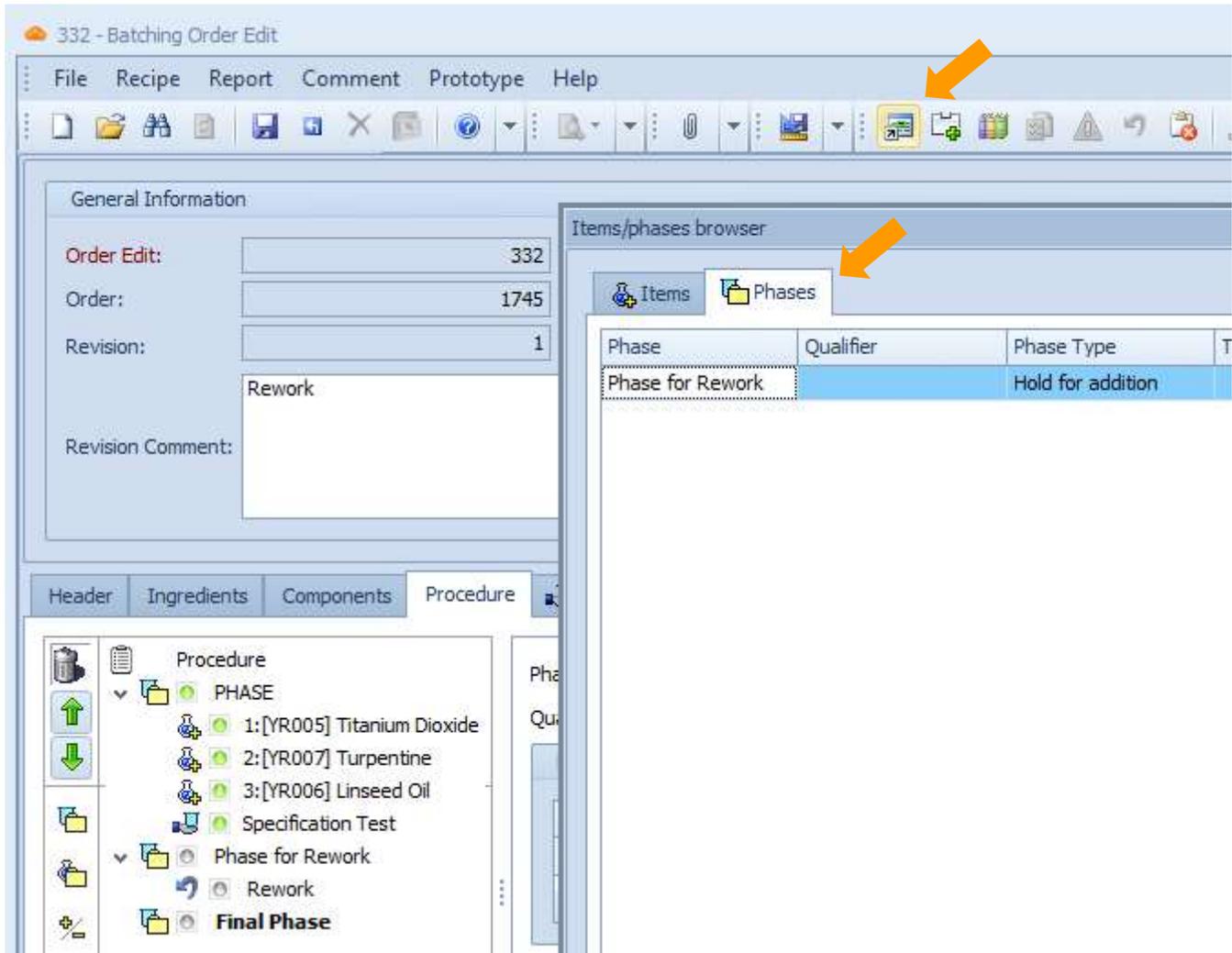
- Rework step is added to the new phase. You can add additional ingredients, steps and phases to define the reworking of the product. When this is executed in Batch Execution it adds all of the packed-out product back into the current vessel.



Enter a name for the rework Phase and specify a new Final Phase:



Open the 'Items Browser' and select the 'Phases' tab.



Drag and drop the phase from the browser onto the new Final Phase:

General Information

Order Edit: 332 Edit S

Order: 1745 Recip

Revision: 1

Rework

Revision Comment:

Header Ingredients Components Procedure

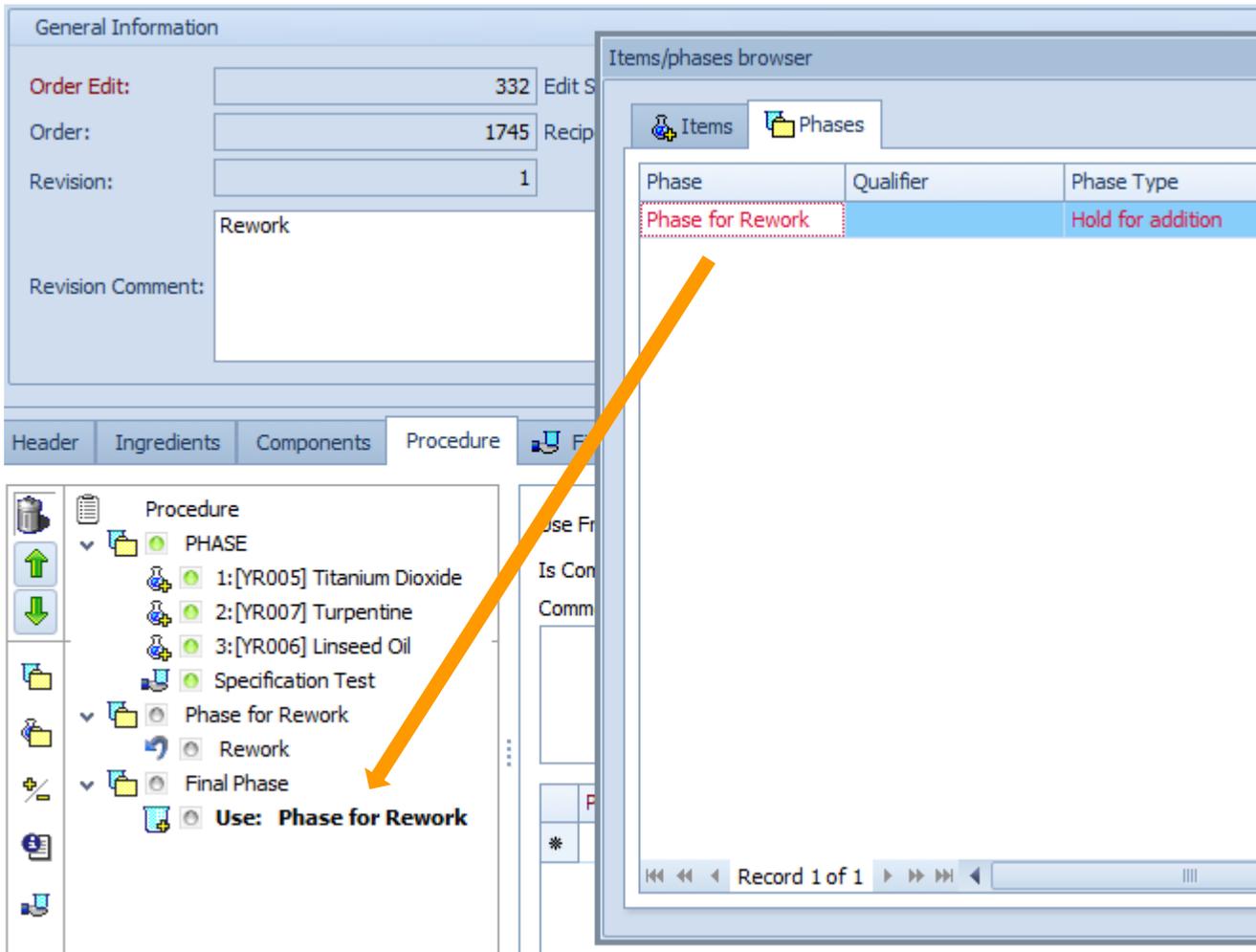
Procedure

- PHASE
  - 1:[YR005] Titanium Dioxide
  - 2:[YR007] Turpentine
  - 3:[YR006] Linseed Oil
  - Specification Test
  - Phase for Rework
  - Rework
  - Final Phase
    - Use: Phase for Rework

Items/phases browser

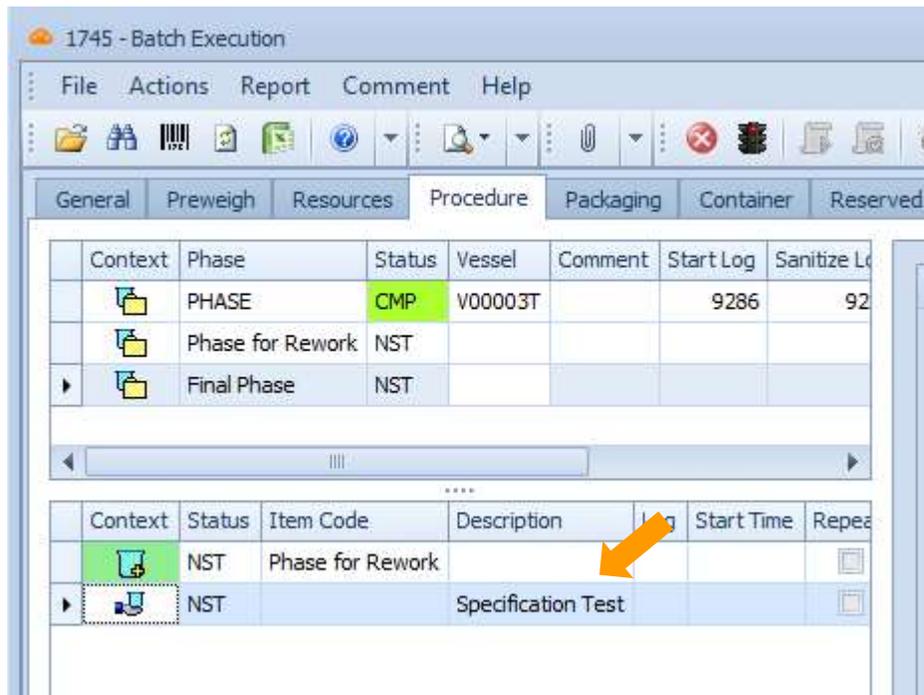
Phase	Qualifier	Phase Type
Phase for Rework		Hold for addition

Record 1 of 1



Save and publish the edit record.

On the batch Execution form, a new Specification Test will be added to the end of the Final phase:



A batch may be packed out and then reworked any number of times.