

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:



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:

Test	Group	Test Result Type	Specification								
DEF	-	Dace/Eail									
DEF		Сору									
		Comment									
	1	Log History									
	1	Pending Test Set Viewer									
		TestGroup Update	•								



DEFAULT - TestGroup	Update											
File Comment P	rototype He	elp										
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Test Group:	DEFAULT		Is Re	tain:			-	lĒ	Mul	ti Res	ult Sav	/e;
Description:	Default TestG	roup]`
Sample Size:	0	.005	Maxin	num Sa	amp	le Size	d.					Unit
Sample Size Per:		1	Maxin	num Sa	amp	le Size	Per:					
Sampling Method:	Lot	JP	Samp	ling Mo	ode:						*	
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	Planninguping an	d Labels Testing
Auto Approve	:: 🔲 No Expiry:	📝 Is Cof ARequi



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:

4	1836 - Bat	th Execut	ion															
1	File Act	ons R	eport Cor	mment Help														
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	General	Preweigh	Resource	es Procedure	Packagir	g Container	Res	erved	Cor	taine	ers				Execut	te Procedure	Step (Ctrl+E)	
	Context	Phase	Status Ve	ssel Comment	Start Log	Sanitize Log	Date S											
	<u>۲</u>	PHASE	STD VO	0007E	1284	2 12841	2021-0		-	Inp	proces	s Testin	g					
									De Su St	script blot: atus: Tests	tion:	Specifica	ation Test					
	4						•											
	Cartaut	Chathar	These Coulo	Description	1	Obach Taxa				0	Contain	her	Test	Description	Test Result	Qualifier	Target	M
	Context	Status	Item Code	Description	Log	Start Time				•			APPEARANCE	Verify opaci	Pass/Fail			
	<u></u>	CMP	YR005	Titanium Dioxide	12845	2021-01-05 4:4	40 PM						VISCOSITY	Viscosity	Numeric			
	- ÷	CMP	YR007	Turpentine	12845	21-01-05 4:4	41 PM											
	- ÷	CMP	YR006	Linseed Oil	1 4	2021-01-05 4:4	41 PM											
	• 🚽	NST		Specification Test														

Hit 'Save' to generate samples:

•	2	In-process testi	ng									23
	l	a 🔶										
	2	😃 In Process T	esting									
	D	escription: Spe	cification Test									
	Т	ests										
		Test	Description	Test Result Type	Qualifier	Target	Min	Max	Comment	Line	Lot	
	۲	APPEARANCE	Verify opacity and color	Pass/Fail						1		
		VISCOSITY	Viscosity	Numeric			1.00	10.00		2		
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The sample label(s) will be printed. This allows you to label sample containers:



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 sam	ple, or scan	the sample	a label:
The the Thild	button unu	pick the sum	pic, or scurr	the sumpre	- iubcii

Enter Test R	esi	ılts							
File Rep		C	omment	Help					
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Sample:	All '	Tes	t Containers	;					×
Item:		₫	B - 1	- X -	-				
Test Group:									_
Sublot:			Location	Sample	Test Group	Test Group Description	Sampled By	Sample Dat	te
Manufacture		۹	=	=	=	RBC	=	-	•
Orden			BRECEIVE	тооозк	MICRO	Micro TestGroup	vvilor@mar-kov.com	2020-12	
Order:			BRECEIVE	T00003L	DEFAULT	Default TestGroup	vvilor@mar-kov.com	2020-12	
PO Receipt:			BRECEIVE	T00003M	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12	
Tests Se			BRECEIVE	T00003N	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12	
Tests 50			BRECEIVE	T00003P	PKG-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12	
Test			BRECEIVE	T00003Q	J-FIPT	FIPT Test Group for Package Execution	sgallant@mar-kov.com	2020-12	
		۲	BRECEIVE	T00003R	DEFAULT	Default TestGroup	vvilor@mar-kov.com	2021-01	
		н	🕂 🕴 Reco	rd 33 of 33	► ₩ ₩ 4				

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



4	ь то)0003R - Ente	r Test Results								
	Fi	e Report	Comment Help								
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	San	nple:	T00003R	Sampled By:	vvilor@	mar-kov	.com		Sample Dat	e:	2021-01-05
	Iter	n:	WPAINT	White Paint					4		
	Tes	t Group:	DEFAULT	Received Date:					Manf Date:		
	Sub	lot:	215001	Manf Lot:	ManfLot: 215001						
	Mar	nufacturer:	SELF	Supplier:							
	Ord	ler:	1836	Reference:					Recipe Num	ber:	WPAINT.03
	PO	Receipt:		Sampled:	V				CofA Group	oing:	
	Те	sts Source	Containers								
		Test	Description	Test Result Type	Min	Max	Target	Result	Status	Unit	Bypass Test P
		APPEARANC	E Verify opacity and color	Pass/Fail					Passed		
	۲	VISCOSITY	Viscosity	Numeric	1.00	10.00		2.00	Passed		

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 sublot 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:



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File Actions Comment Help											-
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Sublot: 215001	Status:	Quar	I	is Sublot At F	Risk:						
Item: WPAINT	White Paint										
Retest:											
Manufacturer: SELF	Manf Lot:	215001	1	Manf Date:							
Manufacturer Name: Self											
Supplier:	Sup Lot:		F	Received Da	te:						
Supplier Name:											
Order: 1836	Recipe Number:	WPAINT.03	F	Reference:							
Phase: PHASE											
Purity:	Expiry Date:		-	Destruct Da	te:			-			
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	
Mi di di Berord 1 of 2 h hh hi d	1111										
Record 1012 / W M											

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						
		Context	Status	Item Code	Description	Lo
File Actions Report Comm	۲	<u>&</u> ,	CMP	YR005	Titanium Dioxide	9
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General Prew s		<u>.</u>	CMP	.J06	Linseed Oil	9
Refresh (F5)		J	CMP		Specification Test	9
Context Phase Status Vessel						



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:

	File A	Actions R	eport Co	mm	vent H	eln						
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ļ	General	Preweigh	Resource	es	Proced	ure	Pack	aging		Desel	ect Ord	ler

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

4	Batch	ning Or	der	Edi	it													
:	File	Reci	pe	F	Report	Co	mment	Pro	totype	Help								
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					Order	•	Reference		Recipe		Recipe (Comment	Date	Comp	leted	Date	Order	ed
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	Revi	ision			18	333			YB001.06		ab					2020	-12-18	
					18	330			ABBLEND.	08	ab					2020	-12-16	
					18	319			BLUE PAIN	NT.08	Blue pai	nt				2020	-12-08	
				144	18	317	nd 1 of 51		BLUE PAIN	VT.06	Blue pai	nt				2020	-12-0:	•
				144	TT T	(eco	10131	-	17 PR 4									

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



Hea	Header Ingredi		Compo	nents	Proc	edur	🛃 Final IPT			
Desa	ription:	Sp	ecification	Test E	Edited					
Quali	lifier: F Number Of Samples:									
Comr	ment:									
Fir	nal Inprocess T	ests								
	Test		Qualifier	Min	Max	Targe	Test Group	Comme		
	APPEARANCE						DEFAULT			
Ø.	VISCOSITY			1.00	8.00		DEFAULT			
*	*									

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

•	329 - Batching Order	Edit					
	File Recipe Rep	oort mment Prototy	/pe Help				
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	General Information	1					
	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					
		FIPT Edit					
	Revision Comment:						



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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:

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1	File Actions Report Comment Help														
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L		Context	Phase	Status	Vessel		Comment	Start L	og	Sanitiz	ze Log	Date S			
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L	۲	<u></u>	CMP	128	345 2	021-01	1-05 4:4								
	CMP YR007 Turpentine 1284										021-01	1-05 4:4			
		<u></u>	CMP	YR006	Lin	Linseed Oil				351 2	021-01	1-05 4:4			
		•2	CMP		Sp	Specification Test				2 2	021-01	1-05 4:4			
		-8	NST		Sp	ecif	ication Tes	t 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:

4	*-	Batchin	g Order E	Edit									
1	File	e Rec	ipe Re	eport Comme	nt Prototype	e Help							
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	0	rder Edi	t:		* Edi	t Status:	STD		Order	Status:	STD	Lot	:
	0	rder:			1836 Re	cipe Number:	WPAINT.03		Placed	By:	/vilor@mar-kov	.com Sec	curit
	R	evision:			2								
	Hea	evision (ider	Comment	nts Component	s Procedure	aU Final IPT							
		Line 🔺	Item	Description	Qty Required	Weight	Volume S	tatus	Hold Allowed	AltDescription	Add Method	% Stock Conc	М (
		1	YR005	Titanium Dioxide	1.000 lb	0.454 kg	0.454 l C	MP			Commingle		
		2	YR007	Turpentine	1,910 lb	0.454 kg	0.454 l C	MP			Commingle		
		3	YR006	Linseed Oil	.000 lb	0.907 kg	0.907 I C	CMP			Commingle		
	۲	4	YR005	Titanium Dioxide	0.220 lb	0.100 kg	0.100 l N	IST			Commingle	100.0%	
	*												

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



🗠 * - Batching Order Ed	it						
File Recipe Rep	ort Comment	Prototype	Help				
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General Information						Items b	rowser
Order Edit:			* Edit Status:	STD			Order S
Order:		183	6 Recipe Numb	er: WPA	AINT.03		Placed
Revision:			2				
Revision Comment:							
Header Ingredients	Components	Procedure	🛃 Final IPT				
Procedu	 Procedure PHASE PHASE O PHASE O 1:[YR005] Titanium Dioxide O 2:[YR007] Turpentine O 3:[YR006] Linseed Oil 			PHASE			
	Image: Specification Test Image: Specification Test Edit			e Speci	fication Ca	tegory	Туре

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



General Inform	nation		Items/phas	es brows	er			
Order Edit:		*						
Order:		1836	🗞 Iter	ns 🍯	Phases			
Revision:		2	Line	Item		Description	A	ItDescription
			1	YR005		Titanium Dioxid	le	
			2	YR007		Turpentine		
Revision Comm	ient:		3	YR006		Linseed Oil		
			4	YR005		Titanium Dioxid	le	
Header Ingre	dients Components ocedure PHASE PHASE 1:[YR005] Titaniu 2:[YR007] Turpe 3:[YR006] Linsee 3 0 Specification Tes 3 0 Specification Tes General Information Order Edit: Order:	Procedu E	18	* Ite	ms/phases	browser		
	Revision:			2	Line 1	item	Description	
					1	/R005	Titanium Dio	xide
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	Revision Comment:				3 1	/R006	Linseed Oil	
					4	/R005	Titanium Dio	xide
	Header Ingredient	S Components ure IASE 1:[YR005] Titanium 2:[YR007] Turpenti 3:[YR006] Linseed (Specification Test	Procedure Dioxide ne Dil -	Iter Des Cor				

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



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

-	18	336 - Batcl	h Executi	ion										
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	Ge	neral P	reweigh	Reso	urce	s P	rocedure	Packag	jing (Container	Rese	erve	ed Co	ntai
	•	Context	Phase PHASE	Status STD	Ves	sel)007E	Comment	Start Lo	og Sani 42	tize Log 12841	Date Si 2021-0		é	<u>ک</u> و (
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		Context	Status	Item Co	de	Descr	iption		Log	Start Tir	ne		Ba	alan ase l
	•	وي ي	CMP	YR005		Turpe	um Dioxide		12845	2021-01	1-05 4:4 1-05 4·4		Ta	ag:
			CMP	YR006		Linsee	ed Oil		12851	2021-01	1-05 4:4			
		4	CMP			Specif	fication Tes	t	12852	2021-01	1-05 4:4			
		4	CMP			Specif	fication Tes	t Edited	125 3	2021-01	1-05 5:5			
		÷.	NST	YR005		Titani	um Dioxide							
		-₽	NST			Specif	fication Tes	t 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:

Hea	ader	Ingredien	nts	Compo	nents	Proc	edure	🛃 Final IPT	-						
Des	criptio	n:	Spe	ecification	Test E	Edited									
Qua	lifier:		F				Numbe	r Of Samples:	:						
Com	ment:	:													
	Final Inprocess Tests														
F	Final Inprocess Tests Test Qualifier Min Max Target Test Group Comment Precision														
	Test Qualifier Min Max Target Test Group Comment Precision														
×.	APP	EARANCE						DEFAULT							
	VISC	COSITY			1.00	8.00		DEFAULT		2					
*															
H4 44 4 Record 1 of 2 > >> >> ++ +															
	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:

۵	1746 - Bat	ch Execut	ion																			
1	File Act	ions R	eport Cor	mment Help																		
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	Context	t Status	Item Code	Description	Log	Start Time			Tests													
	÷.	CMP	YR005	Titanium Dioxide	9324	2020-08-26 5:2					_											
	<u></u>	CMP	YR007	Turpentine	9327	2020-08-26 5:2			Cont	ainer	Test	t	Descri	ption	Test R	esult	Qua	lifier	Ta	irget	Min	
	<u></u>	CMP	YR006	Linseed Oil	9330	2020-08-26 5:2																
	-8	CMP		Specification Test	9331	2020-08-26 5:2																
	• 📲	STD		Specification Test	9338	2020-08-26 8:5																

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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:

🧢 332 - Batching Order	Edit										
File Recipe Rep	port Comment Prototype	Help									
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General Information	n:			Rew	ork						
Order Edit:	332	Edit Status:	STD	Order Status:	BAT						
Order:	1745	Recipe Number:	cipe Number: WPAINT.03 Placed By: vvilc								
Revision:	1										
Revision Comment:	Rework										

The following will happen:

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

Heade	er Ingredients	Components	Procedur	e 🛃	Final IPT					
	Procedure	E		Pha	se:	PHASE			Continue From:	
Î	ä. 💽 1:	[YR005] Titanium	Dioxide	Qua	lifier:				Phase Type:	For rework
♣	🦓 💽 2:	[YR007] Turpenti	ne	F	lesources:					
ъ	i∰ 0 3: ∎⊒ 0 Sp	ecification Test			Resource	Specification	Category	Туре	Date Sanitized	Description

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

Heade	er Ingredients Components Procedure	-	😃 Final IPT									
	Procedure ✓ [™] O PHASE	Phi	ase:					Phase Time	Hold for addition	20		E
÷	 [™] (1:1/R005) Titanium Dioxide [™] (2:1/R007) Turpentine [™] (2:1/R006) Linseed Oil [™] [™] (2:1/R006) Linseed Oil [™] [™]		Resources:									
1 2.,	Specification Test		Resource		Specification	Category	Туре	Date Sanitized	Description	Log Sanitization	Log Release	Is
€_ •⁄_	Phase O Rework		*	ord 0	of0 ► 🕨 🙌	+ - • ~ ×						

• 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.

Procedure PHASE PHASE	

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

Н	leade	er Ingredients	Components	Procedure	•	😃 Final IPT									
	}	Procedure	E [YR005] Titanium	Dioxide	Ph Qu	nase: ualifier:	Final Ph	nase			Continue From: Phase Type:	Finished produ	ct		E) Ta
	Ļ	💑 💽 2:	[YR007] Turpent	ine		Resources:									
	ъ	' 🍇 🙆 3: 🎝 🖉 🙆 Sn	[YR006] Linseed ecification Test	Oil -		Resource	Sp	pecification	Category	Type	Date Sanitized	Description	Log Sanitization	Log Release	Is
	2	v 🛅 💿 Phase	for Rework			*							_	_	-
	۳ <u>ـ</u>	🌱 🙆 Re	ework			HI II Rec	ord 0 of	fo ⊧ ⊮ ⊮	+ - • • ×	4					T a
	%	🖳 🖸 Final	rnase												

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

ns/phases browser	Phase Type Hold for addition
ns/phases browser	Phase Type Hold for addition
Phase for Rework	Phase Type Hold for addition
Items Phases Phase Qualifier Phase for Rework	Phase Type Hold for addition
Phase Qualifier Phase for Rework	Phase Type Hold for addition
Phase for Rework	Hold for addition

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



General Information	ı			_				
			E lu e	Ite	ms/phases b	rowser		
Order Edit:		332	Edit S	ſ	-	TTT		
Order:		1745	Recip		💑 Items	Phase Phase	S	
Revision:		1			Phase		Qualifier	Phase Type
	Rework				Phase for R	ework		Hold for addition
Revision Comment:								
Header Ingredient	s Components	Procedure						
Procedu	Jre							
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📕 🕹 🖸	1:[YR005] Titanium D	ioxide	Is Con					
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₩ <u></u>	3:[YR006] Linseed Oi	1						
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⊕∕ ✔ 🚰 🖲 Fin	al Phase	1						
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					144 44 4 R	ecord 1 of		

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:



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