Critical manufacturing
an ASM PT company

# Tutorial: Rework

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# Tutorial: Rework

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*Estimated time to read: 6 minutes*

## Objective

Learn how to set up a rework station, send a Material to rework, and return it to production with the **Return to Production** wizard.

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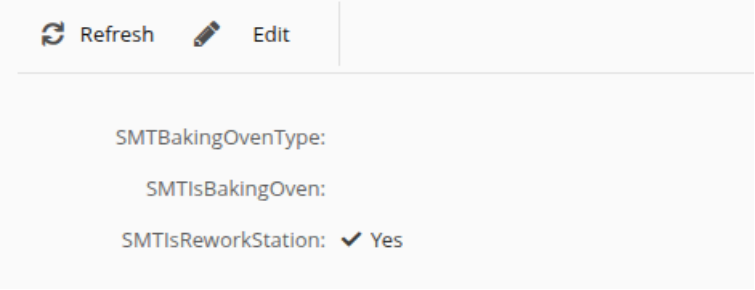
## Step 1: Enable the required security features

- Go to the system security configuration.
- Grant the `SMT.ReworkView` security feature, so the Rework View is available.
- Grant the `SMT.ReturnFromRework` security feature, so the **Return to Production** wizard can be run.

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## Step 2: Configure the rework station

- Navigate to **Resources**.
- Select or create the Resource that will act as the rework station. Its Processing Type must be **Process**.
- Set the attribute `SMTIsReworkStation` to `true`.




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## Step 3: Review the rework configuration entries

- Go to **Administration > Configuration** and open `/SMT/MaterialRework/`.
- `AllowReturnWithOpenDefects` (default `false`): leave it off to block the return of Materials that still have open defects, or turn it on to allow it.
- `AgingTimeWarning` and `AgingTimeLimit` (in minutes, optional): set them to highlight the **Aging** cell of Materials that stay too long at the rework Step.

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## Step 4: Send a Material to rework

A Material can be sent to rework in two ways:

- **Manually**, with the **Rework** action on the Material, choosing the rework path to follow.
- **Through Defect Actions**, with the **Send to Rework** Defect Action, configured on the Product and triggered when a defect is recorded or a Material is tracked out. See Defect Actions ↗ for how to configure and trigger it.

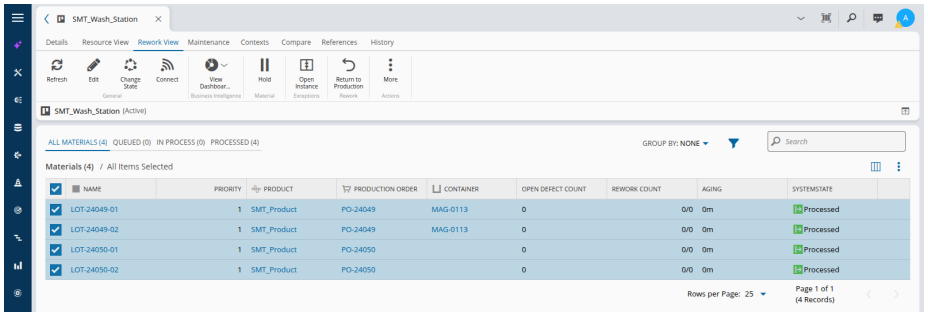
To prepare a Material for the return:

- Send the Material to rework manually, or record a defect (or track out the Material) so that **Send to Rework** is applied.
- Process the Material at the rework station until it reaches the **Processed** state. The Rework View's **Track-In** and **Track-Out** actions can be used for this.

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## Step 5: Open the Rework View

- Open the rework station Resource and go to **Views > Rework View**.



- Use the tab filters, the filter panel, the search box, or **Group By** to find the Materials to return.
- Select the Materials in the grid, or scan their barcodes. Scanning a Container selects all of its Materials.

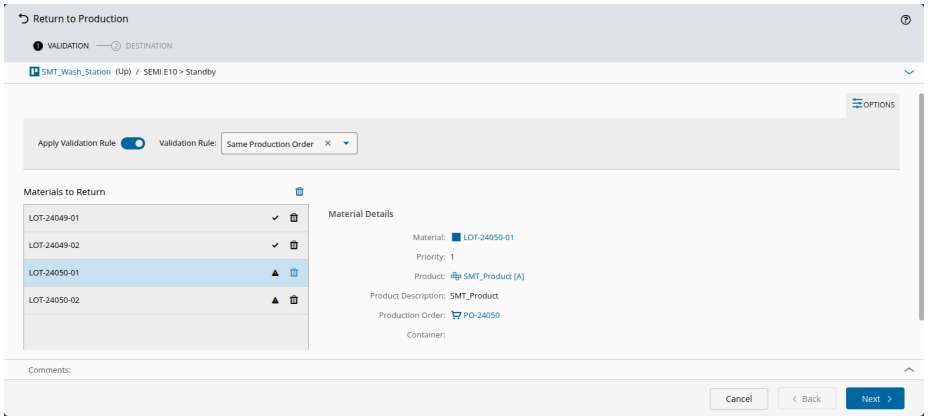
## Step 6: Launch Return to Production

- In the **Rework** group of the action bar, click **Return to Production**.

> The button is only enabled when every selected Material is in rework, **Processed**, and was last processed at this Resource.

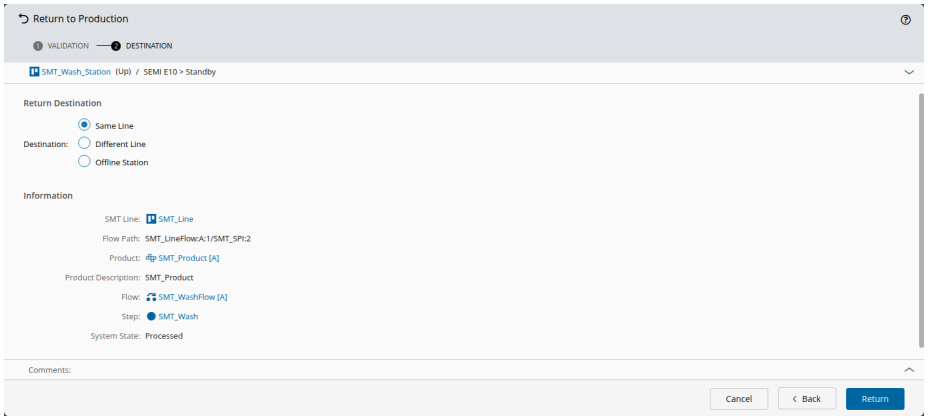
## Step 7: Validation step

- Open **Options**. **Apply Validation Rule** is on by default with the rule **Same Product**.
- Choose the rule you need: **Same Product**, **Same Product Group**, or **Same Production Order**. To return Materials without a grouping rule, turn **Apply Validation Rule** off.
- If a Material does not match the rest of the selection, it is flagged with a warning icon and a tooltip explaining why. The wizard won't continue until it is removed.
- Remove the flagged Materials, or turn the rule off.
- Select a Material to review its details on the right, then click **Next**.



## Step 8: Destination step, Same Line

- Choose **Same Line**.
- The original Line and its FlowPath are shown read-only, together with the Information panel.

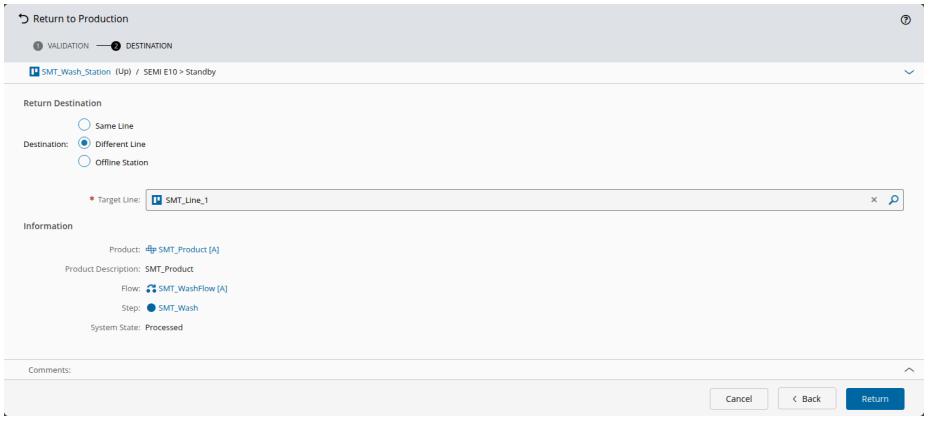



- Click **Return**.

> If the Materials don't all return to the same Line, or a return Line can't be found for some of them, the wizard shows an error when you click **Return**. Go back to **Validation** and remove those Materials, or choose another destination.

## Step 9 (Optional): Destination step, Different Line

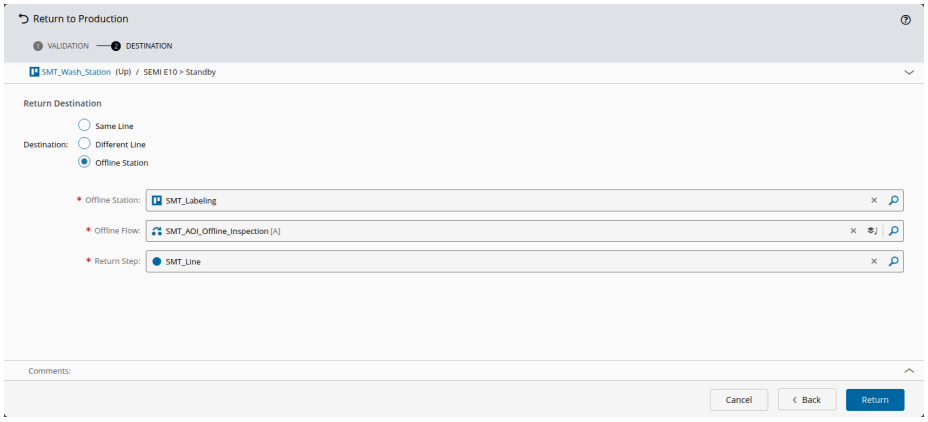
- Choose **Different Line**.
- Select the **Target Line**. The Materials' original Line is not listed.
- If the Line has lanes, select the **Target Lane**.




- Click **Return**.

## Step 10 (Optional): Destination step, Offline Station

- Choose **Offline Station**.
- Select the **Offline Station** (the inspection Resource).
- Select the **Offline Flow** the Materials should follow at the station.
- If the station can perform more than one Step of that flow, select the **Offline Step**. Otherwise it is chosen automatically.
- Check the **Return Step**: the Step of the main flow the Materials go back to after the offline flow. It defaults to their original return Step.




- Click **Return**.

## Step 11: Confirm the result

- On success, the wizard shows: *"N Material(s) set to return to production successfully. New destination: `<Resource name>`"*.
- The Rework View refreshes and the returned Materials are no longer listed.

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## Expected Result

- The selected Materials are moved in bulk to the destination and FlowPath of the chosen return type.
- **Same Line** and **Different Line**: the Materials are added to a matching parent Lot on the destination Line, which is created automatically if none is being produced.
- **Offline Station**: the Materials follow the offline flow, then return to the selected **Return Step** of the main flow.
- If the wizard fails, no Materials are moved and the error is shown.
- **MoveNext** isn't offered in the Rework View; **Return to Production** is the action that takes the Materials out of rework.

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## Frequent Configuration Questions

### Why isn't the Rework View available on my Resource?

Check that:

- The Resource has Processing Type **Process**.
- The Resource has `SMTIsReworkStation` enabled.
- The current user has the `SMT.ReworkView` security feature.

### Why is Return to Production disabled?

Check that:

- The current user has the `SMT.ReturnFromRework` security feature.
- Every selected Material is in rework, in the **Processed** state, and was last processed at this Resource.

### Why can't I proceed past the Validation step?

Either the selection is empty, or at least one Material is still flagged by the validation rule. Remove the flagged Materials, or turn **Apply Validation Rule** off if grouping isn't required.

### Why does Same Line show an error?

The selected Materials don't all return to the same Line, or a return Line can't be found for some of them. Remove those Materials in the Validation step, or choose **Different Line** or **Offline Station**.

### Why does Different Line fail for my Line?

Check that:

- The target Resource is a Line.
- A lane is selected if the Line has lanes.
- The smart table **StepLineFlowContext** has an entry for the Line, the Materials' Product, and their return Step.

### Why does Offline Station say the station is not valid?

The selected Resource can't perform any Step of the selected **Offline Flow**. Choose another flow or another station.

### Why isn't MoveNext in the Rework View?

MoveNext is left out of the Rework View so that Materials are returned through the wizard, which resolves and validates the destination and FlowPath. Use **Return to Production**.

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