

Inspection Data Interface (QM-IDI)



Release 4.6C



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Icons

Icon	Meaning
	Caution
	Example
	Note
	Recommendation
	Syntax

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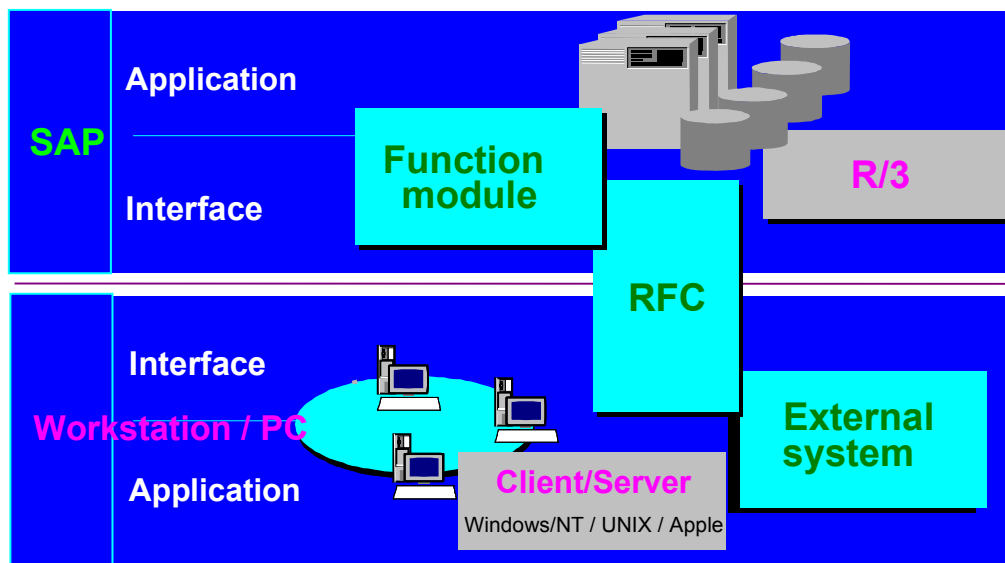
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Inspection Data Interface (QM-IDI)

Purpose

The QM-IDI interface ("Inspection Data Interface in Quality Management") is an open interface designed for exchanging inspection processing data between the QM application component and external systems. Inspection specifications defined in the QM component are transferred to the external system. The external system independently carries out the inspection and transfers the results back to QM.

The following graphic shows how the R/3 System interacts with a subsystem.



Features

The transfer between subsystem and QM is done synchronously as direct program-to-program communication. The subsystem takes over the active part in establishing the communication both for requesting the inspection specifications and for retransferring the result data. This type of communication has the advantage that the subsystem on its own can request inspection lots from QM for further processing and adapt the extent of its worklist to its specific processing times and capacities according to extensive selection criteria.

SAP provides function modules for transferring the inspection specifications and for retransferring the inspection results. These function modules can be invoked from "non-SAP systems" and then run in the QM component.

Inspection Data Interface (QM-IDI)

To this purpose, the SAP Remote Function Call interface (RFC) is used. The technology and the prerequisites required from a subsystem in order to use SAP's RFC function modules are described in the BC documentation [Remote Communications \[Ext.\]](#).

Assignment of Subsystems on Operation Level

Use

The inspection characteristics of different operations can be processed in different systems. The business object used for the assignment of operations to subsystems is the work center. Every operation has a work center assigned to it which in turn can be assigned to a subsystem. You can assign several work centers to a subsystem.

Valuation and Usage Decision in the Subsystem

Valuation and Usage Decision in the Subsystem

Use

The structures for transferring characteristic specifications contain fields in which you can transfer the specifications for the characteristic valuation from the QM module to the subsystem. If requested by the subsystem, the QM module fills these fields when the characteristic specifications are transferred. The characteristic valuation can then be carried out in the subsystem. Otherwise, the valuation is carried out in QM.

The following valuation algorithms have been implemented in the standard system:

- Manual valuation
- Valuation by the number of non-conforming units
- Valuation by the number of defects
- Valuation based on the tolerance limits
 - Valuation according to the s-Method (single-sided and double-sided limited tolerance range)
- SPC inspection according to control charts

Usage decisions for inspection lots made by the subsystem can be transferred to the QM module.

Log Table for the Transfer (Table QIWL)

Use

When the inspection lots are released in the QM module, an entry is made in a transfer table for every operation to be processed in the subsystem. This log table contains the work list of all operations to be transferred. It has the following structure:

- Key:
 - Client
 - Subsystem
 - Inspection lot
 - Task list sequence
 - Operation number
- Data:
 - Work center
 - Plant of the work center
 - Date when the entry was made
 - Time when the entry was made
 - Change date
 - Change time
 - Send date of the first transmission for the inspection lot
 - Send time of the first transmission for the inspection lot
 - Send date of the correction transmission for the inspection lot
 - Send time of the correction transmission for the inspection lot
 - Send status for first transmission/correction transmission
 - Inspection status: released/completed/discarded/canceled
 - Selection criteria for operations, see also [RFC Function Modules for Downloading \[Page 20\]](#)

Entries in the Log Table

Entries in the Log Table

Use

- When the operation data for an inspection lot is transferred for the first time, the time stamp for the first transmission is entered in the log table. In the inspection lot, a status indicates that the data has been transferred to an external system.
- An inspection lot can be transferred several times. After every correction transmission, the current time stamp is written to the log.
- The inspection status in the log table is updated, when:
 - The processing of a transferred inspection lot is completed in the QM module
 - An inspection is canceled
 - An inspection lot is discarded
- As soon as an inspection lot is reorganized in the QM module or the subsystem has transferred the usage decision to the QM module, the log records for the transfer of this inspection lot are deleted.

Logical Locking of the Transferred Inspection Characteristics

Use

Inspection characteristics that have been transferred to a subsystem are locked using a special processing status as soon as the transfer has taken place. This processing status (processed in subsystem) is posted with the results data for the characteristics. (In the QM data model for inspection processing, the inspection characteristic is split up into separate entities for task list-related inspection specifications, such as tolerance limits, and the inspection results confirmed. The data record with the characteristic specifications is generated when the inspection lot is created. The results record is created when the results are confirmed or when the characteristic specifications are transferred to the subsystem.)

After the characteristic specifications have been transferred to the subsystem, a results record is created in the QM module. In this record, the processing status is set to *Processed in subsystem*. This means that the inspection characteristics are locked for processing in QM. The status field of the characteristic specifications still contains the information whether processing of the characteristic is required or optional.

Inspection characteristics which are locked for processing in QM can normally only be displayed in results recording. They can, however, be processed within QM by users that have a special authorization.

Documentation of Results Confirmation by Subsystem

Documentation of Results Confirmation by Subsystem

After the characteristic results have been confirmed by the subsystem, the processing status of the inspection characteristics in the QM modules is changed and posted accordingly. The results record documents whether the characteristics were valuated in QM or whether the result of the valuation was transferred from the subsystem.

Changes to the results data can be made both in the QM module and via correction confirmation by the subsystem. These changes can be documented in the QM module using change documents.

Documentation of Canceled Inspections / Discarded Inspection Lots

It is possible that not all the characteristics transferred to the subsystem have been confirmed when a usage decision is made in the QM module. This can have the following reasons:

- In the case of optional characteristics: The characteristics were transferred to the subsystem, but they were not processed there.
- In the case of required characteristics: The inspection was canceled in the QM module.

In the log table, the inspection status is updated in the data records for an inspection lot when:

- The usage decision is made for an inspection lot
- The inspection is canceled in the QM module
 - The inspection is completed
- The inspection lot is discarded

Functional Enhancements

Functional Enhancements

Functional enhancements (user exits) have been included at the start and the finish of the function modules for the upload and the download. For more detailed information on the functional enhancements, refer to the implementation guide for *Quality Management* under *Environment* → *Tools*.

Record Types

Use

In the QM-IDI interface, the data records to be transferred are distinguished by a three-character record type. The individual transfer structures and corresponding record types are listed below. Note that record types are always transferred in capital letters.

Record type	Name of structure	Meaning
Q40	QAILS	Request for inspection lots by subsystem
Q41	QAIVC	Transfer of operation header data
Q42	QAIMV	Transfer of characteristic specifications
Q45	QAICA	Transfer of catalog data
Q51	QAISE	Quantitative single result
Q52	QAISE	Code as single result
Q53	QAISE	Valuation OK/not OK as single result
Q54	QAISE	Quantitative single result for inspection point
Q55	QAISE	Code as single result for inspection point
Q56	QAISE	Valuation as single result for inspection point
Q58	QAISE	Cancel single result
Q61	QAISR	Quantitative sample result
Q62	QAISR	Code as sample result
Q63	QAISR	Valuation OK/not OK for sample
Q64	QAISR	Quantitative result for inspection point
Q65	QAISR	Code for inspection point
Q66	QAISR	Valuation OK/not OK for inspection point
Q68	QAISR	Cancel sample record
Q69	QAISR	Close sample record
Q71	QAIMR	Quantitative characteristic result
Q72	QAIMR	Code as characteristic result
Q73	QAIMR	Valuation OK/not OK for characteristic
Q79	QAIMR	Close characteristic
Q83	QAIPP	Confirmation for inspection point
Q84	QAIPP	Valuation for entire inspection point

Record Types

Q85	QAIPP	Download inspection points
Q88	QAIVE	Transfer of usage decision
Q89	QAIVE	Cancellation of inspection, usage decision transferred
Q90	QMIFE	Defect item for inspection lot
Q91	QMIFE	Defect item for operation
Q92	QMIFE	Defect item for characteristic Independent multiple sample
Q95	QMIFE	Defect item for operation with reference to inspection point
Q96	QMIFE	Defect item for characteristic with reference to inspection point

Application Log

Use

In the IDI interface, all error messages as well as changes to the worklist are written to an application log.

Features

The exceptions, messages of the error log QIERRTAB, and the beginning and end of a function are recorded. In Customizing, you can define the level of detail for the application log.

Use report RQEIFML1 to display the application log. Use report RQEIFML2 to delete the log.

RFC Function Modules for Downloading

Use

Data transfer between a subsystem and QM is started from the subsystem using RFC function modules (Remote Function Call). The function modules are integrated by the subsystem, processed in QM, and carry out data transfer as required.

For more information, see the graphic [RFC-Function Modules for Downloading \[Page 21\]](#).

Features

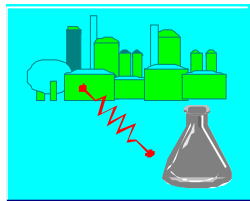
In the standard system, there are function modules for the following tasks:

- Selection of operations, transfer of worklist
- Transfer of characteristic specifications and catalog entries for the worklist
- Selection of operations, transfer of operations, characteristic specifications, and catalog data
- Updating of transfer table and lock entries
- Transfer of catalog entries
- Downloading of inspection points

Function module	Transfers
QIRF_SEND_INSP_REQUIREMENTS	Worklist using selection criteria [Page 22]
QIRF_SEND_INSP_DATA_FOR_WL2 [Page 25]	Inspection specifications using worklist
QIRF_SEND_REQUIREMENTS_GET_DAT2 [Page 28]	Inspection specifications using selection criteria
QIRF_SEND_COMMIT_TO_QM [Page 31]	Confirming receipt of inspection specifications
QIRF_SEND_CATALOG_DATA2 [Page 32]	Catalog entries
QIRF_SEND_CATALOG_TYPES [Page 34]	All catalog types with their short texts
QIRF_INSPPOINT_GETLIST [Page 37]	Inspection points
QIRF_NOTIFY_FUNCTION [Page 39]	Own logic when worklist changes

RFC Function Modules for Downloading

- QIRF_SEND_INSP_REQUIREMENTS
- QIRF_SEND_INSP_DATA_FOR_WL2
- QIRF_SEND_REQUIREMENTS_GET_DAT2
- QIRF_SEND_COMMIT_TO_QM
- QIRF_SEND_CATALOG_DATA2
- QIRF_SEND_CATALOG_TYPES
- QIRF_INSPPOINT_GETLIST
- QIRF_NOTIFY_FUNCTION



External
subsystem



Transfer of Worklist Using Selection Criteria: Function Module QIRF_SEND_INSP_REQUIREMENTS

Transfer of Worklist Using Selection Criteria: Function Module QIRF_SEND_INSP_REQUIREMENTS

Use

Using the specified selection criteria, the QM system determines the worklist for the operations to be processed (structure QIWLR) and transfers the worklist table to the subsystem.

If the indicator *Correction transmission of operations possible* has been set, the system also selects data records for the worklist, which have already been transferred.

Parameters of Function Module QIRF_SEND_INSP_REQUIREMENTS

→ Input	Extensive selection criteria for operations (see below), I_QAILS
	Indicator: Sort operations in ascending order according to creation date, I_IND_SORT_ASCENDING_TO_DATE
	Indicator: Sort operations in descending order according to creation date, I_IND_SORT_DESCENDING_TO_DATE
	Indicator: Correction transfer of operations is possible, I_IND_MULTI_TRANSFER_POSSIBLE
← Output	Output table:
	Worklist table (structure QIWLR), T_QIWLTAB

Selection Criteria for Operations (Structure QAILS)

- Subsystem
- Inspection lot numbers (interval from ... to ...)
- Task list sequence
- Numbers of the operations to be processed (interval from ... to)
- Plant for the operations to be processed
- Work center, plant for the work center
- Material number
- Creation dates for inspection lots (interval from ... to)
- Inspection status (default value = "released lots")
- Inspection type
- Origin of the inspection lots
- Batch

Transfer of Worklist Using Selection Criteria: Function Module QIRF_SEND_INSP_REQUIREMENTS

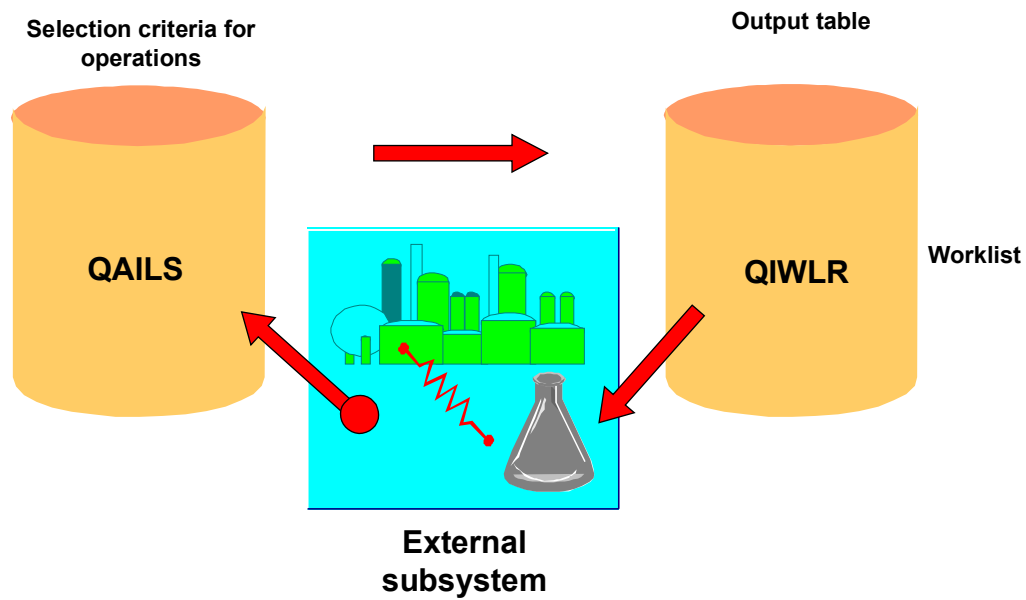
- Order numbers (interval from ... to)
- Vendor number
- Customer number
- Number of the material document
- Maximum number of inspection lots to be transferred

See also:

[Function Module QIRF_SEND_INSP_REQUIREMENTS \[Page 24\]](#)

Function Module QIRF_SEND_INSP_REQUIREMENTS

● Transfer of worklist



Transfer of Inspection Specifications Using the Worklist: Function Module QIRF_SEND_INSP_DATA_FOR_WL2

Use

The function module reads the operation and inspection lot data for the specified worklist (structure QIWLR - determined via function module QIRF_SEND_INSP_REQUIREMENTS) and transfers this data to the subsystem in the form of a list (structure QAIVC).

Depending on the input control indicators of the function module, additional data from master records can be read and added to the QAIVC structure. The inspection characteristics to be processed are transferred to the subsystem as a list with QAIMV structure. Using input control indicators, the subsystem specifies whether:

- All characteristics or only characteristics requiring inspection are to be transferred
- Transfer is to be limited to characteristics not yet transferred or whether correction transfers are possible

If there are catalog specifications for the characteristics to be transferred and the corresponding input indicator is set in the function module, the quantity codes and group codes for the catalog specifications are transferred in the form of a list with QAICA structure.

Parameters of Function Module QIRF_SEND_INSP_DATA_FOR_WL2

→ Input	– Worklist (structure QIWLR), T_QIWLTAB
	– Indicator: Transfer valuation specifications for characteristics, I_IND_EVALUATE_CHARACTERISTIC
	– Indicator: Set lock entries in QM, I_IND_SET_BLOCK_INDICATORS
	– Indicator: Transfer only required characteristics, I_IND_ONLY_OBLIGATORY_CHARACT
	– Indicator: Correction transfers for characteristics possible, I_IND_MULTI_TRANSFER_POSSIBLE
	– Indicator: Transfer catalog data for inspection characteristics, I_IND_TRANSFER_CHAR_CODES
	– Indicator: Read work center data, I_IND_READ_WORK_CENTER
	– Indicator: Read vendor data, I_IND_READ_VENDOR_AND_PRODUCER
	– Indicator: Read data from purchasing information record, I_IND_READ_PURCHASING_INFO
	– Indicator: Read data from sales information record, I_IND_READ_SALES_INFO
	– Indicator: Send error log by mail, I_IND_SEND_PROTOCOL_MAIL
	– Indicator: Transfer catalog data for usage decision, I_IND_TRANSFER_USAGE_DEC_CODES

Transfer of Inspection Specifications Using the Worklist: Function Module QIRF_SEND_INSP_DATA_FOR_WL2

← Output	Output tables:
	– List of operations and inspection lots (structure QAIVC), T_QAIVCTAB
	– List of inspection characteristics to be processed (structure QAIMV), T_QAIMVTAB
	– List of catalog entries (structure QAICA), T_QAICATAB
	– Error log list (structure QIERR), T_QIERRTAB

Features

If the indicator *Set lock entries in QM* has been set, the valuation fields in the structure for the transfer of characteristic specifications QAIMV are filled.

If the indicator *Update transfer table and lock characteristics for QM* has been set, the following activities are carried out in the QM component:

- Transfer table QIWL is updated with the current inspection status and time stamp.
- The inspection lot status is set to *Transmission executed*.
- Results records for all transferred characteristics are created and posted.
- The characteristics are locked for processing in QM via the processing status *Processed in subsystem* in the results record.

If the indicator *Transfer catalog data for usage decision* has been set, the quantity codes of a selected set, which has been assigned to the inspection category in Customizing, are transferred in the list of catalog entries.

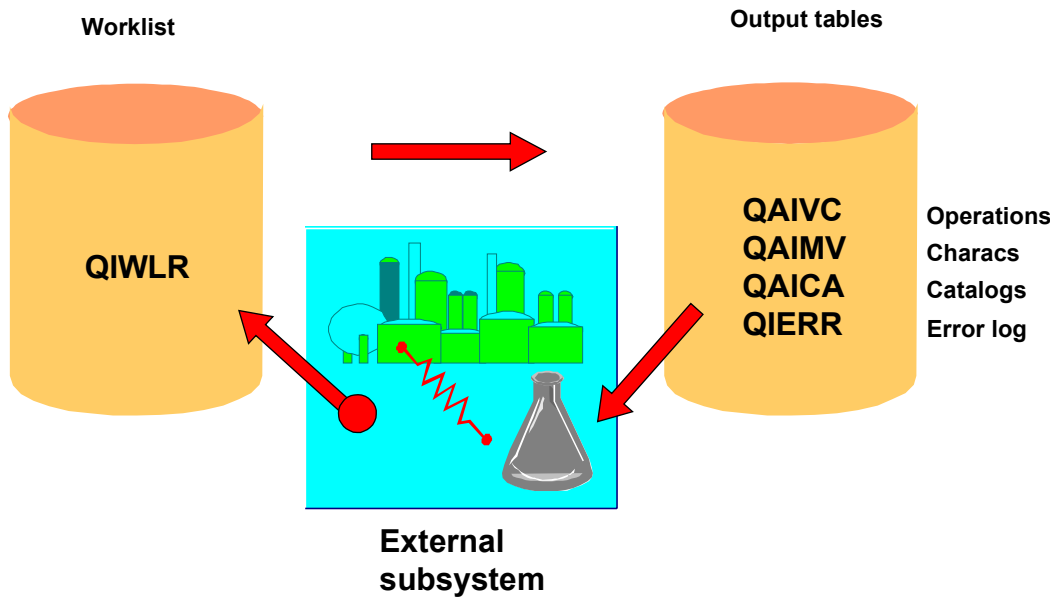
Posting as well as locking of data is carried out after the function module QIRF_SEND_COMMIT_TO_QM has been called up.

See also:

[Function Module QIRF_SEND_INSP_DATA_FOR_WL2 \[Page 27\]](#)

Function Module QIRF_SEND_INSP_DATA_FOR_WL2

- Transfer of inspection specifications based on a worklist
- Updating lock entries



Before Release 4.6, this function module was called QIRF_SEND_INSP_DATA_FOR_WL. You can continue to use the old module.

Transfer of Inspection Specifications Using Selection Criteria: Function Module QIRF_SEND_REQUIREMENTS_GET_DAT2

Transfer of Inspection Specifications Using Selection Criteria: Function Module QIRF_SEND_REQUIREMENTS_GET_DAT2

Use

Using the selection criteria defined in the subsystem, the QM system determines the worklist for the operations to be processed. Inspection lot data and operation data is read for the worklist and transferred to the subsystem as a list with QAIVC structure. Inspection characteristics to be checked and catalog entries are transferred to the subsystem as lists with QAIVC structure or QAICA structure.

Internally, function modules QIRF_SEND_INSP_REQUIREMENTS and QIRF_SEND_INSP_DATA_FOR_WL are processed in one step, and the worklist is not transferred to the subsystem.

Parameters of Function Module QIRF_SEND_REQUIREMENTS_GET_DAT2

→ Input	Extensive selection criteria for operations, I_QAILS (see also Transfer of Worklist Using Selection Criteria [Page 22])
	Indicator: Sort operations in ascending order according to creation date, I_IND_SORT_ASCENDING_TO_DATE
	Indicator: Sort operations in descending order according to creation date, I_IND_SORT_DESCENDING_TO_DATE
	Indicator: Correction transfers of operations possible, I_IND_MULTI_TRANSFER_POSSIBLE
	Indicator: Transfer valuation specifications for characteristics, I_IND_EVALUATE_CHARACTERISTIC
	Indicator: Set lock entries in QM, I_IND_SET_BLOCK_INDICATORS
	Indicator: Only transfer required characteristics, I_IND_ONLY_OBLIGATORY_CHARACT
	Indicator: Transfer catalog data for inspection characteristics, I_IND_TRANSFER_CHAR_CODES
	Indicator: Read work center data, I_IND_READ_WORK_CENTER
	Indicator: Read vendor data, I_IND_READ_VENDOR_AND_PRODUCER
	Indicator: Read data from purchasing information record, I_IND_READ_PURCHASING_INFO
	Indicator: Read data from sales information record, I_IND_READ_SALES_INFO
	Indicator: Send error log by mail, I_IND_SEND_PROTOCOL_MAIL
	Indicator: Transfer catalog data for usage decision, I_IND_TRANSFER_USAGE_DEC_CODES

Transfer of Inspection Specifications Using Selection Criteria: Function Module QIRF_SEND_REQUIREMENTS

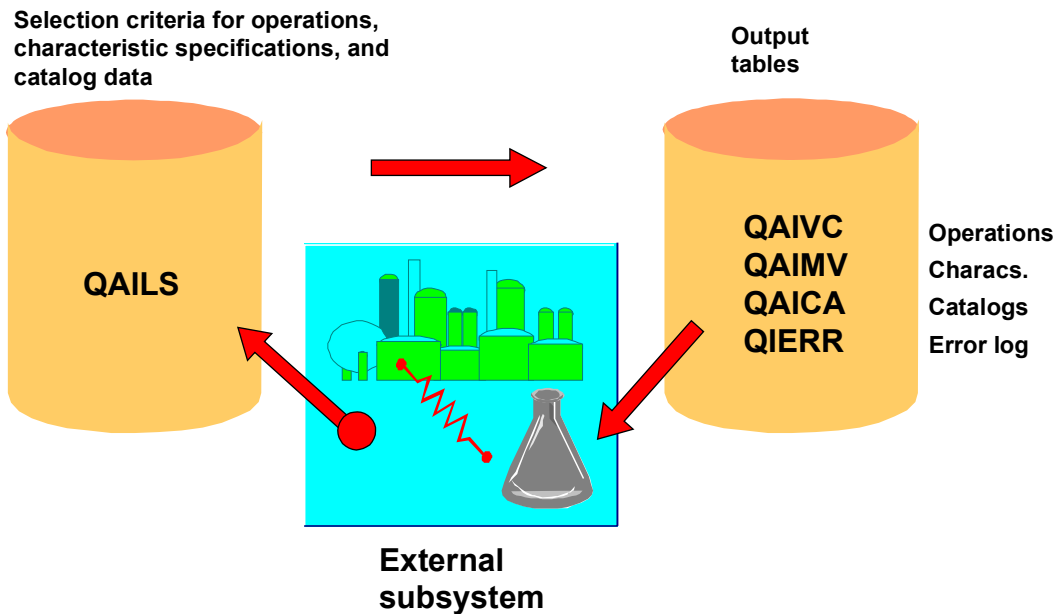
← Output	Output lists:
	– List of operations and inspection lots (structure QAIVC), T_QAIVCTAB
	– List of inspection characteristics to be processed (structure QAIMV), T_QAIMVTAB
	– List of catalog entries (structure QAICA), T_QAICATAB
	– Error log list (structure QIERR), T_QIERRTAB

See also:

[Function Module QIRF_SEND_REQUIREMENTS_GET_DAT2 \[Page 30\]](#)

Function Module QIRF_SEND_REQUIREMENTS_GET_DAT2

- Transfer of inspection specs based on selection criteria
- Updating lock entries



Before Release 4.6, this function module was called QIRF_SEND_REQUIREMENTS_GET_DATA. You can continue to use the old module.

Confirming Receipt of Inspection Specifications: Function Module QIRF_SEND_COMMIT_TO_QM

Use

Parameters of function module QIRF_SEND_COMMIT_TO_QM

↔	No parameters required
---	------------------------

This function module sends a COMMIT-WORK to the QM databases. It must be called by the subsystem after the inspection specifications have been transferred.

As a result, the transfer table (QIWL) and lock entries are updated.

Transfer of Catalog Entries: Function Module QIRF_SEND_CATALOG_DATA2

Transfer of Catalog Entries: Function Module QIRF_SEND_CATALOG_DATA2

Use

Parameters of Function Module QIRF_SEND_CATALOG_DATA2

→ Input	–	Indicator: Choose selected set, I_IND_CATALOG_IS_SEL_SET
	–	Indicator: Choose code groups, I_IND_CATALOG_IS_CODEGROUP
	–	Catalog type, I_CATALOG_TYPE
	–	Plant of selected set, I_PLANT_OF_SELECTED_SET
	–	Catalog (selected set or code group), I_CATALOG
	–	Language, I_LANGUAGE
← Output	–	List of catalog entries (structure QAICA), T_QAICATAB
	–	Error log (structure QIERR), T_QIERRTAB

Features

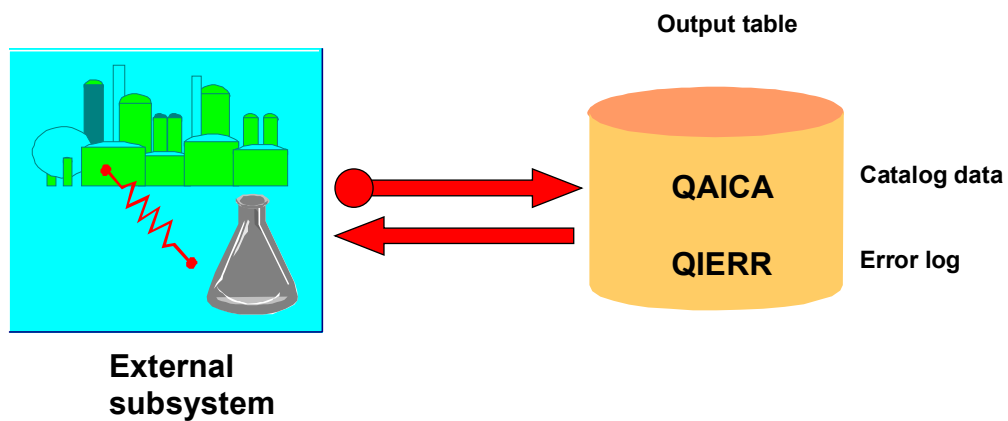
The function module transfers all codes contained in table QAICA that match the selection criteria specified when the function module is called up. The fields transferred for the individual codes are those contained in the QAICA table. If no selection criteria are specified, the function module transfers the codes of all selected sets, code groups, and catalog types.

See also:

[Function Module QIRF_SEND_CATALOG_DATA2 \[Page 33\]](#)

Function Module QIRF_SEND_CATALOG_DATA2

● Transfer of catalog data



Before Release 4.6, this function module was called QIRF_SEND_CATALOG_DATA. You can continue to use the old module.

Transfer of all Catalog Types with their Short Texts: Function Module
QIRF_SEND_CATALOG_TYPES

Transfer of all Catalog Types with their Short Texts: Function Module QIRF_SEND_CATALOG_TYPES

Use

The function module transfers all texts of all catalog types.

Parameters of function module QIRF_SEND_CATALOG_TYPES

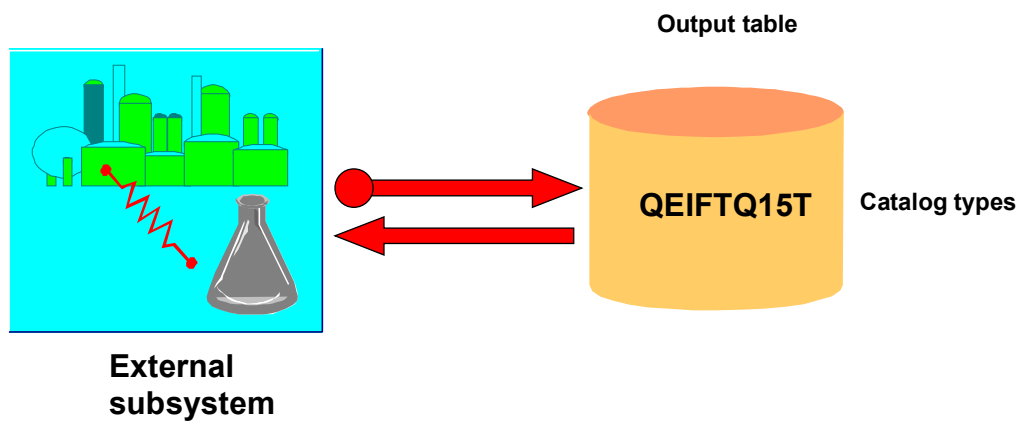
← Output	Texts of the catalog type (structure QEIFTQ15T), T_TQ15TTAB
----------	---

See also:

[Function Module QIRF_SEND_CATALOG_TYPES \[Page 35\]](#)

Function Module QIRF_SEND_CATALOG_TYPES

- Transfer of catalog types with short text



Transfer of Inspection Points

Transfer of Inspection Points

Use

Parameters of the function module QIRF_INSPPOINT_GETLIST

→ Input	–	Inspection lot number, INSPLOT
	–	Inspection lot operation number, INSPOPER
	–	First inspection point to be read, INSPPOINT_FROM
	–	Last inspection point to be read, INSPPOINT_TO
	–	I_SUBSYS
← Output	–	Inspection point table: T_QAIPPTAB
	–	Error message, E_QIERR

Features

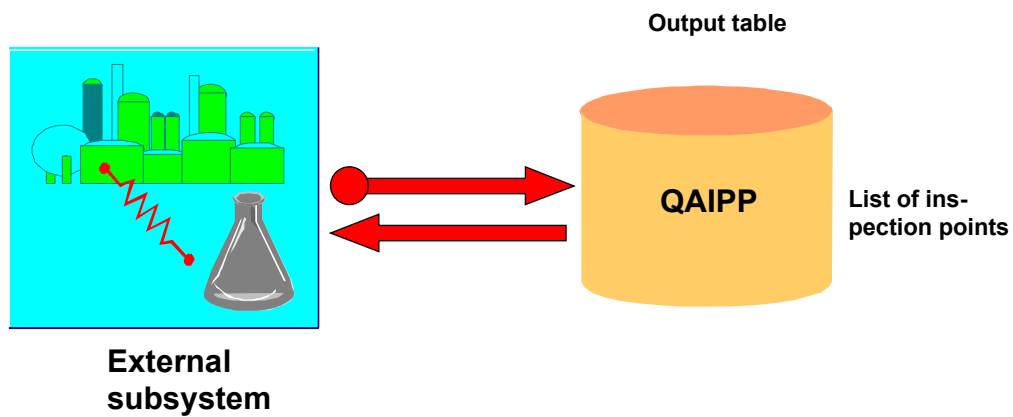
The function module transfers the inspection points for an inspection lot and an operation. You can limit the number of inspection points delivered by using the parameters INSPPOINT_FROM and INSPPOINT_TO.

See also:

[Function module QIRF_INSPPOINT_GETLIST \[Page 37\]](#)

Function module QIRF_INSPPOINT_GETLIST

● Transfer of inspection points



Own Logic When Work List Changes

Own Logic When Work List Changes

Use

Parameters of the function module QIRF_NOTIFY_FUNCTION

→ Input	Work list table (across subsystems): T_QIWLTAB
	I_SUBSYS

Features

You can program your own logic by using this function module as a template for a function module to be created by you. This function module then reacts to changes in the subsystem's work list. It can serve, for example, as a notification algorithm.

Integration

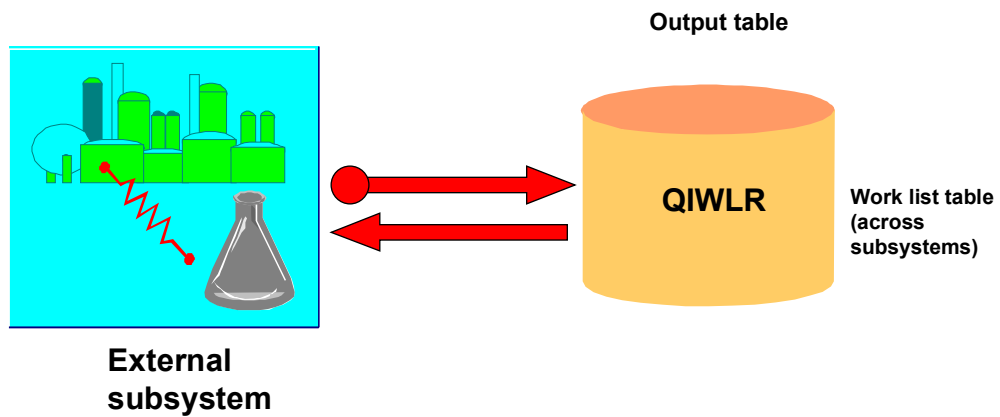
In the subsystem's Customizing (transaction QSUB), a corresponding function module must be defined.

See also:

[Function module QIRF_NOTIFY_FUNCTION \[Page 39\]](#)

Function Module QIRF_NOTIFY_FUNCTION

● Own Logic When Work List Changes



RFC Function Modules for Uploading

Use

The confirmation of inspection results for an inspection characteristic is carried out using a confirmation number that uniquely identifies a characteristic. (The assignment of a confirmation number to an inspection lot number, operation number, and characteristic number is contained in the transfer record QAIMV for the characteristic specifications.) The *Recording type* field (ERFASSART), which is transferred to the subsystem in the characteristic specification record, uniquely specifies how results recording and confirmation are to be carried out for a characteristic.

Every recording type has one record type for results confirmation assigned to it. Each record type in the results confirmation structures contains required entry fields and fields that require no entry.

The confirmation tables created for the recording types of the inspection characteristics must be transmitted to RFC (remote function call) function modules for transfer to the QM component (see the graphic [RFC Function Modules for Uploading \[Page 42\]](#)). In the QM component, the results data is checked for consistency. If a confirmation record contains an error, a corresponding entry is made in the error log. Correct confirmation records are posted to the QM databases.

Please note the following when transferring inspection results from a subsystem:

- Before the results are transferred, the function module sorts the data for the confirmation tables according to confirmation number, record type, start date and time of the inspection. The data is transferred in this order.
- If there is no entry in a confirmation field (the field content is blank), the existing value in the data field is not changed.
- If the first byte of a field contains an exclamation mark (!), the field is set back to the initial value.
- Some of the function modules for confirmation contain the control indicators *Call up program for updating results* and *Trigger commit work to database*. Normally (that is, if the data is to be posted within QM), you need to set both indicators. If you do not set the indicators, the function modules are processed in test mode during which the system checks whether the confirmed data matches the specifications without posting the data. For more information, see [Example for Results Confirmation \[Page 94\]](#).

The standard system provides RFC function modules for the following tasks:

- Results confirmation for single results using record types Q51, Q52, Q53, Q54, Q55, Q56, and Q58
- Results confirmation for sample results using record types Q61, Q62, Q63, Q64, Q65, Q66, Q68, and Q69
- Results confirmation for characteristic results using record types Q71, Q72, Q73, and Q79
- Results confirmation for all record types
- Confirmation of usage decision for inspection lot

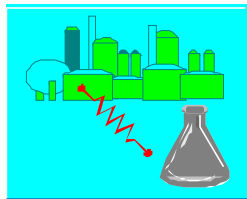
RFC Function Modules for Uploading

- Confirmation of inspections points using record types Q83 and Q84
- Confirmation of defect items with record types Q90, Q91, Q92, Q95, and Q96

Function module	Confirmation for
QIRF_GET_ORIGINAL_VALUES2 [Page 43]	Single results using record types Q51, Q52, Q53, Q54, Q55, Q56, and Q58
QIRF_GET_SAMPLE_VALUES2 [Page 46]	Sample results using record types Q61, Q62, Q63, Q64, Q65, Q66, Q68, and Q69
QIRF_GET_FEATURE_VALUES2 [Page 48]	Characteristic results using record types Q71, Q72, Q73, and Q79
QIRF_GET_ALL_DATA_VALUES2 [Page 50]	All record types
QIRF_GET_USAGE_DECISION2 [Page 52]	Usage decision of an inspection lot using record types Q88 and Q89
QIRF_GET_INSP_POINT2 [Page 54]	Inspection points using record types Q83 and Q84
QIRF_GET_DEFECT_ITEMS2 [Page 58]	Defect items using record types Q90, Q91, Q92, Q95, and Q96

RFC Function Modules for Uploading

- QIRF_GET_ORIGINAL_VALUES2
- QIRF_GET_SAMPLE_VALUES2
- QIRF_GET_FEATURE_VALUES2
- QIRF_GET_ALL_DATA_VALUES2
- QIRF_GET_USAGE_DECISION2
- QIRF_GET_INSP_POINT2
- QIRF_GET_DEFECT_ITEMS2



External
subsystem



Results Confirmation for Single Results Using Record Types Q51, Q52, Q53, Q54, Q55, Q56, and Q58: Function Module QIRF_GET_ORIGINAL_VALUES2

Use

Parameters of Function Module QIRF_GET_ORIGINAL_VALUES2

→ Input	Indicator: Transfer valuations from subsystem, I_IND_EVALUATION_TRANSFER
	Indicator: Close samples or characteristics, I_IND_CLOSE_PROCESSING
	Table of single results (structure QAISE), T_QAISETAB
	Indicator: Send error log by mail, I_SEND_PROTOCOL_MAIL
	Subsystem confirms results, I_SUBSYS
	Indicator: Call up program for updating results, I_IND_POSTING_KZ
	Indicator.: Trigger commit work to database, I_IND_PROC_COMMIT_WORK
← Output	Error log list (structure QIERR), T_QIERRTAB

If the indicator *Transfer of valuations from subsystem* is set, the valuation and defect class for the single results are transferred from the subsystem to the QM component. If a single result to be transferred is marked as the last single value (field KZLWERT) and partial samples are to be taken for a characteristic, the data in the MBEWERTGPR and FEHLKLASPR fields (valuation and defect class for sample) is transferred. If only the result of a single sample is requested for a characteristic, the valuation and defect class are transferred in the MBEWERTGMK and FEHLKLASMK fields (valuation and defect class for characteristic).

If characteristics or samples are to be closed (*Close samples or characteristics* indicator), and a single result record is marked as the last single value, either the sample or the characteristic is closed depending on whether partial samples are to be taken for the characteristic or not.

When closing characteristics requiring documentation (QAIMV-KZDOKU) an inspection description must be confirmed at characteristic level. These characteristics cannot be closed using function module QIRF_GET_ORIGINAL_VALUES2. In this case, the characteristics are closed using record type Q79 and function module QIRF_GET_FEATURE_VALUES2.

If the indicator *Transfer of valuation from subsystem* is not set, the characteristics are valued in the QM component.

If the [ERFASSART \[Page 102\]](#) field has value J, K, L, M, N, or O, the sample number must be entered.

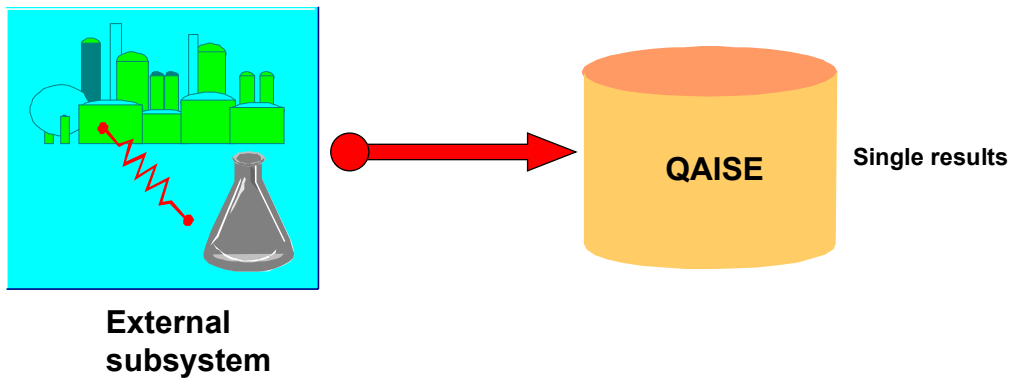
See also:

Graphic [Function Module QIRF_GET_ORIGINAL_VALUES2 \[Page 45\]](#)

Results Confirmation for Single Results Using Record Types Q51, Q52, Q53, Q54, Q55, Q56, and Q58: Function Module QIRF_GET_ORIGINAL_VALUES2

Function Module QIRF_GET_ORIGINAL_VALUES2

- Results confirmation for single results (record types Q51, Q52, Q53, Q54, Q55, Q56)
- Canceling single results (record type Q58)



Before Release 4.6, this function module was called QIRF_GET_ORIGINAL_VALUES. You can continue to use the old module.

Results Confirmation for Sample Results Using Record Types Q61, Q62, Q63, Q64, Q65, Q66, Q68, and Q69: Function Module QIRF_GET_SAMPLE_VALUES2

Results Confirmation for Sample Results Using Record Types Q61, Q62, Q63, Q64, Q65, Q66, Q68, and Q69: Function Module QIRF_GET_SAMPLE_VALUES2

Use

Parameters of Function Module QIRF_GET_SAMPLE_VALUES2

→ Input	Indicator: Transfer valuations from subsystem, I_IND_EVALUATION_TRANSFER
	Indicator: Close samples or characteristics, I_IND_CLOSE_PROCESSING
	Table of sample results (structure QAISR), T_QAISRTAB
	Indicator: Send error log by mail, I_SEND_PROTOCOL_MAIL
	Subsystem confirms results, I_SUBSYS
	Indicator: Call up program for updating results, I_IND_POSTING_KZ
	Indicator: Trigger commit work to database, I_IND_PROC_COMMIT_WORK
← Output	Error log list (structure QIERR), T_QIERRTAB

The control indicators are evaluated in the same way as function module QIRF_GET_ORIGINAL_VALUES2. However, the *Last single value* indicator does not exist for record types Q61, Q62 and Q63.

When closing characteristics requiring documentation (QAIMV-KZDOKU) an inspection description must be confirmed at characteristic level. These characteristics cannot be closed using the function module QIRF_GET_SAMPLE_VALUES2. In this case, the characteristics are closed using record type Q79 and function module QIRF_GET_FEATURE_VALUES2.

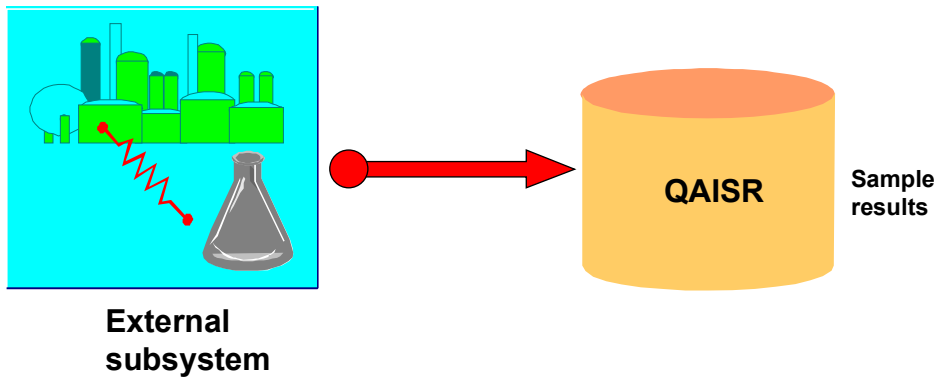
Sample numbers must be entered for record types Q61, Q62, Q63, Q64, Q65, and Q66 (this means, the [ERFASSART \[Page 102\]](#) field has value D, E, F, P, Q, or R).

See also:

Graphic [Function Module QIRF_GET_SAMPLE_VALUES2 \[Page 47\]](#)

Function Module QIRF_GET_SAMPLE_VALUES2

- Results confirmation for sample results (record types Q61, Q62, Q63, Q64, Q65, Q66)
- Canceling samples (record type Q68)
- Closing samples (record type Q69)



Before Release 4.6, this function module was called QIRF_GET_SAMPLE_VALUES. You can continue to use the old module.

Results Confirmation for Characteristic Results Using Record Types Q71, Q72, Q73, and Q79: Function Module QIRF_GET_FEATURE_VALUES2

Results Confirmation for Characteristic Results Using Record Types Q71, Q72, Q73, and Q79: Function Module QIRF_GET_FEATURE_VALUES2

Use

Parameters of Function Module QIRF_GET_FEATURE_VALUES2

→ Input	Indicator: Transfer valuations from subsystem, I_IND_EVALUATION_TRANSFER
	Indicator: Close characteristics, I_IND_CLOSE_PROCESSING
	Indicator: Send error log by mail, I_SEND_PROTOCOL_MAIL
	Subsystem confirms results, I_SUBSYS
	Table of characteristic results (structure QAIMR), T_QAIMRTAB
	Indicator: Call up program for updating results, I_IND_POSTING_KZ
	Indicator: Trigger commit work to database, I_IND_PROC_COMMIT_WORK
← Output	Error log list (structure QIERR), T_QIERRTAB

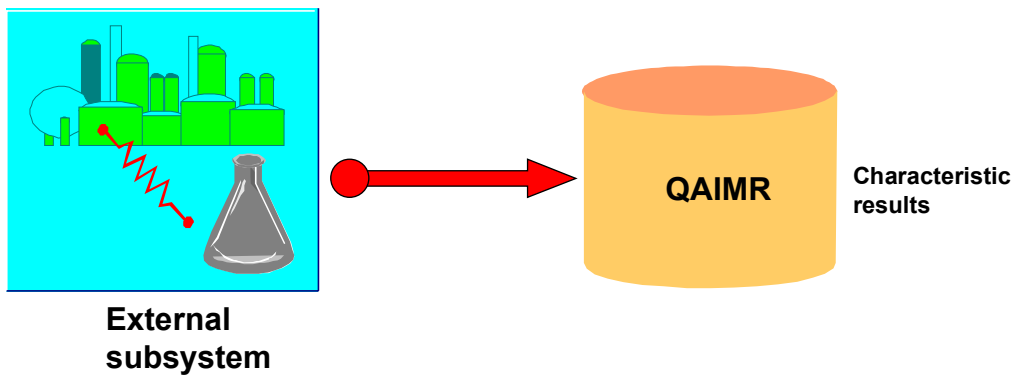
The control indicators are evaluated in the same way as function module QIRF_GET_ORIGINAL_VALUES2. However, the *Last single value* indicator does not exist for record types Q71, Q72, and Q73.

See also:

Graphic [Function Module QIRF_GET_FEATURE_VALUES2 \[Page 49\]](#)

Function Module QIRF_GET_FEATURE_VALUES2

- Results confirmation for characteristic results (record types Q71, Q72, Q73)
- Closing characteristics (record type Q79)



Before Release 4.6, this function module was called QIRF_GET_FEATURE_VALUES. You can continue to use the old module.

Results Confirmation for all Record Types: Function Module QIRF_GET_ALL_DATA_VALUES2

Results Confirmation for all Record Types: Function Module QIRF_GET_ALL_DATA_VALUES2

Parameters of Function Module QIRF_GET_ALL_DATA_VALUES2

→ Input	Indicator: Transfer valuations from subsystem, I_IND_EVALUATION_TRANSFER
	Indicator: Close samples or characteristics, I_IND_CLOSE_PROCESSING
	Indicator: Send error log by mail, I_SEND_PROTOCOL_MAIL
	Subsystem confirms results, I_SUBSYS
	Table of single results (structure QAISE), T_QAISETAB
	Table of sample results (structure QAISR), T_QAISRTAB
	Table of characteristic results (structure QAIMR), T_QAIMRTAB
	Indicator: Call up program for updating results, I_IND_POSTING_KZ
	Indicator: Trigger commit work to database, I_IND_PROC_COMMIT_WORK
← Output	Error log list (structure QIERR), T_QAISETAB

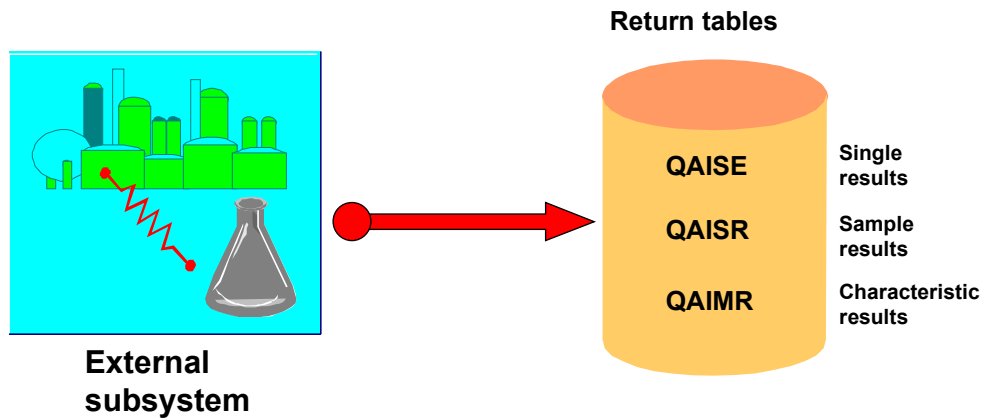
Internally, this function module calls up function modules QIRF_GET_ORIGINAL_VALUES2, QIRF_GET_SAMPLE_VALUES2, and QIRF_GET_FEATURE_VALUES2.

See also:

Graphic [Function Module QIRF_GET_ALL_DATA_VALUES2 \[Page 51\]](#) [\[Page 51\]](#)

Function Module QIRF_GET_ALL_DATA_VALUES2

● Results confirmation for all record types



Before Release 4.6, this function module was called QIRF_GET_ALL_DATA_VALUES. You can continue to use the old module.

Confirmation of the Usage Decision for an Inspection Lot Using Record Types Q88 and Q89: Function Module QIRF_GET_USAGE_DECISION2

Confirmation of the Usage Decision for an Inspection Lot Using Record Types Q88 and Q89: Function Module QIRF_GET_USAGE_DECISION2

Use

Parameters of Function Module QIRF_GET_USAGE_DECISION2

→ Input	Indicator: Trigger inventory posting in QM after usage decision, I_STOCK_POSTING
	Indicator: Send error log by mail, I_SEND_PROTOCOL_MAIL
	Subsystem confirms results, I_SUBSYS
	Table of usage decisions (structure QAIVE), T_QAIVETAB
← Output	Error log list (structure QIERR), T_QIERRTAB

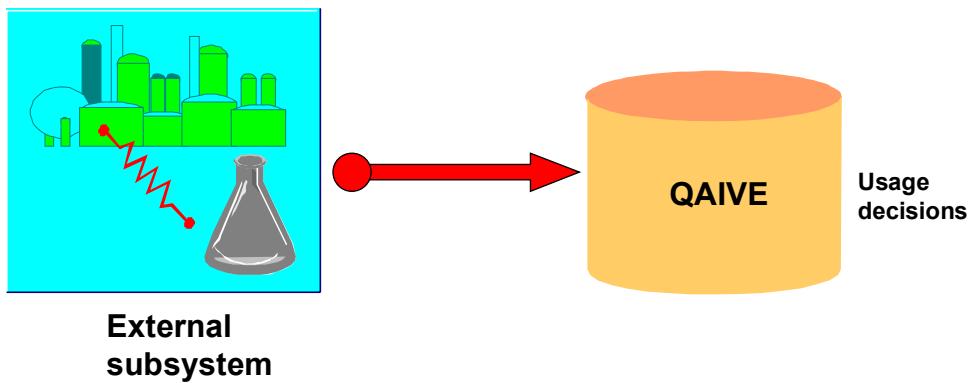
You can use record type Q89 to make a usage decision for an inspection lot even if there are still open required characteristics (inspection cancellation). After the usage decision has been made, the inspection lot is deleted from the worklist.

See also:

Graphic [Function Module QIRF_GET_USAGE_DECISION2 \[Page 53\]](#)

Function Module QIRF_GET_USAGE_DECISION2

- Confirmation of usage decision for inspection lot (record types Q88 and Q89)



Before Release 4.6, this function module was called QIRF_GET_USAGE_DECISION. You can continue to use the old module.

Confirmation of Inspection Points Using Record Types Q83 and Q84: Function Module QIRF_GET_INSP_POINT2

Confirmation of Inspection Points Using Record Types Q83 and Q84: Function Module QIRF_GET_INSP_POINT2

Use

Parameters of Function Module QIRF_GET_INSP_POINT2

→ Input	Indicator: Error log sent by mail, I_SEND_PROTOCOL_MAIL
	Subsystem confirms results, I_SUBSYS
	Table of inspection point data (QAIPP), T_QAIPPTAB
← Output	Error log list (structure QIERR), T_QIERRTAB

You can use record type Q83 to create inspection points in the QM system.

Using record type Q84, you can create inspection points as well as valuate existing inspection points and assign them to partial lots and batches. To confirm inspection results for inspection points, you can use the standard function modules for results confirmation with record types Q54, Q55, Q56 and Q64, Q65, Q66. The inspection points have to be created beforehand. The link between the inspection points and the corresponding results is created via sample numbers (that is, consecutive numbers for the inspection points that have to be assigned by the subsystem).

When closing inspection points requiring documentation (QAIMV-KZDOKU) an inspection description must be confirmed at inspection point level. These inspection points cannot be closed using function module QIRF_GET_INSP_POINT2. In this case, the inspection points are closed using record type Q69 and function module QIRF_GET_SAMPLE_VALUES2.

If additional user fields are activated for inspection points of types 1 and 3, then those are initial when retrieved. The subsystem fills these fields and confirms the inspection types with the record types Q83 or Q84. In these cases, it is possible to confirm additional inspection points for the same equipment, functional location, or physical sample.

If no additional user fields are activated, the inspection points are already complete and do not require confirmation with record type Q83.

Results for incomplete inspection plans cannot be confirmed.

Inspection Point Valuation

If the field EVALUATION in structure QAIVC is initial, QM automatically valuates the inspection point based on proposals from the inspection point identification. The subsystem can also transfer its own, independent valuation. If there is no valuation yet, the valuation is done once automatically when the last characteristic of the inspection point is closed. If all characteristics are accepted, the proposal for the acceptance of the inspection point becomes valid. If at least one characteristic is rejected, the proposal for the rejection of the inspection point becomes valid.

The valuation of the inspection point can be changed manually by both the subsystem and the user. This is especially important if the valuation of materials is changed at a later point, because there will then be no automatic valuation of the inspection point.

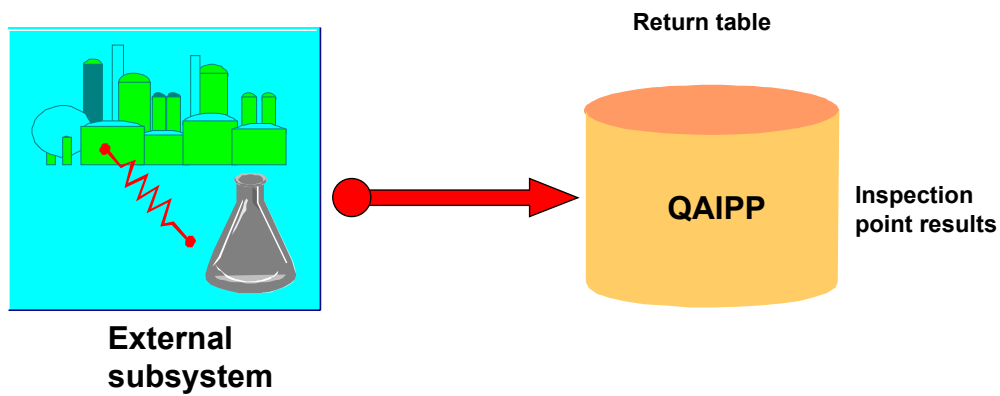
Confirmation of Inspection Points Using Record Types Q83 and Q84: Function Module QIRF_GET_INS

See also:

Graphic [Function Module QIRF_GET_INSP_POINT2 \[Page 56\] \[Page 56\]](#)

Function Module QIRF_GET_INSP_POINT2

- Confirmation of inspection points, partial lots (record types Q83, Q84)



Before Release 4.6, this function module was called QIRF_GET_INSP_POINT. You can continue to use the old module.



Confirmation of Defect Items

Use

You can use function module QIRF_GET_DEFECT_ITEMS2 to confirm defect items for different reference objects:

Parameters for Function Module QIRF_GET_DEFECT_ITEMS2

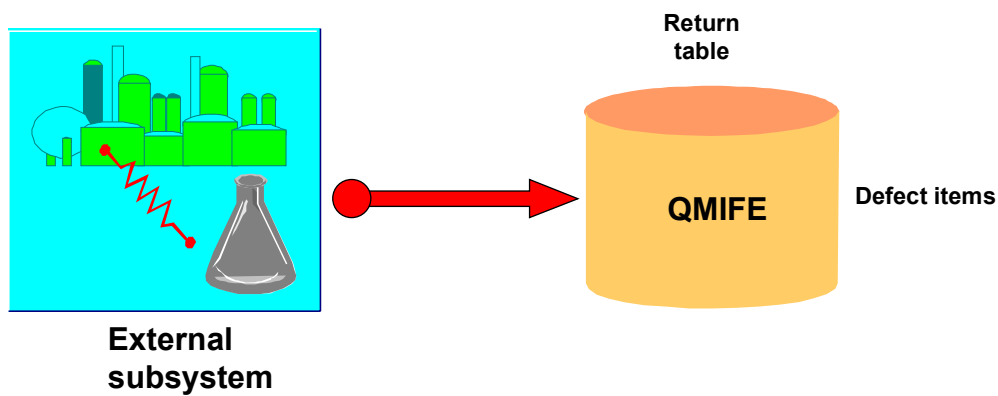
→ Input	Indicator: Send error log by mail, I_SEND_PROTOCOL_MAIL
	Subsystem makes confirmation, I_SUBSYS
	Table of defect items (QMIFE), T_QMIFE TAB
← Output	Error log list (structure QIERR), T_QIERRTAB

The defect items are confirmed using the following record types:

Record type	Meaning
Q90	Defects for inspection lot
Q91	Defects for operation
Q92	Defects for characteristic/independent multiple sample
Q95	Defects for operation (reference to inspection point)
Q96	Defects for characteristic (reference to inspection point)

Function Module QIRF_GET_DEFECT_ITEMS2

- Confirmation of defect items
(record types Q90, Q91, Q92, Q95, Q96)



Before Release 4.6, the function module was called QIRF_GET_DEFECT_ITEMS. You can continue to use the old module.

Data Structures

Use

The following sections contain tables with information on the fields of the data structures used to transfer data via the QM-IDI interface.

Some data structures comprise the SATZART field. Depending on the record type you choose, you can transfer different kind of information with these data structures.

In the following sections, you will find a list for each data structure. These lists contain the allowed record types as well as the fields for which an entry is required or fields that must not be filled for the respective record types.

For additional notes to all other fields of the individual data structures, please refer to [General Notes on the Tables \[Page 97\]](#)

Features

[Data Structure for Request of Inspection Lots from Subsystem to QM Module \(QAILS\), Record Type Q40 \[Page 60\]](#)

[Data Structure for Work List of Operations to be Processed \(QIWLR\) \[Page 63\]](#)

[Data Structure for Transferring Operation Header Data from the QM Module to the Subsystem \(QAIVC\), Record Type Q41 \[Page 65\]](#)

[Data Structure for Transferring Characteristic Specifications to Subsystem\(QAIMV\), Record Type Q42 \[Page 70\]](#)

[Data Structure for Transferring Inspection Catalog Data\(QAICA\), Record Type Q45 \[Page 75\]](#)

[Data Structure for Confirming Single Results Data\(QAISE\) \[Page 77\]](#)

[Data Structure for Confirming Sample Results\(QAISR\) \[Page 81\]](#)

[Data Structure for Confirming Characteristic Results Data \(QAIMR\) \[Page 84\]](#)

[Data Structure for Confirming Inspection Results\(QAIPP\) \[Page 87\]](#)

[Data Structure for Confirming the Usage Decision for the Inspection Lot \(QAIVE\) \[Page 90\]](#)

[Data Structure for Transferring Catalog Types and Texts\(QEFTQ15T\) \[Page 92\]](#)

[Data Structure for Transferring Error Messages \(QIERR\) \[Page 93\]](#)

Data Structure for Request of Inspection Lots from Subsystem to QM Module (QAILS),
Record Type Q40

Data Structure for Request of Inspection Lots from Subsystem to QM Module (QAILS), Record Type Q40

Use

Field	Type	Length	Text
SATZART [Page 62]	CHAR	3	Record type for request record
LOSNR_VON	NUMC	12	From inspection lot number
LOSNR_BIS	NUMC	12	To inspection lot number
PLNFL	CHAR	6	Operation sequence in task list
VORNR_VON	CHAR	4	From operation number
VORNR_BIS	CHAR	4	To operation number
VORGWERK	CHAR	4	Plant of operation to be processed
SUBSYS	CHAR	6	Identifier of the subsystem
PRPLATZ	CHAR	8	Work center
PRPLATZWRK	CHAR	4	Plant of the work center
MATNR	CHAR	18	Material number
DATUM_VON	DATE	8	From creation date of inspectn. lot
DATUM_BIS	DATE	8	To creation date of inspection lot
PRUEFSTAT [Page 119]	CHAR	1	Status of the inspection
ART	CHAR	8	Inspection type
HERKUNFT [Page 103]	CHAR	2	Origin of the inspection lot
CHARG	CHAR	10	Batch number
AUFNR_VON	CHAR	12	From order number
AUFNR_BIS	CHAR	12	To order number
LIFNR	CHAR	10	Vendor number
KUNNR	CHAR	10	Customer number

Data Structure for Request of Inspection Lots from Subsystem to QM Module (QAILS), Record Type Q4

MBLNR	CHAR	10	Number of the material document
MAXLOSANZ	NUMC	4	Maximum number of lots

Record Types for Structure QAILS

Record Types for Structure QAILS

You can use record type Q40 to request inspection lots from the subsystem. The following table lists the fields that must or may not be filled for this data structure, depending on the record type.

Use

Record type	Required fields	Fields not permitted
Q40	SATZART, SUBSYS	

Data Structure for Work List of Operations to be Processed (QIWLR)

Data Structure for Work List of Operations to be Processed (QIWLR)

Use

Field	Type	Length	Text
MANDANT	NUMC	3	Client
SUBSYS	CHAR	6	Identifier of the subsystem
PRUEFLOS	NUMC	12	Number of the inspection lot
PLNFL	CHAR	6	Operation sequence in task list
VORNR	CHAR	4	Operation number
PRPLATZ	CHAR	8	Work center
PRPLATZWRK	CHAR	4	Plant of the work center
EINFUEGDAT	DATE	8	Creation date of entry in work list
EINFUEGTIM	TIME	6	Creation time of entry in work list
AENDERDAT	DATE	8	Change date of the entry
AENDERTIM	TIME	6	Change time of the entry
SENDATERST	DATE	8	Date of first transmission
SENTIMERST	TIME	6	Time of first transmission
SENDATKOR	DATE	8	Date of correction transmission
SENTIMKOR	TIME	6	Time of correction transmission
SENDSTAT [Page 120]	CHAR	1	Status of the transmission
PRUEFSTAT [Page 119]	CHAR	1	Status of the inspection
ART	CHAR	8	Inspection type
ENSTEHDAT	DATE	8	Creation date of the inspection lot
HERKUNFT [Page 103]	CHAR	2	Origin of the inspection lot

Data Structure for Work List of Operations to be Processed (QIWLR)

VORGWERK	CHAR	4	Plant of the operation
MATNR	CHAR	18	Material number
CHARG	CHAR	10	Batch number
AUFNR	CHAR	12	Order number
LIFNR	CHAR	10	Vendor number
KUNNR	CHAR	10	Customer number
MBLNR	CHAR	10	Number of the material document
UPSL	CHAR	1	Ctrl ind.: only for internal use

Data Structure for Transferring Operation Header Data from the QM Module to the Subsystem (QAIVC), Record Type Q41

Use

Field	Type	Length	Text
SATZART	CHAR	3	Record type for header record
PRUEFLOS	NUMC	12	Number of the inspection lot
PLNFL	CHAR	6	Operation sequence in task list
VORNR	CHAR	4	Operation number
WERK	CHAR	4	Plant of the inspection lot
ART	CHAR	8	Inspection type
HERKUNFT [Page 103]	CHAR	2	Origin of the inspection lot
ENTSTEHDAT	DATE	8	Creation date of the inspection lot
ERSTELLER	CHAR	12	User who created the data record
AENDERER	CHAR	12	User who changed the data record
AENDERDAT	DATE	8	Change date of the data record
KZVESUBSYS	CHAR	1	Ind.: make usage decision in subsystem
VKATART	CHAR	1	Catalog type for usage decision
VWERKS	CHAR	4	Plant of selected set for usage dec.
VAUSWAHLMG	CHAR	8	Selected set for usage decision
PPVEKATART	CHAR	1	Catalog type for inspection point valuation
PPVEWERK	CHAR	4	Plant of the selected set for the inspection point valuation
PPVEMENGE	CHAR	8	Selected set for the inspection point valuation
PPVECODGRA	CHAR	4	Code group proposal when inspection point is accepted (acceptance of all characteristics)
PPVECODEA	CHAR	4	Code proposal when inspection point is accepted

Data Structure for Transferring Operation Header Data from the QM Module to the Subsystem (QAIVC), Record Type Q41

PPVECODGRR	CHAR	4	Code group proposal when inspection point is rejected (rejection of one characteristic at least)
PPVECODER	CHAR	4	Code proposal when inspection point is rejected
PLNTY	CHAR	1	Task list type
PLNNR	CHAR	8	Key of task list group
PPLVERW	CHAR	3	Task list usage
PLNAL	CHAR	2	Task list group counter
ZAEHL	NUMC	8	Version counter for task list
PLANKTEXT	CHAR	40	Short text of the task list
DATUV	DATE	8	Start of validity for task list header
PASTRTERM	DATE	8	Start date of the inspection
PAENDTERM	DATE	8	Finish date of the inspection
KUNNR	CHAR	10	Customer number
NAME1KUN	CHAR	35	Name 1 of the customer
LIFNR	CHAR	10	Vendor number
NAME1LIF	CHAR	35	Name 1 of the vendor
HERSTELLER	CHAR	10	Number of the manufacturer
NAME1HER	CHAR	35	Name 1 of the manufacturer
MATNR	CHAR	18	Material number
KTEXTMAT	CHAR	40	Short text of the material
KTEXTLOS	CHAR	40	Short text of the inspection lot
CHARG	CHAR	10	Batch number
LAGORTCHRG	CHAR	4	Storage location of the batch
LICHN	CHAR	15	Batch number used by vendor
IDNLF	CHAR	35	Material number used by vendor
KDMAT	CHAR	35	Material number used by customer
POSTX	CHAR	40	Mat. short text used by customer

Data Structure for Transferring Operation Header Data from the QM Module to the Subsystem (QAIVC)

WERKVORG	CHAR	4	Plant of the goods movement
LAGORTVORG	CHAR	4	Storage location for the goods movement
LOSMENGE	CHAR	17	Inspection lot quantity
MENGENEINH	CHAR	3	Base unit of measure of the inspection lot
GESSTICHPR	CHAR	17	Sample size for inspection lot
EINHPROBE	CHAR	3	Unit of measure for sample
EBELN	CHAR	10	Purchasing document number
EBELP	NUMC	5	Item no. of purchasing document
MJAHR	NUMC	4	Year of the material document
MBLNR	CHAR	10	Number of the material document
ZEILE	NUMC	4	Item in material document
BUDAT	DATE	8	Posting date in document
AUFNR	CHAR	12	Order number
KDAUF	CHAR	10	Customer order number
KDPOS	NUMC	6	Item number in sales order
VORKTXT	CHAR	40	Short text for operation
PRPLATZ	CHAR	8	Work center
PRPLATZWRK	CHAR	4	Plant of the target work center
PRPLATZTXT	CHAR	40	Short text of the work center
SUBSYS	CHAR	6	Identifier of the subsystem
QKZPRZEIT	CHAR	1	Ind.: work cycle = time
QKZPRMENG	CHAR	1	Ind.: work cycle = quantity
QKZPRFREI	CHAR	1	Ind.: any work cycle
QRASTZEHT	CHAR	3	Time unit of inspection grid
QRASTZFAK	NUMC	6	Time factor for inspection grid

Data Structure for Transferring Operation Header Data from the QM Module to the Subsystem (QAIVC), Record Type Q41

QRASTMENG	CHAR	17	Quantity between two inspections
QRASTEREH	CHAR	3	Unit of measure of the insp. grid
PPKTTYP	CHAR	1	Inspection point type space - inspection point for an inspection during production 1 - inspection point for equipment 2 - inspection point for functional locatioun 3 - inspection point for physical sample production
KZEQUNR	CHAR	1	Indicator: user field EQUNR active
SWEQUNR	CHAR	20	Key word for user field EQUNR
KZTPLNR	CHAR	1	Indicator: user field TPLNR active
SWTPLNR	CHAR	20	Key word for user field TPLNR
KZPHYNR	CHAR	1	Indicator: user field PHYNR active
SWPHYNR	CHAR	20	Key word for user field PHYNR
KZUSERC1	CHAR	1	Indicator: user field USERC1 active
SWUSERC1	CHAR	20	Key word for user field USERC1
KZUSERC2	CHAR	1	Indicator: user field USERC2 active
SWUSERC2	CHAR	20	Key word for user field USERC2
KZUSERN1	CHAR	1	Indicator: user field USERN1 active
SWUSERN1	CHAR	20	Key word for user field USERN1
KZUSERN2	CHAR	1	Indicator: user field USERN2 active
SWUSERN2	CHAR	20	Key word for user field USERN2
KZUSERD1	CHAR	1	Indicator: user field USERD1 active
SWUSERD1	CHAR	20	Key word for user field USERD1
KZUSERT1	CHAR	1	Indicator: user field USERT1 active
SWUSERT1	CHAR	20	Key word for user field USERT1
TEILLOSPFL	CHAR	1	Indicator: assignment of partial lot to an inspection point required
CHARGPFL	CHAR	1	Indicator: batch management required
QUANTITIES	CHAR	1	Confirmation of quantity required
EVALUATION	CHAR	1	Confirmation of a valuation required, else confirmation by QM
KOSTL	CHAR	10	Cost center

Data Structure for Transferring Operation Header Data from the QM Module to the Subsystem (QAIVC)

KZKORRTRAN [Page 106]	CHAR	1	Ind.: Correction transmission
PRUEFSTAT [Page 119]	CHAR	1	Status of the inspection
EINHVORG	CHAR	3	Unit of measure for operation
RUECKMPP	CHAR	1	Indicator: confirmation of inspection point required This field is currently not supported.

Data Structure for Transferring Characteristic Specifications to Subsystem (QAIMV),
Record Type Q42

Data Structure for Transferring Characteristic Specifications to Subsystem (QAIMV), Record Type Q42

Use

Field	Type	Length	Text
SATZART	CHAR	3	Record type
RUECKMELNR	NUMC	8	Confirmation number for inspection characteristic
ERFASSART [Page 102]	CHAR	1	Recording type for insp. charact.
KZBEWSUBSY [Page 104]	CHAR	1	Ind.: valuation by subsystem
BEWART [Page 100]	CHAR	1	Valuation type for insp. charact.
KZRZWANG [Page 112]	CHAR	1	Results recording required
KZPRUMF [Page 110]	CHAR	1	Ind.: inspection scope
KZDOKU [Page 105]	CHAR	1	Documentation required
KZSERNR [Page 113]	CHAR	1	Ind.: record serial number
KZTSTICHPR [Page 114]	CHAR	1	Ind.: partial samples for charact.
KZRAST [Page 111]	CHAR	1	Ind.: inspection with insp. grid
RASTER [Page 129]	NUMC	3	Inspection frequency within inspection grid
SOLLSTPANZ	CHAR	5	No. of partial samples planned
BEWARTSP [Page 101]	CHAR	1	Valuation type of partial sample
PRUEFLOS	NUMC	12	Number of the inspection lot
PLNFL	CHAR	6	Number of the task list sequence
VORNR	CHAR	4	Operation number
MERKNR	NUMC	4	Characteristic number
QPMK_WERKS	CHAR	4	Plant of master inspection charact.
VERWMERKM	CHAR	8	Master inspection characteristic

Data Structure for Transferring Characteristic Specifications to Subsystem (QAIMV), Record Type Q42

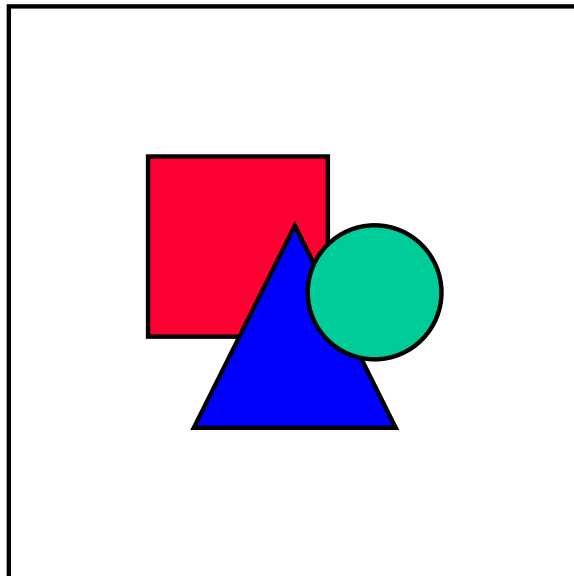
MKVERSION	CHAR	6	Version of master insp. charact.
QMTB_WERKS	CHAR	4	Plant of the inspection method
PMETHODE	CHAR	8	Inspection method
PMTVERSION	CHAR	6	Version of the inspection method
PMTKURZTXT	CHAR	40	Short text of the inspection method
PRUEFQUALI	CHAR	5	Inspector qualification
MERKGEW	CHAR	2	Weighting of insp. characteristic
GEWKURZTXT	CHAR	40	Short text for weighting of inspection characteristic
KURZTEXT	CHAR	40	Short text of the characteristic
FORMEL	CHAR	120	Formula for inspection charact.
DUMMY10	CHAR	10	Additional information 1
DUMMY20	CHAR	20	Additional information 2
DUMMY40	CHAR	40	Additional information 3
STELLEN	NUMC	2	No. of digits after decimal point
MASSEINHSW	CHAR	3	Unit of measure for insp. charact.
SOLLWERT	CHAR	16	Target value/nominal value
TOLERANZOB	CHAR	16	Upper tolerance limit
TOLERANZUN	CHAR	16	Lower tolerance limit
PLAUSIOBEN	CHAR	16	Upper plausibility limit
PLAUSIUNTE	CHAR	16	Lower plausibility limit
GRENZEOB1	CHAR	16	First upper limit value
GRENZEUN1	CHAR	16	First lower limit value
GRENZEOB2	CHAR	16	Second upper limit value
GRENZEUN2	CHAR	16	Second lower limit value
KATAB1	CHAR	1	Ind.: catalog entry 1 is selected set
KATALGART1	CHAR	1	Catalog type 1

**Data Structure for Transferring Characteristic Specifications to Subsystem (QAIMV),
Record Type Q42**

AUSWMGWRK1	CHAR	4	Plant of selected set 1
AUSWMENGE1	CHAR	8	Selected set / code group 1
KATAB2	CHAR	1	Ind.: catalog entry 2 is selected set
KATALGART2	CHAR	1	Catalog type 2
AUSWMGWRK2	CHAR	4	Plant of selected set 2
AUSWMENGE2	CHAR	8	Selected set / code group 2
KATAB3	CHAR	1	Ind.: catalog entry 3 is selected set
KATALGART3	CHAR	1	Catalog type 3
AUSWMGWRK3	CHAR	4	Plant of selected set 3
AUSWMENGE3	CHAR	8	Selected set / code group 3
KATAB4	CHAR	1	Ind.: catalog entry 4 is selected set
KATALGART4	CHAR	1	Catalog type 4
AUSWMGWRK4	CHAR	4	Plant of selected set 4
AUSWMENGE4	CHAR	8	Selected set / code group 4
KATAB5	CHAR	1	Ind.: catalog entry 5 is selected set
KATALGART5	CHAR	1	Catalog type 5
AUSWMGWRK5	CHAR	4	Plant of selected set 5
AUSWMENGE5	CHAR	8	Selected set / code group 5
SOLLSTPUMF	NUMC	7	Sample size to be checked per inspection characteristic
PROBEMGEH	CHAR	3	Unit of measure for sample
PROBMGFAK	NUMC	6	Factor for sample unit of measure
ANNAHMEZ [Page 128]	NUMC	5	Acceptance number for attributive inspection
RUECKWEZ [Page 128]	NUMC	5	Rejection number for attributive inspection
KFAKTOR [Page 128]	CHAR	16	K factor for variable inspection
QRKNR	NUMC	12	Control chart number

Data Structure for Transferring Characteristic Specifications to Subsystem (QAIMV), Record Type Q42

PHYSPROBE	NUMC	6	Number of the physical sample
KZKORRTRAN [Page 106]	CHAR	1	Ind.: correction transmission
ZAEHL [Page 130]	NUMC	8	Version counter
ANTVERF [Page 98]	CHAR	1	Share calculation procedure



Classed characteristics are not transferred.

[Determining the Sample Size \[Page 74\]](#)

Determining the Sample Size

Determining the Sample Size

Extract from QAIMV

PROBMGFAK	5	5 ml are to be taken for each measurement.
PROBEMGEH		ml
SOLLSTPUMF	6	A total number of 6 measured values are to be recorded.
SOLLSTPANZ	3	3 samples are planned.

=> 3 samples of $2 * 5 = 10$ ml respectively are to be processed.

2 measured values are to be recorded for each sample.

A total number of 6 measured values and $6 * 5 = 30$ ml is required..

Data Structure for Transferring Inspection Catalog Data(QAICA), Record Type Q45

Use

Field	Type	Length	Text
SATZART	CHAR	3	Record type
KATAB	CHAR	1	Ind.: entry is selected set
KATALGART [Page 76]	CHAR	1	Catalog type
AUSWMGWRK	CHAR	4	Plant of the selected set
AUSWMENGE	CHAR	8	Selected set
CODEGRUPPE	CHAR	8	Code group
CODE	CHAR	4	Code
KURZTEXT	CHAR	40	Short text of the code
BEWERTUNG [Page 115]	CHAR	1	Valuation
FEHLKLASSE [Page 122]	CHAR	2	Defect class
MUSSTEXTKZ [Page 118]	CHAR	1	Ind.: text required for confirmatn.
BB_VORSCH	CHAR	1	Ind.: carry out inventory posting
QKENNZahl	NUMC	3	Quality score

Field KATALGART

Field KATALGART

The following fields are always filled for catalog type 1 and 3:

Field	Catalog type 1	Catalog type 3
SATZART	filled	filled
KATAB	filled	filled
KATALGART	filled	filled
AUSWMGWRK	filled	filled
AUSWMENGE	filled	filled
CODEGRUPPE	filled	filled
CODE	filled	filled
KURZTEXT	filled	filled
BEWERTUNG	filled	filled
FEHLKLASSE	filled	not filled
MUSSTEXTKZ	filled	not filled
BB_VORSCH	not filled	filled
QKENNZAH	not filled	filled

Data Structure for Confirming Single Results Data(QAISE)

Use

Field	Type	Length	Text
SATZART [Page 79]	CHAR	3	Record type
RUECKMELNR	NUMC	8	Confirmation no. of the charact.
PROBENR	NUMC	6	Number of the partial sample
STUECKNR	NUMC	4	Consecutive number for test units
KZSERNR [Page 113]	CHAR	1	Ind.: serial number filled
SERIALNR	CHAR	18	Serial no. of the test unit
KZLWERT [Page 131]	CHAR	1	Ind.: last single value
KZLRPOBE [Page 107]	CHAR	1	Ind.: last sample
KZABSCHL [Page 125]	CHAR	1	Ind.: close characteristic (sample)
KZBEWEEEXT [Page 126]	CHAR	1	Ind.: transfer valuation
ATTRIBUT [Page 99]	CHAR	1	Attribute of the individual result
MESSWERT	CHAR	16	Measured value
GRUPPE1	CHAR	8	Code group 1
CODE1	CHAR	4	Code 1
GRUPPE2	CHAR	8	Code group 2
CODE2	CHAR	4	Code 2
GRUPPE3	CHAR	8	Code group 3
CODE3	CHAR	4	Code 3
GRUPPE4	CHAR	8	Code group 4
CODE4	CHAR	4	Code 4

Data Structure for Confirming Single Results Data(QAISE)

GRUPPE5	CHAR	8	Code group 5
CODE5	CHAR	4	Code 5
BEWERTUNG [Page 115]	CHAR	1	Valuation
FEHLKLAS [Page 122]	CHAR	2	Defect class
ANZFEHLER	NUMC	2	Number of defects
PRUEFDATUV	DATE	8	Start date of the inspection
PRUEFZEITV	TIME	6	Start time of the inspection
PRUEFER	CHAR	12	Name of the inspector
QERGDATH	CHAR	2	Origin of results data (on completion)
MASCHINE	CHAR	18	Machine
POSITION	NUMC	4	Position on the machine
PRUEFBEMKT	CHAR	40	Short text for inspection descript.
MBEWERTGPR [Page 117]	CHAR	1	Valuation of the sample
FEHLKLASPR [Page 123]	CHAR	2	Defect class for sample valuation
MBEWERTGMK [Page 116]	CHAR	1	Valuation of the characteristic
FEHLKLASMK [Page 124]	CHAR	2	Defect class for characteristic valuation

Record Type for Structure QAISE

Use

You can use the following record types to process individual results. The following table lists the fields that must or may not be filled for this data structure, depending on the record type.

Record type	Required fields	Fields not permitted
Q51, Q54	SATZART, RUECKMELNR, PROBENR ^{b)} , KZSERNR ^{a)} , STUECKNR ^{a)} , SERIALNR ^{a)} , MESSWERT	CODE1, GRUPPE1
Q52, Q55	SATZART, RUECKMELNR, PROBENR ^{b)} , KZSERNR ^{a)} , STUECKNR ^{a)} , SERIALNR ^{a)} , CODE1, GRUPPE1	MESSWERT
Q53, Q56	SATZART, RUECKMELNR, PROBENR ^{b)} , KZSERNR ^{a)} , STUECKNR ^{a)} , SERIALNR ^{a)} , BEWERTUNG	MESSWERT, CODE1, GRUPPE1
Q58	SATZART, RUECKMELNR, PROBENR ^{b)} , KZSERNR ^{a)} , STUECKNR ^{a)} , SERIALNR ^{a)}	all other fields

See also [Notes on the Required Fields of Structures QAISE und QAIPP \[Page 80\]](#).

Notes on the Required Fields of Structures QAISE und QAIPP

- a) There are two ways of identifying a single-value record:
 - i) KZSERNR = "X": the SERIALNR field must be filled.
 - ii) KZSERNR = " " (blank): the STUECKNR field must be filled.
- b) In the case of characteristics for which only the data of a single sample is to be reported, the PROBENR field must be filled with "000000". In the case of record types referring to an inspection point, the PROBENR field must be filled with a value not equal to '000000'.
- c) The key words for user fields transferred in the QAIVC structure have an indicator that specifies whether the user field is active. For active user fields, a confirmation is required.

Data Structure for Confirming Sample Results(QAISR)

Use

Field	Type	Length	Text
SATZART [Page 83]	CHAR	3	Record type
RUECKMELNR	NUMC	8	Confirmation no. of the charact.
PROBENR	NUMC	6	Number of the sample
KZLPROBE [Page 107]	CHAR	1	Ind.: last sample for the charact.
KZABSCHL [Page 125]	CHAR	1	Ind.: close characteristic (sample)
KZBEWEEEXT [Page 126]	CHAR	1	Ind.: transfer valuation
ATTRIBUT [Page 99]	CHAR	1	Attribute of the results record
GRUPPE1	CHAR	8	Code group 1
CODE1	CHAR	4	Code 1
GRUPPE2	CHAR	8	Code group 2
CODE2	CHAR	4	Code 2
GRUPPE3	CHAR	8	Code group 3
CODE3	CHAR	4	Code 3
GRUPPE4	CHAR	8	Code group 4
CODE4	CHAR	4	Code 4
GRUPPE5	CHAR	8	Code group 5
CODE5	CHAR	4	Code 5
ANZWERTG	NUMC	4	Number of valid values
ANZFEHLEH	NUMC	4	Number of non-conforming units
ANZFEHLER	NUMC	4	Number of defects
ANZWERTO	NUMC	4	Values above upper tolerance limit

Data Structure for Confirming Sample Results(QAISR)

ANZWERTU	NUMC	4	Values below lower tolerance limit
MITTELWERT	CHAR	16	Average of valid measured values
VARIANZ	CHAR	16	Variance of valid measured values
MAXWERT	CHAR	16	Max. of valid measured values
MEDIANWERT	CHAR	16	Median of valid measured values
MINWERT	CHAR	16	Min. of valid measured values
PRUEFDATUV	DATE	8	Start date of inspection
PRUEFDATUB	DATE	8	Finish date of inspection
PRUEFZEITV	TIME	6	Start time of inspection
PRUEFZEITB	TIME	6	Finish time of inspection
PRUEFER	CHAR	12	Name of the inspector
QERGDATH	CHAR	2	Origin of results data
MASCHINE	CHAR	18	Machine
POSITION	NUMC	4	Position on the machine
PRUEFBEMKT	CHAR	40	Short text for inspection descript.
MBEWERTGPR [Page 117]	CHAR	1	Valuation of the sample
FEHLKLASPR [Page 123]	CHAR	2	Defect class of the sample
MBEWERTGMK [Page 116]	CHAR	1	Valuation of the characteristic
FEHLKLASMK [Page 124]	CHAR	2	Defect class of the characteristic

Record Types for Structure QAISR

Use

You can use the following record types to process sample results. The following table lists the fields that must or may not be filled for this data structure, depending on the record type.

Record type	Required fields	Fields not permitted
Q61, Q64	SATZART, RUECKMELNR, PROBENR, MITTELWERT, VARIANZ, ANZWERTG	CODE1, GRUPPE1
Q62, Q65	SATZART, RUECKMELNR, PROBENR, CODE1, GRUPPE1, ANZWERTG	MITTELWERT, VARIANZ, MAXWERT, MINWERT, MEDIAN, ANZWERTO, ANZWERTU
Q63, Q66	SATZART, RUECKMELNR, PROBENR, MBEWERTGPR, ANZWERTG	MITTELWERT, VARIANZ, MAXWERT, MINWERT, MEDIAN, ANZWERTO, ANZWERTU, CODE1, GRUPPE1
Q68	SATZART, RUECKMELNR, PROBENR	all other fields
Q69	SATZART, RUECKMELNR, PROBENR	all other fields

Data Structure for Confirming Characteristic Results Data (QAIMR)

Data Structure for Confirming Characteristic Results Data (QAIMR)

Use

Field	Type	Length	Text
SATZART [Page 86]	CHAR	3	Record type
RUECKMELNR	NUMC	8	Confirmation no. of the charact.
KZABSCHL [Page 125]	CHAR	1	Ind.: close characteristic
KZBEWEEXT [Page 126]	CHAR	1	Ind.: transfer valuation
ATTRIBUT [Page 99]	CHAR	1	Attribute of the results record
MBEWERTG [Page 115]	CHAR	1	Valuation of characteristic for usage decision
FEHLKLAS [Page 122]	CHAR	2	Defect class
GRUPPE1	CHAR	8	Code group 1
CODE1	CHAR	4	Code 1
GRUPPE2	CHAR	8	Code group 2
CODE2	CHAR	4	Code 2
GRUPPE3	CHAR	8	Code group 3
CODE3	CHAR	4	Code 3
GRUPPE4	CHAR	8	Code group 4
CODE4	CHAR	4	Code 4
GRUPPE5	CHAR	8	Code group 5
CODE5	CHAR	4	Code 5
ANZWERTG	NUMC	7	Number of valid values
ANZFEHLEH	NUMC	7	Number of non-conforming units
ANZFEHLER	NUMC	7	Number of defects

Data Structure for Confirming Characteristic Results Data (QAIMR)

ANZWERTO	NUMC	7	Values above upper tolerance limit
ANZWERTU	NUMC	7	Values below lower tolerance limit
MITTELWERT	CHAR	16	Average of valid measured values
VARIANZ	CHAR	16	Variance of valid measured values
MAXWERT	CHAR	16	Max. of valid measured values
MEDIANWERT	CHAR	16	Median of valid measured values
MINWERT	CHAR	16	Min. of valid measured values
IVARIANZ	CHAR	16	Inner variance of measured values
PRUEFDATUV	DATE	8	Start date of the inspection
PRUEFDATUB	DATE	8	Finish date of the inspection
PRUEFZEITV	TIME	6	Start time of the inspection
PRUEFZEITB	TIME	6	Finish time of the inspection
PRUEFER	CHAR	12	Name of the inspector
QERGDATH	CHAR	2	Origin of results data
MASCHINE	CHAR	18	Machine
POSITION	NUMC	4	Position on the machine
PRUEFBEMKT	CHAR	40	Short text for inspection descript.

Record Types for Structure QAIMR

Record Types for Structure QAIMR

Use

You can use the following record types to process characteristic results. The following table lists the fields that must or may not be filled for this data structure, depending on the record type.

Record type	Required fields	Fields permitted
Q71	SATZART, RUECKMELNR, MITTELWERT, VARIANZ, ANZWERTG	CODE1, GRUPPE1
Q72	SATZART, RUECKMELNR, CODE1, GRUPPE1, ANZWERTG	MITTELWERT, VARIANZ, MAXWERT, MINWERT, MEDIAN, ANZWERTO, ANZWERTU
Q73	SATZART, RUECKMELNR, MBEWERTG, ANZWERTG	MITTELWERT, VARIANZ, MAXWERT, MINWERT, MEDIAN, ANZWERTO, ANZWERTU, CODE1, GRUPPE1
Q79	SATZART, RUECKMELNR	MITTELWERT, VARIANZ, MAXWERT, MINWERT, MEDIAN, ANZWERTO, ANZWERTU, CODE1, GRUPPE1, MBEWERTG, ANZWERTG

Data Structure for Confirming Inspection Results(QAIPP)

Use

[QIRF_INSPPOINT_GETLIST \[Page 37\]](#)

Field	Type	Length	Text
SATZART [Page 89]	CHAR	3	Record type
PRUEFLOS	NUMC	12	Inspection lot number
PLNFL	CHAR	6	Operation sequence in task list
VORNR	CHAR	4	Operation number
PROBENR	NUMC	6	Sample number
TEILLOS	NUMC	6	Partial lot number
MENGE	CHAR	17	Inspection point quantity
EINHPR	CHAR	3	Unit of measure for inspection point
EQUNR	CHAR	18	Equipment number Cannot be defined freely (value range determined by inspection lot); inspection points of type 1 through 3 already defined (these inspection points can be retrieved with function module QIRF_INSPPOINT_GETLIST [Page 37])
TPLNR	CHAR	13	Number of functional location (see EQUNR)
PHYNR	CHAR	12	Number of physical sample (see EQUNR)
USERC1	CHAR	18	User field for 18 characters
USERC2	CHAR	10	User field for 10 characters
USERN1	NUMC	10	User field for 10 digits
USERN2	NUMC	3	User field for 3 digits
USERD1	DATE	8	User field for date
USERT1	TIME	6	User field for time
VKATART	CHAR	1	Catalog type

Data Structure for Confirming Inspection Results(QAIPP)

VWERKS	CHAR	4	Plant
VAUSWAHLMG	CHAR	8	Selected set of the usage decision for the inspection point
VCODEGRP	CHAR	8	Code group of the usage decision
VCODE	CHAR	4	Code of the usage decision
VTEXT	CHAR	40	Short text for partial lot
MATNR	CHAR	18	Material number
CHARG	CHAR	10	Batch number
PRUEFDATUM	DATE	8	Start date of the inspection
PRUEFZEIT	TIME	6	Start time of the inspection
PRUEFER	CHAR	12	Name of the inspector
KZRMART	CHAR	1	Confirmation type, currently not used
URSACHEAS	CHAR	4	Reason for scrap, currently not used
MENGEAS	CHAR	17	Scrap quantity
MENGENA	CHAR	17	Rework quantity

Record Types for Structure QAIPP

Use

You can use the following record types to create inspection points or carry out valuations. The following table lists the fields that must or may not be filled for this data structure, depending on the record type.

Record type	Required fields	Fields not permitted
Q83,Q84	SATZART, PRUEFLOS, PLNFL, VORNR, PROBENR, user fields from structure QAIPP ^{b), c)}	

See also [Notes on the Required Fields of Structures QAISE und QAIPP \[Page 80\]](#).

Data Structure for Confirming the Usage Decision for the Inspection Lot (QAIVE)

Data Structure for Confirming the Usage Decision for the Inspection Lot (QAIVE)

Use

Field	Type	Length	Text
SATZART [Page 91]	CHAR	3	Record type
PRUEFLOS	NUMC	12	Inspection lot number
AUSWMENGE	CHAR	8	Selected set of the usage decision
AUSWMGWRK	CHAR	4	Plant of the selected set
CODE	CHAR	4	Code
CODEGRUPPE	CHAR	8	Code group
VNAME	CHAR	12	Person who made usage decision
VDATUM	DATE	8	Date when usage decision was made
VZEIT	TIME	6	Time when usage decision was made
VTEXT	CHAR	80	Text for usage decision

Record Types for Structure QAIVE

Use

You can use the following record types to transfer a usage decision or a canceled inspection. The following table lists the fields that must or may not be filled for this data structure, depending on the record type.

Record type	Required fields	Fields not permitted
Q88	SATZART, PRUEFLOS, AUSWMENGE, AUSWMGWRK, CODE, CODEGRUPPE	
Q89	SATZART, PRUEFLOS, AUSWMENGE, AUSWMGWRK, CODE, CODEGRUPPE	

Data Structure for Transferring Catalog Types and Texts(QEIFTQ15T)

Use

Field	Type	Length	Text
KATALOGART	CHAR	1	Catalog type
KATALOGTXT	CHAR	40	Short text

Data Structure for Transferring Error Messages (QIERR)

Data Structure for Transferring Error Messages (QIERR)

Use

Field	Type	Length	Text
LFDNR	NUMC	4	Consecutive number
MSGID	CHAR	20	Message class
MSGNR	NUMC	3	Message number
MSGTYPE	CHAR	1	Message type (E, I, W,...)
MSGTEXT	CHAR	73	Message text
LOG_NO	CHAR	20	Application log: protocol number
LOG_MSG_NO	NUMC	6	Application log: number of current message
PARAM_NAME	CHAR	32	Parameter name
PARAM_ROW	NUMC	10	Line in parameter
PARAM_FIELD	CHAR	30	Field in parameter
PRUEFLOS	NUMC	12	Inspection lot number
PLNFL	CHAR	6	Sequence of operations within a task list
VORNR	CHAR	4	Operation number
VORGLFNR	NUMC	8	Consecutive node number from order counter APLZL
MERKNR	NUMC	4	Inspection characteristic number
KATAB	CHAR	1	Indicator: catalog entry is a selected set
KATALGART	CHAR	1	Catalog type of the assigned code group or selected set
AUSWMGWRK	CHAR	4	Plant of the assigned selected set
AUSWMENGE	CHAR	8	Assigned code group or selected set
CODEGRUPPE	CHAR	8	Code group
CODE	CHAR	4	Code
RUECKMELNR	NUMC	8	Confirmation number for the inspection point
PROBENR	NUMC	6	Number of the sample
STUECKNR	NUMC	4	Consecutive number for unit to be inspected
SATZART	CHAR	3	Record types

Example of Results Confirmation

Example of Results Confirmation

For the inspection characteristic with the confirmation number 00000007, the measured values of 10 inspected single units are to be confirmed. The characteristic specification record transferred to the subsystem contains the following data:

Field	Content
ERFASSART	A
KZPRUMF	=
SOLLSTPUMF	0000010
KZSERNR	X

If processing of the inspection characteristic is to be completed successfully in QM, 10 single-result records with the QAISE structure and the record type Q51 must be created for the inspection characteristic. The following required fields must be filled:

Field	Content
SATZART	Q51
RUECKMELNR	00000007
PROBENR	000000
KZSERNR	X
SERIALNR	XYZ1000000000-4711
MESSWERT	0000000000123.45

Data Structure for Transferring Defect Items (QMIFE)

Use

Field	Type	Length	Text
SATZART	CHAR	3	Record type
PRUEFLOS	NUMC	12	Inspection lot number
PLNFL	CHAR	6	Sequence of operations in task list
VORNR	CHAR	4	Operation number
MERKNR	NUMC	4	Characteristic number
PROBENR	NUMC	6	Number of partial sample/inspection point
RUECKMELNR	NUMC	8	Confirmation number for inspection characteristic
POSNR	NUMC	4	Sort number for item
FEKAT	CHAR	1	Catalog type - defects
FEGRP	CHAR	8	Code group - defects
FECOD	CHAR	4	Defects
SERIALNR	CHAR	18	Single-unit number of unit to be inspected
ANZFEHLER	CHAR	7	Number of defects
FEQKLAS	CHAR	2	Defect class
KZSYSFE	CHAR	1	Indicator: systematic defect
OTKAT	CHAR	1	Catalog type - object parts
OTGRP	CHAR	8	Code group - object parts
OTEIL	CHAR	4	Object part
FETXT	CHAR	40	Short text for defect item
BAUTL	CHAR	18	Assembly
FEHLBEW	CHAR	10	Quantitative defect valuation
UNITFLBEW	UNIT	3	Unit for defect valuation
FENAM	CHAR	12	Name of person who processed defect record
FEDAT	DATS	8	Date of record processing
FZEIT	TIMS	6	Time of record processing

Record Types for Structure QMIFE

Record Types for Structure QMIFE

Use

On the basis of the record type, the system can identify the reference object for which a confirmation should be made. The record type defines key fields for the confirmation record. Using the following table, you can determine which key fields must be filled for which record type:

Record type	Required fields
Q90	PRUEFLOS
Q91	PRUEFLOS, PLNFL, VORNR
Q92	PRUEFLOS, PLNFL, VORNR, MERKNR + if required PROBENR Or: RUECKMELNR + if required PROBENR
Q95	PRUEFLOS, PLNFL, VORNR, PROBENR
Q96	PRUEFLOS, PLNFL, VORNR, MERKNR, PROBENR Or: RUECKMELNR, PROBENR



The following fields are required in the QMIFE data structure, regardless of the record type:

Field	Text
POSNR	Sort number for item
FEKAT	Catalog type - Defects
FEGRP	Code group - Defects
FECOD	Defects
ANZFEHLER	Number of defects

General Notes on the Tables

General data formats:

Type	Initial value	Example
DATE	00000000	19951120
TIME	000000	125013
CHAR	" " (blank)	abc
NUMC	0	7

Floating point numbers are transferred in character fields (type CHAR) with a decimal point.

Fixed Values for Field ANTVERF**Fixed Values for Field ANTVERF**

A set of fixed values has been defined for the ANTVERF field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
ANTVERF	A	Binomial distribution
	B	Poisson distribution
	C	Normal distribution
	“ “ (blank)	Distribution not specified

Fixed Values for Field ATTRIBUT

A set of fixed values has been defined for the ATTRIBUT field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
ATTRIBUT	" " (blank)	Valid
	>	Value is greater than specified
	<	Value is less than specified
	?	Estimated value (valid)
	*	Outlier (invalid)
	/	Invalid (corresponds to "discarded")

Fixed Values for Field BEWART

Fixed Values for Field BEWART

The BEWART field is only filled if KZBEWSUBSY = "X".

A set of fixed values has been defined for the BEWART field. The value ranges for the individual fields are listed in the following table:

Value	Meaning	Download	Upload
A	Valuation by number of non-conforming units (N-C relation)	ANNAHMEZ, RUECKWEZ	ANZWERTG, ANZFEHLEH
B	Valuation by number of defects (N-C relation)	ANNAHMEZ, RUECKWEZ	ANZWERTG, ANZFEHLER
C	Valuation according to s method (ISO3951)	KFAKTOR, TOLERANZOB, TOLERANZUN	MITTELWERT, VARIANZ
D	Valuation according to code	-	GRUPPE1, CODE1
E	Manual valuation	-	MBEWERTG or. MBEWERTGMK
F	Valuation based on the mean value within tolerance limits	TOLERANZOB, TOLERANZUN	MITTELWERT
G	Valuation at sample level	-	-
H	Valuation according to control chart	QRKNR	-

If BEWART contains values *A* or *B*, the ANNAHMEZ field contains the acceptance number and the RUECKWEZ field contains the rejection number of the attributive inspection.

If BEWART contains value *C*, the KFAKTOR field contains the value for the K factor of the variable inspection.

If BEWART contains value *G*, the inspection characteristic must be valued according to the sample valuations. In this case, the BEWARTSP field contains the specification for the valuation of a (partial) sample for the characteristic.

If BEWART contains value *H*, the QRKNR field contains the number of the control chart.

Valuation types are maintained using transaction OQFM.

Fixed Values for Field BEWARTSP

The BEWARTSP field is only filled if KZBEWSUBSY = "X".

A set of fixed values has been defined for the BEWARTSP field. The value ranges for the individual fields are listed in the following table:

Value	Meaning	Download	Upload
A	Valuation by number of non-conforming units (N-C relation)	ANNAHMEZ, RUECKWEZ	ANZWERTG, ANZFEHLEH
B	Valuation by number of defects (N-C relation)	ANNAHMEZ, RUECKWEZ	ANZWERTG, ANZFEHLER
C	Valuation according to s method (ISO3951)	KFAKTOR, TOLERANZOB, TOLERANZUN	MITTELWERT, VARIANZ
D	Valuation according to code	-	GRUPPE1, CODE1
E	Manual valuation	-	MBEWERTGPR
F	Valuation based on the mean value within tolerance limits	TOLERANZOB, TOLERANZUN	MITTELWERT
G	Not allowed	-	-
H	Valuation according to control chart	QRKNR	-

The BEWARTSP field contains the specification for the valuation of a (partial) sample for the characteristic. BEWART if the BEWART fields contains value G, that is, the inspection characteristic must be valued according to the sample valuations.

Valuation types are maintained using transaction OQFM.

Fixed Values for Field ERFASSART

Fixed Values for Field ERFASSART

A set of fixed values has been defined for the ERFASSART field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
ERFASSART	A	Measured value for single unit
	B	Code for single unit
	C	Valuation for single unit (OK/not OK)
	D	Measured value for sample
	E	Code for sample
	F	Valuation of a sample
	G	Measured value for a characteristic
	H	Code for a characteristic
	I	Valuation of a characteristic
	J	Measured value for single unit in a sample
	K	Code for single unit in a sample
	L	Valuation for single unit in a sample
	M	Measured value for sample of an inspection point
	N	Code for single unit of an inspection point
	O	Valuation for single unit of an inspection point
	P	Measured value for sample of an inspection point
	Q	Code for sample of an inspection point
	R	Valuation for sample of an inspection point

Fixed Values for Field HERKUNFT

A set of fixed values has been defined for the HERKUNFT field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
HERKUNFT	01	Goods receipt
	02	Goods issue
	03	Production order
	04	Goods receipt with production order
	05	Miscellaneous goods receipt
	06	Return from customer
	07	Audit
	08	Stock transfer
	10	Delivery to customer with customer order
	11	Delivery to customer without customer order
	12	Delivery (general)
	89	Miscellaneous

Fixed Values for Field KZBEWSUBSY**Fixed Values for Field KZBEWSUBSY**

A set of fixed values has been defined for the KZBEWSUBSY field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZBEWSUBSY	" " (blank)	Valuation not in subsystem
	X	Valuation in subsystem (further fields are filled - see note 2)

Fixed Values for Field KZDOKU

A set of fixed values has been defined for the KZDOKU field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZDOKU	" " (blank)	Inspection description for characteristic is optional
	.	Inspection description required in case of rejection
	+	Inspection description required

Fixed Values for Field KZKORRTRAN**Fixed Values for Field KZKORRTRAN**

A set of fixed values has been defined for the KZKORRTRAN field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZKORRTRAN	" " (blank)	First transmission
	X	Correction transmission

Fixed Values for Field KZLPROBE

A set of fixed values has been defined for the KZLPROBE field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZLPROBE	" " (blank)	No information
	X	Last sample for charact.

Fixed Values for Field KZMERKAB**Fixed Values for Field KZMERKAB**

A set of fixed values has been defined for the KZMERKAB field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZMERKAB	" " (blank)	No activity
	X	Characteristic is to be closed

Fixed Values for Field KZPROBEAB

A set of fixed values has been defined for the KZPROBEAB field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZPROBEAB	" " (blank)	No activity
	X	Sample is to be closed

Fixed Values for Field KZPRUMF**Fixed Values for Field KZPRUMF**

A set of fixed values has been defined for the KZPRUMF field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZPRUMF	=	Specified scope of insp. must be adhered to
	<	Scope of insp. may be below specification
	>	Specified scope of inspection may be exceeded
	" " (blank)	Scope of insp. may fall below or exceed specification

Fixed Values for Field KZRAST

A set of fixed values has been defined for the KZRAST field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZRAST	" " (blank)	Sampling procedure without inspection grid
	X	Sampling procedure with inspection grid

Fixed Values for Field KZRZWANG**Fixed Values for Field KZRZWANG**

A set of fixed values has been defined for the KZRZWANG field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZRZWANG	" " (blank)	Inspection for characteristic is optional
	+	Inspection required if result for preceding required characteristic is OK
	-	Inspection required if result for preceding required characteristic is not OK
	X	Inspection for characteristic is required

Fixed Values for Field KZSERNR

A set of fixed values has been defined for the KZSERNR field. The value ranges for the individual fields are listed in the following table:

If the field is used in the QAIMV table, download

Field	Value	Meaning
KZSERNR (in table QAIMV, download)	" " (blank)	Serial number optional with single values
	X	Serial number required with single values

If the field is used in the QAISE table, Upload

Field	Value	Meaning
KZSERNR (in table QAISE, upload)	" " (blank)	Part number used
	X	Serial number used

Fixed Values for Field KZTSTICHPR**Fixed Values for Field KZTSTICHPR**

A set of fixed values has been defined for the KZTSTICHPR field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZTSTICHPR	" " (blank)	Inspect single sample for characteristic
	X	Inspect multiple sample for charact.

Fixed Values for Field(M)BEWERT(UN)G

A set of fixed values has been defined for the MBEWERT(UN)G field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
(M)BEWERT(UN)G	" " (blank)	Valuation not carried out
	A	Acceptance (OK)
	R	Rejection (not OK)

Fixed Values for Field MBEWERTGMK**Fixed Values for Field MBEWERTGMK**

A set of fixed values has been defined for the MBEWERTGMK field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
MBEWERTGMK	A	Acceptance (OK.)
	R	Rejection (not OK)

Fixed Values for Field MBEWERTGPR

A set of fixed values has been defined for the MBEWERTGPR field. The value ranges for the individual fields are listed in the following table:

Feld	Value	Meaning
MBEWERTGRP	A	Acceptance (OK.)
	R	Rejection (not OK)

Fixed Values for Field MUSSTEXTKZ**Fixed Values for Field MUSSTEXTKZ**

A set of fixed values has been defined for the MUSSTEXTKZ field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
MUSSTEXTKZ	“ “ (blank)	Text not obligatory
	X	Text obligatory

Fixed Values for Field PRUEFSTAT

A set of fixed values has been defined for the PRUEFSTAT field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
PRUEFSTAT	A	Inspection released
	B	Inspection completed
	C	Inspection discarded
	D	Inspection canceled
	E	Skip

Fixed Values for Field SENDSTAT**Fixed Values for Field SENDSTAT**

A set of fixed values has been defined for the SENDSTAT field. The value ranges for the individual fields are listed in the following table:

Feld	Value	Meaning
SENDSTAT	A	First transmission carried out
	B	Correction transmission carried out
	" " (blank)	no transmission carried out so far

Fixed Values for Field SUBSYS

A set of fixed values has been defined for the SUBSYS field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
SUBSYS		defined in Customizing for results recording (View V_QISUB)

Fixed Values for Field FEHLKLAS(SE)

Fixed Values for Field FEHLKLAS(SE)

A set of fixed values has been defined for the FEHLKLAS(SE) field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
FEHLKLAS(SE)		Always the same values allowed. Defined in Customizing (transaction OQC7)

Fixed Values for Field FEHLKLASPR

A set of fixed values has been defined for the FEHLKLASPR field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
FEHLKLASPR		Always the same values allowed. Defined in Customizing (transaction OQC7)

Fixed Values for Field FEHLKLASMK**Fixed Values for Field FEHLKLASMK**

A set of fixed values has been defined for the FEHLKLASMK field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
FEHLKLASMK		Always the same values allowed. Defined in Customizing (transaction OQC7)

Fixed Values for Field KZABSCHL

A set of fixed values has been defined for the KZABSCHL field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZABSCHL	X	Close characteristic
	“ “ (blank)	Do not close characteristic

Fixed Values for Field KZBEWEEXT**Fixed Values for Field KZBEWEEXT**

A set of fixed values has been defined for the KZBEWEEXT field. The value ranges for the individual fields are listed in the following table:

Field	Value	Meaning
KZBEWEEXT	X	Transfer valuation
	“ “ (blank)	Do not transfer valuation

Fixed Values for Field KZSYSFE

Fixed values are stored for field *KZSYSFE*. Refer to the following table for the value ranges.

Field	Value	Meaning
KZSYSFE	X	Systematic defect
	No entry	No systematic defect

Valuation in the Subsystem - Filled Fields**Valuation in the Subsystem - Filled Fields**

In this case, the KZBEWSUBSY field is set to "X". The field BEWART contains one of the following values:

Value	Meaning
A	Attributive inspection for number of non-conforming units
B	Attributive inspection for number of defects
C	Variable inspection according to s-Method
D	Valuation according to code
E	Manual valuation
F	Inspection based on tolerance limits
G	Valuation based on sample valuation
H	SPC inspection according to control charts

If BEWART contains values "A" or "B", the ANNAHMEZ field contains the acceptance number and the RUECKWEZ field contains the rejection number of the attributive inspection.

If BEWART contains value "C", the KFAKTOR field contains the value for the K factor of the variable inspection.

If BEWART contains value "G", the inspection characteristic must be valued according to the sample valuations. In this case, the BEWARTSP field contains the specification for the valuation of a (partial) sample for the characteristic.

If BEWART contains value "H", the QRKNR field contains the number of the control chart.

Notes on Field RASTER

Defines the inspection interval on the basis of the inspection grid.

If you enter an **inspection frequency** of **3**, for example, in the sampling procedure, inspection results will be recorded for this characteristic at **every third inspection point**. This means that results are recorded at the first inspection point of the operation. At the second and third inspection point, the characteristic has status *Skip*. Results will then again be recorded at inspection point number four, and so on.

Valuation in the Subsystem - Filled Fields**Notes on Field ZAEHL**

The field is filled. However, the field content remains the same unless changes are made to the characteristic using engineering change management.

Notes on Field KZLWERT

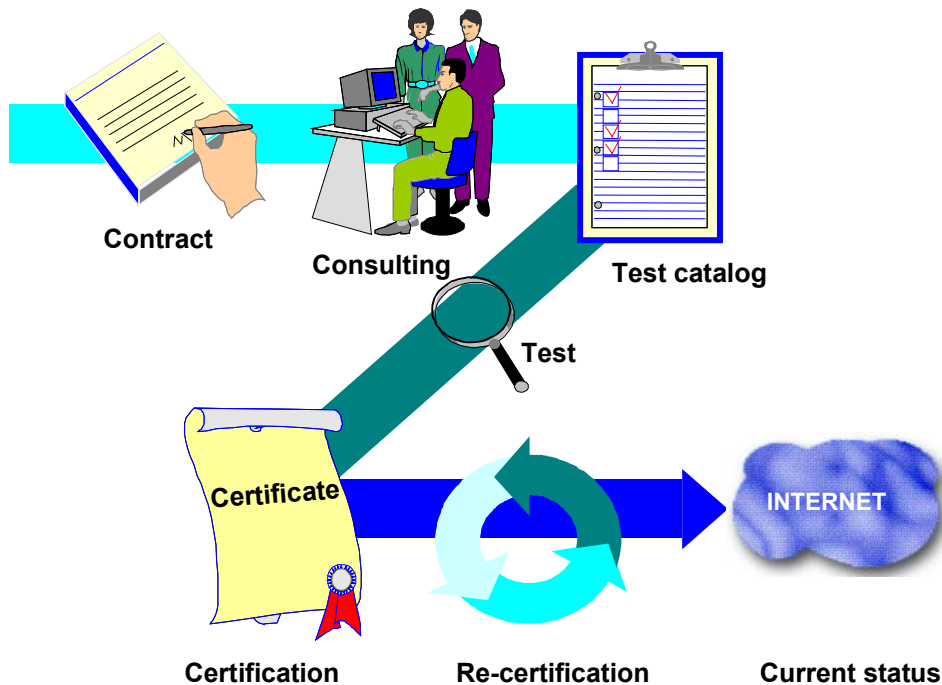
For manual valuation, you may not set the *KZLWERT* indicator since automatic valuation is not possible. The system issues an error message.

Certification

Certification

The QM-IDI interface is certified, using a test catalog created by SAP.

During certification, it is checked whether the non-SAP system is able to exchange the required data with the SAP system. However, only the interface between the SAP system and the non-SAP system is certified. The application functions of the non-SAP system are not certified.



The certified functions of the data transfer over the interface take place according to the following sequence.

Example

Download	Inspection requirements
----------	-------------------------

Upload

- Single results (quantitative, code, valuation)
- Sample results (quantitative, code, valuation)
- Characteristic results (quantitative, code, valuation)
- Single results for inspection points (quantitative, code, valuation)
- Sample results for inspection points (quantitative, code, valuation)
- Usage decision supported

The example shows the full range of functions. If one of these functions is not supported, this is indicated in the sequence (for example, "no code").