Part No.	S403-3-1/4
Work Order No.	628737
Order Otv	10



Distinguishing Traceablity Numbers					
Flare Nuts	Six digit no. located on the box label under box quantity.				
Brazing Rings	Located on the box label, directly above the word "heat."				
Copper Tubing	Located on the spool label, starting with the letter "M."				
Flare Tubes	Use their work order number and date on the box label.				
Snap Rings	Located on the bag followed by "Lot Number."				
Caps/Plugs	Do not require traceability.				

Operations	Mach. No.	Setup Min	Cycle Time	Pcs/Hr	Thru-put/8 hrs	
AUTO BRAZE 1ST OP		10	144 sec	25	180	
AUTO BRAZE 2ND OP		10	144 sec	25	180	
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432	

Com	ponent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF403-3-1/4	DIST, NOZZLE, FOR ASSY FLARE	1	
CUTU-1-1/2	1/2 COPPER TUBING, 1" LG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS	1	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	

<u>u</u>	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
ıtio										
per										
1st Operation										
15										
	OUTING:	l		1						
tion										
era										
2nd Operation										
2nd										
	OUTING:	L								
3rd Operation										
per										
0 p							-		_	_
35										

Special Notes / Instructions	Down Time Codes	First Part Inspection Record						
Additional ops: PACK / REPORT / TRANSFER TO SH	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup							
	4 FAIR 5 Training							
	6 Meeting							