

control devices, LLC
Leave Open
Will Come back to RD

OPERATION 1						THRU-PUT/8HRS				
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
7-42 KF CNC	11-11-15	BJ				7	3	setup in progress		
C DI CNC	11-11-15	JO	3.5	20	20	2.5	3	Setup complete		
Setup Hrs.	11-11-15	BA	1.0	9	28					
	11-11-15	LJ	5.0	31	59					
	11/12/15	BT	8	40	99					
Cycle Time	11-12-15	JO	8	44	143					
6min	11-12-15	BA/LJ	8	51	194					
53sec	11-12-15	JO	1.0	9	203					
Pcs/Hr	11-25-15	JO		5	5	3.5	3	2ND SET UP		
7	11-25-15	BA	8.0	45	50					
	11/30/15	BO	7.5	35	85					

ROUTING:

OPERATION 2						THRU-PUT/8HRS				
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
	11/30/15	JO	7.0	37	122					
	11/30/15	BA	6.5	31	153					
Setup Hrs.	12/1/15	BJ	6.5	34	187					
	12/1/15	JO	4.5	22	209	3.0		waiting-for material		
	12/1/15	BA	3.0	14	223					
Cycle Time	12/2/15	BJ	4.5	47	270					
	12/2/15	JO	8.0	41	311					
	12/2/15	BA	8.0	38	349					
Pcs/Hr	12/3/15	BJ	6.5	32	381					
	12-3-15	JO	6.5	35	416					
	12.3.15	BA	8.0	43	459					

ROUTING:

OPERATION 3					THRU-PUT/8HRS	
DATE	Down	Down time	Notes	Scrap	Scrap Code	

DATE 12/3/15	SCRAP TICKET	No 016158
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NAME Jan ORDER NO. 389122
BJ MACHINE NO. T42

	MACHINE NO.	DATE
QUANTITY	CODE	PART #
1	14 F	MPC 40001
1		chunk out of END
		NC

APPROVED Doug / Bev

[illegible]

Part Inspection Record			
Ctrl eck	Rev Letter	Inspector	Notes
<input checked="" type="checkbox"/>	B	DIH	CD Drawing #09
<input checked="" type="checkbox"/>		DIH	SB RESET