


Part No.	S2020001-10	Component	S20S20001-20	
Order No.	391634	Heat Lot #		
Order Qty	300	W/O # from Box		

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
Okuma	11/24/15	JO	.5	2	2	1.5	3			
	11/24/15	BA	6.0	69	71					
Setup Hrs.	11/25/15	BJ	6.5	82	153					
1.5	11/25/15	BA	8.0	86	239			JOB OUT		
	11/30/15	BS	8.0	79	318					
Cycle Time										
2:46 MIN										
Pcs/Hr								124.5		
19										

ROUTING:										THRU-PUT/8HRS
OPERATION 2										
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
Okuma	11-30-15	JO	1.5	23	23	2.5	3	Setup and op		
	11-30-15	BA	6.5	61	84	1.5	2	Tooling		
Setup Hrs.										
2.5										
Cycle Time										
2.50 sec										
Pcs/Hr										

ROUTING:										THRU-PUT/8HRS
OPERATION 3										
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
Setup Hrs.										
Cycle Time										
Pcs/Hr										

Notes / Instructions	Down Time Codes	First Part Inspection Record						
1 Maintenance 2 Tooling 3 Setup 4 FAIR 5 Training 6 Meeting		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes