


Part No.		S20S20001		Component		S20S20001-10						
Order No.		390985		Heat Lot #								
Order Qty		300		W/O # from Box		robot						
OPERATION 1										THRU-PUT/8HRS		184
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code		
OKUMA	11/30	JO	1.5	23	23	0.25	3	SETUP 2nd op.				
	11/30	BA	6.5	61	84	1.5	2	TOOLING				
Setup Hrs.	12/1/15	JO	4.5	48	132							
2.5	12/2/15	JO		14	146							
	12/1/15	BA	6.0	56	202							
Cycle Time	12/2/15	JO	6.5	81	283							
25 MIN	12-2-15	JO	4.0	39	322							
Pcs/Hr												
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		
OKUMA												
Setup Hrs.												
Cycle Time												
Pcs/Hr												
ROUTING:												
OPERATION 3										THRU-PUT/8HRS		
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												
ROUTING:												
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		