





Part No.	S404-8-3/16014P
Work Order No.	628736
Order Qty	2



Component(s) (See BOM)		QTY	Heat Lot/Traceability No(s)
SF404-8-3/16	DIST, NOZZLE, FOR ASSY FLARE	1	
CUTU-2.15-1/2	1/2" COPPER TUBE, 2.15" LONG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS	1	
CUTU-14-3/16	3/16" COPPER TUBING, 14" LG .188 OD X .028 WALL	8	
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED MTL CERTS	8	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	

Distinguishing Traceability 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
MANUAL BRAZING		10	4 sec	900	6480
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432
PACK/REPORT/SNED TO MS-KF FG		0	3 sec	1425	10260

1st Operation	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
ROUTING:										
2nd Operation										
ROUTING:										
3rd Operation										

Special Notes / Instructions	Down Time Codes	First Part Inspection Record						
		Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes



Part No.	S404-8-3/16217F
Work Order No.	628732
Order Qty	75



Component(s) (See BOM)		QTY	Heat Lot/Traceability No(s)
SF404-8-3/16	DIST, NOZZLE, FOR ASSY FLARE	1	
L2	NOZZLE, STANDARD	1	
L-RING	RETAINING RING, .45" DIA. .031 SS / 112789-A	1	
CUTU-1.9-1/2	1/2 COPPER TUBING, 1.9" LG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MT	1	
CUTU-17-3/16	3/16" COPPER TUBING, 17" LG .188 OD X .028 WALL	8	
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED MTL CERTS	8	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	
A-KF001	ASSEMBLY DRAWING, DISTRIBUTOR NATL REFRIG PART NUMBERS	0	

Distinguishing Traceability 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
MANUAL BRAZING		10	4 sec	900	6480
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432
PACK/REPORT/SNED TO MS-KF FG		0	3 sec	1425	10260

1st Operation	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
ROUTING:										
2nd Operation										
ROUTING:										
3rd Operation										

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

Part No.	S40333/16-1-17F
Work Order No.	628731
Order Qty	340



Distinguishing Traceability 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 BRAZING		15	144 sec	25	180
AUTO BRAZE 2ND OP		20	144 sec	25	180
BRAZING WASH,RINSE, WATER TEST		20	60 sec	60	432

Component(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF403-3-3/16	DIST, NOZZLE, FOR ASSY	1
L1	NOZZLE, STANDARD	1
CUTU-17-3/16	3/16" COPPER TUBING, 17" LG .188 OD X .028 WALL	3
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED MTL CERTS	3
CUTU-1.9-1/2	1/2 COPPER TUBING, 1.9" LG .500 OD X .032 WALL	1
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS	1
L-RING	RETAINING RING, .45" DIA. .031 SS / 112789-A	1
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1
A-KF001	ASSEMBLY DRAWING, DISTRIBUTOR NATL REFRIG PART NUMBERS	0

	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
<b>1st Operation</b>										
ROUTING:										
<b>2nd Operation</b>										
ROUTING:										
<b>3rd Operation</b>										

Special Notes / Instructions	Down Time Codes	First Part Inspection Record						
Additional ops: -- PACK/REPORT/SNED TO MS-KF FG	1 Maintenance	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	2 Tooling							
	3 Setup							
	4 FAIR							
	5 Training							
	6 Meeting							

