


Part No.	M30091	Component	A02002-0032	
Order No.	390317-391873	Heat Lot #		
Order Qty	1340 450	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	12/18/15	BT				4	3			
Setup Hrs.	12/18/15	BA	5.5	26	26	2.5	3			
	12/19/15	BT	6	36	62					
	12/20/15	BA	6.5	40	102					
Cycle Time	12/21/15	BT	8	47	149					
7m 53	12/21/15	BT	2.5	15	164					
	12/21/15	BA	6.5	32	196					
Pcs/Hr	12/22/15	BT	7.5	45	241	5	6			
7	12/22/15	BT	5.0	25	266					
	12/22/15	BA	6.5	34	300					

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
	12/23/15	BT	8	48	348					
	12/23/15	BT	6.5	31	379					
Setup Hrs.	12/23/15	BA	7.0	34	413					
	12/24/15	BT	7.0	33	446					
	12/29/15	BT	3	16	464					
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
Cobra	12/30/15	BT				?	3			
	12/30/15	BT	5.0	37	37	1.5	3			
Setup Hrs.	1/4/16	BT	8	85	122					
	1/4/16	BT	7.0	59	181					
	1/4/16	BA	6.5	55	236					
Cycle Time	1/5/16	BT	8	80	316					
	1/5/16	BT	7.0	60	376					
	1/5/16	BA	2.0	27	403					
Pcs/Hr	1/6/16	BT	5.5	58	461					
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ROUTING:

Notes / Instructions	Down Time Codes	First Part Inspection Record						
1 Maintenance 2 Tooling 3 Setup 4 FAIR 5 Training 6 Meeting	2 m 0 p	Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
		12/30	1:58 PM	NO	V	A	MPG	298 length
		12/30	7:45 PM	YES	OK		SR	