

Part No.	7-4-27	Component	7-4-J-BLNK	No Parts control devices, LLC
Order No.	403242	Heat Lot #		
Order Qty	13	W/O # from Box		

OPERATION 1								THRU-PUT/8HRS	16	
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
8	3-10-16	DG	8		13					
	3-11-16	NI	6	13	26			Wrong angle		
Setup Hrs.								Thin Side wall	26	22
12 MIN										
Cycle Time	3-11-16	CS	10	9	35			Wrong Angle	4	22
45 MIN	3-11-16	DG		10	45			Thin Side wall		
	3-12-16	CS	6	8	53					
Pcs/Hr	3-12-16	DG	2	5	58			JOB		
2								OUT		

ROUTING: SANDBLAST / BRIGHT DIP / REAM / MS PACK

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
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
		3-10-16	5:30	Y	✓	B	JC	