


Part No.	IL10005-20	Component	A09001-0056	
Order No.	395017	Heat Lot #	22268221	
Order Qty	1200	W/O # from Box		

OPERATION 1										THRU-PUT/8HRS	72
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code	
CNC T42	1-7-16	BJ	6.5	41							
	1-7-16	lrvb	6	41	82						
Setup Hrs.	1-7-16	BA	7.5	33	115	.5	2				
2	1-8-16	BJ	6.5	42	157						
	1-8-16	HVD	6.5	59	216						
Cycle Time	1-8-16	BA	7.5	49	265						
5MIN 37SEC	1-9-16	BT	6	33	298						
	1-9-16	Jo/HVD	5.5	42	340						
Pcs/Hr	1-9-16	BA	6.0	37	377						
9	1-11-16	JO	4.5	29	406						
	1-11-16	BA	6.5	35	441						

ROUTING: WASH & PACK DEPT

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	
	1/12/16	BS	7	48	489						
	1/12/16	JO	7.5	42	531						
Setup Hrs.	1-12-16	BA	6.5	38	569			HVD			
	1/13/16	BS	8	48	617						
	1-13-16	JO	3.5	21	638						
Cycle Time											
Pcs/Hr											

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		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes	
2 Tooling		1-7-16	3AM	YES	✓	F	MR		
3 Setup									
4 FAIR									
5 Training									
6 Meeting									