

Control Devices LLC / Work Order Production Record

Part No.	IC10013	Rev Letter	B	Heat Lot #	CHI49904
Order No.	341672	Component	A02002-0048	or	
Order Qty	75			Box W/O #'s	
				Found on Label	

Special Notes / Instructions

CYCLE TIME: ~~2.5~~ S/U HRS OK PER MR

Date	Emp. Name	Prod. Hours	Setup Hours	Total Pcs	Planned Hours	Cum. Total	Balance Due Pcs	Plan Pcs/Day	Actual Pcs/Day	% Oper. Efficiency	Down Time	Code	Scrap Pcs.	Pcs/Hr	S/U hrs	Actual S/U	Setup %
Machine #	CNC OKUMA					0	75			A				3	4	4	100%
7/24/14	JO	4	4	23	8	23	52	12	23	191.7%	0	0	0				
7/29/14	JO/BJ	8	0	59	8	82	-7	24	59	245.8%	0	0	0				
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
						82	-7	0	0								
Total Efficiency				82	0			36	82	227.8%			0				

Routing: HARDING

Machine #	CNC HARDING					75				B							
8/4/14	JO	0	2.5	0	2.5	0	75	0	0		0	0	0				
8/4/14	BJ	3.5	0	50	3.5	50	25	0	50		0	0	0				
8/5/14	BJ	2.5		30		50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
						50	25	0	0								
Total Efficiency				50	0			0	50	#DIV/0!			0				

Routing: PACK DEPT

Machine #						75										0	#DIV/0!
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
						0	75	0	0								
Total Efficiency				0	0			0	0	#DIV/0!			0				

Routing:

Final Part Calculation					Code	Total Down Time Description	Hours	First Part Inspection Record				
Total Counted Pcs	(from packing)	1	Maintenance	#REF!				Date Part Submitted	Time of Day	Approved Yes / No	Inspector	Notes
Total Scrapped	0	2	Tooling	#REF!								
3rd Operation Count	0	3	Setup Idle	#REF!								
2nd Operation Count	50	4	Other	#REF!								
1st Operation Count	82											

Need S/U hrs OK'd for 2nd op as well as cycle time