


Part No.	IL20014	Component	IL20014-10	
Order No.	391831	Heat Lot #		
Order Qty	2000	W/O # from Box	374781	

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
B&S-17 (HAND)	12-7-15	np				4	103		15	11
	12-7-15	DH	6	275	275	15	2	1.5 soft parts	1	11
Setup Hrs.	12-8-15	DH	2.5	90	365	20	102	5 soft part, reset job	12	B4
	12-10-15	np	2.5	95	464	3	2	1.5 fill up gears	16	11
	12-11-15	np	4.0	200	664					
Cycle Time	12-11-15	DH	8	380	1044					
	12-12-15	np	3.5	176	1220				8	C-1
Pcs/Hr	12-14-15	F.B.	7	320	1540	1		50 ft parts		
	12-14-15	DH/PEO	7.5	413	1953			5 soft parts / keep flg		
								JOB OUT		

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
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
		12-7-15	1:30	YES	OK	B		