


Part No.	IL10005-20	Component	A09001-0056	 control devices, LLC cycle time is now 3min 58sec
Order No.	401184	Heat Lot #		
Order Qty	900	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										
Setup Hrs.	2-19-16	JO	6.0	52	52	1.5	3	make adj/edits		
	2-19-16	BA	8.0	64	116					
	2-20-16	JO	2.0	19	135					
Cycle Time	2-20-16	BA	6.0	59	194					
5MIN	2-22-16	BT/NP	8	75	269					
37SEC	2-12-16	BA	3.0	29	298	1.0	3			
Pcs/Hr	2-23-16	BT	6	50	348					
13	2-23-16	JO	8.0	68	416					
9	2-23-16	BA	6.5	41	457					

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
	2-24-16	BT	2.8	66	523	1.0	3			
	2-24-16	MS	2.5	20	543	1	3	SETUP ADJUSTMENTS		
Setup Hrs.	2-24-16	BA	4.5	31	574					
	2-25-16	BT	5	39	613					
Cycle Time								JOB OV		
								3-1-16		
Pcs/Hr								55		

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
		2-19-16	8a	YES	✓	F	DA	
		2-22-16	7p	YES	✓		TC	