


Part No.	VC10071-10	Component	VC10071-20	
Order No.	375255	Heat Lot #		
Order Qty	4200	W/O # from Box		

OPERATION 1

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
B/S 17	11-3-15	up				3.5	3		4	11
Setup Hrs.	11-4-15	E.B.	8	356						
6	11-4-15	up	1.5	113				working on boss		
	11-5-15	E.B.	1.5	100	579					
Cycle Time										
29 SEC	11-5-15	SB	8	400	979					
	11-6-15	DH	5.5	475	1454	-	-	15 min In HASS		
Pcs/Hr	11-6-15	up				1	2	Sharp tooling Replace chisels		
99	11-6-15	SB	8	442	1896					
	11-9-15	E.B.	8	465	2361				4	

ROUTING:

WASH & PACK

OPERATION 2

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
	11-9-15	up	2	192	2553					
Setup Hrs.	11-9-15	SB	8	476	3029					
	11-10-15	DH	6	503	3528	-	-	2hr secondary		
Cycle Time										
								BC		
Pcs/Hr										

ROUTING:

OPERATION 3

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
								\$4.44 11/2/15 36		
Setup Hrs.										
Cycle Time										
Pcs/Hr										

ROUTING:

Notes / Instructions	Down Time Codes	First Part Inspection Record						
FOR B&S ONLY: To Figure Pieces From Loads = Pcs/Bar x Total loads ran during shift x Bars per load	1 Maintenance	Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
	2 Tooling	11-3-15	9:50	YES	OK	B		
	3 Setup							
	4 FAIR							
	5 Training							
	6 Meeting							