


Part No.	IL20015	Component	IL10012	
Order No.	387243	Heat Lot #		
Order Qty	1100	W/O # from Box		

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	11-11-15	WD				4	3	Meeting 11-11-15	21	11
	11-12-15	P/H	2.5	200	200			Moved to HAAS		
Setup Hrs.	11-12-15	SB	8	760	960					
4 hrs	11-13-15	D/L	1.5	184	1119			1.5 set parts, moved to secondary		
	11-13-15			4	1123					
Cycle Time										
18 sec										
Pcs/Hr										
160										

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						
		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
1 Maintenance		11-11-15	1:45	YES	OK	B		
2 Tooling								
3 Setup								
4 FAIR								
5 Training								
6 Meeting								