


Part No.	C5038B22-10	Component	A02002-0022	 <i>CB no parts</i>
Order No.	397761	Heat Lot #		
Order Qty	250	W/O # from Box		

OPERATION 1

THRU-PUT/8HRS

104

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
OKUMA	2-12-16	BA	1	9	9	5	3			
	2-13-16	BS	6	54	63					
Setup Hrs.	2-13-16	JO	4.0	50	93					
	2-13-16	BA	6	52	145					
	2-15-16	BS	8	84	129					
Cycle Time	2-15-16	BA	6	43	267					
Brin										
50sec										
Pcs/Hr										
13										

ROUTING:

TO THREAD ROLLER

OPERATION 2

THRU-PUT/8HRS

2104

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
OKUMA	3-9-16	JO	1.0	26	26	1.5		Setup and op		
Cobra	3-9-16	BA	5.0	63	89					
Setup Hrs.	3-10-16	BS	7	97	186					
1.5	3-10-16	SM		86	272					
Cycle Time										
1min										
39sec										
Pcs/Hr										
30										

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
		2-12-16	9:10	Y	✓	A	JC	
		3-9-16	12:30	YES	✓		21F	