

Part No.	FC7504	Component	FC7504-10	control devices LLC
Order No.	385472	Heat Lot #		
Order Qty	4500	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	11-13-15	MyP	1.5	54	54	3.5	3		12	11
Setup Hrs.	11-13-15	SB	8	784	839				2	K
4	11-16-15	DH	8	957	1796	-	-	New tap	1	K14
	11-16-15	SB	6	555	2351	2	2	NEW TAP	19	K14
Cycle Time	11-17-15	DH	4.5	493	2844	-	-	3.5 Sec on try	2	K14
15 SEC 19 SEC	11-17-15	MP	1.5	188	3032				3	K-14
	11-17-15	SB	8	975	4007	0	0			
Pcs/Hr	11-18-15	E.B.	4.5	527	4534					
192 152								TOB ok		

ROUTING: wash & pack

WASH & PACK DEPT

OPERATION 2

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

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						
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	11-13-15	1:30	YES	✓			
	3 Setup							
	4 FAIR							
	5 Training							
	6 Meeting							