


Part No.	103147-1	Component	100046-999	
Order No.	391001	Heat Lot #		
Order Qty	30	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
CNCT42	11-20-15	JO	4.0	31	31	1.0	3	setup facing op.	0	
	11-20-15	JO	1.5	2	2	1.5	3	setup 1st op		
Setup Hrs.	11-20-15	BA	8.0	19	21					
2.5	11/21/15	BT	5.5	10	31					
		2nd op								
Cycle Time	11/21/15	BT				.5	3			
	11/23/15	BT	6.5	12	12	1.5	3			
	11-23-15	JO	5.0	10	22	2.0		change cutoff blade and program		
Pcs/Hr	11-23-15	BA	5.0	9	31					

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
CNCT42	11-23-15	LJ	1.0	10	10	1.0	3			
	11/24/15	138	2.5	21	31					
Setup Hrs.										
Cycle Time										
Pcs/Hr										

Job out 12-4-15 5.5

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
CNC- T42										
Setup Hrs.										
Cycle Time										
Pcs/Hr										

Notes / Instructions	Down Time Codes	First Part Inspection Record						
1 Maintenance 2 Tooling 3 Setup 4 FAIR 5 Training 6 Meeting	1 Maintenance	Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
	2 Tooling							
	3 Setup							
	4 FAIR							
	5 Training							
6 Meeting								