


Part No.	IL10005-20	Component	A09001-0056	
Order No.	392597	Heat Lot #		
Order Qty	1200	W/O # from Box		

OPERATION 1

THRU-PUT/8HRS 72

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
CNC T42	12-9-15	JO				3.0	3	setup in progress		
	12/10/15	BS	8	46	46					
Setup Hrs.	12-10-15	JO/HVD	7.0	42	88	1.0	1	coolant leak		
	12-10-15	BA	8.0	53	141					
	12/11/15	BS	6.5	41	182					
Cycle Time	12-11-15	JO	6.5	42	224					
5MIN	12-11-15	BA	8.0	57	276					
37SEC	12/12/15	BS	6	36	312					
Pcs/Hr	12-12-15	JO	5.5	29	341					
9	12-12-15	BA	6	39	380					
	12/14/15	BS	2	13	393					

ROUTING:

WASH & PACK DEPT

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
	12/15/15	BS	1.5	9		3	1/3	inspection/wiring		
	12/15/15	HVD	6	36						
Setup Hrs.	12/15/15	BA	6.5	42	480					
	12/16/15	BS	7.5	48						
	12-16-15	LJ	1.5	27						
Cycle Time	12-16-15	BA	6.5	40	595					
	12/17/15	BS	7.5	49						
	12-17-15	HVD	3	25						
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							
	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	
		12-9-15	8:45	Y	✓	F	J. Jones		
		12-15-15	1:40AM	X	✓	F	M. Morse		