


Part No.	S20S20001	Component	S20S20001-10	
Order No.	396993	Heat Lot #		
Order Qty	450	W/O # from Box	396728	

OPERATION 1

THRU-PUT/8HRS 184

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
H1 GRUMA	1-14-16	JB/GA	3.5	110		4	3	wrote Program	0	
	1-15-16	BAI	3.5	109	229	4	3		0	
Setup Hrs.	1-16-16	JB	2.5	75	304	5	3		0	
4 25	1-18-16	JB	1.5	58	362	7	3			
	1-19-16	JB/BAI	2	78	440	6	3	Job not BAI		
Cycle Time										
10 MINS \$										
42 SEC										
Pcs/Hr										
31 25										

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						
1 Maintenance		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
2 Tooling		1-14-16	12:45pm	YES	✓	C	DT	CD On Insp #09
3 Setup								
4 FAIR								
5 Training								
6 Meeting								