


Part No.	.430-3-3	Component	A02071-0024	
Order No.	398104	Heat Lot #	190699.19.1	
Order Qty	5000	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
C1	1-26-16	JB	10	626		3 1/2	3	clean out stainless	1	11
	1-27-16	JB	16	1000	1600	0			0	
Setup Hrs.	1-28-16	JB	13.5	621	2421	0			0	
3 1/2	1-29-16	JB	16	1000	3421	0			0	
	1-30-16	JB	9	595	4016	0			0	
Cycle Time	2-2-16	JB	5	329	4345	0	3		0	
54	2-3-16	JB	9	570	4915	0			0	
	2-4-16	JB	6	515	5430	0			0	
Pcs/Hr	2-5-16	JB	9	566	5996	0			0	
60	2-6-16	JB	4.5	277	6273	0			0	
	2-8-16	JB	8	526	6799	0			0	

ROUTING: TO THREAD ROLLER

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
	2-10-16	JB	4	256	7055			Job Out JB		
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 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
		1-26-16	10A	YES	✓	B	AT	60# dsul v00 00