

10/10/23

Part No.	CY20020	Thru-Put/Hrs		Wgt/Pc.	0.145	Mach No.	114
Order No.	9016003	Planned Pcs/Hr	324	Wgt/Bar	15.98	Setup Allowed Hrs.	
Order Qty	20,000	Actual Pcs/Hr		Component	A09031-0038	Pcs/Bar	110
		Actual					

- DOWN TIME CODES
- 1 - Maintenance
 - 2 - Tooling
 - 3 - Setup
 - 4 - FAIR
 - 5 - Training
 - 6 - Meeting

Date	Emp. Name	Prod. Hours	Total Pcs	Cum. Total	Material Heat Lot No.	Down Time	Down Time Code	Notes	Scrap Pcs.	Scrap Code
2-16-16	DR					6.5	3	FEEDER - Quality was bawled up	4	11
2-17	TC	0	0	0		8	3		6	11
2-18	TC	1.5	270	270		2.5	3	barrel chutte/switched unit	15	11
2-18	DR					1	6	FEAIR - Quality was bawled up		
2-18	DR	4	780	1050		3	0	working on recess & chip cing	125	AS
2-19	TC	8	1290			0	0	Feed / Angle drill / inverse	156	AMH
2-19	DR	7	1125	3465		1	1	Bar Feeder adjustment		
2-22	TC	1	185			-	-	moved to 53-54 - Cold	10	0
2-22	DR	8	2010	5660				start also		
2-23	MB	8	1945	7585				low spot in bar ->	75	AS
2-23	DR	7	2020	9605		1	2	SHS recess - new tool flow control		
2-24	MBSP	3.5	1005	10610		3.5	2	DRIVE START	167	AS
2-24	DR	8	2170	12780		0	0	LEFT EARLY / END OPERATION		
2-25	MBSP	8	2130	14910		0	0		107	AS
2-25	MBSP	8	2340	17250		0	0			
2-25	DR	7.5	1665	18915		0.5	2	stop & resharpen to fix bar	10	0

TOTAL PCS. PRODUCED

TOTAL SCRAP PCS.



Special Notes / Instructions
FOR DAVENPORTS & BROWN & SHARPES ONLY: To Figure Pieces
From Loads = Pcs/Bar x Total loads ran during shift x Bars per load

First Part Inspection Record

Date Part Submitted	Time of Day	Approved Yes/No	Mtr Check	Rev Letter	Inspector
2-18-16	12:20	YES*	✓	?	2/19

Notes

44 for Burn on last
0.0. stud (e-ring grv)
B4 - RUN