


Part No.	IL10005-10	Component	IL10005-20	
Order No.	392598	Heat Lot #		
Order Qty	1500	W/O # from Box		

OPERATION 1										THRU-PUT/8HRS	192
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code	
CNC T42	12-14-15	BJ	5	118	118	1.5	3				
	12-14-15	JO	3.0	69	187						
Setup Hrs.	12-14-15	BA	6.5	180	367						
4	12-15-15	BJ	1.5	26	393						
	12-17-15	HVD	2	40	433						
Cycle Time	12-17-15	BA	7.5	236	669						
2MIN	12-17-15	BJ	.1	3	672						
Pcs/Hr											
24											

ROUTING: 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	
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