

Part No.	11489 MPC40003
Order No.	391873
Order Qty	1340

Component	1 1/2 HX Bms
Heat Lot #	
W/O # from Box	

now 4min 22sec
 control devices, LLC

OPERATION 4

THRU-PUT/8HRS

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
OK	2/26/16	BT				4.5	3		9	B20
	2-26-16	JO	6.5	30	30	1.0	3	change to correct drill and boring bar		
Setup Hrs.	2/26/16	BA	7.5	42	72					
4.5	2/27/16	BT	6	30	103					
	2/29/16	JT	3.6	21	124					
Cycle Time	2/29/16	BT	4	28	152					
7min 7sec	2-29-16	JO	7.0	40	192	1.0	2			
	2-29-16	BA	8.0	42	234					
Pcs/Hr	3/1/16	BT	6.5	46	280					
7.2	3-1-16	JO	8.0	62	342					
	3-1-16	BA	8.0	54	396					

ROUTING:

OPERATION 5

THRU-PUT/8HRS

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
	3/2/16	BT	6.5	44	440					
	3-2-16	JO	6.0	36	476					
Setup Hrs.	3-2-16	BA	6.5	39	515					
	3-3-16	JO	3.0	19	534					
Cycle Time										
Pcs/Hr										

ROUTING:

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
		2-26-16	5:50 AM	yo	v	B	M. Pige	

Z-Zero = 2.6100