Part No.		S20S20001		Component		S20S20001-10				77	contr	ol es, Luc
Order No.		390985		Heat Lot #		1 2					device	es, Luc
Orde	er Qty	30	00		from Box	7000	100					ace!
				OPERATIO	N 1	Down				THRU-PU	JT/8HRS	
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code		Notes		Scrap	Scrap Code
OKUMA	11/30	JO	6.5	61	2503	21.5	3	SET	IN/	of.		
Setup Hrs.	12/11/15	130	4.5	48	132							
2.5	12.1.15	JO	6.0	14	146							
Cycle Time	12/2/15	135	6.5	81	243				1.6			
2 SMIN	12-2-15	20	4.0	39	322			1:0	THE			
Pcs/Hr								10	M 55			
200		3									0	
ROUTING:	W	ash								700 - 700 o - 60 o - 100 o - 1		
Mark and	The Charles			OPERATION 2		Down time					U-PUT/8HRS Scrap	
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	time	code		Notes		Scrap	Code
OKUMA												
Setup Hrs.	1											
Cycle Time												
										1		
5 /11												
Pcs/Hr										_		
ROUTING:				ODERATIO	N 2					TUDU DU	IT/OUDE	
A Control of	D. I.	Deta Sara Nassa Baad Ha		OPERATION 3 Total Pcs. Cum. Tot		Down time				THRU-PU		Scrap
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	time	code		Notes		Scrap	Code
C-1												
Setup Hrs.),						
Cycle Time												
Cycle Time												
Pcs/Hr												
						8						
ROUTING:												
Notes / Instructions		Down Time Codes				First Part Inspection			Record			
		1 Maintenance 2 Tooling 3 Setup		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Rev Letter Inspector		Notes	
		4 FAIR 5 Training										
SECONDARY	/ PRODUCTIO	6 Meeting			PAGE 1						Test Form	10/15/15