

Heat Lot #	
or	
Box W/O #'s	
Found on Label	

Standard Cycle Time & Setup Time Verified	
1st Operation	
2nd Operation	
3rd Operation	

Special Notes / Instructions

											3rd Operation						
Date	Emp. Name	Prod. Hours	Setup Hours	Total Pcs	Planned Hours	Cum. Total	Balance Due/Pcs	Plan Pcs/Day	Actual Pcs/Day	% Oper. Efficiency	Down Time	Code	Scrap Pcs.	Pcs/Hr	S/U hrs	Actual S/U	Setup %
Machine #	20000					0	0	STD CYCLE TIME								0	#DIV/0!
9/26 T.W.J.	1.5	8				0	0	0	0								
9/29 T.W.J.	8	540				0	0	0	0								
9/30 T.W.J.	3	210				0	0	0	0								
10/6 T.W.J.	3.5	225				0	0	0	0								
10/7 T.W.J.	8.0	560				0	0	0	0								
10/10 T.W.J.	6.0	370				0	0	0	0								
10/20 T.W.J.	7.5	520				0	0	0	0								
10/21 T.W.J.	8.0	600				0	0	0	0								
10/22 T.W.J.	6.75	460	1.25			0	0	0	0								
10/31 T.W.J.	8.0	440				0	0	0	0								
11/3/14 T.W.J.	8.0	540				0	0	0	0								
Total Efficiency	0	0	0	0	0	0	0	0	0	#DIV/0!	0		0				
Routing:																	

Routing:

Machine #					Routing					STC/CYCLE TIME					#DIV/O				
11/4/14	TW	7.5	15	520	0	0	0	0											
11/5/14	TW	7.5	~	510	0	0	0	0											
11/6/14	TW	8.0	—	520	0	0	0	0											
11/7/14	TW	8.25	—	180	0	0	0	0											
11/8/14	TW	8.0	—	540	0	0	0	0											
11/9/14	TW	25	—	180	0	0	0	0											
11/11/14	TW	8.0	—	535	0	0	0	0											
					0	0	0	0											
					0	0	0	0											
					0	0	0	0											
					0	0	0	0											
					0	0	0	0											
					0	0	0	0											
Total Efficiency		0	0	0	0	0	0	0	#DIV/O	0		0							

Routing:

Machine #						Routing:								
						0	0	STD CYCLE TIME					0	#DIV/0!
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
						0	0	0	0					
Total Efficiency	0	0	0	0	0	0	0	0	0	#DIV/0!	0		0	

Routing:

Final Part Calculation					First Part Inspection Record				
	Code	Total Down Time Description	Hours	Date Part Submitted	Time of Day	Approved Yes / No	Inspector	Notes	
Total Counted Pcs	(from packing)	1	Maintenance	0	9-26-11	11:15	YES	JA	
Total Scrapped	0	2	Tooling	0					
3rd Operation Count	0	3	Setup Idle	0					
2nd Operation Count	0	4	Other	0					
1st Operation Count	0								