


Part No.	M30090	Component	A02002-0032	
Order No.	390315	Heat Lot #		
Order Qty	480	W/O # from Box		

OPERATION 1								THRU-PUT/8HRS		
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
OKUMA	11/16/15	BT				5.5	3	Setup in progress		
	11/18/15	JO	3.0	22	22	3.0	3	Load right program and finish setup		
Setup Hrs.	11-18-15	BA	8.0	47	69					
	11/19/15	BT	4	29	198	1	6			
	11/19/15	JO	6.5	38	136					
Cycle Time	11-19-15	BA	5.5	33	169					
7min	11/20/15	BT	6.5	48	217					
25sec	11/22/15	JO	6.0	41	258					
Pcs/Hr	11-20-15	BA	8.0	49	307					
7	11/21/15	BT	5.5	28	335					
	11-21-15	HVD	4.0	36	371					

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
	11/23/15	BT	6.5	40	411					
	11-23-15	JO	6.0	39	450					
Setup Hrs.	11-23-15	BA	6.5	36	486					
	11/24/15	BT	6.5	32	518					
	11-24-15	JO	3.0	15	533					
Cycle Time										
Pcs/Hr										

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										

Notes / Instructions	Down Time Codes	First Part Inspection Record						
1 Maintenance		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
2 Tooling		11-18-15	10:00am	Yes	✓	A	JO	
3 Setup								
4 FAIR								
5 Training								
6 Meeting								