


Part No.	M4-4-3	Component	A02071-0026	
Order No.	389815	Heat Lot #	190167.1.1	
Order Qty	2500	W/O # from Box		

OPERATION 1									THRU-PUT/8HRS	376
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
C2	11-9-15	JB	3.5	188	188	2.5	3		0	
	11-10-15	JB	8.5	418	606				0	
Setup Hrs.	11-11-15	JB	8	550	1156				0	
2.5	11-12-15	JB	8	500	1656				0	
	11-13-15	JB	7	393				Job Out JB	0	
Cycle Time										
61g								250		
Pcs/Hr										
47								11-23-15 SS	0	

ROUTING: WASH / SANDBLAST / PACK

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
		11-10-15	8:45	YES	✓	A	DM	60# 65J WD 69

Nov 09, 2015 12:58:35

Control Devices, LLC

PRODUCTION WORK ORDER

Page 1



Run



Setup



Inspect



Down

Order-No	Byr	Loc	Item-No	Description	Order-Qty	Unit-Price	Unit-Cost	Start-Dte	Due-Dte
389815	K1	MS	M4-4-3	DISTRIBUTOR, VENTURI, SPECIAL	2,500.0000	.000000	.375400	11/05/15	11/09/15
Primary Work Cell: CNC				Customer:	Ref:	Job No:			
Lev Seq Loc Item-No.				Description	Sales-Order-No:	Parent Order No:			
1	1	MS	A02071-0026	13/16" BRASS ROUND	Qty Needed	UOM	Qty-Used	Picking	Seq
1	2	MS	SC-1015	SRA W/O MN TEST	550.0000	LB			
				SCRAP - BRASS	300.0000	LB			

uction-Notes: _____

roduced-By: _____
Date: _____

PART NO. M4-4-3

REV. __A__

Mach. No C2

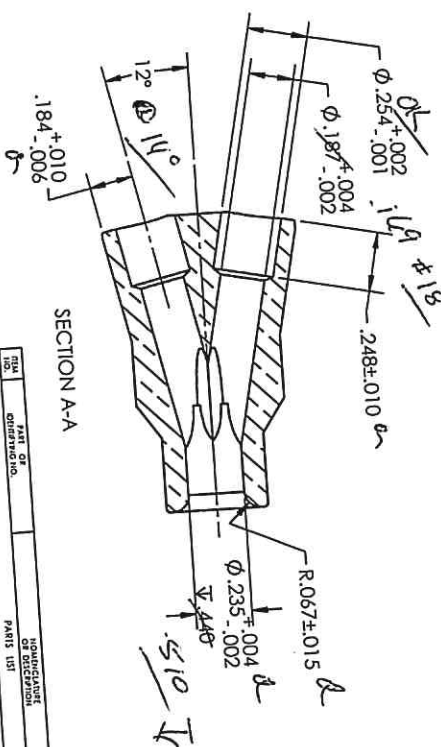
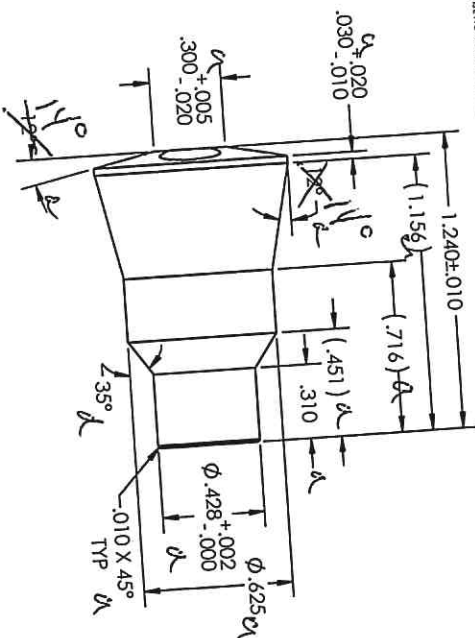
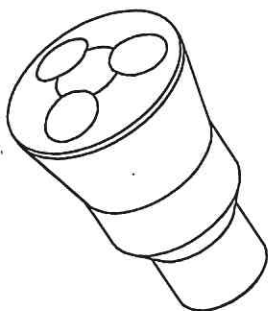
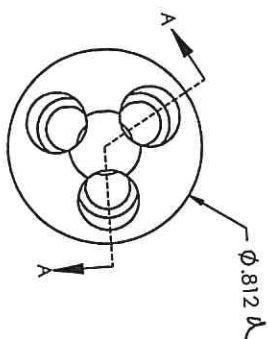
Work Order 309815

CDF328 Rev. A 9/24/2014

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EYES ONLY		DATE	ECN NO.
REV	DESCRIPTION	10/12/15	15-305
A	RELEASE TO PRODUCTION		



SECTION A-A

1. PART TO BE CLEAN AND FREE OF BURR.
2. BEAT ALL UNNARMED CORNERS .005.
3. ALL UNNARMED MACHINED SURFACES .63 MAX.
4. MATERIAL TO BE STRESS RELIEVED (1550°F OR 1 HOUR MIN)
5. INSIDE CAVITY OF DISTRIBUTOR TO BE BEAD BLASTED TO REMOVE ALL BURRS AND SHARP EDGES
6. PRODUCED FOR MACHINE MANUFACTURING
7. CUSTOMER TO BE NOTIFIED OF ANY CHANGES

NO.	PART OF	NON-CLASSIFIED	DATE/TIME
101	DISCRETE NO.	PARIS 1157	8/10/74
UNITES CHIFFREES SPECIFIEES DISTRIBUTION: ATE IN INCHES TO BE ABLE: ABE SPECIFIC: ABE * XOS 1.005		CSC CHIFFREES SPECIFIEES DO NOT MANUALLY WRITE APPROVALS DATE 10/09/75 USE SPECIFIC PLUTIVE DATE/TIME	
UNITES UNSC C5A5000 H02 BRASS M0000		UNITES DATE/TIME 1157	
DO NOT SCALE DRAWING		SCALE 2:1	

CD
Qx Insp
#09

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