


Part No.	A5128	Component	A5128-10	
Order No.	385978	Heat Lot #		
Order Qty	2182	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
DP0062	Balance Forward -				1054			Scrap Bal Forward	3	11
Setup Hrs.	11-16-15	E.B.	3.5	250	1304					
30min	11-17-15	DH	3.5	318	1622			From B17		
Cycle Time	11-18-15							CNC 3:5		
19sec	11-19	DH	1.5	110	2067			CNE		
Pcs/Hr	11-23	E.B.	1	112	2179					
152								B1.87		
								11-20-15		
								11-55		
									(3)	

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										

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 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

Control Devices LLC / Work Order Production Record

Part No.	A5128	Rev Letter	B	Heat Lot #	
Order No.	385978	Component	A5128-10	or	
Order Qty	2182			Box W/O #'s	
				Found on Label	

QTY CHANGE INLS/DATE

Special Notes / Instructions

Standard Cycle Time & Setup Time Verified

1st Operation

2nd Operation

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 # DP 0062						0	2182	STD CYCLE TIME								0.2	0%
10/13/15	JT	0	0.2	4	0.2	4	2178	0	4		0	0	3	11			
10/14/15	BM	5.5	0	1050	5.5	1054	1128	0	1050		0	0	0				
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
						1054	1128	0	0								
Total Efficiency		5.5	0.2	1054	5.7	1054	1128	0	1054	#DIV/0!	0		3				

Routing:

Machine #						2182	STD CYCLE TIME									0	#DIV/0!
						0	2182	0	0								
						0	2182	0	0								
						0	2182	0	0								
						0	2182	0	0								
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						0	2182	0	0								
						0	2182	0	0								
						0	2182	0	0								
Total Efficiency		0	0	0	0	0	2182	0	0	#DIV/0!	0		0				

Routing:

Machine #						2182	STD CYCLE TIME									0	#DIV/0!
						0	2182	0	0								
						0	2182	0	0								
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						0	2182	0	0								
						0	2182	0	0								
Total Efficiency		0	0	0	0	0	2182	0	0	#DIV/0!	0		0				

Routing:

First Part Inspection Record

Final Part Calculation		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	10/13/15	8:50 AM	YES	DH	
Total Scrapped	3	2	Tooling	0					
3rd Operation Count	0	3	Setup Idle	0					
2nd Operation Count	0	4	Other	0					
1st Operation Count	1054								

Test 4/29/15