	Part No.		144002	-	Component		4S144002	2-10	control devices, LL		
Order No.		389659			Heat Lot #		- 1		- Control		
Ord	ler Qty	3	00		# from Box						
Moch No	D-t-	E N		OPERATIO		Down	Down time			RU-PUT/8HRS	Scrap
Mach No.	Date	Emp. Name		Total Pcs.	Cum. Total	time	code		Notes	Scrap	Code
CNC OKUMA	11.12.15	BA	3.5	52	52	1.0	3				
Setup Hrs.	11/12/15	HVD	7.0	48	183		-	-	111)		-
	11-14-15	HVD	5.0	125	308		-	+	Ju -	1	-
4	11/16/15	135	310	44	352	+	1		TO 0 0	1	+
Cycle Time		50	3.5	51	403		1	1	100	× 100	+
2MIN	***		0.0		700				. \		
24SEC								,:	V	/	
Pcs/Hr									40/	9	
20									WA	5 ^	
									11.	0	
ROUTING:	A DESCRIPTION OF THE PERSON OF			OPERATIO		ACK DEPT	W				
Mach No.	Data	France No.	D. LU			Down	Down time			RU-PUT/8HRS	Scrap
iviacii No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	time	code		Notes	Scrap	Code
C		-									
Setup Hrs.						1					
Cycle Time								-			
Cycle Time								-			
											-
Pcs/Hr								<u> </u>			
				_							
ROUTING:											
CASE TO ALLEY	SALES IN THE SALES				OPERATION 3		Down		THRU-PUT/8H		
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code		Notes	Scrap	Scrap
						time					Code
Setup Hrs.	×			_							
Cycle Time	*										
}											
Pcs/Hr	2										
r cs/ HI								1			
ŀ			1								
ROUTING:		3	1199				l.				
	structions	Down Ti	me Codes			- F	irst Part In	spectio	Record		
			1 Maintenance				Approved Mtrl		Rev		
		2 Tooling		Submitted	Time Of Day	Yes / No	Check	Letter	I Inspector I No.		
1		3 Setup 4 FAIR		11-12-15	2pm	Y		0	JC		
		5 Training			V						
		6 Meeting		,							
ECONDARY	PRODUCTIO	N RECORD			PAGE :					Test Form 1	10/15/15

W.