

CY 3000

Part No.	3029387
Order No.	376474
Order Qty	1200

Rev Letter	A
Component	30293B1-10.2

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

QTY CHANGE INLS/DATE	
----------------------	--

Standard Cycle Time &amp; Setup Time Verified

Special Notes / Instructions	
------------------------------	--

Standard Cycle Time & Setup Time Verified	
1st Operation	

1st Operation	
---------------	--

2nd Operation	
---------------	--

10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	----	-----

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 #	CNC					0	0	STD CYCLE TIME								0	#DIV/0!
6-26-15	GLK	-	4	4		0	0	0	0		1	3	-				
						0	0	0	0								
6-26-15	SB	8	0	219		0	0	0	0		0	0	0				
6-27-15	LW	6	0	168		0	0	0	0		0	0	0				
6-27-15	LW	7.6	0	248		0	0	0	0		0	0	0				
						0	0	0	0								
						0	0	0	0								
6-29-15	SB	2.5		77		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	#DIV/0!	0		0				

move to  
DeBurr

716


Routing:

Machine	Part	Qty	RP	0	STD CYCLE TIME					0	#DIV/0!
7-6-15	h w	3.6	4	136	0	0	0	0			
7-6-15	SB	8		262	0	0	0	0			
7-7	GARY				0	0	0	0			
7-7	ZE	7		182	0	0	0	0			
7-8	FG	7.6		60	0	0	0	0			
7-9	h w	?		177	0	0	0	0			
7-9-15	SB	1.5		37	0	0	0	0			
Total Efficiency	0	0	0	0	0	0	0	0	#DIV/0!	0	0

Routing:

Machine #	Case	B.P	92	0	0	STD CYCLE TIME					0	#DIV/0!
7-10-15	LW 7.6			0	0	0	0					4 wire brushes
7-10-15	SB 2		64	0	0	0	0					1 Hrs DEBurri
				0	0	0	0					5 hrs at top
				0	0	0	0					
7-13-15	LW		183	0	0	0	0					
				0	0	0	0					
7-14-15	LW		9	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/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	6-26-15	1 PM	YES	DH	
Total Scrapped	0	2	Tooling	0	6-15	10 AM	YES	PL	
3rd Operation Count	0	3	Setup Idle	0					
2nd Operation Count	0	4	Other	0					
1st Operation Count	0								

Test 4/29/15

Test 4/29/15