


Part No.	P1212001-10	Component	A02002-0060		 control devices, LLC cycle time is now 7min 10sec					
Order No.	391984	Heat Lot #								
Order Qty	600 400	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	2.5.16	BA	—	3	3	4.0	3	Clean out / setup		
	2-8-16	JO	3.0	10	13	3.0		worked on setting tool		
Setup Hrs.	2.6.16	BA	6.0	30	43					
	2/8/16	BT	8	38	81					
	2-8-16	JO	7.0	35	116	1.0		Shorten cycle time		
Cycle Time	2.8.16	BA	8.0	44	160					
10min 10sec	2/9/16	BT	6.5	33	193					
	2-9-16	JO	5.5	26	219					
Pcs/Hr	2.9.16	BA	8.0	48	267					
5	2/10/16	BT	6.5	35	302					
	2-10-16	JO	1.0	8	310					

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
HARDING COBRA	2.10.16	BA	8.0	39	349					
	2/11/16	BT	6.5	33	382					
Setup Hrs.	2.11.16	JO	2.0	10	392					
	2.11.16	BA	8.0	39	431					
	2/12/16	BT	5	24	455					
Cycle Time	2-12-16	JO	1.5	9	464					
								Job Out		
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
2nd op	2/12/16	BT	1	11	11	5	3			
	2.12.16	JO	2.5	16	27	5	3			
Setup Hrs.	2-12-16	BA	1	4	31	1.5	3			
	2-13-16	BT	6	51	82					
	2-13-16	JO	4.0	36	118					
Cycle Time	2.13.16	BA	6	38	156					
4min 11sec	2/15/16	BT	8	71	227					
	2-15-16	SM	5	45	272					
Pcs/Hr	2-15-16	SS	8.0	75	345					
11	2/16/16	BT	6.5	57	402					
	2-16-16	JO	1.5	4	408					

Notes / Instructions		Down Time Codes	First Part Inspection Record						
			Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
1	Maintenance		2-5-16	10:45	Y	✓	A	JC	
2	Tooling		2-2-16	5:00 AM	40	✓	A	mrey	2nd op
3	Setup								
4	FAIR								
5	Training								
6	Meeting								