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|---|---|
| **Part No.** | **S404-8-3/16** |
| **Work Order No.** | **628249** |
| **Order Qty** | **40** |

control devices, LLC

| Distinguishing Traceablity Numbers | |
|---|---|
| Flare Nuts | Six digit no. located on the box label under box quantity. |
| Brazing Rings | Located on the box label, directly above the word "heat." |
| Copper Tubing | Located on the spool label, starting with the letter "M." |
| Flare Tubes | Use their work order number and date on the box label. |
| Snap Rings | Located on the bag followed by "Lot Number." |
| Caps/Plugs | Do not require traceability. |

| Operations | Mach. No. | Setup Min | Cycle Time | Pcs/Hr | Thru-put/8 hrs |
|---|---|---|---|---|---|
| MANUAL BRAZING | | 15 | 75 sec | 48 | 345 |
| BRAZING WASH,RINSE, WATER TEST | | 0 | 60 sec | 60 | 432 |
| PACK/REPORT/SNED TO MS-KF FG | | 0 | 3 sec | 1425 | 10260 |

| Component(s) (See BOM) | | QTY | Heat Lot/Traceability No(s) |
|---|---|---|---|
| **SF404-8-3/16** | DIST, NOZZLE, FOR ASSY FLARE | **1** | |
| **CUTU-1-1/2** | 1/2 COPPER TUBING, 1" LG .500 OD X .032 WALL | **1** | |
| **BRZ23** | BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS | **1** | |
| **CP13** | PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X | **1** | |
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| | Date | Emp. Name | Prod Hrs. | Total Pcs. | Cum. Total | Down Time | Down Time Code | Notes | Scrap | Scrap Code |
|---|---|---|---|---|---|---|---|---|---|---|
| ***1st Operation*** | | | | | | | | | | |
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| **ROUTING:** | | | | | | | | | | |
| ***2nd Operation*** | | | | | | | | | | |
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| **ROUTING:** | | | | | | | | | | |
| ***3rd Operation*** | | | | | | | | | | |
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| Special Notes / Instructions | Down Time Codes |
|---|---|
| | **1** Maintenance<br>**2** Tooling<br>**3** Setup<br>**4** FAIR<br>**5** Training<br>**6** Meeting |

| First Part Inspection Record | | | | | | |
|---|---|---|---|---|---|---|
| Date Part Submitted | Time Of Day | Approved Yes / No | Rev Letter | Material Check | Inspector | Notes |
| | | | | | | |
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