Part No.	FS135	Component	FS135-10		control devices, LLC
Order No.	397456	Heat Lot #			
Order Qty	~~500~~ 600	W/O # from Box			now 2min 37sec

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
HARDING COBRA	2-13-16	JO				3.5	3	Set-up 2nd op		
	2-13-16	BA	2.5	33	33	.5	3			
Setup Hrs.	2/15/16	BJ	8	100	133					
3.5	2-15-16	SM	5	72	205					
	2-15-16	JS+BA	8	115	310 →320					
Cycle Time	2/16/16	BJ	6	72	392					
3 min 10 sec	2-16-16	SM	3.5	60	452					
	2-16-16	BA	7	54	506					
Pcs/Hr	2/17/16	BJ	6	72	578			Job Out		
18	2-17-16	JO	4.0	51	629					

ROUTING: TO THREAD ROLLER

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								2-26-16 3.5		
Pcs/Hr										
									0	

ROUTING:

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										

ROUTING:

Notes / Instructions	Down Time Codes	First Part Inspection Record

	Down Time Codes	Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
	1 Maintenance							
	2 Tooling	2-13-14	1:25 PM	YES	✓	A	WRB	
	3 Setup							
	4 FAIR							
	5 Training							
	6 Meeting							

SECONDARY PRODUCTION RECORD   PAGE 1   Test Form 10/15/15