


Part No.	IL10005-10	Component	IL10005-20	
Order No.	400768	Heat Lot #		
Order Qty	1700	W/O # from Box		

OPERATION 1										THRU-PUT/8HRS	192
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code	
CNC T42	2-22-16	BA	2.5	40	40	1.0	3		2		
	2-23-16	BJ	5.0	70	110						
Setup Hrs.	2-23-16	JM	7	220	330						
4	2-23-16	BA	6.5	73	403						
	2/24/16	BT	4	53	456						
Cycle Time											
2MIN											
Pcs/Hr											
24											

ROUTING: PACK DEPT

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											
Pcs/Hr											

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						
1 Maintenance 2 Tooling 3 Setup 4 FAIR 5 Training 6 Meeting		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes