Part No.	S405-5-1/4-1/2					
Work Order No.	628741					
Order Otv	25					



	Distinguishing Traceablity Numbers						
Flare Nuts	Six digit no. located on the box label under box quantity.						
Brazing Rings	ocated 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	
AUTO BRAZE 1ST OP		10	144 sec	25	180	
AUTO BRAZE 2ND OP		10	144 sec	25	180	
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432	

Compo	nent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF405-5-1/4-1/2	DIST, NOZZLE, FOR ASSY FOR ASSY/ FLARE, 1/2 SIDE TAP	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	

u	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
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Special Notes / Instructions	Down Time Codes	First Part Inspection Record						rd
Additional ops: PACK / REPORT / TRANSFER TO SH	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup							
	4 FAIR5 Training							
	6 Meeting							

Part No.	S403-3-1/4
Work Order No.	628737
Order Oty	10



	Distinguishing Traceablity Numbers						
Flare Nuts	Six digit no. located on the box label under box quantity.						
Brazing Rings	ocated 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	
AUTO BRAZE 1ST OP		10	144 sec	25	180	
AUTO BRAZE 2ND OP		10	144 sec	25	180	
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432	

Com	ponent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF403-3-1/4	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	

u	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
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Special Notes / Instructions	Down Time Codes		First Part Inspection Record					
Additional ops: PACK / REPORT / TRANSFER TO SH	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup							
	4 FAIR 5 Training							
	6 Meeting							

Part No.	S404-8-3/16014P
Work Order No.	628736
Order Oty	2



	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		10	4 sec	900	6480	
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432	
PACK/REPORT/SNED TO MS-KF FG		0	3 sec	1425	10260	

Comp	onent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF404-8-3/16	DIST, NOZZLE, FOR ASSY FLARE	1	
CUTU-2.15-1/2	1/2" COPPER TUBE, 2.15" LONG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS	1	
CUTU-14-3/16	3/16" COPPER TUBING, 14" LG .188 OD X .028 WALL	8	
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED N	8	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	

u	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
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Special Notes / Instructions	Down Time Codes	First Part Inspection Record						
	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup 4 FAIR							
	5 Training							
	6 Meeting							

Part No.	S404-7-3/16014P
Work Order No.	628734
Order Oty	5



	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		10	4 sec	900	6480	
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432	
PACK/REPORT/SNED TO MS-KF FG		0	3 sec	1425	10260	

Compo	onent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF404-7-3/16	DIST, NOZZLE, FOR ASSY ASSEMBLY	1	
CUTU-2.15-1/2	1/2" COPPER TUBE, 2.15" LONG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS	1	
CUTU-14-3/16	3/16" COPPER TUBING, 14" LG .188 OD X .028 WALL	7	
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED N	7	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	

u	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
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Special Notes / Instructions	Down Time Codes	First Part Inspection Record						
	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup 4 FAIR							
	5 Training							
	6 Meeting							

Part No.	S404-8-3/16217F
Work Order No.	628732
Order Oty	75



	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		10	4 sec	900	6480	
BRAZING WASH,RINSE, WATER TEST		0	60 sec	60	432	
PACK/REPORT/SNED TO MS-KF FG		0	3 sec	1425	10260	

Comp	onent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF404-8-3/16	DIST, NOZZLE, FOR ASSY FLARE	1	
L2	NOZZLE, STANDARD	1	
L-RING	RETAINING RING, .45" DIA031 SS / 112789-A	1	
CUTU-1.9-1/2	1/2 COPPER TUBING, 1.9" LG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MT	1	
CUTU-17-3/16	3/16" COPPER TUBING, 17" LG .188 OD X .028 WALL	8	
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED MTL CERTS	8	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	
A-KF001	ASSEMBLY DRAWING, DISTRIBUTOR NATL REFRIG PART NUMBERS	0	

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Special Notes / Instructions	Down Time Codes		First Part Inspection Record					
	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup							
	4 FAIR 5 Training							
	6 Meeting							

Part No.	S40333/16-1-17F
Work Order No.	628731
Order Otv	340



	Distinguishing Traceablity Numbers						
Flare Nuts	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
AUTO BRAZING		15	144 sec	25	180
AUTO BRAZE 2ND OP		20	144 sec	25	180
BRAZING WASH,RINSE, WATER TEST		20	60 sec	60	432

Comp	onent(s) (See BOM)	QTY	Heat Lot/Traceability No(s)
SF403-3-3/16	DIST, NOZZLE, FOR ASSY	1	
L1	NOZZLE, STANDARD	1	
CUTU-17-3/16	3/16" COPPER TUBING, 17" LG .188 OD X .028 WALL	3	
BRZ24	BRAZE RING .041 DIA X .1875 ID SIL-FOS 18 - NEED MTL CERTS	3	
CUTU-1.9-1/2	1/2 COPPER TUBING, 1.9" LG .500 OD X .032 WALL	1	
BRZ23	BRAZE RING .047 DIA X .500 ID SIL-FOS 18 - NEED MTL CERTS	1	
L-RING	RETAINING RING, .45" DIA031 SS / 112789-A	1	
CP13	PLUG, FOR 1/2 OD TUBE, PLASTIC IND COMPONENTS P/N TAP-T-3X	1	
A-KF001	ASSEMBLY DRAWING, DISTRIBUTOR NATL REFRIG PART NUMBERS	0	

u	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
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Special Notes / Instructions	Down Time Codes		First Part Inspection Record					
Additional ops: PACK/REPORT/SNED TO MS-KF FG	Maintenance Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup							
	4 FAIR							
	5 Training6 Meeting							

Part No.	S404-8-3/16
Work Order No.	628249
Order Otv	40



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	

Comp	onent(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	

u	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
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Special Notes / Instructions	Down Time Codes	First Part Inspection Record						
	1 Maintenance2 Tooling	Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
	3 Setup							
	4 FAIR							
	5 Training6 Meeting							