


Part No.	ASC-7	Component	A02071-0032			
Order No.	397117	Heat Lot #	192943.7.1			
Order Qty	500	W/O # from Box				

OPERATION 1								THRU-PUT/8HRS	1168	
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
H83	1-19-16	HVD	2	51		46	3		3	3
	1-20-16	HVD	10	215	266	0		Jobout	0	
Setup Hrs.	1-21-16	HVD	10	234	500	0			0	
3.5	1-22-16	HVD	7	151	651	1	3	HVD	0	
Cycle Time										
2m35g										
Pcs/Hr										
20										

ROUTING: TO THREAD ROLLER										
OPERATION 2								THRU-PUT/8HRS	272	
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
H2	1-22-16	HVD	6.5	208		0			0	
	1-22-16	RS	5	160	368	0			0	
Setup Hrs.	1-22-16	M	5	158	524	0			0	
3hr	1-23-16	HVD-RS	2	64	588	6	3		0	
	1-25-16	RS	2	63	651	6	3	Jobout	0	
Cycle Time								HVD		
1m39s										
Pcs/Hr										
34										

ROUTING: OPERATION 3										
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
				1-19-16	2:45~	YES	✓	-	DT	OK'd per J.E.
				1-21-16	9A	YES	✓	-	DT	" " " "