

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



Component(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" DIA. .031 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	

Distinguishing Traceability 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
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

	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down Time	Down Time Code	Notes	Scrap	Scrap Code
<b>1st Operation</b>										
ROUTING:										
<b>2nd Operation</b>										
ROUTING:										
<b>3rd Operation</b>										

Special Notes / Instructions		Down Time Codes		First Part Inspection Record						
Additional ops: -- PACK/REPORT/SNED TO MS-KF FG		1 Maintenance		Date Part Submitted	Time Of Day	Approved Yes / No	Rev Letter	Material Check	Inspector	Notes
		2 Tooling								
		3 Setup								
		4 FAIR								
		5 Training								
		6 Meeting								