


Part No.	FS135-10	Component	A02002-0022
Order No.	397455	Heat Lot #	
Order Qty	500 600	W/O # from Box	



is now 4min50sec

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	2-8-16	JO				3	3	Setup 1st op		
	2-8-16	BA	3.0	25	25					
Setup Hrs.	2/9/16	BS	8	53	78					
3.0	2-9-16	JO	5.0	32	110					
	2-9-16	BA	6.5	38	148					
Cycle Time	2/10/16	BS	8	54	202					
9min total	2-10-16	JO	8.0	67	269					
4min 50sec	2-10-16	BA	6.5	65	334					
Pcs/Hr	2/11/16	BS	7.5	61	395					
all / new	2/11/16	BA/JO	8.0	87	482					
5/11	2/12/16	BS	6.5	52	534					

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
				28	562					
	2-12-16	BA	.5	8	570					
Setup Hrs.	2/13/16	BS	6	51	621					
	2-13-16	JO	1.5	8	629					
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
Cobra										
2nd op										
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
		2-8-16	5:25	✓	✓	A	JC	