


Part No.	S144S144002	Component	S144S144002-10	 is now 1min 30sec
Order No.	401594	Heat Lot #	No parts 9B	
Order Qty	1000	W/O # from Box		

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
CNC OKUMA	3-7-16	BA	4.5	54	54	3.5	3			
	3-8-16	NI	5	81	135					
Setup Hrs.	3-8-16	MC	5.5	72	207	Ø				
4	3-8-16	BA	8.0	92	299			John T		
	3-9-16	BT	3	38	337			HUB		
Cycle Time	3-9-16	MC/JO	8	108	445	Ø				
2MIN 24SEC	3-9-16	BA	4.5	65	510					
	3-10-16	BT	7	82	592					
Pcs/Hr	3-10-16	MC	7	100	692	Ø				
20 36	3-11-16	BT	5.5	60	752					
	3-11-16	JO	6.5	117	869					

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
	3-11-16	BA	6.5	127	998					
Setup Hrs.										
Cycle Time										
								3-21-16		
Pcs/Hr								SS		

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
		3-7-16	6:40 PM	YES	✓	C	WRB	