


Part No.	FS22-10	Component	FS22-20	
Order No.	384865	Heat Lot #		
Order Qty	2572	W/O # from Box		

OPERATION 1

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
B/S 17	11-19	E.B.	87					COUNTER BROKE		
	11-18	MP				4	3		14	11
Setup Hrs.	11-19-15	MP	5.5	496	1200	.5	6			
4	11-20-15	E.B.	8	625	1825					
	11-20-15	MP	6	583	2408				15	E-18
Cycle Time										
59 SEC										
Pcs/Hr										
49										

ROUTING:

WASH & PACK DEPT

OPERATION 2

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:

OPERATION 3

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						
FOR B&S ONLY: To Figure Pieces From Loads = Pcs/Bar x Total loads ran during shift x Bars per load	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
		11/19/15	2:55 P	YES	✓	G	AT	