

Heat Lot #	
or	
Box W/O #'s	
Found on Label	

QTY CHANGE INLS/DATE

Special Notes / Instructions

10-2-14 drilled 525 CYLIND

Standard Cycle Time & Setup Time Verified

1st Operation

2nd Operation

3rd Operation

Date	Emp. Name	Prod. Hours	Setup Hours	Total Pcs	Planned Hours	Cum. Total	Balance Due Pcs	Plan Pcs/Day	Actual Pcs/Day	% Oper. Efficiency	Down Time	3rd Operation				S/U hrs	Actual S/U	Setup %
												Code	Scrap Pcs.	Pcs/Hr				
Machine #																		
9-26-14	T.A.	8	-	870		0	0	STDCYCLE TIME								0	#DIV/0!	
9-25-14	SB	4.5		900		0	0									339976		
9-30-14	GA	5.0		1000		0	0											
10-1-14	GA	4.25		1000		0	0											
10-2-14	GA	4.5		1000		0	0									Change bit= rear		
10-4-14	GA	.5				0	0											
10/31	T.A.	1.5				0	0									Change front bit		
10/6/14	T.A.	6.0		1000		0	0									Change rear bit		
10-14-14	GA	7.5	-	1350		0	0											
10-15-14	GA	7.5		1400		0	0											
Total Efficiency	0	0	0	0	0	0	0	0	0	#DIV/0!	0	0	0			Change front Bit		


Routing:

Machine #				Routing:											
				0	STD CYCLE TIME								0	#DIV/0!	
10-16-14	56	4	-	750	0	0	0	0							
11-4-14	5-13	2.5	-	400	0	0	0	0							
12-5-14	16A	2.75	-	200	0	0	0	0							
12-11-14	16A	200	-	300	0	0	0	0							
12-18-14	7-8	2.5	-	350	0	0	0	0							
12-19-14	40	5.5	-	850	0	0	0	0							
12-16-14	7-16	8.0	-	1300	0	0	0	0							
					0	0	0	0							
					0	0	0	0							
					0	0	0	0							
					0	0	0	0							
					0	0	0	0							
Total Efficiency	0	0	0	0	0	0	0	0							
					0	0	0	0	#DIV/0!	0					

Routing:

Machine #					Routing:									
						0	STD CYCLE TIME						0	#DIV/0!
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Routing:

Final Part Calculation				First Part Inspection Record					
		Code	Total Down Time Description	Hours	Date Part Submitted	Time of Day	Approved Yes / No	Inspector	Notes
Total Counted Pcs	(from packing)	1	Maintenance	0	12-5-14	7:10	YES	STH	
Total Scrapped	0	2	Tooling	0					
3rd Operation Count	0	3	Setup Idle	0					
2nd Operation Count	0	4	Other	0					
1st Operation Count	0								