

Control Devices LLC / Work Order Production Record

Part No.	IF5050B24	Rev Letter	F	Heat Lot #													
Order No.	379645	Component	IF5050B24-20	or													
Order Qty	2000			Box W/O #'s													
QTY CHANGE INLS/DATE				Found on Label													
Special Notes / Instructions				Standard Cycle Time & Setup Time Verified													
4 PARTS PER CYCLE - CHECK WHEN RUNNING ON HAAS.				1st Operation	MR 8/5/15												
				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	Code	Scrap Pcs.	Pcs/Hr	S/U hrs	Actual S/U	Setup %
Machine #						0	2000	STD CYCLE TIME	2M 58SEC					64	4	1.5	267%
8/7/15	MS	4	1.5	228	5.5	228	1772	256	228	89.1%	0	0	0				
8/7/15	SB	6	0	316	6	544	1456	384	316	82.3%	0	0	0				
8/8/15	TG	5.6	0	187	5.6	731	1269	358.4	187	52.2%	0	0	0				
8/8/15	MS	6	0	300	6	1031	969	384	300	78.1%	0	0	0				
8/10/15	TG	7.6	0	317	7.6	1348	652	486.4	317	65.2%	0	0	0				
8/10/15	MS	7	0	332	7	1680	320	448	332	74.1%	0	0	0				
8/10/15	SB	8	0	348	8	2028	-28	512	348	68.0%	0	0	0				
8/11/15	TG	7.6	0	344	7.6	2372	-372	486.4	344	70.7%	0	0	0				
8/11/15	MS	0	0	0	0	2372	-372	0	0		0	0	0				
8-11-15 MS		10	-	332		2372	-372	0	0		2						
						2372	-372	0	0								
Total Efficiency		51.8	1.5	2372	53.3	2372	-372	3315.2	2372	71.5%	0		0				
Routing: PACK DEPT																	
Machine # B17							2000	STD CYCLE TIME							0	#DIV/0!	
8-11-15 SB		4.5		160		0	2000	0	0		0	0	0		3.5 HAS		
						0	2000	0	0						running 8/31-10		
8-12-15 TG		2.6				0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
Total Efficiency		0	0	0	0	0	2000	0	0	#DIV/0!	0		0				
Routing:																	
Machine #							2000	STD CYCLE TIME							0	#DIV/0!	
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
						0	2000	0	0								
Total Efficiency		0	0	0	0	0	2000	0	0	#DIV/0!	0		0				
Routing:																	
First Part Inspection Record																	
Final Part Calculation		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	8/7/15	730AM	YES	DH									
Total Scrapped	0	2	Tooling	0													
3rd Operation Count	0	3	Setup Idle	0													
2nd Operation Count	0	4	Other	0													
1st Operation Count	2372																