


Part No.	CY12001	Component	CY12001-10	 <i>Part on JL Left</i>
Order No.	388433	Heat Lot #		
Order Qty	1814	W/O # from Box	369122	

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
HAAS	10-30	MS	3	80	80			Wrote NEW PROGRAM - DESIGNED		
	10-31	LJ	1.5	30	112			* MACHINED TOOLING		
Setup Hrs.	10-30-15	SR	5	134	246			3 HRS OF B-17		
5	11-2-15	DH	7	203	449			1 hr secondary	3	N9
	11-2-15	SM	7	260	709					
Cycle Time	11-2-15	LJ	5	86	795			Running both Handings		
3 min	11-3-15	DH	7	220				1 hr B35 (stuck)		
2 PCS	11-3	MS	4	104	1119					
Pcs/Hr	11-3-15	LJ	4.5	112	1231			Running other Machine	2	E18
32	11-4-15	DH	6.5	222	1453			1.5 Secondary (stuck)	1	N9
	11-4-15	SM		182	1635					

ROUTING:										THRU-PUT/8HRS
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:										THRU-PUT/8HRS
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										

Notes / Instructions	Down Time Codes	First Part Inspection Record						
1 Maintenance 2 Tooling 3 Setup 4 FAIR 5 Training 6 Meeting	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
		10/30/15	11:20 AM	YES	OK	B	SR	CD 03