

Part No.	M20021	Component	M20021-10	control devices, LLC						
Order No.	388978	Heat Lot #								
Order Qty	1120	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
HAAS VERT MILL										
Setup Hrs.										
Cycle Time										
Pcs/Hr										

ROUTING:										
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
470	12/19/15	IT	.4	29		.75		2, 3	15	11
	12/10/15	NK	6	400						
Setup Hrs.	12/11/15	NK	1	74						
1.2										
Cycle Time										
Pcs/Hr										

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
				12-10-15	7am	yes	✓	E	DT	60# down to Q3