


Part No.	103151-1	Component	A06202-0048	
Order No.	398741	Heat Lot #		
Order Qty	70 35	W/O # from Box		

OPERATION 1

THRU-PUT/8HRS

110

Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
OKUMA	2/4/16	BT	1.0	2	2	5	3	setup 1st op		
	2-4-16	JO	2.0	15	17	1.0	3	edit program		
Setup Hrs.	2.4.16	BA	6.5	15	32					
JO	2/5/16	BT	3	6	38					
Cycle Time										
24min										
15 or 15 min										
Pcs/Hr										
2										

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
OKUMA	2/5/16	BT				3	3			
	2-5-16	JO	2.0	38	38	1.0	3	finish setup		
Setup Hrs.										
40										
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
		2-4	3:30 AM	Yes	0	A	M. Boyk	

15min 42sec