

Part No.	G50-10	394152	Component	A02001-0020	NO Part 98 
Order No.	GV SAMPLE		Heat Lot #		
Order Qty	900		W/O # from Box		

OPERATION 1										THRU-PUT/8HRS	272
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code	
OKUMA	1-7-16	BA	—	—		4.0	3	program + setup			
	1-8-16	BA	7.5	216	216	.5	2,3				
Setup Hrs.	1/9/16	BT	6	158	374						
4.5	1/9/16	JO	5.5	137	511						
	1/9/16	BA	6.0	183	694						
Cycle Time	1/11/15	BJ	7.5	189	883						
1m35	1/11/15	JO	4.0	80	963						
Pcs/Hr											
34											

OPERATION 2										THRU-PUT/8HRS	144
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code	
HAAS VERT	3-1-16	Rm	6.0	25	25			Setup Job + wrote			
	3-2-16	Rm	8.0	125	150			the program			
Setup Hrs.	3-3-16	Rm	8.0	110	260						
2.0	3/4/16	ST	8	130	390						
	3-4-16	Rm	8	90	480			Trained on Lathe			
Cycle Time	3/5/16	ST	7	115	595						
3.0 min	3-5-16	Rm	6.0	90	685						
	3-7-16	NI	6.0	105	790						
Pcs/Hr	3-7-16	MC	6.5	100	890	0.5		Tooling			
18	3-7-16	Rm	3.0	40	930						
	3-8-16	NI	45 min	17				Running another machine			

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	
								JOB OUT			
Setup Hrs.											
Cycle Time											
Pcs/Hr											

Notes / Instructions	Down Time Codes	First Part Inspection Record						
1 Maintenance		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
2 Tooling		1-8-16	2:10	YES	✓			
3 Setup		3-1-16	7:15p	YES	✓	A		
4 FAIR								
5 Training								
6 Meeting								