

Part No.	0042-SS-0
Order No.	NA 3494180
Order Qty	300

Component	13/32 303 SS
Heat Lot #	NO TAG
W/O # from Box	



OPERATION 4										THRU-PUT/8HRS
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
	1/28/16	BT				4	3			
	1/29/16	BT	7.5	34	34	.5	3			
Setup Hrs.	1-29-16	JO	7.0	30	64					
	1-29-16	BA	6.5	36	100					
	1/30/16	BT	6	29	129					
Cycle Time	1-30-16	JO	6.0	30	159					
	2/1/16	BT	8	40	199					
	2-1-16		5.0	24	223	3.0	2	change inserts and drills / setup oking		
Pcs/Hr	2-1-16	BA	7.0	31	250					
	2/2/16	BT	8	43	297					
	2-2-16	JO	2.0	10	307					

ROUTING: STAYS AT MACH OPT B

OPERATION 5										THRU-PUT/8HRS
Mach No.	Date	Emp. Name	Prod Hrs.	Total Pcs.	Cum. Total	Down time	Down time code	Notes	Scrap	Scrap Code
T-42	2-2-16	JO	3.5	38	38	1.5	3	Setup and op		
	2-2-16	BA	6.5	94	132					
Setup Hrs.	2/3/16	BT	8	116	248					
2.0	2-3-16	JO	6.0	58	306					
Cycle Time										
2 min 30 sec										
Pcs/Hr										
21										

ROUTING:

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		Date Part Submitted	Time Of Day	Approved Yes / No	Mtrl Check	Rev Letter	Inspector	Notes
2 Tooling		1-28-16	5:20 am	4/20	✓	B	mmg	
3 Setup		1-29-16	7A	4/25	✓	B	OH	Resub 1st of
4 FAIR		2-2-16	11a	4/25	✓		OH	2nd of
5 Training								
6 Meeting								