

Control Devices LLC / Work Order Production Record

Part No.	0017-89-C	Rev Letter	A	Heat Lot #	0560750F
Order No.	369909	Component	0017-89-C-10	or Box W/O #'s	
Order Qty	60			Found on Label	

QTY CHANGE INLS/DATE

Special Notes / Instructions

Standard Cycle Time & Setup Time Verified

1st Operation

2nd Operation

3rd Operation

Date	Emp. Name	Prod. Hours	Setup Hours	Total Pcs	Planned Hours	Cum. Total	Balance Due Pcs	Plan Pcs/Day	Actual Pcs/Day	% Oper. Efficiency	Down Time	Code	Scrap Pcs.	Pcs/Hr	S/U hrs	Actual S/U	Setup %
Machine #						0	60	STD CYCLE TIME							4	4.5	89%
5/5/15	JO	0	3	0		0	60	0	0		0	0	0		4 ARS programing		
5/6/15	JO	4.5	1.5	30		30	30	0	30		0	0	0				
5/6/15	BA	8	0	46		76	-16	0	46		0	0	0		JOB OUT-MR		
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
						76	-16	0	0								
Total Efficiency		12.5	4.5	76	17	76	-16	0	76	#DIV/0!	0		0				

Routing: HOLD AT MACH

Machine #						60	STD CYCLE TIME									3	0%
5/8/15	JO	0.5	3	0	3.5	0	60	0	0		0	0	0				
5/9/15	JO	6	0	55	6	55	5	0	55		0	0	0				
5/9/15	BA	4	0	23	4	78	-18	0	23		0	0	0	0			
						78	-18	0	0								
						78	-18	0	0								
						78	-18	0	0								
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						78	-18	0	0								
						78	-18	0	0								
						78	-18	0	0								
Total Efficiency		10.5	3	78	13.5	78	-18	0	78	#DIV/0!	0		0				

Routing: HOLD AT MACH

Machine #							60	STD CYCLE TIME		2.10m	55 sec					0	#DIV/0!
5-19-2015	GHK	5	3	78		0	60	0	0		2 days	12:49	7	11	Cotton Medication + tooling		
5-20-2015	GHK	5	4	18		0	60	0	0		3.5	2	13	11			
5-21-2015	GHK	3	3	58		0	60	0	0		2	2:44	1	11			
5-29-2015	GHK	1.5	1.5	54		0	60	0	0		-	-	1	11	JOB OUT		
						0	60	0	0								
						0	60	0	0								
						0	60	0	0								
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						0	60	0	0								

Routing:

First Part Inspection Record

Final Part Calculation		Code	Total Down Time Description	Hours	Date Part Submitted	Time of Day	Approved Yes / No	Inspector	Notes
Total Counted Pcs	(from packing)	1	Maintenance	0					
Total Scrapped	0	2	Tooling	0	5/19/15	9:15	YF	DA	360 2/20/16
3rd Operation Count	0	3	Setup Idle	0					
2nd Operation Count	78	4	Other	0					
1st Operation Count	76								

Test 4/29/15