

DATE _____

SHIFT: 1 2 3

WO #: 5:001

LP100

Custom License Plate

Initials:

Total Weight with Trays & Pallet :

BIN #

ALLERGENS:

Standard weight. Pallet weight = 21 lbs . Each Tray weight 2.2 lbs.

Total weight from the Label Subtract Pallet weight and Trays

Product Weight Without Trays & Pallet:

DATE _____

SHIFT: 1 2 3

WO #: 5:001

LP100

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Product Weight Without Trays & Pallet:

Extruder #: 1 2 3 4 5					EXTRUDED PRODUCT QUALITY INSPECTION				
Date: _____		Den #: LP100		Product Name: Custom License Plate					
Machine Start Time: _____		Operator Name: _____			QC Name: _____				
MO #: 5:001									
Product Standard Specification									
Length: <u>in</u>		Weight: <u>lbs</u>		Die:		Color Outside:		Color Inside:	
First Piece Specification & Characteristics									
Length: <u>in</u>		Weight: <u>lbs</u>		Die:		Color Outside:		Color Inside:	
Pass		Fail				Approved Time: _____		Approved by: _____	
<p>For every 30 minutes, line operator needs to check, verify and record the data to make sure product is running as per standard specification. Supervisor needs to check once (1) per hour. QC Spot Checks paperwork. If there is an item out of spec (Fail), problem needs to be fixed. Record all findings.</p>									
1st Shift					2nd Shift				
Time	Size	Wt.	Op. Sig.	Supervisor Sig.	Time	Size	Wt.	Op. Sig.	Supervisor Sig.
7:00 AM					3:30 PM				
7:30 AM					4:00 PM				
8:00 AM					4:30 PM				
8:30 AM					5:00 PM				
9:00 AM					5:30 PM				
9:30 AM					6:00 PM				
10:00 AM					6:30 PM				
10:30 AM					7:00 PM				
11:00 AM					7:30 PM				
11:30 AM					8:00 PM				
12:00 PM					8:30 PM				
12:30 PM					9:00 PM				
1:00 PM					9:30 PM				
1:30 PM					10:00 PM				
2:00 PM					10:30 PM				
2:30 PM					11:00 PM				
3:00 PM					11:30 PM				
3:20 PM					12:00 AM				
3rd Shift									

DATE: 04/30/2021

F-247-018 B

Operator 1 Name: _____

Production Run for: LP100 - Custom License Plate

MO #: 5:001

#	WHAT TO CHECK	Checked	COMMENTS
1	Do you have the batch sheet according to the production schedule?		
2	According to the last run, are you required to clean?		
3	Do you have the setting sheet for the machine according to the product?		
4	Do you have any Regrind Material for that run? If yes make sure it's		
5	Do you have any Liquid Mix on the side? Make sure you take it.		
6	Do you have all the materials to run the full batch?		
7	Supporting Operator 2 for line set up?		
8	Before starting the machine make sure the downstream line is ready.		
9	Make sure all the paper work is filled up completely.		
10	Do you have quality check sheet and approved sample on the table?		

OPERATOR 1 INITIAL: _____

#	OPERATOR 2 Name: _____	Checked	COMMENTS
1	Help support Operator 1 to getting everything ready.		
2	Is the Head and Screw clean? If its not clean, it needs to be cleaned.		
3	Check Conveyor #1 to make sure its plugged in and running fine?		
4	Adjusted all 4 rollers according to the product size?		
5	Set the CUTTER for the Bone Length according to the standard size.		
6	Check Conveyor #2 to make sure its plugged in and running fine?		
7	At the end of the Conveyor 2 make sure you have bin ready for regrind.		
8	Turn on the conveyor for cooling tunnel.		
9	Make sure all the finished product and regrind is weighted and recorded.		

OPERATOR 2 INITIAL: _____

PRODUCTION BATCH SIGNOUT SHEET

DATE	04/30/2021	# OF PEOPLE		WORK ORDER	5:001
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CIRCLE THE LINE YOU ARE RUNNING

PONGA UN CIRCULO EN SU LINEA DE TRABAJO

EXTRUSION MACHINE #	1 2 3 4 5									
INJECTION MACHINE #	1 2 3 4 5 6 7 8 9									
LP100	Custom License Plate									
Initials	Pallet #	Lot Code	Product Weight	# of Trays	Finished Time					
	1									
	2									
	3									
	4									
	5									
	6									

Initials	BIN #	Lot Code	Product Weight

NECESITA PONER EN LA PALLETA	
INITIALS	
DATE	
Total Weight	
Total Trays	

REGRIND GENERATED	Y / N	Wt. of Pallet = 50 lbs.
Bin #: _____ Wt. Made: _____ Initials: _____		Wt. of Tray = 2.2 lbs.
		Wt. of Bin = 100 lbs.

Required
RECORD TEMPERATURE BELOW:
_____ Degrees F. Initials: _____ Time: _____