

SHAKAMBHARI ENTERPRISES

DAILY PRODUCTION REPORT

Date: 08/04/2022

Shift: A

M/C	OPERATOR NAME	PART NAME	SETUP	TARGET QTY.	ACTUAL QTY.	PROD %.	Reason For Looss Production.	Rj(Qty.)	Reason For Rej.
CNC-1	Salman	lip seal	II	750	510				
CNC-2	new	K-8	II	792	577				
CNC-3	vijay	lip seal	III	1500	270				
CNC-4	new	no. screw	I	600	320				
CNC-5	mukesh	Tapcomp	II I		132 405		setting	0	
CNC-6	Santosh	JIA	II	820	635				
CNC-7	new	JIA	II	820	345				
CNC-8	new	Hero	I	2475	1040				
CNC-9	Sandeep	Extmy21	I II		873 56		setting		
CNC-10	Rive	CAPADWA	II	600	460				
CNC-11	Rakesh	KOPG	I	3000	2200				
CNC-12	Bhironav	Honda	I	1800	1140				
Traub-1									
Traub-2									
Traub-3									
Traub-4									
Traub-5	Avinash	K-23	cut	940	877			EP. 7.00	Rej 0-790
Traub-6	Avinash	K-23	u	940	877				
Traub-7	Aradeep	K-2	u	680	114				
Traub-8	u	A.B-902	u	550	390			2.680	0-500
Traub-9	Kharth	JIA	u	680	649			9.850	1.980
Traub-10	u	JIA	u	680	649				
Milling-1	new	JIA	mill	1200	1000				
Taping-1									
Taping-2									
Taping-3	new	JIA K-60	Tap	1200	1030, 2000				
Drilling-1		Hero Honda			500 800				
Drilling-2									
Belt Grind									
Bench Grind.									
C/L Grind-1	Ingle	K-60	Gr	4500	2400				
C/L Grind-2									
Rolling-1	Gupta	K-60	Roll	9000	2500				
Rolling-2		Honda		Riv	3200				

SHAKAMBHARI ENTERPRISES

F.No-F/11
R. No - 00

Works : G-29, M.I.D.C. Area, Waluj, Aurangabad - 431 136.

HOURLY PRODUCTION AND INSPECTION REPORT

PART NAME : *6hp sent Imp / 1404*
OPERATOR NAME *Manmath*
MACHINE NAME : *CNC-13*

DATE : *09/04/12*
SHIFT : *A*
TARGET :

CYCLE TIME :
PROGRAM NO.

Sr. No.	SPECIFICATION IN MM							PROJECTION			R/W	PRODN.	PART COUNT
	T.L	dim	Id	dim	dim	Id	ob	check	angle				
01	<i>11±0.05</i>	<i>5.5-0.3</i>	<i>45-0.24/45-0.29</i>	<i>10-0.2</i>	<i>5.2-0.2</i>	<i>42-0.2</i>	<i>51.556-51.557-44.8-0.3</i>	<i>45</i>	<i>Ampr 40</i>				
02													
03	<i>11-0.2</i>	<i>5.34</i>	<i>45-0.2</i>	<i>10-0.2</i>	<i>5.2-0.2</i>	<i>41.98</i>	<i>51.557</i>	<i>44.82</i>	<i>OK</i>	<i>OK</i>			
04													
05	<i>11-0.3</i>	<i>5.35</i>	<i>45-0.3</i>	<i>10-0.1</i>	<i>5.2-0.3</i>	<i>41.94</i>	<i>51.558</i>	<i>44.83</i>	<i>OK</i>	<i>OK</i>			
06													
07	<i>11-0.2</i>	<i>5.36</i>	<i>45-0.2</i>	<i>9.98</i>	<i>5.2-0.2</i>	<i>42-0.1</i>	<i>51.557</i>	<i>44.82</i>	<i>OK</i>	<i>OK</i>			
08													
09													
10													
11													
12													

TOTAL PRODUCTION :	% Rejection	Total Production
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REASONS FOR LOW LEVEL PERFORMANCE :

- | | | |
|-----------|-----------|-----------|
| 01) _____ | 05) _____ | 09) _____ |
| 02) _____ | 06) _____ | 10) _____ |
| 03) _____ | 07) _____ | 11) _____ |
| 04) _____ | 08) _____ | 12) _____ |

OPERATOR

Manmath
SIGNATURE

SUPERVISOR

SHAKAMBHARI ENTERPRISES

F-No.F/11
R-No.-00

Works G-29,MIDC Area,Waluj Aurangabad HOURLY PRODUCTION AND INSPECTION REPORT

PART NAME : F-B J1A
OPERATOR NAME Santosh
MACHINE NAME : CNC-06

DATE : 10-4-2022
SHIFT : B
TARGET :

CYCLE TIME :
PROGRAM NO.

Sr. No.	SPECIFICATION IN MM						PROJECTION			R/W	PRODN.	PART COUNT
	48±0.2	7	5	3	38.2-0.2	33±0.2	4.5±0.2	37	5±0.04			
01	48.05	7.05	4.98	3.00	38.06	33.05	4.57	37.16				
02												
03	48.02	7.02	5.02	3.00	38.07	33.08	4.57	37.16				
04												
05	48.02	7.03	5.02	3.01	38.07	33.04	4.58	37.17				
06												
07	48.06	7.06	5.02	3.00	38.08	33.04	4.57	37.16				
08												
09												
10												
11												
12												
TOTAL PRODUCTION :			% Rejection			Total Production						

REASONS FOR LOW LEVEL PERFORMANCE :

- | | | |
|-----------|-----------|-----------|
| 01) _____ | 05) _____ | 09) _____ |
| 02) _____ | 06) _____ | 10) _____ |
| 03) _____ | 07) _____ | 11) _____ |
| 04) _____ | 08) _____ | 12) _____ |

OPERATOR

Avinash
SIGNATURE

SUPERVISOR

SHAKAMBHARI ENTERPRISES

F.No-F/11
R. No - 00

Works : G-29, M.I.D.C. Area, Waluj, Aurangabad - 431 136.

HOURLY PRODUCTION AND INSPECTION REPORT

PART NAME : Tap Rebound Split

DATE : 9-4-2022

CYCLE TIME :

OPERATOR NAME : Suresh

SHIFT : B

PROGRAM NO.

MACHINE NAME : CNC-03 2st

TARGET :

Sr. No.	SPECIFICATION IN MM					PROJECTION			R/W	PRODN.	PART COUNT
	46.5±0.15	14±0.1	1±0.1	1.6±0.1	7.4±0.1	9-0.1	17gX1-6g				
01	46.58	14.02	1.00	1.54	7.41	8.92	OK				
02											
03	46.60	14.02	0.97	1.55	7.41	8.91	OK				
04											
05	46.53	14.01	0.98	1.55	7.42	8.91	OK				
06											
07	46.57	14.01	0.98	1.54	7.41	8.91	OK				
08											
09											
10											
11											
12											

TOTAL PRODUCTION :

% Rejection

Total Production

REASONS FOR LOW LEVEL PERFORMANCE :

- | | | |
|-----------|-----------|-----------|
| 01) _____ | 05) _____ | 09) _____ |
| 02) _____ | 06) _____ | 10) _____ |
| 03) _____ | 07) _____ | 11) _____ |
| 04) _____ | 08) _____ | 12) _____ |

OPERATOR

Suresh
SIGNATURE

SUPERVISOR



SHAKAMBHARI ENTERPRISES

G-29, MIDC Waluj

SCRAP NOTE

Date	Item Name / Item No	Scrap QTY	Reason	Sign
	F-B J1A	10	end piece	TEamb-11
	Extension 6102	3	T-L VLS upto 11mm	TEamb-10
10-4-22	lip seal	2	O.D VLS upto 50mm	CNC-01
Shift B	Tap Reb.	1	Threading O/S	CNC-05
	A-Bush 902	2	I.D O/S 50mm	} CNC-10
	A-Bush 902	1	Insert Break	
	F-B RE	4	T-L VLS upto 4mm	TEamb-2
	F-B 1223	7	————— 8mm	TEamb-3
	F-B 1223	11	————— 16mm	TEamb-4
	F-B 1223	5	————— 5mm	TEamb-5
	A-B 902	3	————— 15mm	TEamb-9
	Ext. 6102	2	————— 7mm	TEamb-10



SHAKAMBHARI ENTERPRISES

G-29, MIDC Waluj

SCRAP NOTE

Date	Item Name / Item No	Scrap QTY	Reason	Sign
09/04/22	JIA	08	End piece	Trub also - 10-15
Shift A	Adaptor bush 42	62	T.L.C. upto 24mm	Trub also - 09
	Lip seal Finish	20	step	CNC - 13
	Lip seal Finish	20	OD v/s upto 50mm	
9-4-22	Lip seal	10	ID O/S upto 50mm	CNC-01
Shift B	A Bush 902	1	face v/c	CNC-03
	F.B Honda	2	OD v/s upto 0.1mm	CNC-12
	F.B H230	3	OD v/s upto 0.08mm	CNC-08
	F.B 115	2	TAP BECAME	TAP-2
	F.B 115	2	Thread wash out	
	F.B Honda	3	Rolling out	Rolling-2
	F.B RE	3	T.L.C v/s upto 7mm	TEmb-2
	F.B K23	6	————— 12 ——— 17mm	TEmb-3
	F.B K23	3	————— 11 ——— 4mm	TEmb-4
	F.B K23	7	————— 11 ——— 8mm	TEmb-5