





**Supplier Final Run at Rate Form - Example**

<b>SECTION 1 - GENERAL INFORMATION</b>	
Stackpole Receiving Division: <input type="text" value="Engineered Products Division - Ancaster"/>	SI Contact: <input type="text" value="I.M. Quality"/>
Supplier Name: <input type="text" value="ABC Stamping Co. - #99911"/>	Date: <input type="text" value="04/20/12"/>

SECTION 2 - PRODUCT INFORMATION				SECTION 3 - SUPPLIER WORK SCHEDULE - (Supplier)			
SI Part Numbers	Part Description	Program Name	CPV Volume	Days/Wk	Wks/Year	Annual Shutdown	
12345AB	Cover Housing Bracket LH	Ford F150	750,000	5	48	<input checked="" type="checkbox"/> YES	<input type="checkbox"/> NO
12346AB	Cover Housing Bracket RH	Ford F150	750,000				
				Planned Down Time (min/shift)			
				5	(Minutes)	Start of shift meeting	
				10	(Minutes)	Clean up	
				60	(Minutes)	Breaks (Rest and Meals)	
					(Minutes)	TPM stops	
				5	(Minutes)	Other ( Changeover )	
			<b>Totals</b>	<b>1,500,000</b>	<b>80</b>	<b>Total Fixed Loss min/shift</b>	

SECTION 4 - SUPPLIER PROCESS FLOW (Supplier Data to Determine / Estimate Efficiency and Scrap)											
OP #	Description	HRS/Shift	Shifts/Day	Cycle (Sec.)	Efficiency %	% Scrap	Adj. Cycle	Allocation %	PCS/HR	Target/HR	Utilization %
10	Stamp Bracket in Press	10.00	2	6.00	95%	3.0%	6.49	75.5%	555	478	86%
20	Vibratory Debur	8.00	2	3.20	95%	1.0%	3.39	100.0%	1061	469	44%
30	Weld stud to bracket	8.00	2	6.50	80%	8.0%	8.42	100.0%	427	469	110%
40	E-Coat (Batch)	8.00	3	2.10	97%	5.0%	2.27	55.0%	1585	568	36%
50	Inspect Part	8.00	2	4.50	90%	0.0%	4.95	100.0%	727	469	64%
60	Pack and label box	8.00	2	5.50	90%	0.0%	6.05	100.0%	595	469	79%
											<b>Primary Capacity Constraint</b>
											<b>110%</b>

SECTION 5 - ACTUAL RUN OFF RESULTS AND CAPACITY PERCENTAGES FOR EACH PRODUCTION LINE / TOOL													
OP #	Description	Qty Attempted	Qty Rejected	Qty Good	FTC %	Start Time	End Time	Total Time (hrs)	Act Rate (pc/hr)	Actual Capacity	STATUS		
10	Stamp Bracket in Press	2,040	25	2,015	98.77%	9:00 AM	12:00 PM	3	672	71%	GREEN		
20	Vibratory Debur	1,278	45	1,233	96.48%	2:10 PM	3:20 PM	1.17	1,057	44%	GREEN		
30	Weld stud to bracket	1,233	34	1,199	97.24%	1:00 PM	4:00 PM	3	400	117%	RED		
40	E-Coat (Batch)	1,199	0	1,199	100.00%	4:15 PM	5:00 PM	0.75	1,599	36%	GREEN		
50	Inspect Part	625	0	625	100.00%	10:00 AM	11:00 AM	1	625	75%	GREEN		
60	Pack and label box	700	0	700	100.00%	11:00 AM	12:00 PM	1	700	67%	GREEN		
					<b>OVERALL LINE FTC %</b>	<b>92.67%</b>						<b>OVERALL LINE CAPACITY %</b>	<b>117%</b>

SECTION 6 - DOWNTIME/NON-CONFORMANCE ANALYSIS					
OP #	Description	Downtime	Reject Qty	DOWNTIME REASON	REJECT REASON
10	Stamp Bracket in Press	15.0	25	Straightner on press not functioning properly	Bad parts due to too much camber in coil
20	Vibratory Debur		45		burrs
30	Weld strap to bracket	20 min.	34	Problem with current of 25 KVA welder	Incomplete welds

SECTION 7 - CHECKLIST ITEMS			
ITEM	YES	NO	COMMENTS
Product - Has AIAG APQP A-2 been verified and acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	Current design level is AB. Team Feasibility is approved without issues
Process Plan - have A-3, 5, 6 & 7 been verified and acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	one custom gauge owned by Ford to measure stud location. Stamping tool and gauge marked as "Property of Ford Motor Co."
Process Implementation - has A-4 been verified and acceptable?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Operator training complete on 1st shift only. Second shift to be complete by 6/20/06
Are the correct number of operators being used per quote?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	3.5 operators quoted in RFQ and verified
Control Plan - has A-8 been verified as complete and acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Is mistake proofing acceptable (including zebra parts)?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
- zebra part listing including back-ups			
- mistake proofing for changeovers if applicable			
- mistake-proof of non-automated operations to prevent manual mistakes			mistake proofing in place but back-up zebra parts not available. Back-up parts to be created and logged in system by 4/24/06
Are both the calculated and actual capacity <100%?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	No, new welder is being installed to double capacity for welding operation - ready on 8/5/06
Are all FTC %s > 70%? And Overall Line FTC acceptable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Is SPC in place per control plan and visual near production?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	SPC charts are kept in QC area - need to bring out to work cells
Has the ramp plan been discussed and verified?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Have all open MMCARs and SECRs been reviewed?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	SL12020069999 corrective action verified, no SECRs
Has sub-supplier Run-at-Rate been completed and approved?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	R@R completed at stud supplier 4/14/06. Results acceptable and on file.
Have provisions been made to address shelf-life if applicable?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	does not apply
Have long lead-time components been ordered to support SOP?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Is packaging in place per the approved Packaging Declaration?	<input checked="" type="checkbox"/>	<input type="checkbox"/>	
Has a contingency plan been developed?	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Evaluating running die on alternate presses for contingency plan

SECTION 8 - SIGNATURES		
Supplier Sign-Off	Stackpole International Sign-Off	Date
<input type="text" value="Joe Smith"/>	<input type="text" value="Mary Jane"/>	<input type="text" value="20-Apr-12"/>



WORKSHEET TO DETERMINE ALLOCATION %			Use this form if the machine or work cell requires significant changeover time between products					
AVAILABLE HOURS PER YEAR		Hours/yr available	Operation Description		Enter Operation Description Here			
AVAILABLE HOURS PER MONTH		#VALUE!						
Part Loading on Machine	Annual Volume Requirement	Monthly Volume Requirement	No. of Runs per Month	Set-Up Time (Hours)	Run Rate (Units/Hr)	Machine Utilization		
						Hrs/Month	% Allocation	
SI Part being studied								
Other part on this machine								
Other part on this machine								
						Required Time (Hrs)	0.00	#VALUE!
						Available Time (Hrs)	#VALUE!	100%
						Available Capacity (Hrs)	#VALUE!	#VALUE!
Note: Do not include setup time in fixed loss summary on R@R form if setup time is used in this worksheet						<b>Total % Allocation for Stackpole Int'l</b>		
						<b>Total % Allocation for SI and Open</b>		#VALUE!





WORKSHEET TO DETERMINE ALLOCATION %			Use this form if the machine or work cell requires significant changeover time between products					
AVAILABLE HOURS PER YEAR		6,720	Operation Description		250T Injection Molding #12			
AVAILABLE HOURS PER MONTH		560						
Part Loading on Machine	Annual Volume Requirement	Monthly Volume Requirement	No. of Runs per Month	Set-Up Time (Hours)	Run Rate (Units/Hr)	Machine Utilization		
						Hrs/Month	% Allocation	
Stackpole Int'l Brackets	200,000	16,667	4	0.5	60	279.78	50.0%	
Customer A Part	50,000	4,167	2	0.5	55	76.76	13.7%	
Customer B Part	40,000	3,333	2	0.8	45	75.67	13.5%	
Note: Do not include setup time in fixed loss summary on R@R form if setup time is used in this worksheet						Required Time (Hrs)	432.21	77.2%
						Available Time (Hrs)	560.00	100%
						Available Capacity (Hrs)	127.79	22.8%
						<b>Total % Allocation for Stackpole Int'l</b>		<b>50.0%</b>
<b>Total % Allocation for SI and Open</b>		<b>72.8%</b>						







Instructions: record time observations for 12 cycles. The formula in column P will automatically take out the min and max value and average the remaining values.

Cycle Time Observations for Supplier Run at Rate														
TIME IN SECONDS														
OP #	OPERATION DESCRIPTION	Time 1	Time 2	Time 3	Time 4	Time 5	Time 6	Time 7	Time 8	Time 9	Time 10	Time 11	Time 12	Average
10		12.00	10.00	5.00	13.00	14.00	12.00	19.00	13.00	15.00	10.00	12.00	11.00	12.20
														0.00
														0.00
20														0.00
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30														0.00
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70														0.00
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80														0.00
														0.00
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90														0.00
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														0.00
100														0.00
														0.00
														0.00
Comments:														