

ArcWorks Job Ticket				Ticket Prep By	JR	Technical Review By & Date	
				Date	9/7/10		RS 9/21/06
CUSTOMER:	Nalge Nunc International	ESTIMATE #:	4088	Production Supervisor Assigned			
DESCRIPTION:	Closure Tube Assy 53mm Natural	REV.	C	Start Date			
PART NO.:	1-1208-51	JOB NO.:	51-0602	1st Pc Approval			
ORDER QTY.:	2037	LOT NO.:	7129329-060	Closed Date			
Order Unit of Measure	each						
DUE DATE:	9/17/10	P.O. NO.:	7129329				

OPER.		U/M	Rate/Hr	Rate Per 100 Assy	Additional Comments and Notes
1	Tubing 1-1206-91; .161 ID x .25 OD - cut tubing to length of 5.68 +/- 0.020" per drawing B-1207-XX Rev. 2	assemblies	1000	0.7940	Distribution: Release JT to Production Supervisor; Release Ship Info to Expeditor; Controlled Copies to QC Inspector START UP SAMPLES REQUIRED: 25 Tubes - verify length is 5.68 +/- .020 @ Set-Up Accept / Reject _____ (initial & date) 25 CLOSURES PEGGED @ S/U: ACCEPT / REJECT _____ (initial & date) 25 CLOSURES COMPLETE ASSY @ S/U: ACCEPT / REJECT _____ (initial & date) NOTE: 25 start up samples required for each lot of closures and/or tubes provided NOTE: Use fixture to spot check closure bend angle prior to assembly Identify rejected/damaged material by component # Report component # & qty on Material Request Form - identify as "scrap" Submit form to QC Inventory / Surplus Material Requirements Return surplus material to warehouse - surplus material must be identified by component # and quantity Equipment & Tools List
2	Using fixture assemble closure and adaptor per drawing C-1-1-1208-XX Rev 7	assemblies	415	1.9133	
3	Place tube onto rod of spinwelder and closure assembly into horn; press start button	assemblies	250	3.1760	
4	Form and tape seal wip carton & insert liner	assemblies	15000	0.0530	
5	Bulk pack 500 assemblies; fold & tuck liner bag	assemblies	1500	0.5294	
6	Fold & tuck wip carton flaps- apply transfer wip label & i.d. #	assemblies	15000	0.0530	

Component No.	Description	Units per U/M	Total Qty Required for order
	Refer to NNI BOM 1st and compare to		0.0000
	Great Plains Pick List		0.0000
	Report errors to Great Plains support staff and Materials Manager immediately		0.0000
			0.0000
			0.0000
			0.0000
			0.0000

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	and Materials Manager immediately		0.0000
			0.0000
			0.0000
			0.0000
			0.0000