RUN@RATE PROCESS AUDIT

FRAM FILTRATION

Auditor Name:	Supplier:
Audit Date:	Plant location:
Component name/ part #:	PO Number:
Drawing revision: Rev Level:	Customer / Application:

Process audited:

Findings are determined by an automatic formula:

if results are >90% = Passed Run@Rate
if results are>70% and <90% = Interim Approval for Run@Rate
if results are <70% = Failed Run@Rate requirements

Process Audit Findings

Positive Points	**Negative Points**

Summary of the Run@Rate capacity audit

Max customer demand (/day)

Status   PASS

Purchased capacity (/day)

Demonstrated capacity (/day)   #####

Full approval

Interim   Interim recovery worksheet prepared and agreed with the supplier (Y/N)   Y/N

Rejected

FRAM Filtration Representative Name / Signature

Supplier Representative Name / Signature

The Run@Rate can be determined by either conducting the study on individual processes (workcells) and then determing the bottleneck, or if manufacturing is a continuous flow then the study is to be performed on the end product

Process Operations

	Process Name	OP Number	Cycle time (no. of parts / time observed)
Process Operation 1 name			
Process Operation 2 name			
Process Operation 3 name			
Process Operation 4 name			
Process Operation 5 name			
Process Operation 6 name			
Process Operation 7 name			
Process Operation 8 name			

RUN @ RATE CALCULATION WORKSHEET

FRAM FILTRATION

Type of Run @ Rate:	FRAM Filtration Monitored		FRAM Filtration Part Number:	
	Supplier Monitored			
Supplier Name:			Part Number Rev. Level:	
Supplier Code:			Part Name:	
Supplier Contact Name:			Program:	
Manufacturing Address:				

Supplier Data			**FRAM Filtration Data**	
A.	PURCHASED CAPACITY (PC) (quantity / week):		MAX CUSTOMER DEMAND (MCD) [quantity / week]:	
B.	Production Days [days / week]:		Workdays of FRAM Filtration plant [days / week]:	
C.	Purchased Daily Capacity [quantity / day]:		Daily volume [quantity / day]:	

please fill in all bordered blank cells to enable formulas

Planned Machine Loading:		**Supplier Tooling Information:** (quantity, description, etc.)
D.	Gross Hrs./Day(total shift time) [hrs / day]	
E.	Planned Machine Loading For FRAM Filtration [%]:	
F.	Planned Machine Loading For This Part [%]:	
G.	Gross Hrs./Day allocated for this part [hrs / day]	0.0

	Supplier Planning Data. Used for preliminary runs and adjustments.		Data from the actual Run@Rate. Used to determine the status of the Run@Rate.		Comments:
Run @ Rate Results:	**Planned** (by the supplier)		**Actual**		Action plan for capacity presented
Date of Run@Rate:					
G. Duration of Run@Rate [hrs]:					

H. Downtime during Run@Rate period	minutes	hours	minutes	hours
1. breaks / shift change over		0.00		0.00
2. lunch		0.00		0.00
3. maintenance		0.00		0.00
4. part # changeover / setup time		0.00		0.00
5. unplanned		0.00		0.00
6. Total [1 through 5]	0	0.00	0	0.00
7. % Downtime {=(H6 /G)} [%]	#DIV/0!		#DIV/0!	
I. Net Productive Time {=(F*(1-H7) [hrs]	#DIV/0!		#DIV/0!	

J. Part Quantities Produced during the Run@Rate		
1. Total Parts [# of]		
2. Rejected [# of]		
3. Net Good {=J1-J2} [# of]	0	0
4. Net Parts / Hr {=J3 / G} [# / hr]	#DIV/0!	#DIV/0!

Production line / Tool Capacity / Schedule	R@R Planning Data. Not for determining final status.	ACTUAL DC	PC	MCD
K. Demonstrated Daily Capacity [quantity / day]	#DIV/0!	#DIV/0!		
L. Demonstrated Weekly Capacity [quantity / week]	#DIV/0!	#DIV/0!	0	0

RUN @ RATE SUMMARY Result		Capacity	Quality	Final Status
ACTUAL DC > PC and ACTUAL DC > MCD	PASS	#DIV/0!		
ACTUAL DC < PC but ACTUAL DC > MCD	OPEN (Failed QTC)	#DIV/0!		
ACTUAL DC > PC but ACTUAL DC < MCD	OPEN (Failed MSV)	#DIV/0!		
ACTUAL DC < PC and ACTUAL DC < MCD	FAIL	#DIV/0!		

Rerun Date (if required):	

REVISION History Log

Rev	Description	Author
-	Initial Release	JP

Date
9/7/2012