

FIGURE 9S.3: Route Sheet for a Bracket

MATERIAL SPECS:____		PART NAME: BRACKET	PART #: BR 1320	
STOCK SIZE: ____		USAGE: BRACKET ASSEMBLY	DATE ISSUED: 11/5/12	
# OF PIECES/STOCK ____		ASSEMBLY #: BR 1324	DATE SUPPLIED: 11/6/12	
WEIGHT: ____		SUBASSEMBLY #:	ISSUED BY: RRV	

Operation Sequence	Operation Description	Department and Machines	Setup Time	Processing Time/Unit
1	Shear to length	Shear: Machine # 2	10 minutes	.025
2	Shear 45° corners	Shear: Machine # 2	6 minutes	.020
3	Drill holes	Drill: Drill press	20 minutes	3.5
4	Bend 90°	Brake: Brake press	9 minutes	.025