



Machine	Doosan Mynx 5400/50	
Horse Power	30	
Taper	Cat 50	
Material	10V12	
	Current	Tested Product

1. Cutting Costs

Cutter / Insert Designation:	335.19 12ST-MD09 MP2500	LMNU1000508-B57T WKP35S
Price Per Insert:	\$16.65	\$19.37
Number of Inserts Per Tool:	12	12
Cutting Edges Per Insert:	4	4
Cost Per Cutting Edge:	\$4.16	\$4.84
Number of Parts Per Index:	2	18
Insert Cost Per Piece	\$24.975	\$3.228
Annual Production - Pieces	100	100
Insert Cost Per Year:	\$2,497.50	\$322.83
Insert Cost Savings / Annual:		\$2,174.67

2. Machine Costs

Hourly Rate - Machine:	\$86.00	\$86.00
Current Supplier:		Creston
Tool Diameter - Decimal:	5.00	5.00
Number of Teeth - Pockets:	6	6
Surface Feet Per Minute:	371	401
RPM:	283	306
Chip Load - Per Tooth-Pocket / Revolution:	.0073	.02
Feed Rate:	12.40	36.72
Cutting Length:	26.00	26.00
Number of Passes - Components:	5	5
Total Cutting Time (Minuntes):	10.49	3.54
Machining Cost / Component:	\$15.03	\$5.07
Annual Production / Pieces:	100	100
Machining Cost / Annual:	\$1,503.25	\$507.44
Machining Cost Savings / Annual:		\$995.80

Current	Tested Product
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3. Tool Changing Costs

Tool Changing Time (Minutes):	5	5
Cost Per Tool Change:	\$7.17	\$7.17
Tool Changes - Annual:	50	6
Tool Changing Cost / Annual:	\$358.33	\$39.81
Tool Changing Cost Savings / Annual:		\$318.52

4. Tool Presetting Costs

Hourly Rate - Presetter:	\$0.00	\$0.00
Total Tool Presetting Time (Minutes):	0	0
Tool Presetting Cost:	\$0.00	\$0.00
Tool Presettings / Annual:	50	6
Costs Annual:	\$0.00	\$0.00
Tool Presetting Cost Savings / Annual:		\$0.00

5. Additional Free Machine Capacity

Tool Changes / Annual:	50	6
Machining Time /Annual (Minutes)	1049	354
Tool Changing Time / Annual (Minutes):	250	28
Machine Capacity (Minutes): (168 Hrs Wk.)	1299	382
Machine Time Gained / Min - Annual		\$ 1,314.32

Cost Comparison Total

	Current	Tested Product	Savings
1	\$2,497.50	\$322.83	\$2,174.67
2	\$1,503.25	\$507.44	\$995.80
3	\$358.33	\$39.81	\$318.52
4	\$0.00	\$0.00	\$0.00
SUM	\$4,359.08	\$870.09	\$3,488.99