



Machine	Haas VF-3	
Horse Power		
Taper	Cat 40	
Material		
	Current	Tested Product

1. Cutting Costs

Cutter / Insert Designation:	XXXX	RA216 13M19-038
Price Per Insert:	\$150.00	\$20.00
Number of Inserts Per Tool:	1	2
Cutting Edges Per Insert:	1	2
Cost Per Cutting Edge:	\$150.00	\$10.00
Number of Parts Per Index:	60	500
Insert Cost Per Piece	\$2.500	\$0.040
Annual Production - Pieces	3,600	3,600
Insert Cost Per Year:	\$9,000.00	\$144.00
Insert Cost Savings / Annual:		\$8,856.00

2. Machine Costs

Hourly Rate - Machine:	\$60.00	\$60.00
Current Supplier:		Creston
Tool Diameter - Decimal:	0.38	0.50
Number of Teeth - Pockets:	2	2
Surface Feet Per Minute:	786	852
RPM:	8000	6500
Chip Load - Per Tooth-Pocket / Revolution:	.00156	.0028
Feed Rate:	24.96	36.40
Cutting Length:	43.50	43.50
Number of Passes - Components:	12	12
Total Cutting Time (Minuntes):	20.91	14.34
Machining Cost / Component:	\$20.91	\$14.34
Annual Production / Pieces:	3,600	3,600
Machining Cost / Annual:	\$75,288.46	\$51,626.37
Machining Cost Savings / Annual:		\$23,662.09

Current	Tested Product
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3. Tool Changing Costs

Tool Changing Time (Minutes):	3	5
Cost Per Tool Change:	\$3.00	\$5.00
Tool Changes - Annual:	60	7
Tool Changing Cost / Annual:	\$180.00	\$36.00
Tool Changing Cost Savings / Annual:		\$144.00

4. Tool Presetting Costs

Hourly Rate - Presetter:	\$60.00	\$60.00
Total Tool Presetting Time (Minutes):	0	0
Tool Presetting Cost:	\$0.00	\$0.00
Tool Presettings / Annual:	60	7
Costs Annual:	\$0.00	\$0.00
Tool Presetting Cost Savings / Annual:		\$0.00

5. Additional Free Machine Capacity

Tool Changes / Annual:	60	7
Machining Time /Annual (Minutes)	75288	51626
Tool Changing Time / Annual (Minutes):	180	36
Machine Capacity (Minutes): (168 Hrs Wk.)	75468	51662
Machine Time Gained / Min - Annual		\$ 23,806.09

Cost Comparison Total

	Current	Tested Product	Savings
1	\$9,000.00	\$144.00	\$8,856.00
2	\$75,288.46	\$51,626.37	\$23,662.09
3	\$180.00	\$36.00	\$144.00
4	\$0.00	\$0.00	\$0.00
SUM	\$84,468.46	\$51,806.37	\$32,662.09