



Machine	Fadal	
Horse Power	20	
Taper	Cat 40	
Material		
	Current	Tested Product

1. Cutting Costs

Cutter / Insert Designation:	XXXX	RA390210-102R38-14M
Price Per Insert:	\$15.00	\$15.00
Number of Inserts Per Tool:	6	6
Cutting Edges Per Insert:	3	4
Cost Per Cutting Edge:	\$5.00	\$3.75
Number of Parts Per Index:	45	45
Insert Cost Per Piece	\$0.667	\$0.500
Annual Production - Pieces	3,600	3,600
Insert Cost Per Year:	\$2,400.00	\$1,800.00
Insert Cost Savings / Annual:		\$600.00

2. Machine Costs

Hourly Rate - Machine:	\$80.00	\$80.00
Current Supplier:		Creston
Tool Diameter - Decimal:	3.00	3.00
Number of Teeth - Pockets:	4	6
Surface Feet Per Minute:	943	1100
RPM:	1200	1400
Chip Load - Per Tooth-Pocket / Revolution:	.0222	.0238
Feed Rate:	106.56	199.92
Cutting Length:	48.00	48.00
Number of Passes - Components:	14	13
Total Cutting Time (Minuntes):	6.31	3.12
Machining Cost / Component:	\$8.41	\$4.16
Annual Production / Pieces:	3,600	3,600
Machining Cost / Annual:	\$30,270.27	\$14,981.99
Machining Cost Savings / Annual:		\$15,288.28

Current	Tested Product
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3. Tool Changing Costs

Tool Changing Time (Minutes):	5	5
Cost Per Tool Change:	\$6.67	\$6.67
Tool Changes - Annual:	80	80
Tool Changing Cost / Annual:	\$533.33	\$533.33
Tool Changing Cost Savings / Annual:		\$0.00

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:	80	80
Costs Annual:	\$0.00	\$0.00
Tool Presetting Cost Savings / Annual:		\$0.00

5. Additional Free Machine Capacity

Tool Changes / Annual:	80	80
Machining Time /Annual (Minutes)	22703	11236
Tool Changing Time / Annual (Minutes):	400	400
Machine Capacity (Minutes): (168 Hrs Wk.)	23103	11636
Machine Time Gained / Min - Annual		\$ 15,288.28

Cost Comparison Total

	Current	Tested Product	Savings
1	\$2,400.00	\$1,800.00	\$600.00
2	\$30,270.27	\$14,981.99	\$15,288.28
3	\$533.33	\$533.33	\$0.00
4	\$0.00	\$0.00	\$0.00
SUM	\$33,203.60	\$17,315.33	\$15,888.28