Productivity Report

APEX PRITTING SLEEVS

Project	APEX PRITTING SLEEVS
Component	SHAFT
Test ID	ADMIN-194695329
Created by	Sahebrao Shinde
Date created	09-01-2019
Your reference	MR RAVI PAGARE
Distribution	MR Durgesh MR ANIL

Approved by

APEX PRITTING SLEEVS
MR RAVI PAGARE

Sandvik Coromant
Sahebrao Shinde

SANDVIK Coromant

Test data

Component - SHAFT

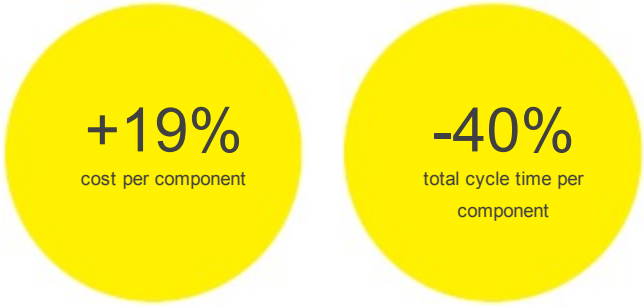
Component	SHAFT
CMC code	02.2
MC Code	
No. of components per set-up	1
no.of components (month)	500
No. of components per year	6000
Current situation	
Recommendation	

Machine - MAZZAK

Machine brand	MAZZAK
Machine ID	01
Machine cost per hour	Rs 1,000
Tool room cost per hour	Rs 0

Analysis per component

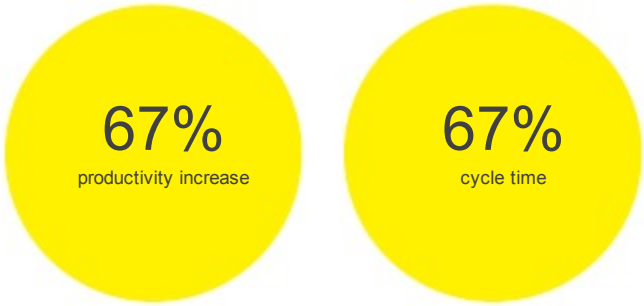
	Reference	Recommended
Machine cost	Rs 0.57 (+0.27)	Rs 0.31
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.08 (+0.03)	Rs 0.05
Insert cost	Rs 8.43 (-2.12)	Rs 10.56
Indexing/Replacement cost	Rs 0.25 (+0.06)	Rs 0.19
Tool room cost	Rs 0.00 (+0)	Rs 0.00
Scrap cost	Rs 0.00 (+0)	Rs 0.00
Rework cost	Rs 0.00 (+0)	Rs 0.00
Additional cost	Rs 0.00 (+0)	Rs 0.00
Total cost	Rs 9.34 (-1.76)	Rs 11.10
Total cycle time per set-up	0.05 (+0.02)	0.03



Productivity result

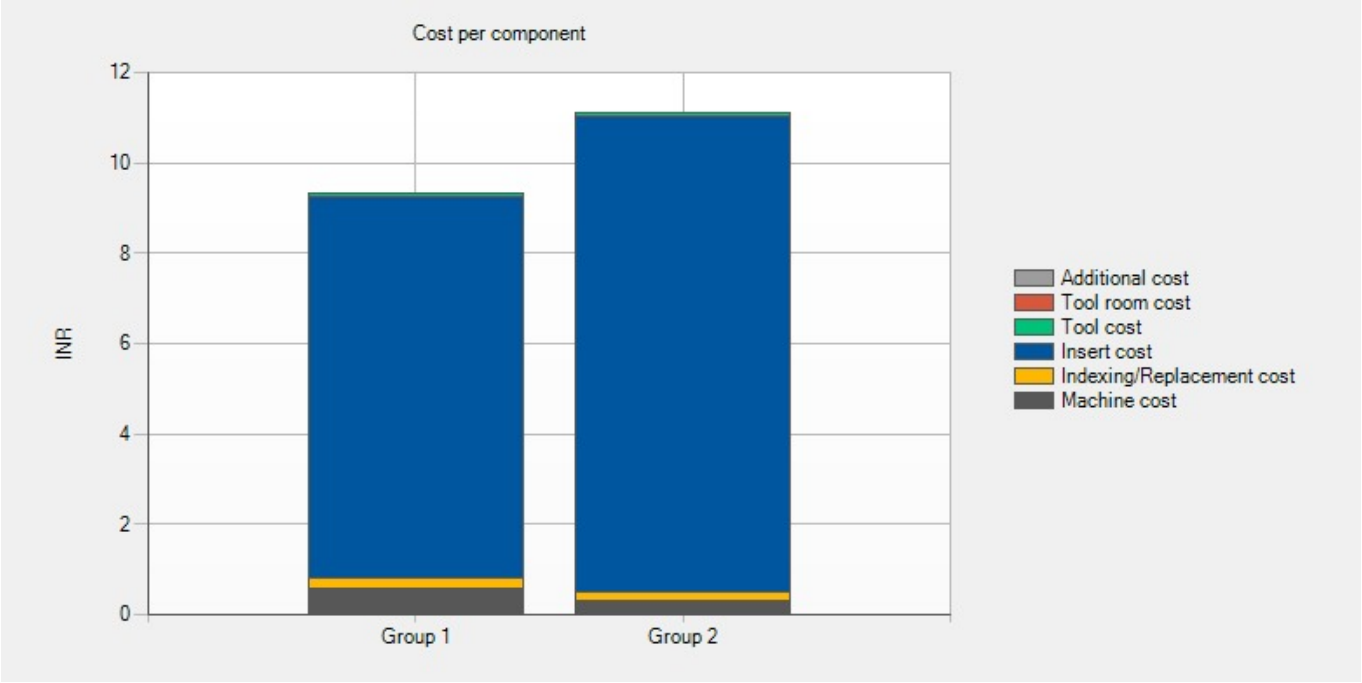
Recommendation

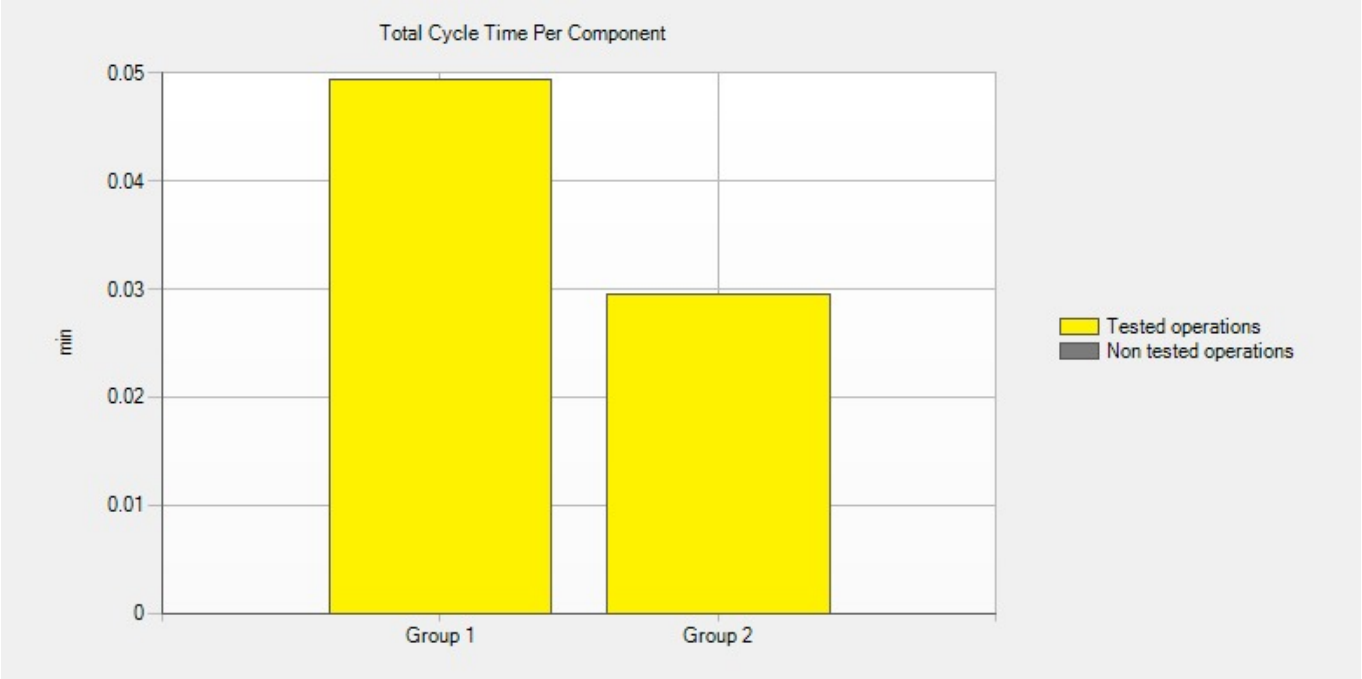
Productivity increase for recommended tools	67%
Productivity increase for total cycle time	67%
Savings in production time per year (h)	**2**
Savings per component	Rs -1.76
Savings per unit	Rs -880.24
Savings per year	**Rs -10,563**



Charts

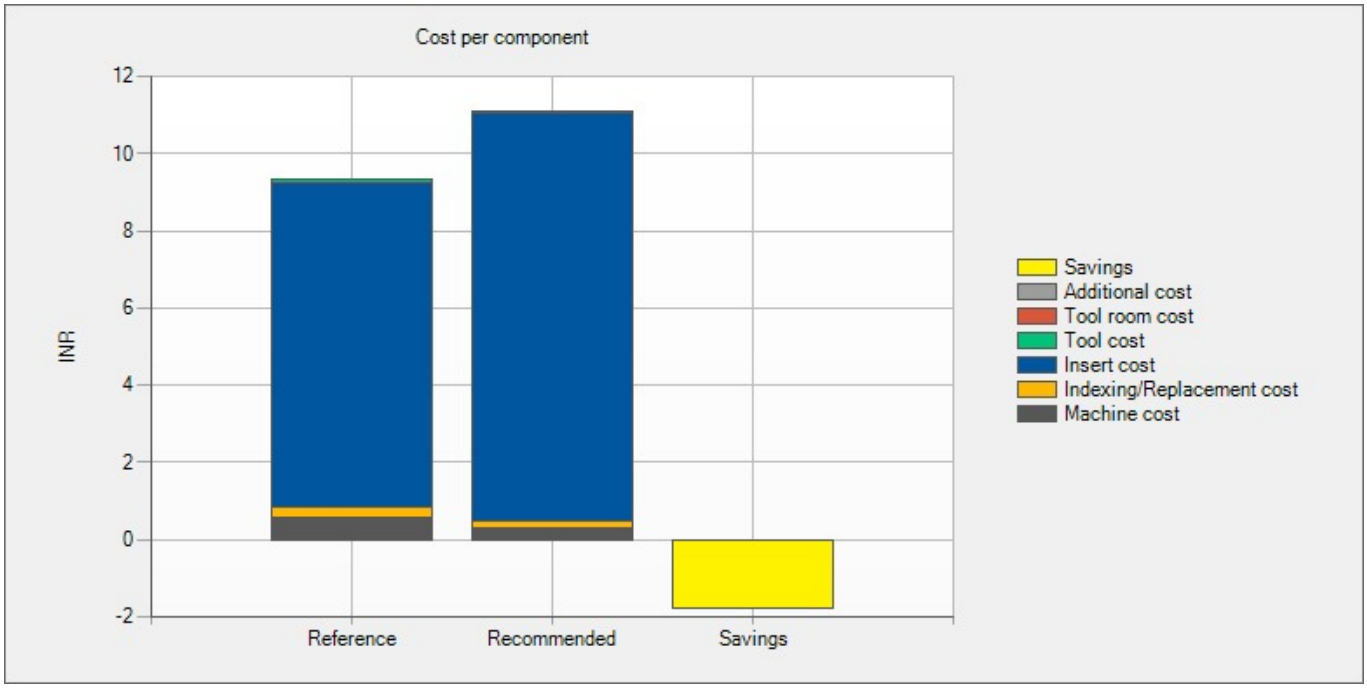
Group data

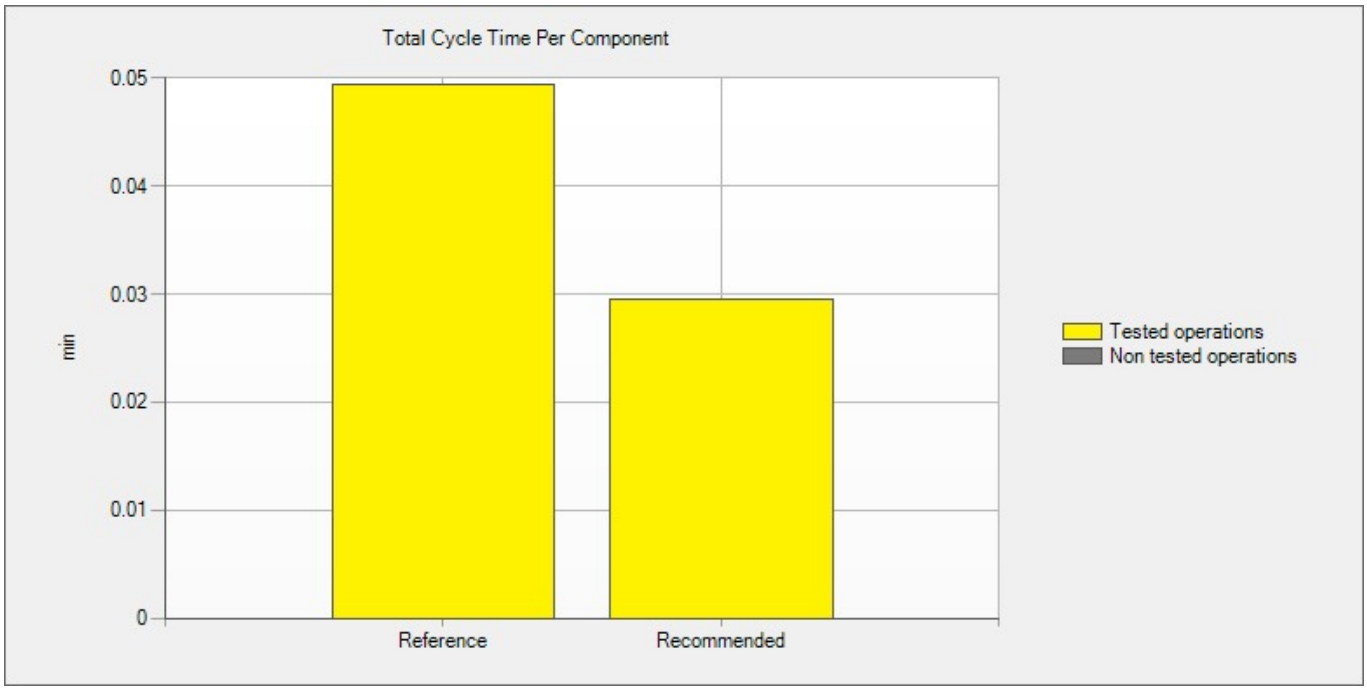




Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	GHFGR 2525	RF123 G07 2525
Cost	Rs 5,500.00	Rs 4,500.00
No. of insert indexes	1000	1000
Insert indexing time (min)	1	1
Insert		
Manufacturer	Iscar	Coromant
Code	GIP 3003Y	N123G2-0300-0003
Grade	908	GM 1125
No. of edges per insert	2	2
Cost per insert	Rs 1,130.00	Rs 1,900.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing
Spindle speed (n) (rev/min)	218	312
Diameter (Dm) (mm)	102	102

Sub-test

	Reference	Recommended
Cutting speed (vc) (m/min)	70	100
Radial feed (fn) (mm/rev)	0.08	0.1
Axial feed (fn) (mm/rev)	3	3
Cutting depth (ap) (mm)	2	2
Length of cut (mm)	6	6
No. of passes	4	3
Time in cut per component (min)	0.03	0.02
Block time per set-up (min)	0.03	0.02
Tool life (no.of components)	67	90
Tool life (minutes)	2.31	1.66
Tool life (meter)	1.51	1.56
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece