Productivity Report

APEX PRITTING

Project	APEX PRITTING SLEEVES
Component	SHAFT
Test ID	ADMIN-19469403
Created by	Sahebrao Shinde
Date created	10-01-2019
Your reference	MR RAVI Pagare
Distribution	MR Durgesh MR Anil

Approved by

APEX PRITTING
MR RAVI Pagare

Sandvik Coromant
Sahebrao Shinde

SANDVIK Coromant

Test data

Component - SHAFT

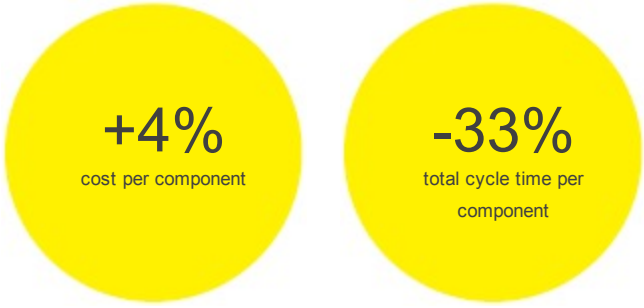
Component	SHAFT
CMC code	02.2
MC Code	
No. of components per set-up	1
no.of components (month)	300
No. of components per year	3600
Current situation	
Recommendation	

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

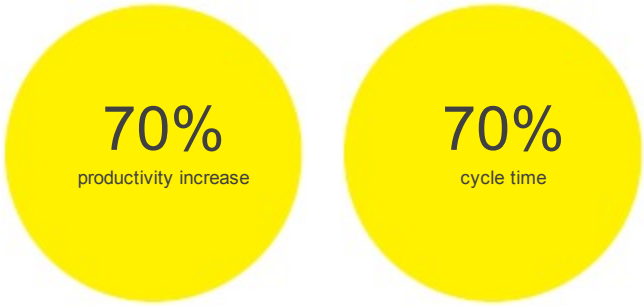
	Reference	Recommended
Machine cost	Rs 0.24 (+0.11)	Rs 0.12
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.09 (+0.02)	Rs 0.07
Insert cost	Rs 8.66 (-.59)	Rs 9.25
Indexing/Replacement cost	Rs 0.30 (+0.11)	Rs 0.19
Tool room cost	Rs 0.00 (+0)	Rs 0.00
Scrap cost	Rs 0.00 (+0)	Rs 0.00
Rework cost	Rs 0.00 (+0)	Rs 0.00
Additional cost	Rs 0.00 (+0)	Rs 0.00
Total cost	Rs 9.29 (-.35)	Rs 9.64
Total cycle time per set-up	0.03 (+0.01)	0.02



Productivity result

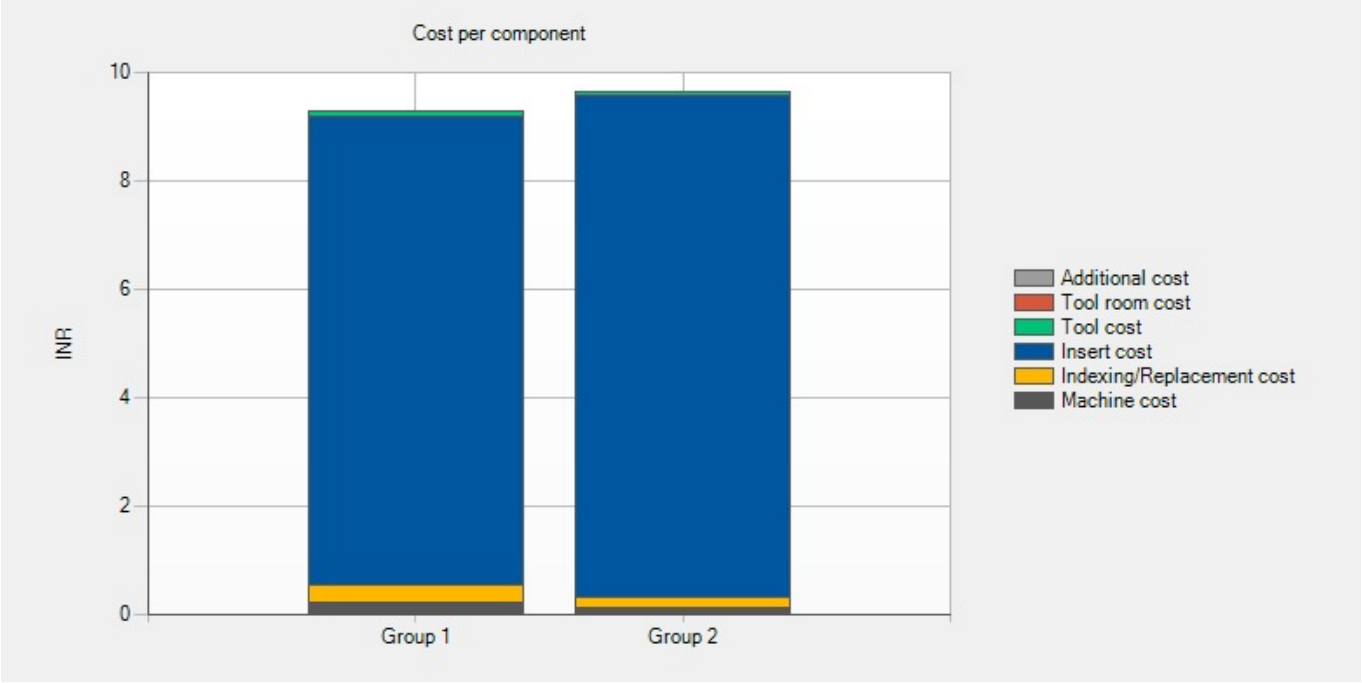
Recommendation

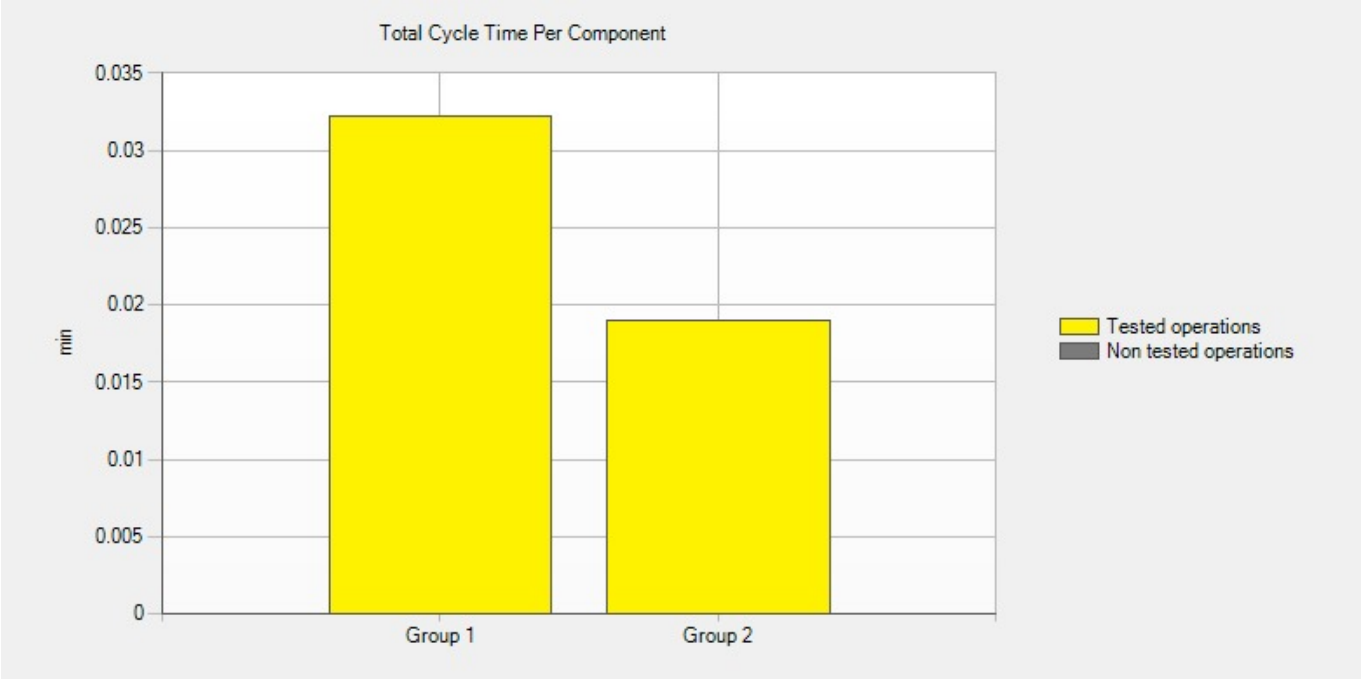
Productivity increase for recommended tools	70%
Productivity increase for total cycle time	70%
Savings in production time per year (h)	**1**
Savings per component	Rs -0.35
Savings per unit	Rs -105.62
Savings per year	**Rs -1,267**



Charts

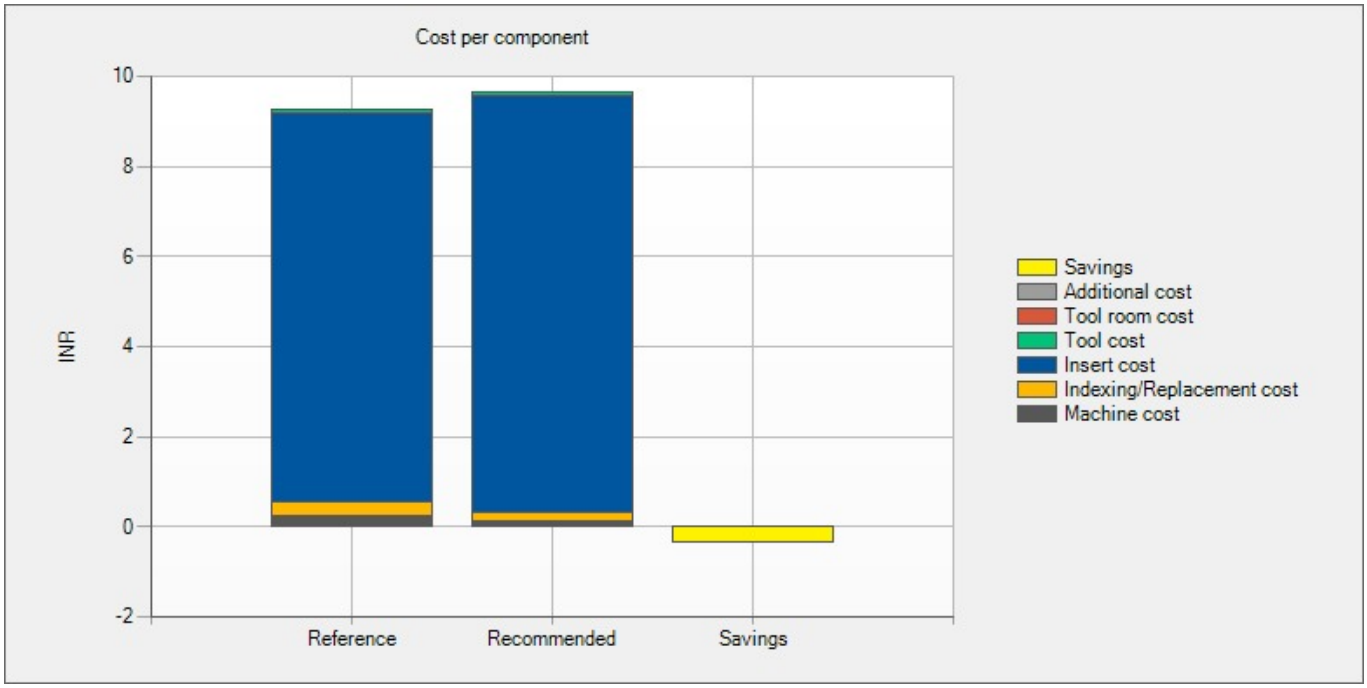
Group data

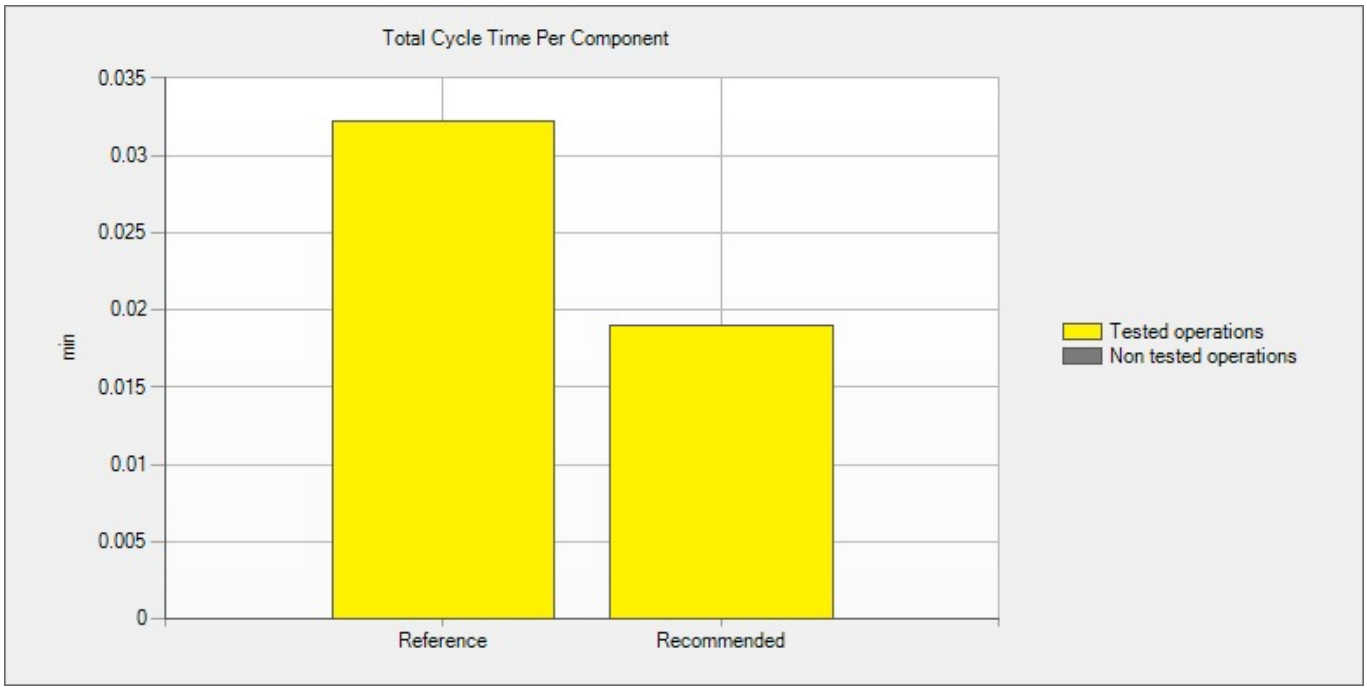




Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	SER 2525	LF123 E07 2525
Cost	Rs 5,000.00	Rs 6,100.00
No. of insert indexes	1000	1000
Insert indexing time (min)	1	1
Insert		
Manufacturer	Iscar	Coromant
Code	GRIP 4020Y	N123E2-0200-0002-GM
Grade	907	1125
No. of edges per insert	2	2
Cost per insert	Rs 970.00	Rs 1,610.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing
Spindle speed (n) (rev/min)	294	392
Diameter (Dm) (mm)	65	65

Sub-test

	Reference	Recommended
Cutting speed (vc) (m/min)	60	80
Radial feed (fn) (mm/rev)	0.1	0.1
Axial feed (fn) (mm/rev)	2	2
Cutting depth (ap) (mm)	2	1.5
Length of cut (mm)	3	3
No. of passes	3	2
Time in cut per component (min)	0.01	0.01
Block time per set-up (min)	0.01	0.01
Tool life (no.of components)	56	87
Tool life (minutes)	0.8	0.65
Tool life (meter)	0.47	0.51
Tool change criteria	(12) Workpiece out of tolerance	(11) Bad surface finish on workpiece