

# Productivity Report

## Bajaj Sons Ltd.

Project	Niddle Turning
Component	Niddle
Test ID	ADMIN-19798431
Created by	Vaikunth Panchal
Date created	20-03-2019
Your reference	

Approved by



## Component - Niddle

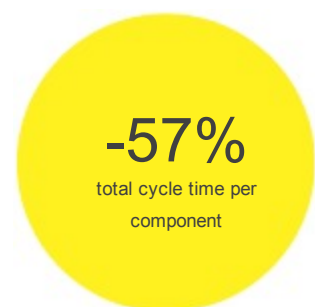
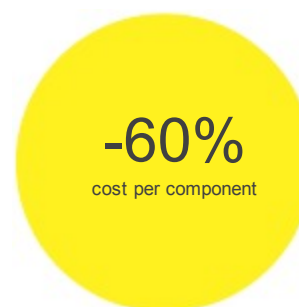
Component	Niddle
CMC code	
MC Code	
No. of components per set-up	1
no.of components ( )	50000
No. of components per year	600000
Current situation	
Recommendation	

## Machine - ACE MICROMATICS

Machine brand	ACE MICROMATICS
Machine ID	
Machine cost per hour	Rs 350
Tool room cost per hour	Rs 0

## Analysis per component

	Reference	Recommended
Machine cost	Rs 0.67 (+0.38)	Rs 0.29
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.18 (+0.08)	Rs 0.10
Insert cost	Rs 3.15 (+1.98)	Rs 1.17
Indexing/Replacement cost	Rs 0.13 (+0.06)	Rs 0.07
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
<b>Total cost</b>	<b>Rs 4.12 (+2.49)</b>	<b>Rs 1.63</b>
<b>Total cycle time per set-up</b>	<b>0.14 (+0.07)</b>	<b>0.06</b>



## Recommendation

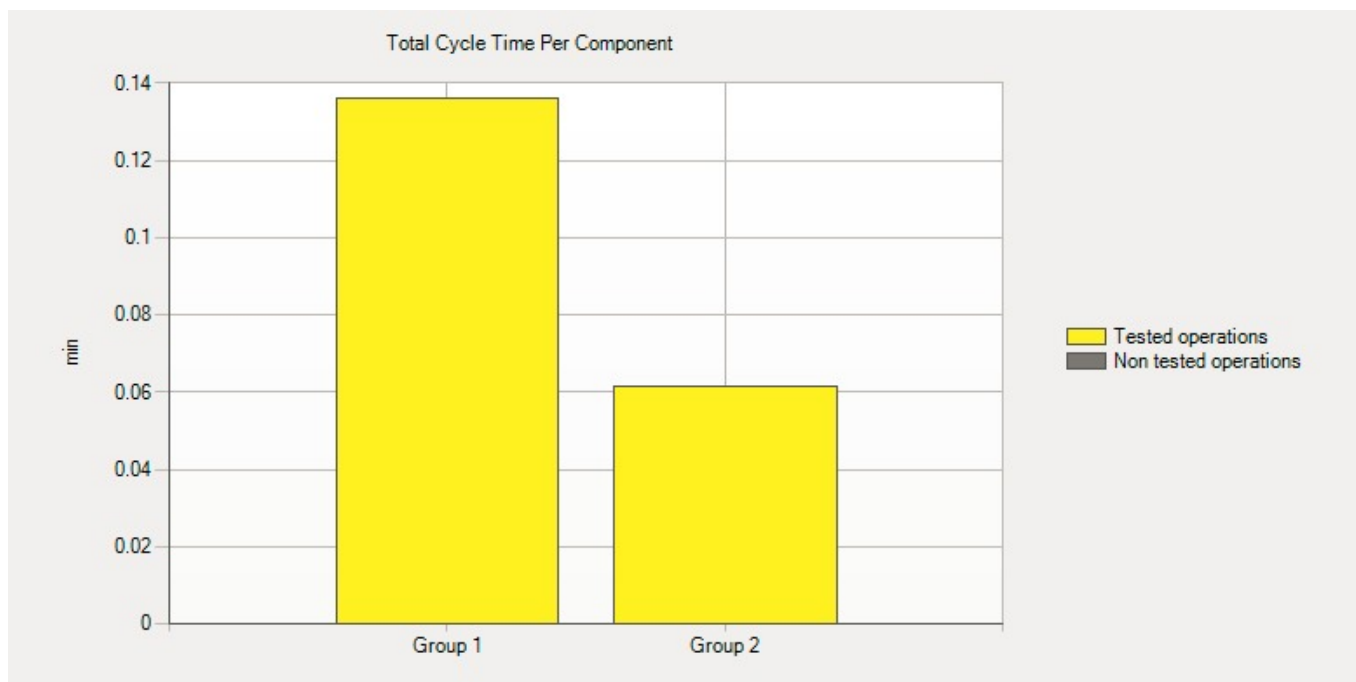
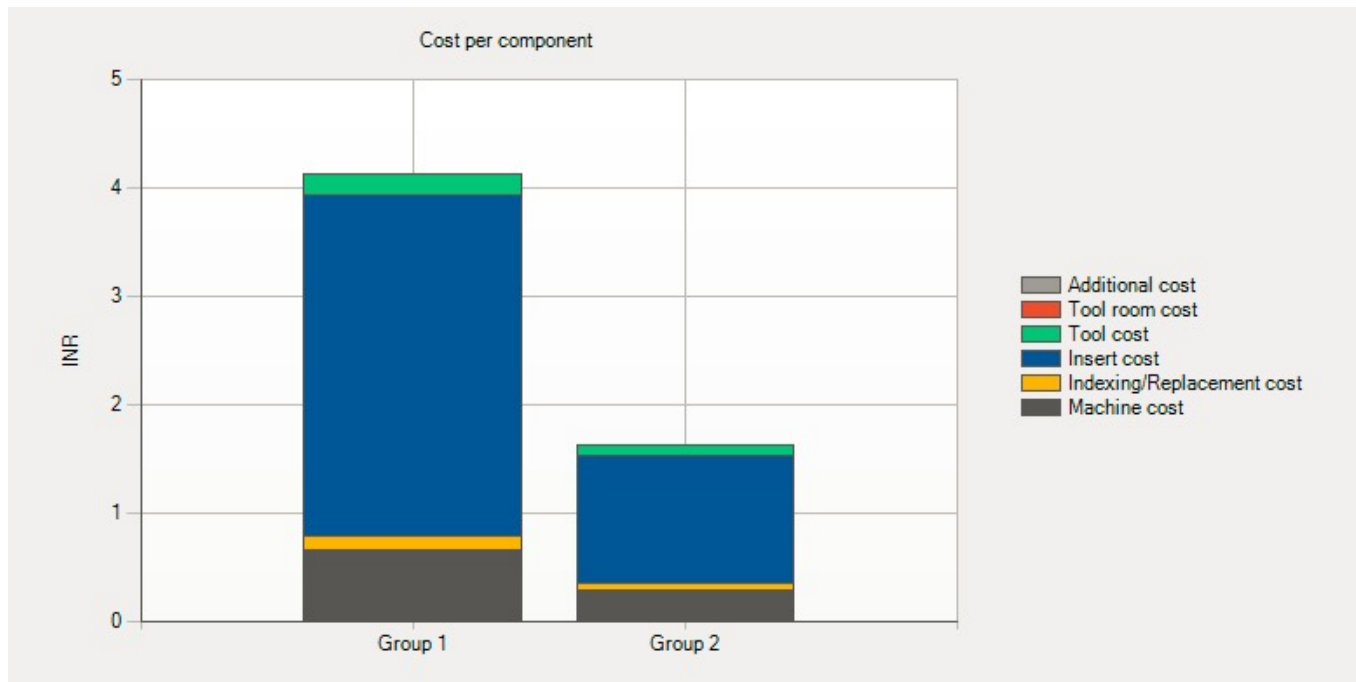
Productivity increase for recommended tools	122%
Productivity increase for total cycle time	122%
<b>Savings in production time per year (h)</b>	<b>749</b>
Savings per component	Rs 2.49
Savings per unit	Rs 1,24,647.88
<b>Savings per year</b>	<b>Rs 14,95,775</b>





# Charts

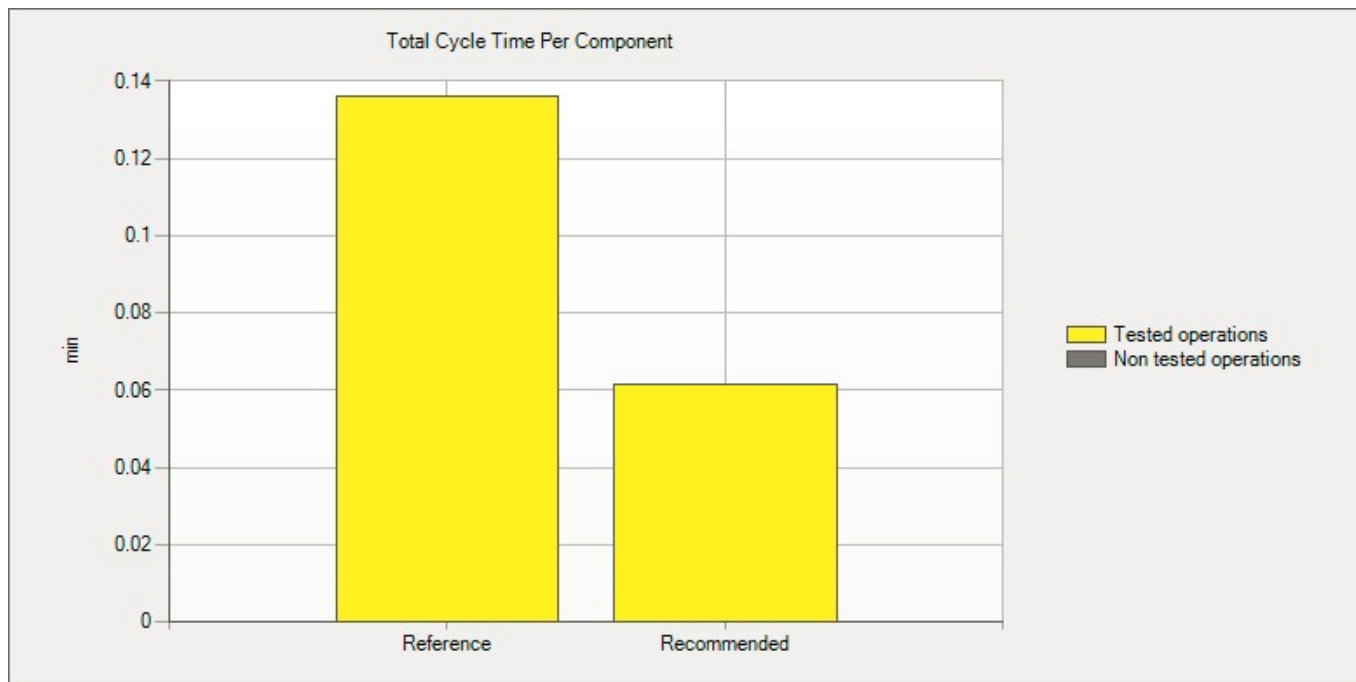
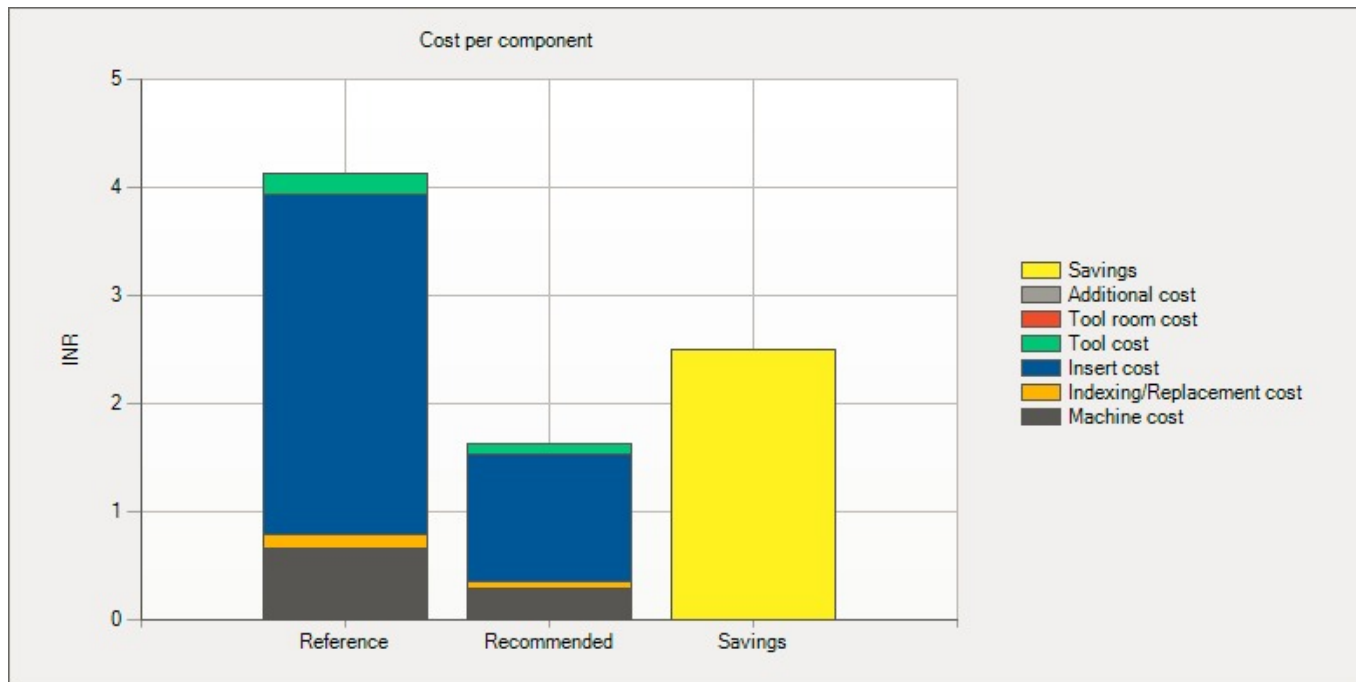
## Group data

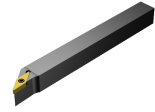




# Charts

## Recommendation





## Reference

## Recommended

Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Coromant	Coromant
Code	SVJBR 1212K 11-S-B1	SVJBR 1212K 11-S-B1
Code (customer denomination)	SVJBR 1212K 11-S-B1	SVJBR 1212K 11-S-B1
Cost	Rs 8,050.00	Rs 8,050.00
No. of insert indexes	200	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	Coromant	Coromant
Code	VCGT 11 03 02-UM 1115	VBMT 11 03 02-PF
Code (customer denomination)	VCGT 11 03 02-UM 1115	VBMT 11 03 02-PF
Grade	1115	4325
No. of edges per insert	2	2
Cost per insert	Rs 1,417.00	Rs 937.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	3000	4000
Diameter (Dm) (mm)	5.2	5.2
Cutting speed (vc) (m/min)	49	65
Feed (fn) (mm/rev)	0.06	0.07
Cutting depth (ap) (mm)	0.25	0.25
Length of cut (mm)	6	4
No. of passes	4	4
Time in cut per component (min)	0.11	0.05
Block time per set-up (min)	0.11	0.05
Tool life (no.of components)	225	400
Tool life (minutes)	25.67	19.56
Tool life (meter)	4.62	5.48
Tool change criteria	(31) Unacceptable vibrations	(25) Predetermined wear criterion