

Productivity Report

Microtech Tools

Project	Grooving
Component	Connection Water Transferer
Test ID	ADMIN-1917615055
Created by	Vaikunth Panchal
Date created	25-06-2019
Your reference	Mr.Niesh Kankaraje

Approved by



Component - Connection Water Transferer

Component	Connection Water Transferer
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	5000
No. of components per year	60000
Current situation	
Recommendation	

Machine - ACE MICROMATICS

Machine brand	ACE MICROMATICS
Machine ID	
Machine cost per hour	Rs 200
Tool room cost per hour	Rs 0



Analysis per component

	Reference	Recommended
Machine cost	Rs 0.62 (+0.19)	Rs 0.42
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.14 (+0.14)	Rs 0.00
Insert cost	Rs 2.29 (+1.6)	Rs 0.69
Indexing/Replacement cost	Rs 0.05 (+0.04)	Rs 0.01
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 3.09 (+1.97)	Rs 1.12
Total cycle time per set-up	0.20 (+0.06)	0.13

-64%

cost per component

-35%

total cycle time per
component



Productivity result

Recommendation

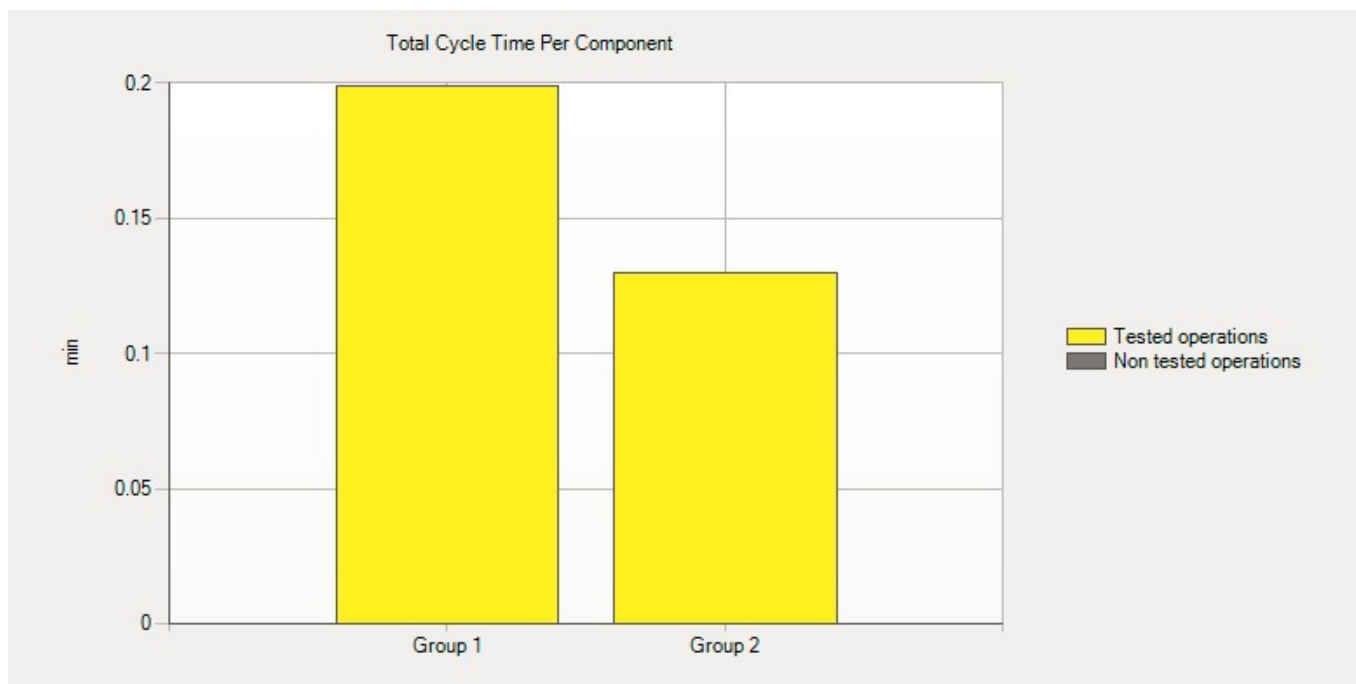
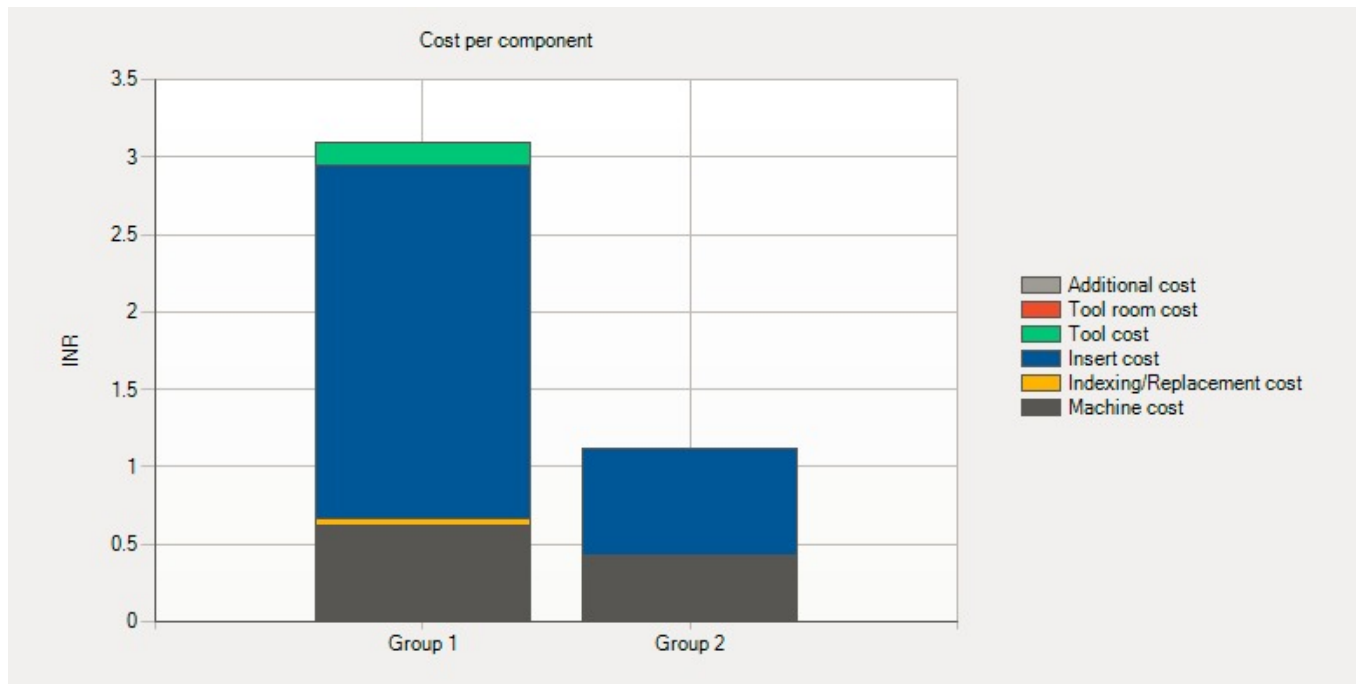
Productivity increase for recommended tools	53%
Productivity increase for total cycle time	53%
Savings in production time per year (h)	69
Savings per component	Rs 1.97
Savings per unit	Rs 9,866.11
Savings per year	Rs 1,18,393





Charts

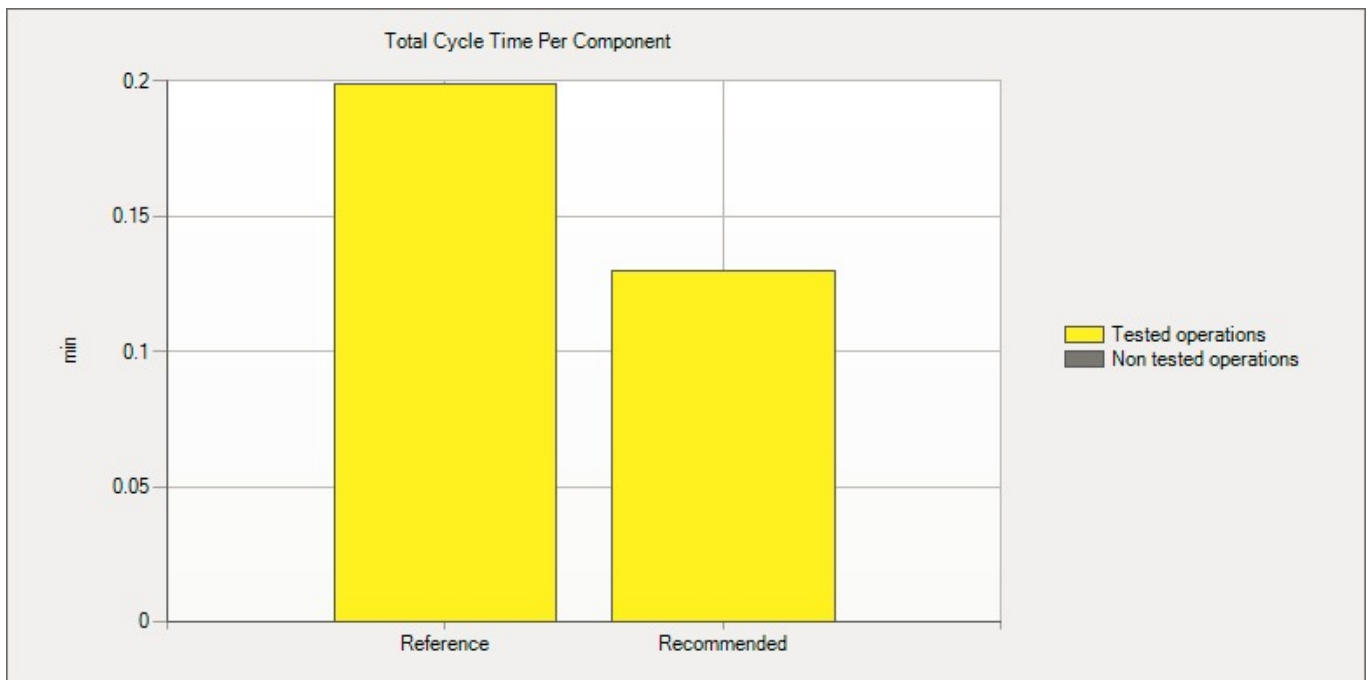
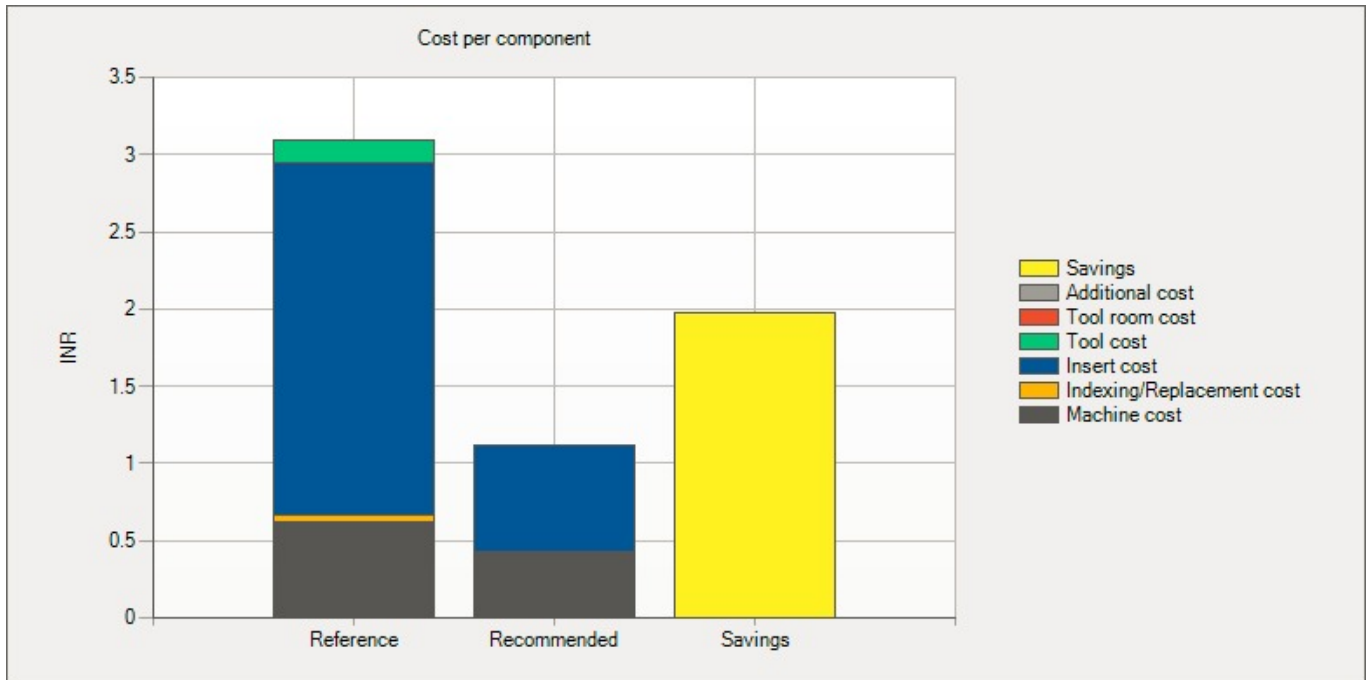
Group data

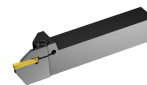




Charts

Recommendation





	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	GHDL 2525	RF123G10-2525B
Code (customer denomination)	GHDL 2525	RF123G10-2525B
Cost	Rs 10,000.00	Rs 0.00
No. of insert indexes	200	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	Incamet	Coromant
Code	GIP 3.0	N123G2-0300-0003-GM
Code (customer denomination)	GIP 3.0	N123G2-0300-0003-GM
Grade	IC 908	1125
No. of edges per insert	2	2
Cost per insert	Rs 1,600.00	Rs 2,057.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	600	700
Diameter (Dm) (mm)	27.38	27.38
Cutting speed (vc) (m/min)	52	60
Feed (fn) (mm/rev)	0.04	0.05
Cutting depth (ap) (mm)	0	0
Length of cut (mm)	2.22	2.22
No. of passes	2	2
Time in cut per component (min)	0.19	0.13
Block time per set-up (min)	0.19	0.13
Tool life (no.of components)	350	1500
Tool life (minutes)	64.75	190.29
Tool life (meter)	1.55	6.66
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece