

Productivity Report

ST INDUSTRIES

Project	Copper Turning
Component	Conductor
Test ID	ADMIN-192764549
Created by	Vaikunth Panchal
Date created	03-10-2019
Your reference	Mr.Shrikant

Approved by



Test data

Component - Conductor

Component	Conductor
CMC code	
MC Code	
No. of components per set-up	1
no.of components ()	250
No. of components per year	3000
Current situation	
Recommendation	

Machine - LMW

Machine brand	LMW
Machine ID	
Machine cost per hour	Rs 200
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 0.99 (+0.28)	Rs 0.71
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 4.50 (+2.7)	Rs 1.80
Insert cost	Rs 22.92 (+7.48)	Rs 15.43
Indexing/Replacement cost	Rs 1.39 (+0.83)	Rs 0.56
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 29.79 (+11.3)	Rs 18.50
Total cycle time per set-up	0.71 (+0.08)	0.38

-38%

cost per component

-46%

total cycle time per
component

Recommendation

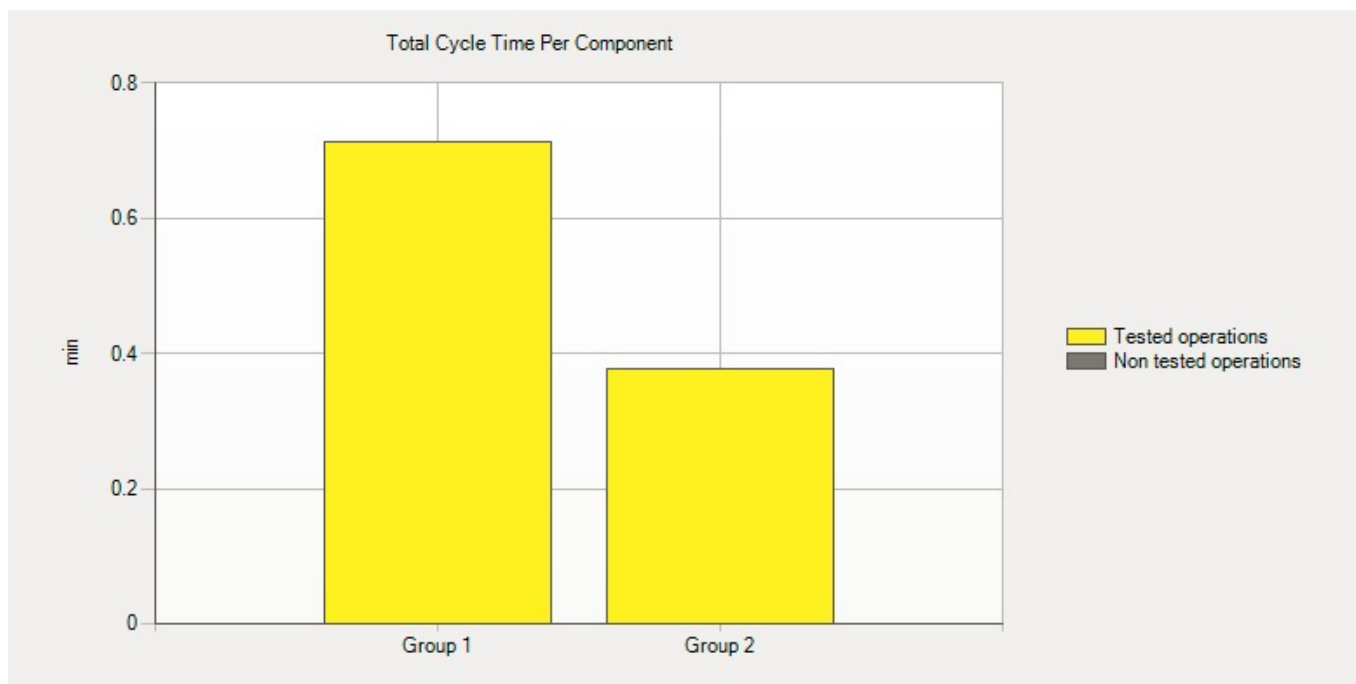
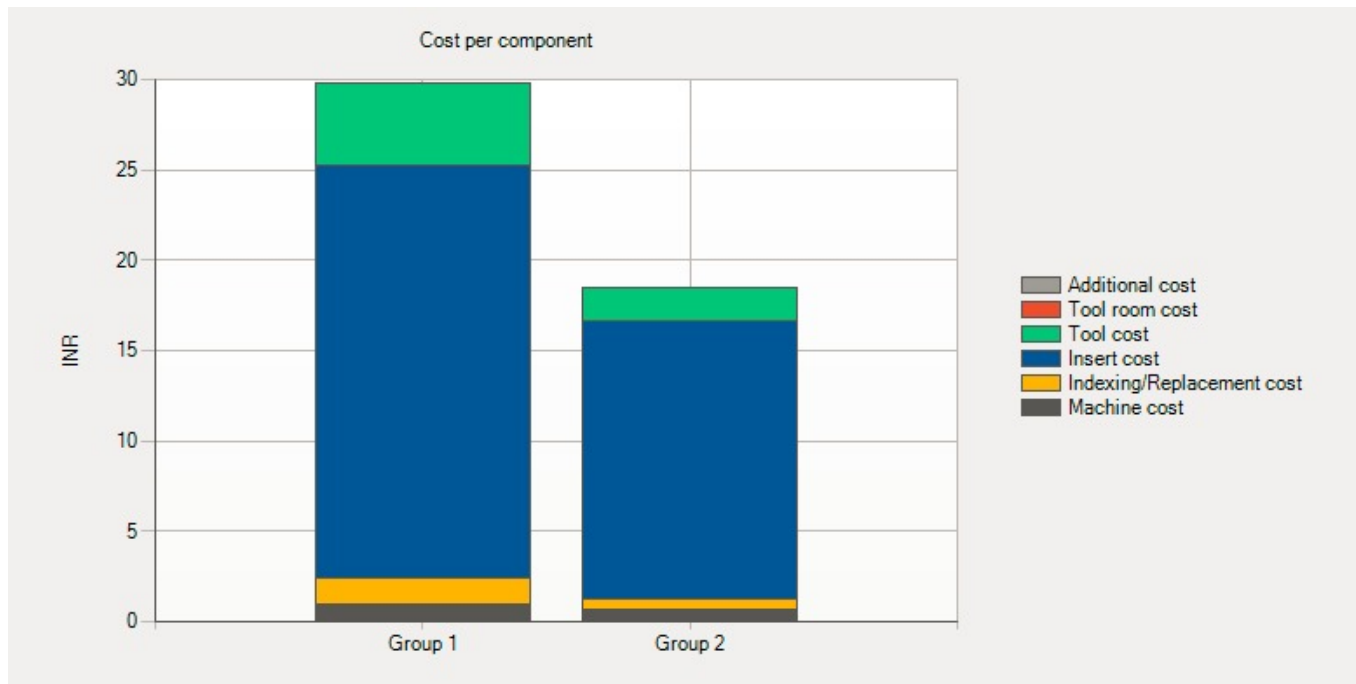
Productivity increase for recommended tools	88%
Productivity increase for total cycle time	88%
Savings in production time per year (h)	17
Savings per component	Rs 11.30
Savings per unit	Rs 2,824.81
Savings per year	Rs 33,898





Charts

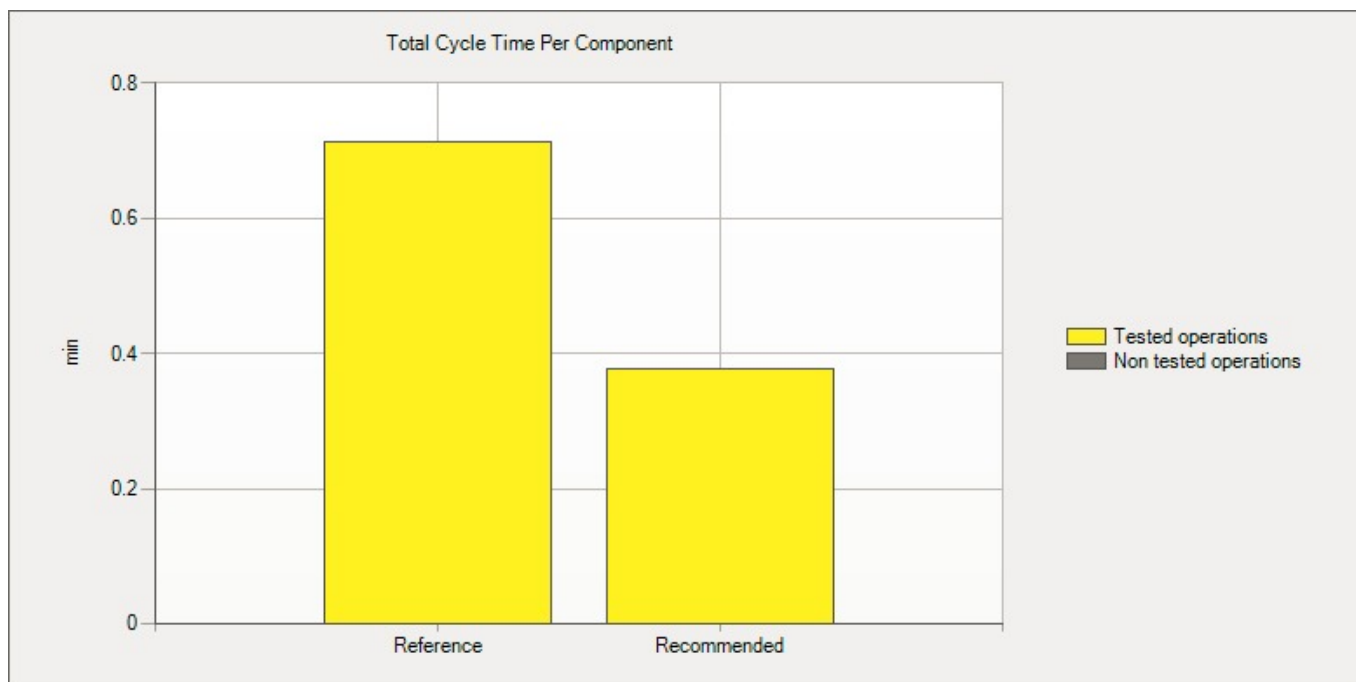
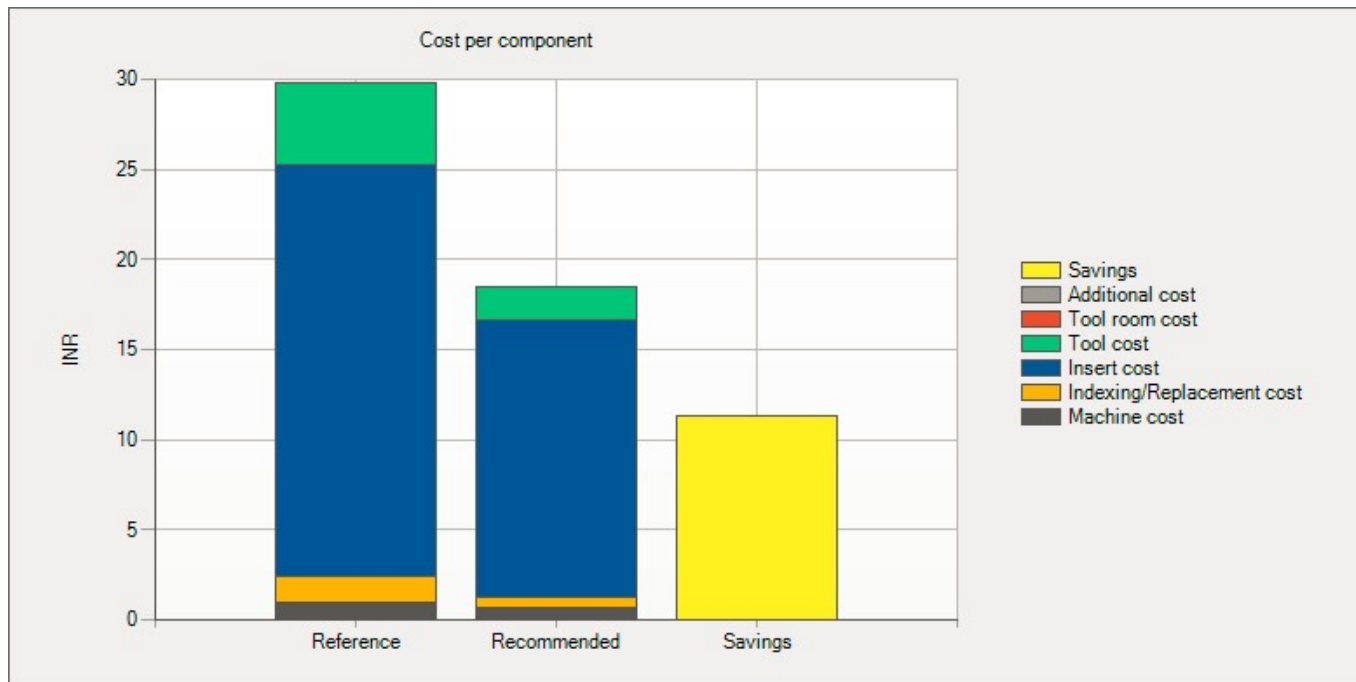
Group data





Charts

Recommendation





Reference

Recommended

Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Coromant	Coromant
Code	A20S-SDXCL 11	A20S-SDXCL 11
Code (customer denomination)	A20S-SDXCL 11	A20S-SDXCL 11
Cost	Rs 10,800.00	Rs 10,800.00
No. of insert indexes	200	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	Iscar	Coromant
Code	DCGT 11 T3 04-AS	DCGX 11 T3 04-AL
Code (customer denomination)	DCGT 11 T3 04-AS	DCGX 11 T3 04-AL
Grade	IC20	H10
No. of edges per insert	2	2
Cost per insert	Rs 550.00	Rs 926.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	1404	1685
Diameter (Dm) (mm)	34	34
Cutting speed (vc) (m/min)	150	180
Feed (fn) (mm/rev)	0.12	0.14
Cutting depth (ap) (mm)	0.5	0.4
Length of cut (mm)	50	50
No. of passes	1	1
Time in cut per component (min)	0.3	0.21
Block time per set-up (min)	0.3	0.21
Tool life (no.of components)	12	30
Tool life (minutes)	3.56	6.36
Tool life (meter)	0.6	1.5
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece