

# Productivity Report

Vaishnavi Auto Pvt.Ltd.

Project	WORM SHAFT
Component	WORM SHAFT
Test ID	ADMIN-1917815212
Created by	Vaikunth Panchal
Date created	27-06-2019
Your reference	Mr.Bhushan Sonar

Approved by



## Component - WORM SHAFT

Component	WORM SHAFT
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	2000
No. of components per year	24000
Current situation	
Recommendation	

## Machine - ACE MICROMATIC

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



## Analysis per component

	Reference	Recommended
Machine cost	Rs 0.87 (+0.29)	Rs 0.58
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.04 (+0.02)	Rs 0.02
Insert cost	Rs 1.71 (+0.4)	Rs 1.31
Indexing/Replacement cost	Rs 0.01 (+0)	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
<b>Total cost</b>	<b>Rs 2.63 (+0.71)</b>	<b>Rs 1.92</b>
<b>Total cycle time per set-up</b>	<b>0.27 (+0.09)</b>	<b>0.18</b>

**-27%**

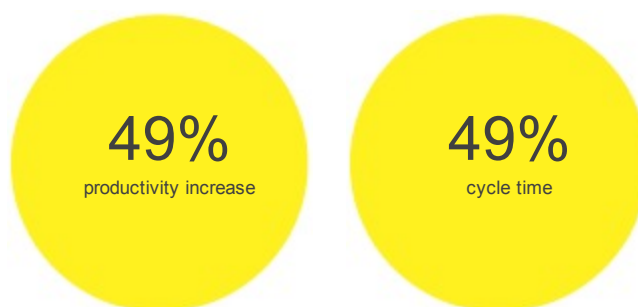
cost per component

**-33%**

total cycle time per  
component

## Recommendation

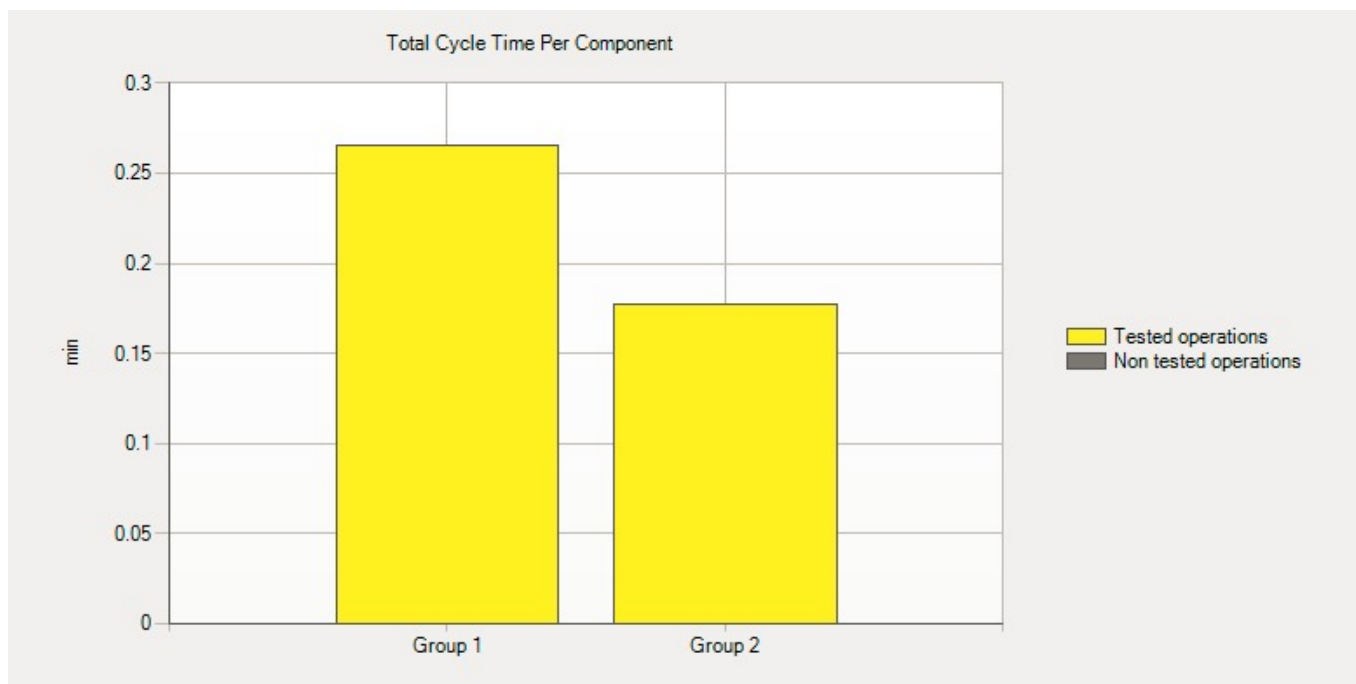
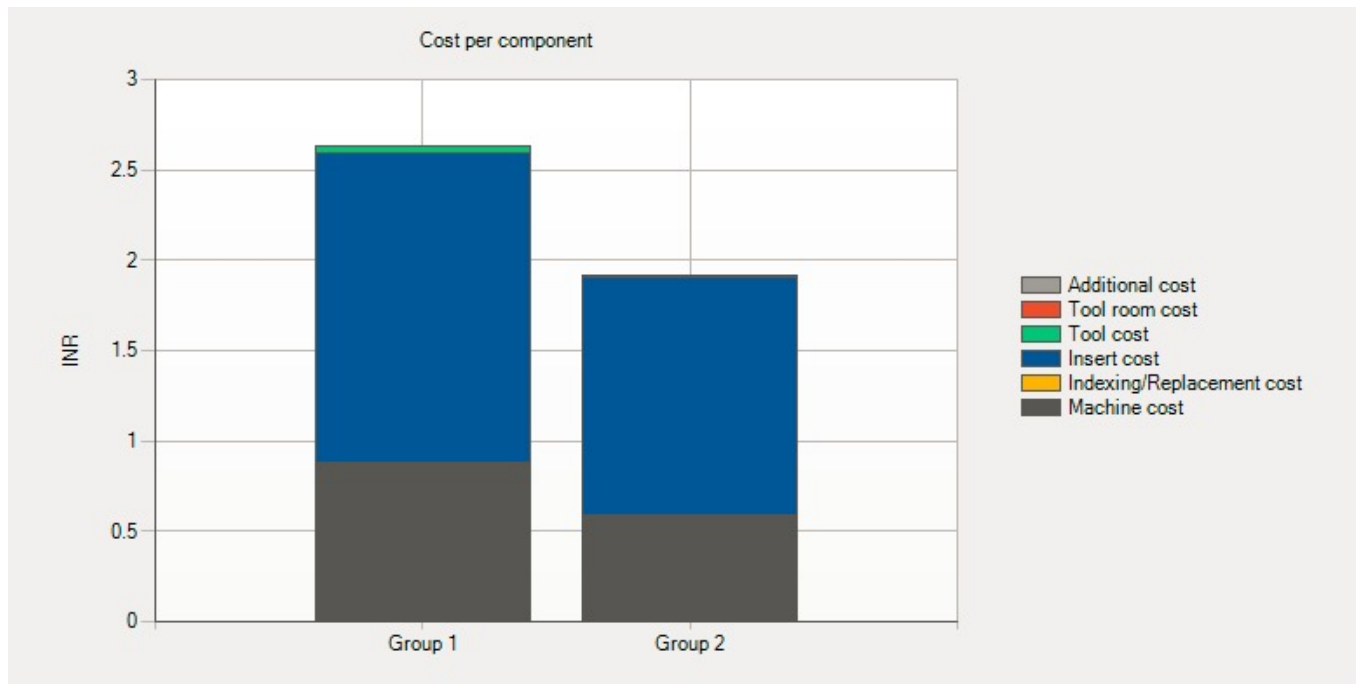
Productivity increase for recommended tools	49%
Productivity increase for total cycle time	49%
<b>Savings in production time per year (h)</b>	<b>35</b>
Savings per component	Rs 0.71
Savings per unit	Rs 1,427.74
<b>Savings per year</b>	<b>Rs 17,133</b>





# Charts

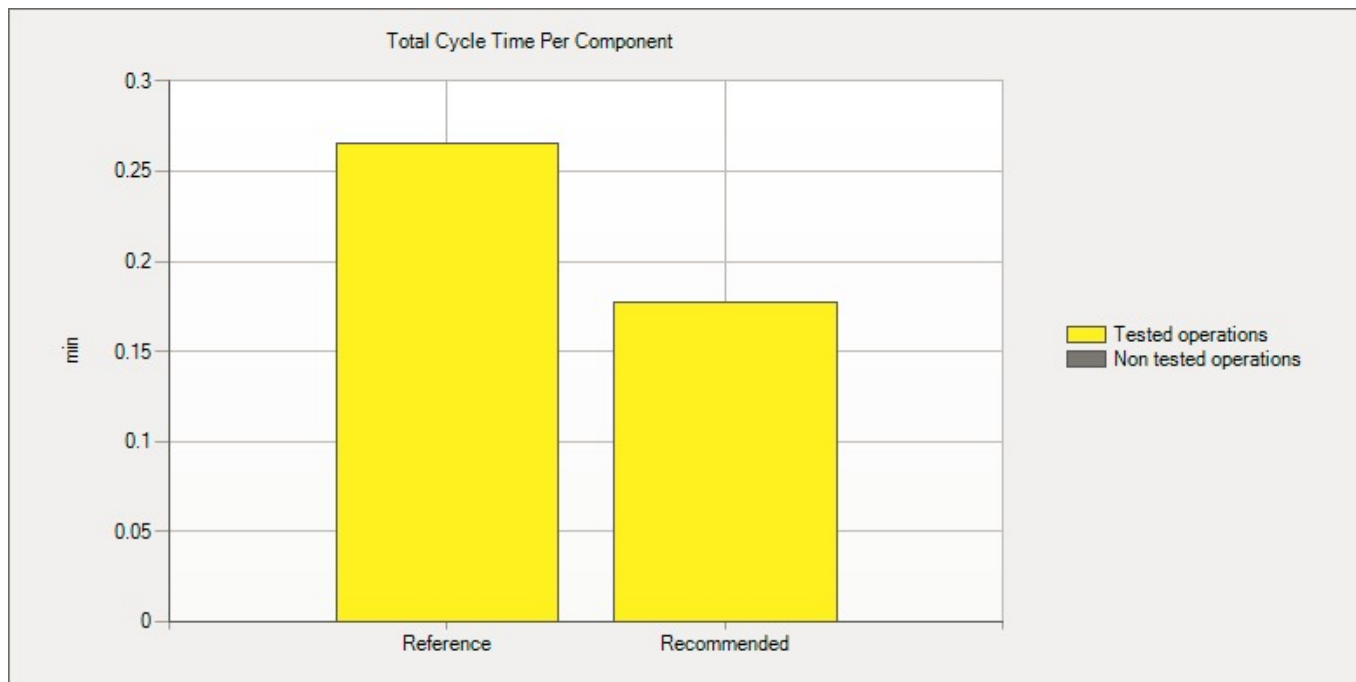
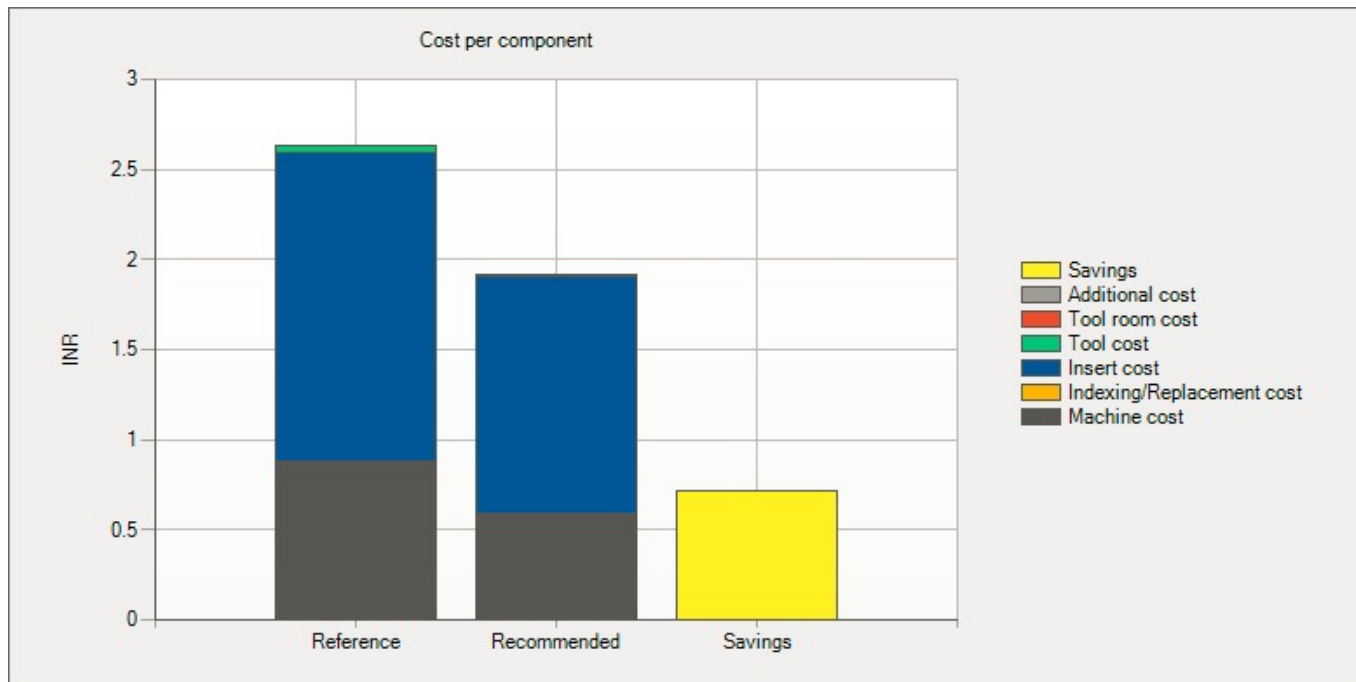
## Group data

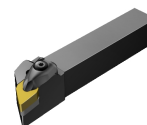




# Charts

## Recommendation





	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Toshiba Tungaloy	Coromant
Code	DDJNL 2525M15	DDJNL 2525M 1504
Code (customer denomination)	DDJNL 2525M15	DDJNL 2525M 1504
Cost	Rs 5,000.00	Rs 6,500.00
No. of insert indexes	100	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	Toshiba Tungaloy	Coromant
Code	DNGA150604	DNGA150404S01525H
Code (customer denomination)	DNGA150604	DNGA150404S01525H
Grade	BXA120	7125
No. of edges per insert	4	4
Cost per insert	Rs 8,200.00	Rs 9,435.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	1692	2068
Diameter (Dm) (mm)	16.93	16.93
Cutting speed (vc) (m/min)	90	110
Feed (fn) (mm/rev)	0.09	0.11
Cutting depth (ap) (mm)	0.1	0.1
Length of cut (mm)	20	20
No. of passes	2	2
Time in cut per component (min)	0.26	0.17
Block time per set-up (min)	0.26	0.17
Tool life (no.of components)	1200	1800
Tool life (minutes)	313.32	314.62
Tool life (meter)	47.72	71.57
Tool change criteria	(12) Workpiece out of tolerance	(12) Workpiece out of tolerance