

Productivity Report

BUNTS TOOLS

Project	Adaptor
Component	Adaptor
Test ID	ADMIN-1918316251
Created by	Vaikunth Panchal
Date created	02-07-2019
Your reference	Mr.Kanan

Approved by

BUNTS TOOLS
Mr.Kanan

Sandvik Coromant
Vaikunth Panchal



Test data

Component - Adaptor

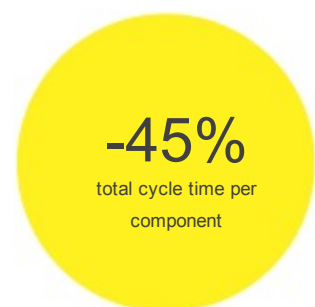
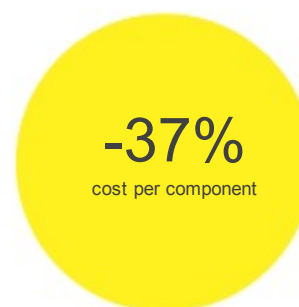
Component	Adaptor
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	4000
No. of components per year	48000
Current situation	
Recommendation	

Machine - Doosan

Machine brand	Doosan
Machine ID	
Machine cost per hour	Rs 350
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 7.72 (+2.94)	Rs 4.79
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.53 (+0.25)	Rs 0.29
Insert cost	Rs 4.00 (+0.48)	Rs 3.52
Indexing/Replacement cost	Rs 4.67 (+2.61)	Rs 2.06
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 16.92 (+6.28)	Rs 10.65
Total cycle time per set-up	2.12 (+0.5)	1.17





Productivity result

Recommendation

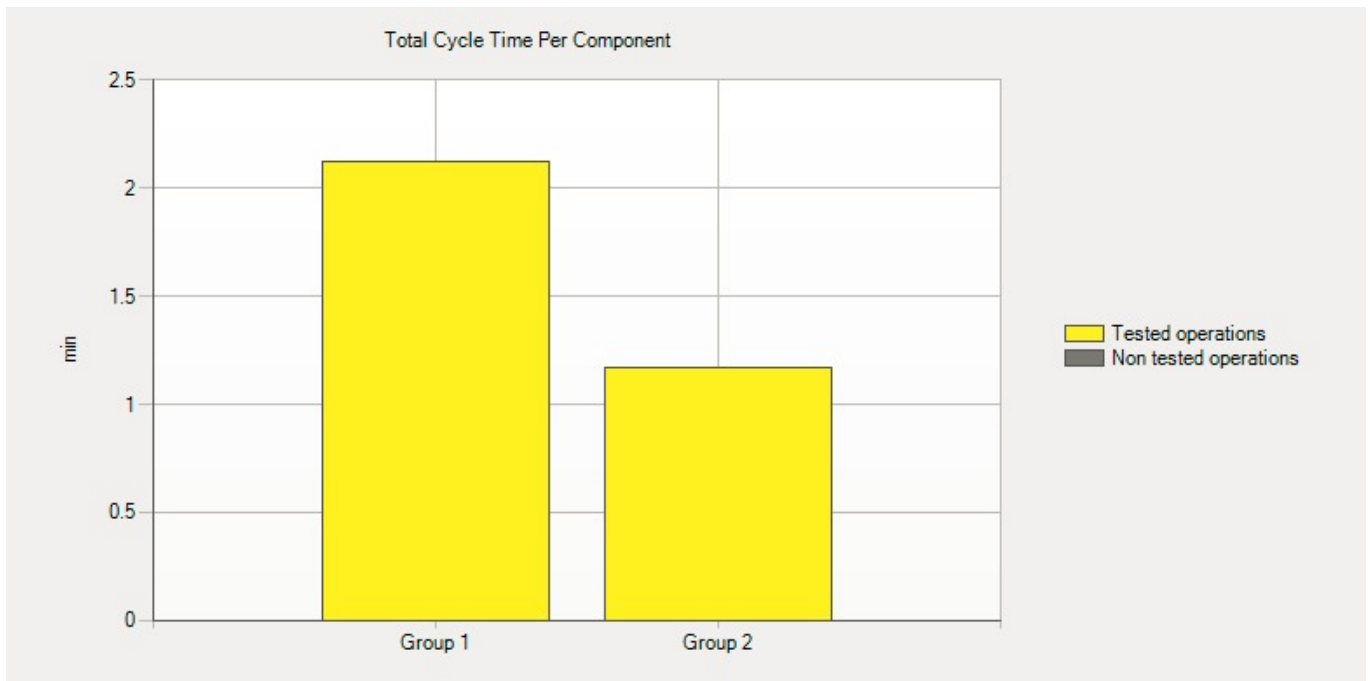
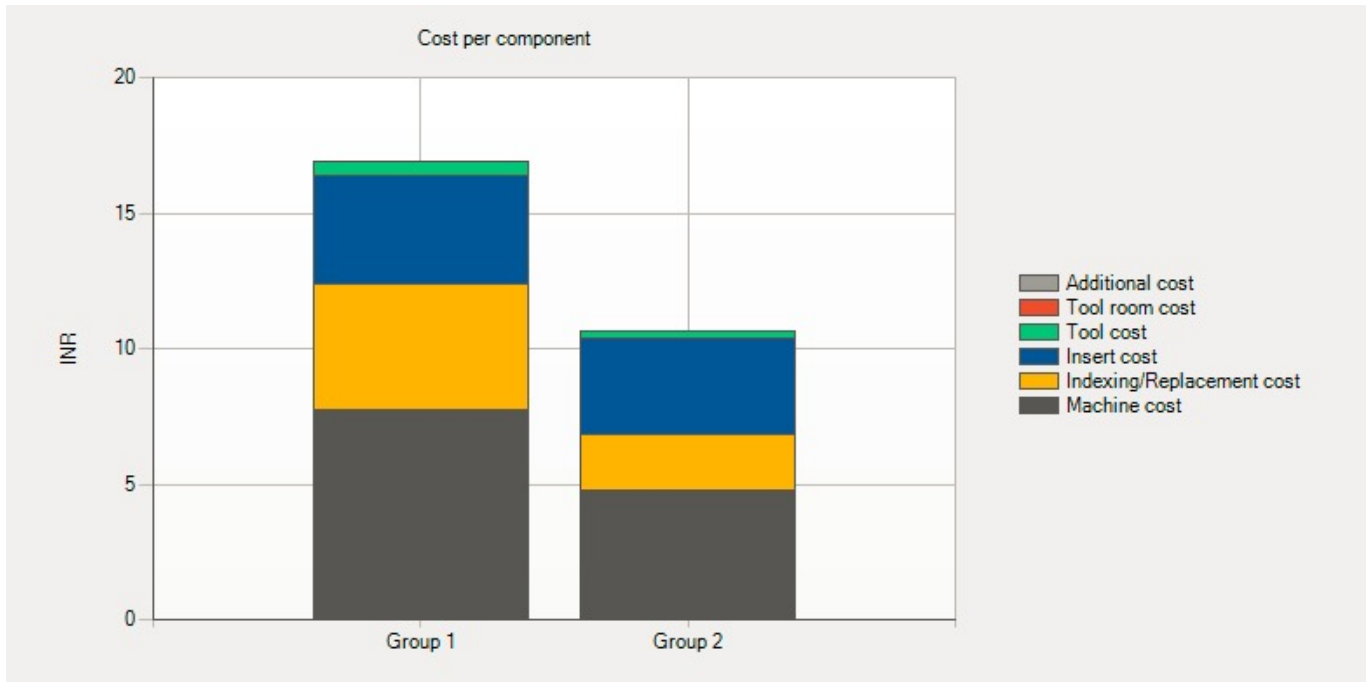
Productivity increase for recommended tools	81%
Productivity increase for total cycle time	81%
Savings in production time per year (h)	760
Savings per component	Rs 6.28
Savings per unit	Rs 25,106.47
Savings per year	Rs 3,01,278





Charts

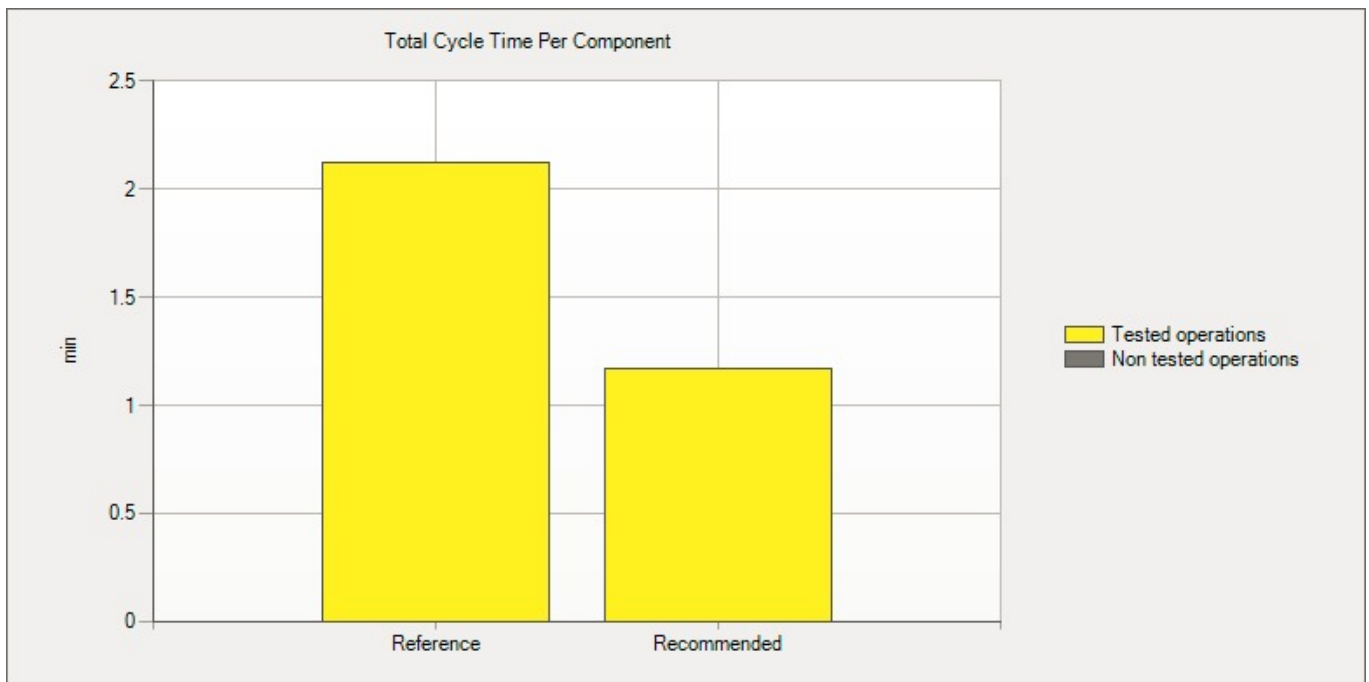
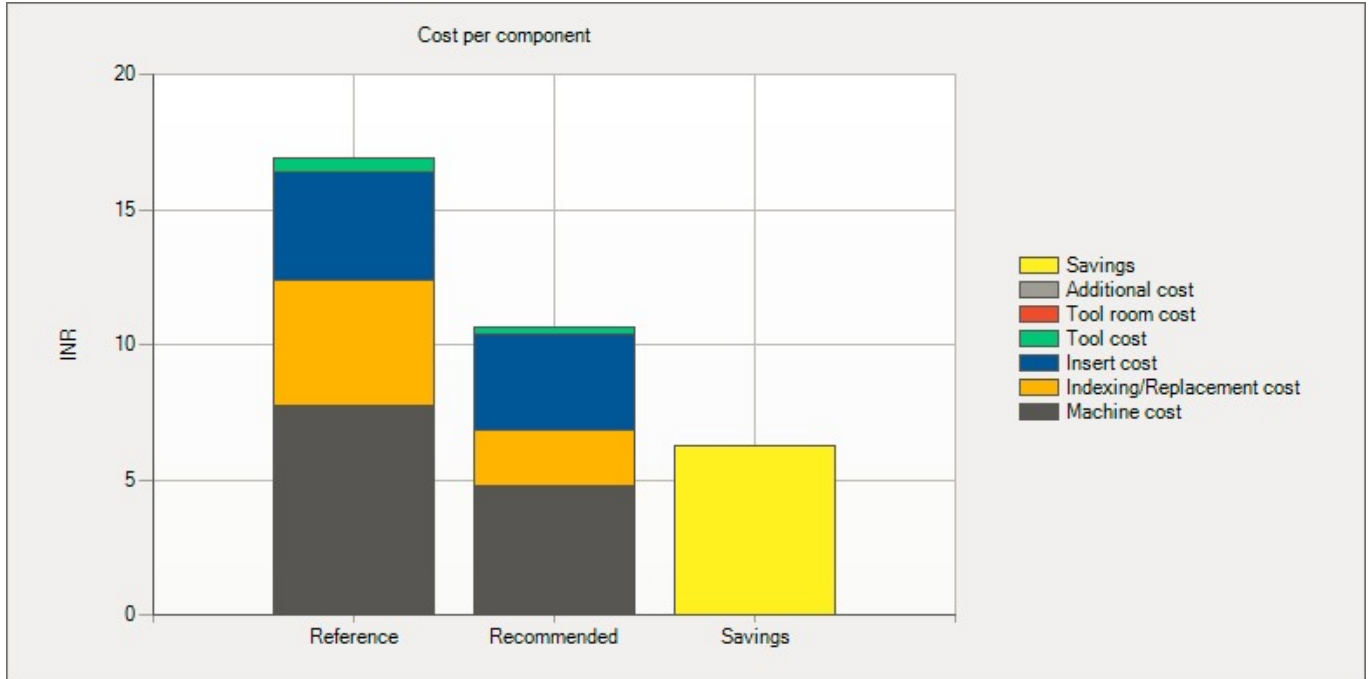
Group data





Charts

Recommendation





	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	TaeguTec	Coromant
Code	SIR 0020S16CB	266RKF-20-16
Code (customer denomination)	SIR 0020S16CB	266RKF-20-16
Cost	Rs 8,000.00	Rs 14,580.00
No. of insert indexes	200	300
Insert indexing time (min)	60	60
Insert		
Manufacturer	TaeguTec	Coromant
Code	16IR 11W	266RL-16WH01A110M
Code (customer denomination)	16IR 11W	266RL-16WH01A110M
Grade	TT8010	1135
No. of edges per insert	3	3
Cost per insert	Rs 900.00	Rs 1,793.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	1000	1150
Diameter (Dm) (mm)	30.4	30.4
Cutting speed (vc) (m/min)	96	110
Feed (fn) (mm/rev)	2.3	2.3
Cutting depth (ap) (mm)	0	0
Length of cut (mm)	35	35
No. of passes	87	62
Time in cut per component (min)	1.32	0.82
Block time per set-up (min)	1.32	0.82
Tool life (no.of components)	75	170
Tool life (minutes)	99.29	139.47
Tool life (meter)	228.38	368.9
Tool change criteria	(12) Workpiece out of tolerance	(12) Workpiece out of tolerance