

# Productivity Report

KOSO INDIA Pvt.Ltd.

Project	Back Facing
Component	Valve
Test ID	ADMIN-197742129
Created by	Vaikunth Panchal
Date created	18-03-2019
Your reference	Mr.Revan Ghongade

Approved by



## Test data

### Component - Valve

Component	Valve
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	20
No. of components per year	200
Current situation	
Recommendation	

### Machine -

Machine brand	
Machine ID	
Machine cost per hour	Rs 500
Tool room cost per hour	Rs 0



## Analysis per component

	Reference	Recommended
Machine cost	Rs 2,774.18 (+554.84)	Rs 2,219.34
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 4,666.67 (+1012.67)	Rs 3,654.00
Insert cost	Rs 25,000.00 (+10760)	Rs 14,240.00
Indexing/Replacement cost	Rs 694.44 (+277.78)	Rs 416.67
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 33,135.29 (+12605.28)</b>	<b>Rs 20,530.01</b>
<b>Total cycle time per set-up</b>	<b>416.24 (+66.58)</b>	<b>316.32</b>

**-38%**

cost per component

**-24%**

total cycle time per  
component

## Recommendation

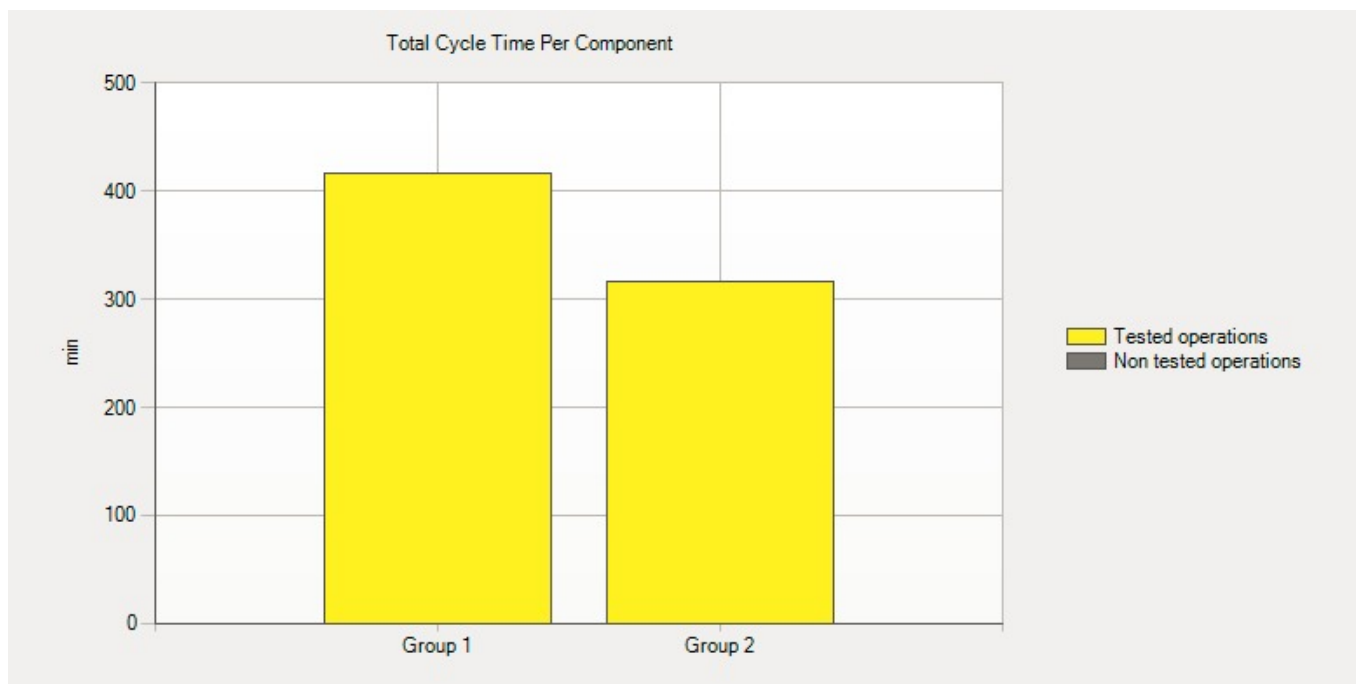
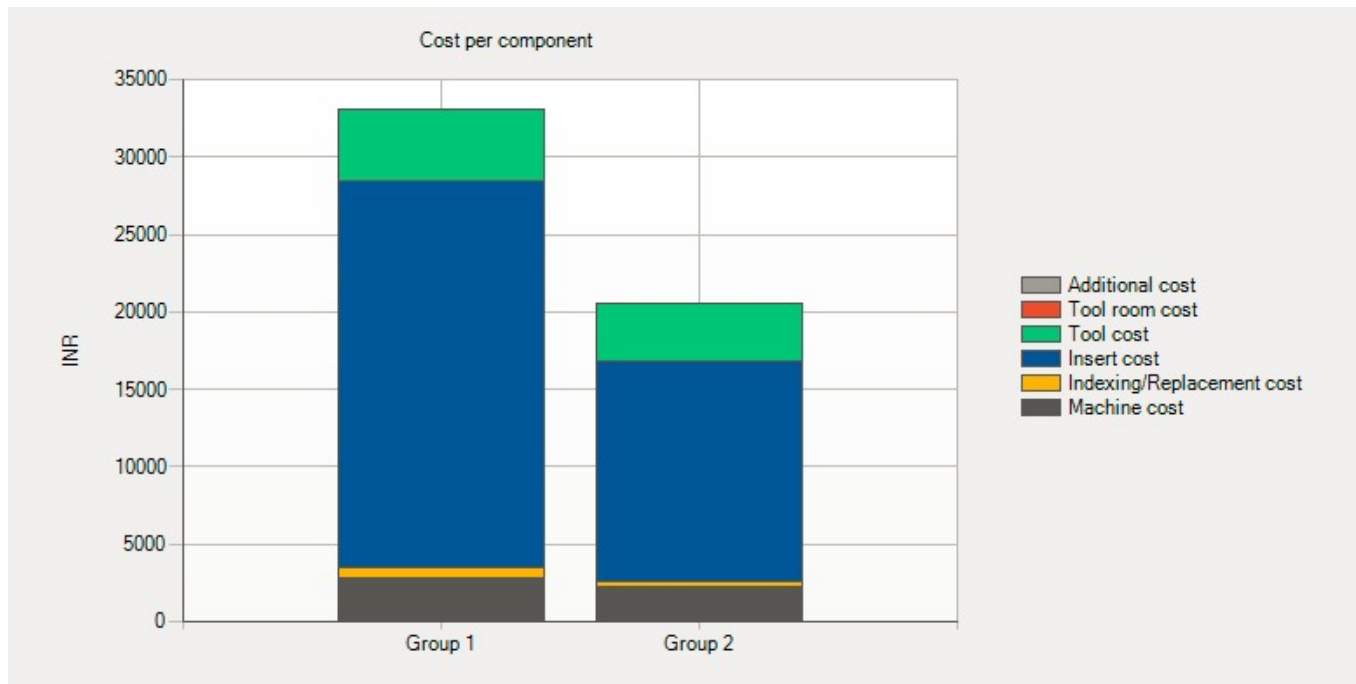
Productivity increase for recommended tools	32%
Productivity increase for total cycle time	32%
<b>Savings in production time per year (h)</b>	<b>333</b>
Savings per component	Rs 12,605.28
Savings per unit	Rs 2,52,105.61
<b>Savings per year</b>	<b>Rs 25,21,056</b>





# Charts

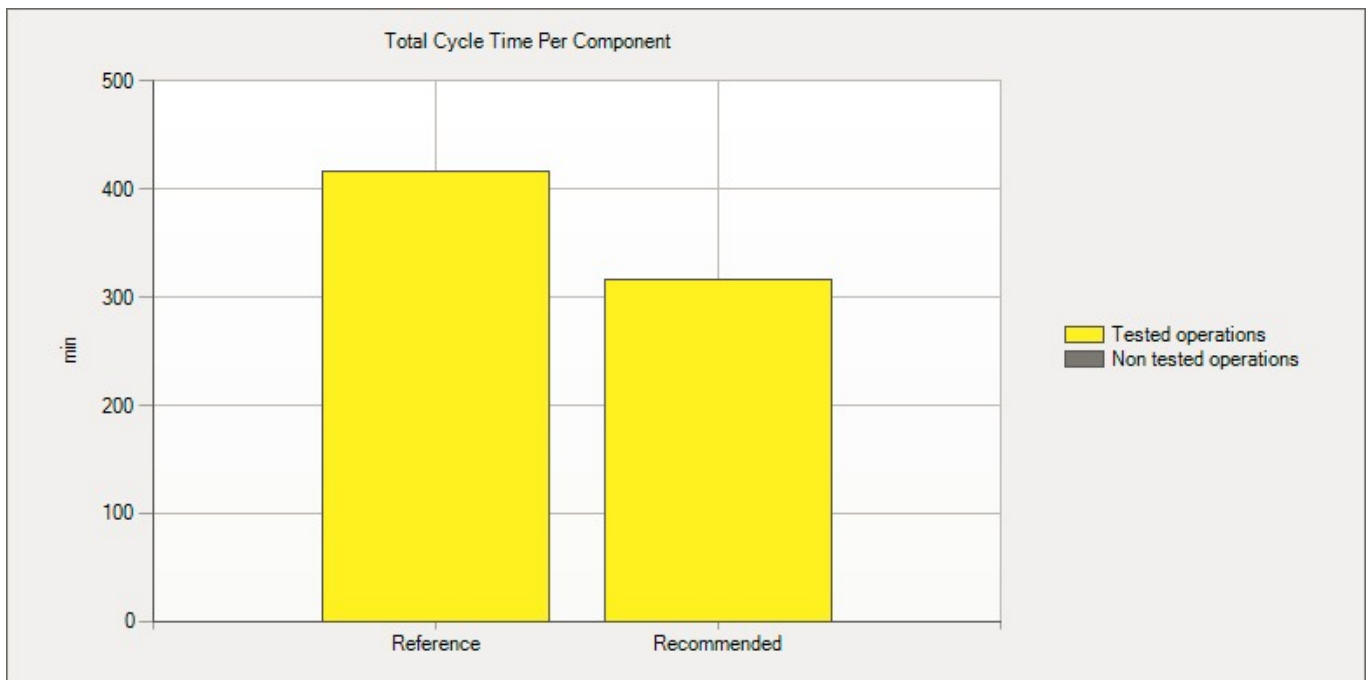
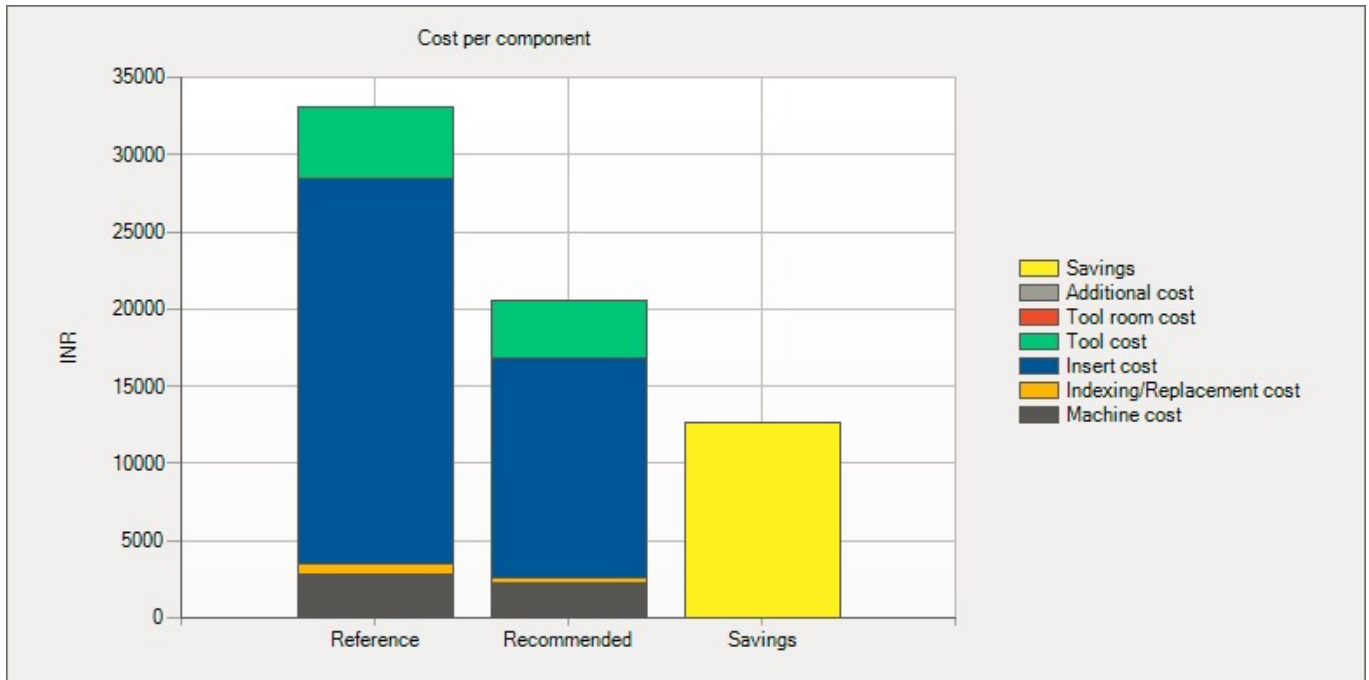
## Group data

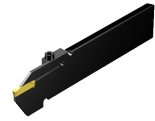




# Charts

## Recommendation





	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	Paring Blade	LF123M100-45B1
Code (customer denomination)	Paring Blade	LF123M100-45B1
Cost	Rs 14,000.00	Rs 18,270.00
No. of insert indexes	50	50
Insert indexing time (min)	5	5
Insert		
Manufacturer	Iscar	Coromant
Code	10mm width insert	N123M2-1000-0008-GM 1125
Code (customer denomination)	10mm width insert	N123M2-1000-0008-GM 1125
Grade		1125
No. of edges per insert	2	2
Cost per insert	Rs 3,000.00	Rs 2,848.00
No. of inserts	1	1
Cutting data		
Cut	Medium	Medium

	Reference	Recommended
Spindle speed (n) (rev/min)	60	60
Diameter (Dm) (mm)	468	468
Cutting speed (vc) (m/min)	88	88
Feed (fn) (mm/rev)	0.08	0.1
Cutting depth (ap) (mm)	5	5
Length of cut (mm)	100	100
No. of passes	20	20
Time in cut per component (min)	332.9	266.32
Block time per set-up (min)	332.9	266.32
Tool life (no.of components)	0.06	0.1
Tool life (minutes)	19.97	26.63
Tool life (meter)	0.1	0.16
Tool change criteria	(13) Burr or spalling of workpiece	(13) Burr or spalling of workpiece