

Productivity Report

SMP ENGINEERING & ELECTRICALS

Project	Prime turning
Component	CAP
Test ID	ADMIN-1936265925
Created by	Vaikunth Panchal
Date created	28-12-2019
Your reference	Mr.Jagtap

Approved by



Test data

Component - CAP

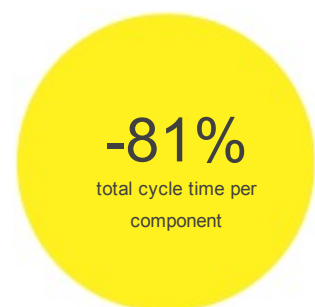
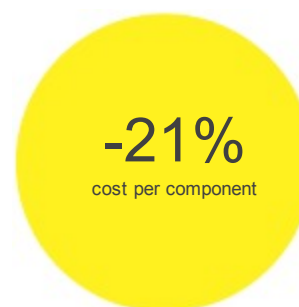
Component	CAP
CMC code	
MC Code	
No. of components per set-up	1
no.of components ()	20000
No. of components per year	240000
Current situation	
Recommendation	

Machine - JYOTI

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

Analysis per component

	Reference	Recommended
Machine cost	Rs 1.00 (+0.84)	Rs 0.16
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.14 (+0.05)	Rs 0.09
Insert cost	Rs 0.86 (-.47)	Rs 1.33
Indexing/Replacement cost	Rs 0.05 (+0.01)	Rs 0.04
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 2.05 (+0.43)	Rs 1.62
Total cycle time per set-up	0.31 (+0.25)	0.06



Recommendation

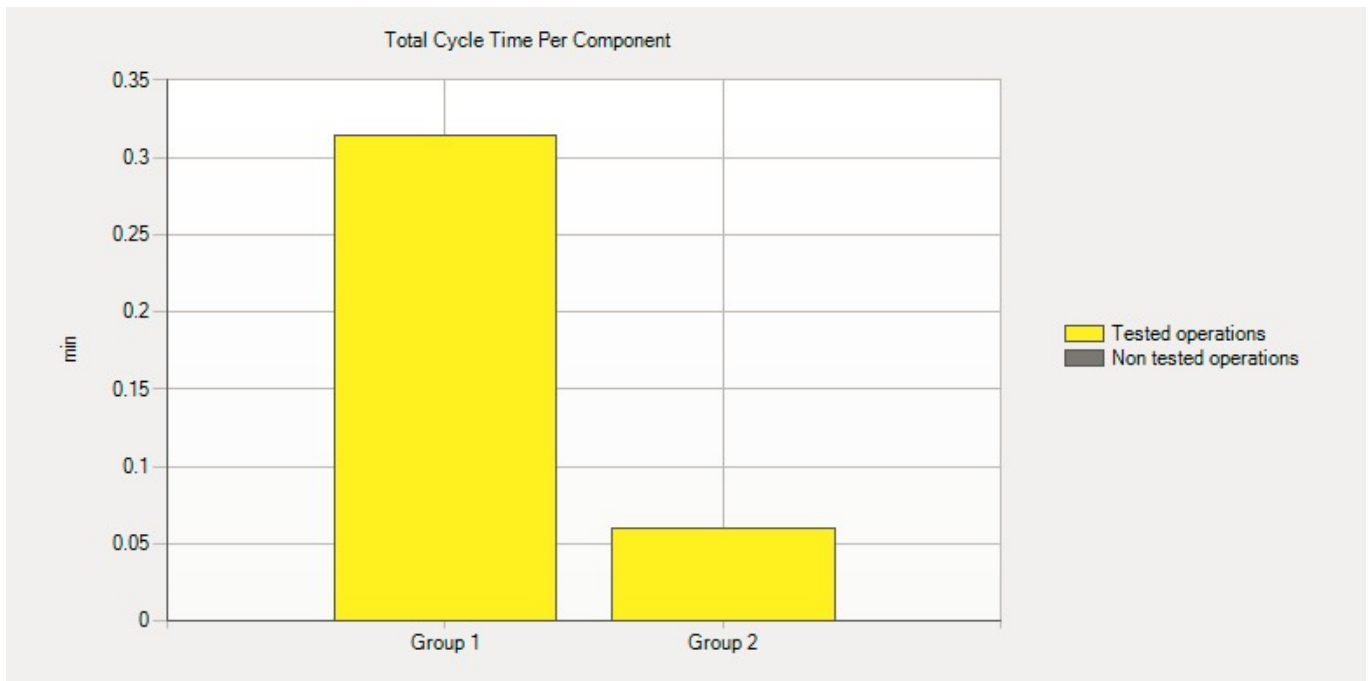
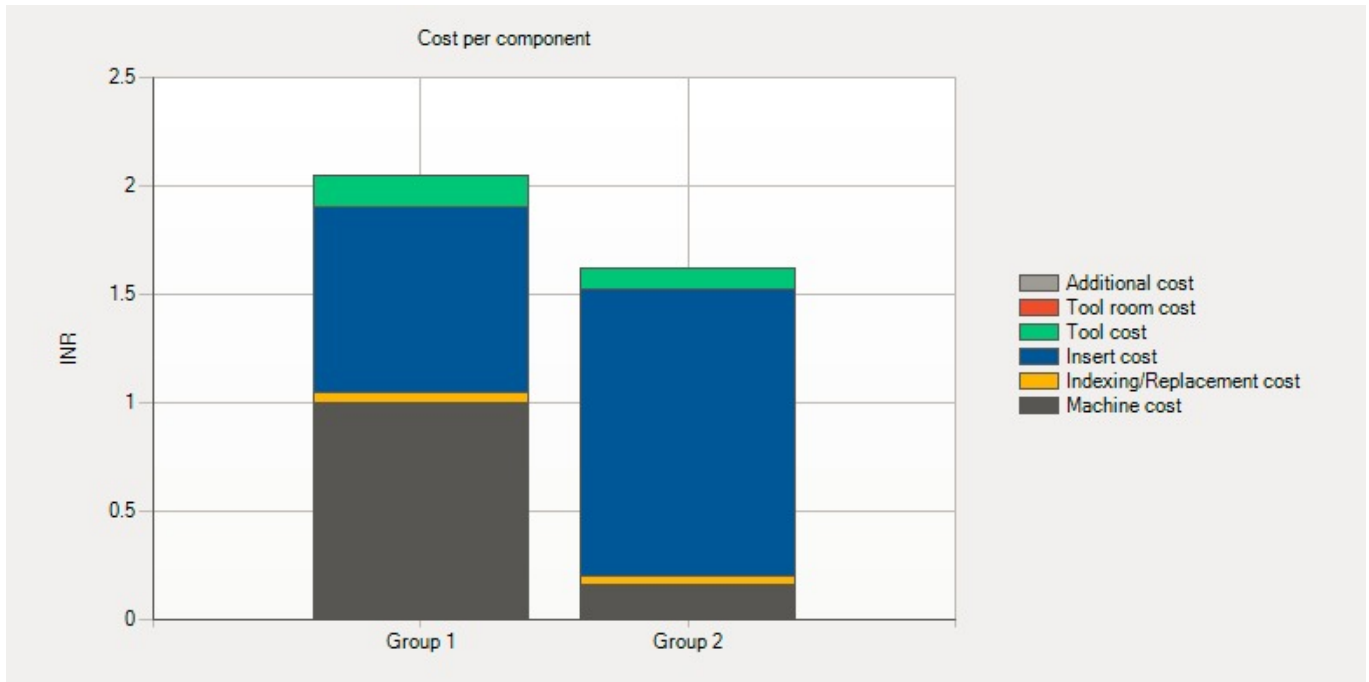
Productivity increase for recommended tools	420%
Productivity increase for total cycle time	420%
Savings in production time per year (h)	1016
Savings per component	Rs 0.43
Savings per unit	Rs 8,580.20
Savings per year	Rs 1,02,962





Charts

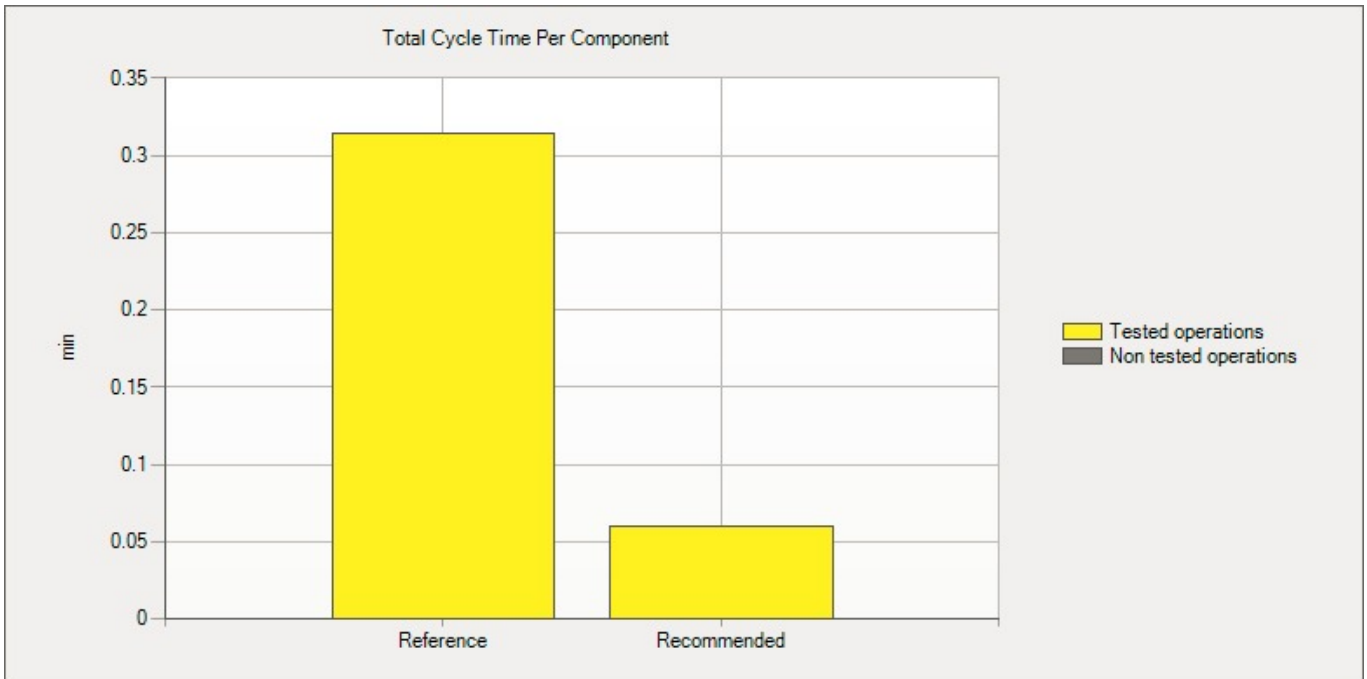
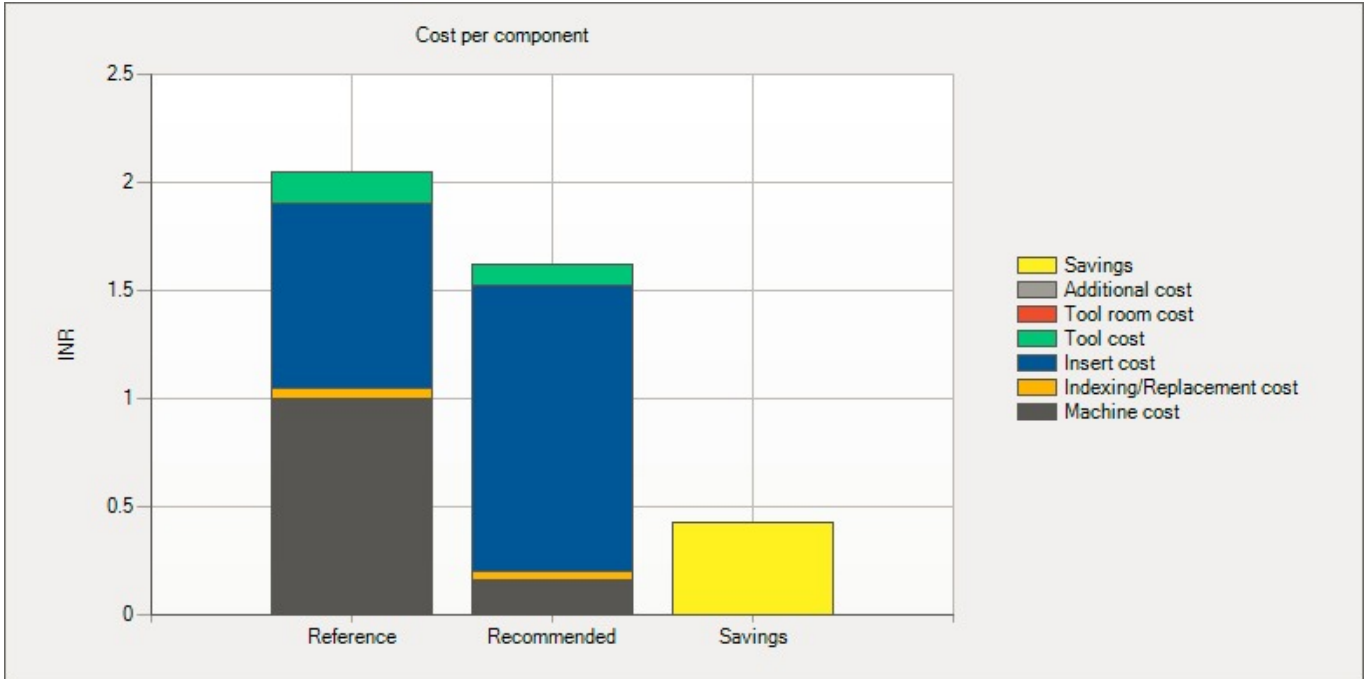
Group data





Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Toshiba Tungaloy	Coromant
Code	TGTSL 2525M22-2	CP-30AL-2525-11
Code (customer denomination)	TGTSL 2525M22-2	CP-30AL-2525-11
Cost	Rs 5,000.00	Rs 7,380.00
No. of insert indexes	100	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	Toshiba Tungaloy	Coromant
Code	GBL43250	CP-A1104-L5
Code (customer denomination)	GBL43250	CP-A1104-L5
Grade	AH710	1115
No. of edges per insert	3	3
Cost per insert	Rs 900.00	Rs 1,590.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	400	550
Diameter (Dm) (mm)	84	84
Cutting speed (vc) (m/min)	106	145
Feed (fn) (mm/rev)	0.05	0.15
Cutting depth (ap) (mm)	2.5	1
Length of cut (mm)	2	2
No. of passes	1	2
Time in cut per component (min)	0.1	0.05
Block time per set-up (min)	0.3	0.05
Tool life (no.of components)	350	400
Tool life (minutes)	35	19.16
Tool life (meter)	0.7	1.58
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece