

Productivity Report

Suru Industries

Project	Bolt
Component	Bolt
Test ID	ADMIN-1937141558
Created by	Vaikunth Panchal
Date created	06-02-2019
Your reference	Mr.Saurab Shirode

Approved by



Test data

Component - Bolt

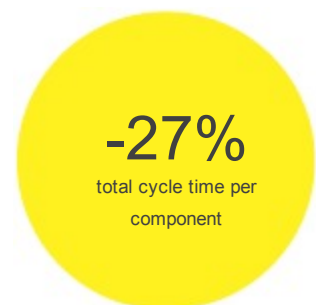
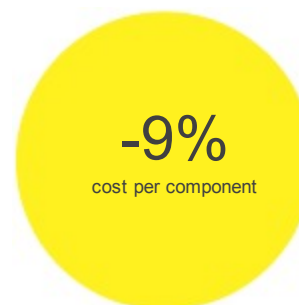
Component	Bolt
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	40000
No. of components per year	500000
Current situation	
Recommendation	

Machine - Ace Micromatic

Machine brand	Ace Micromatic
Machine ID	
Machine cost per hour	Rs 180
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 3.47 (+0.93)	Rs 2.55
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.19 (+0.05)	Rs 0.14
Insert cost	Rs 0.40 (-.65)	Rs 1.05
Indexing/Replacement cost	Rs 0.19 (+0.05)	Rs 0.14
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 4.24 (+0.38)	Rs 3.87
Total cycle time per set-up	1.22 (+0.31)	0.89





Productivity result

Recommendation

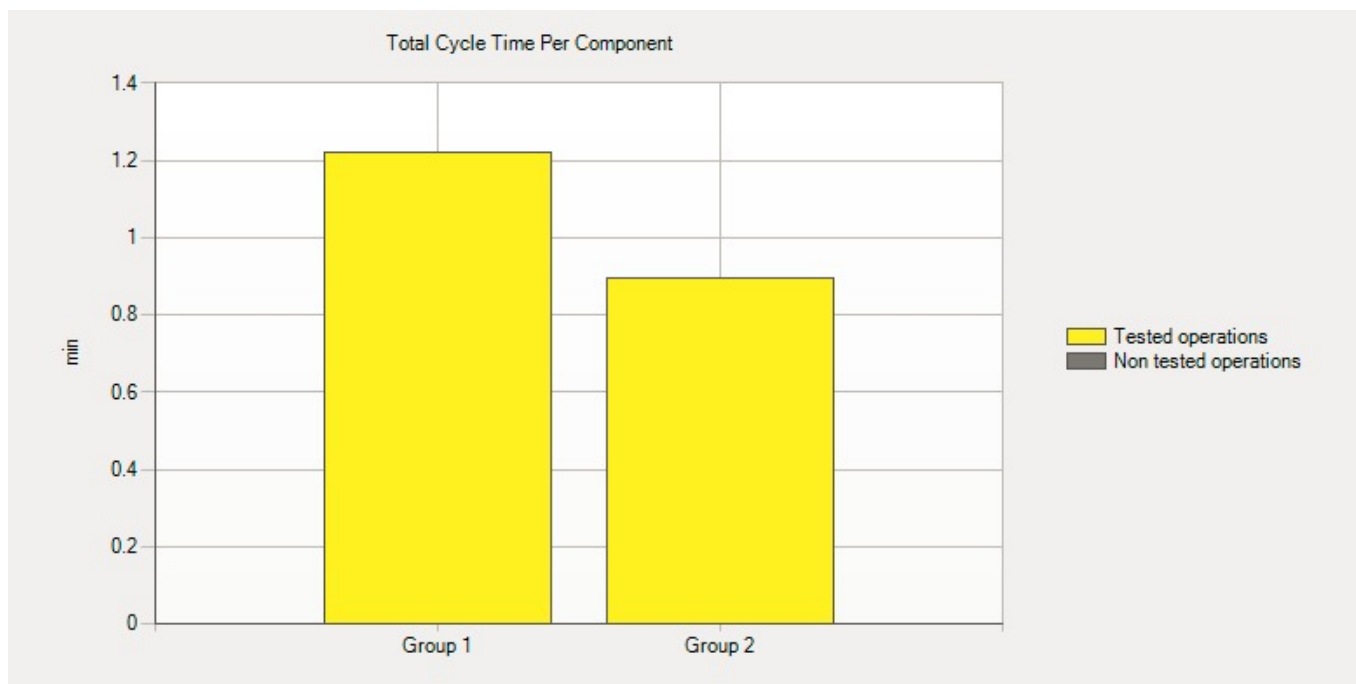
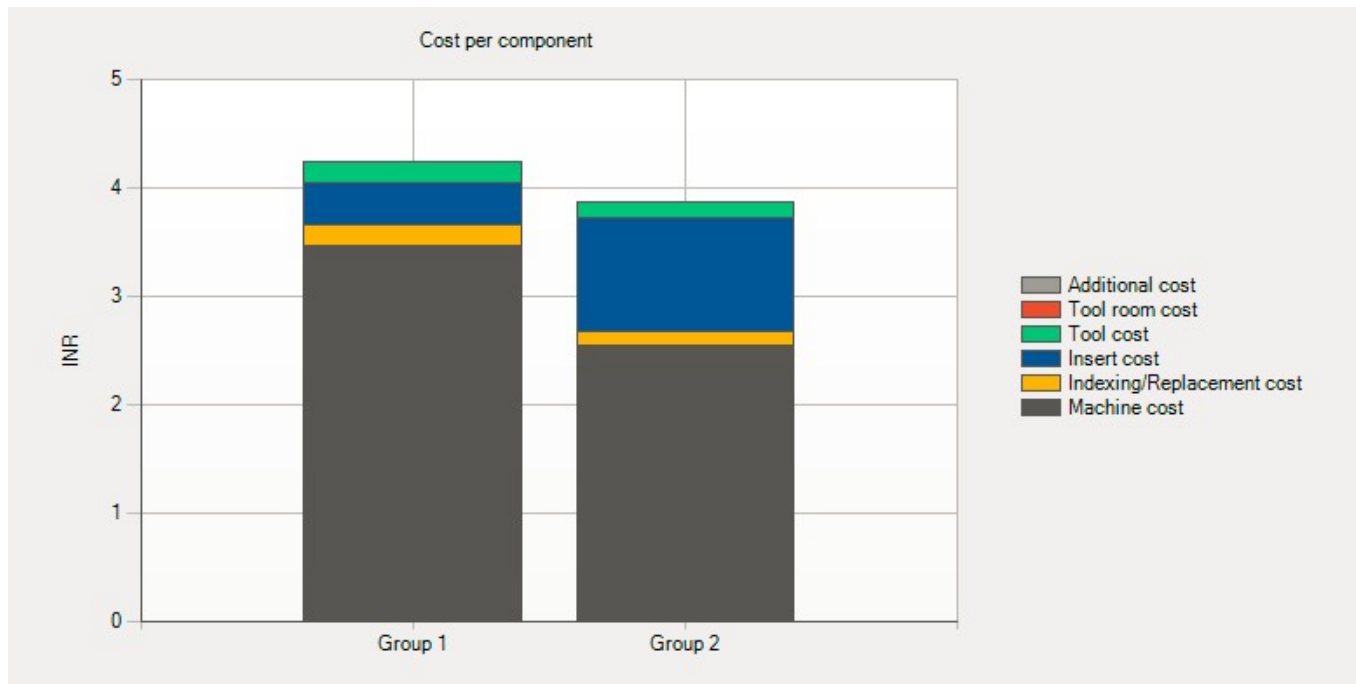
Productivity increase for recommended tools	36%
Productivity increase for total cycle time	36%
Savings in production time per year (h)	2715
Savings per component	Rs 0.38
Savings per unit	Rs 15,089.45
Savings per year	Rs 1,88,618





Charts

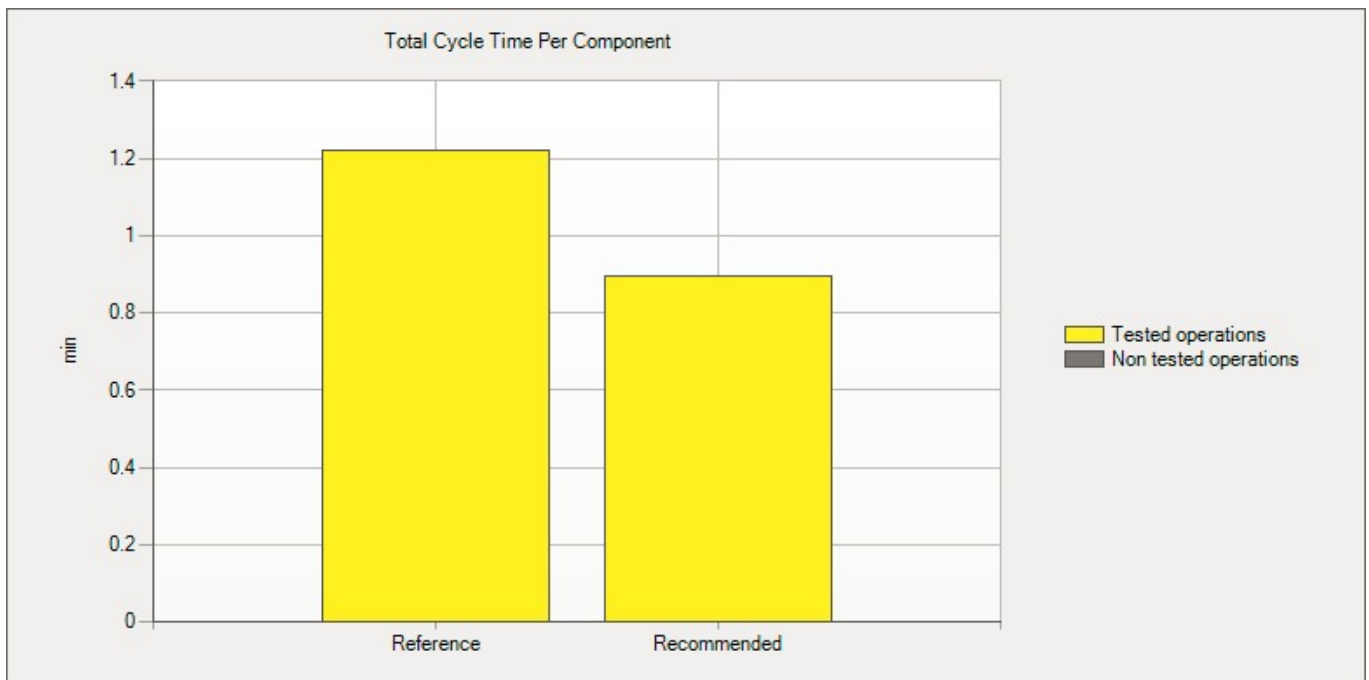
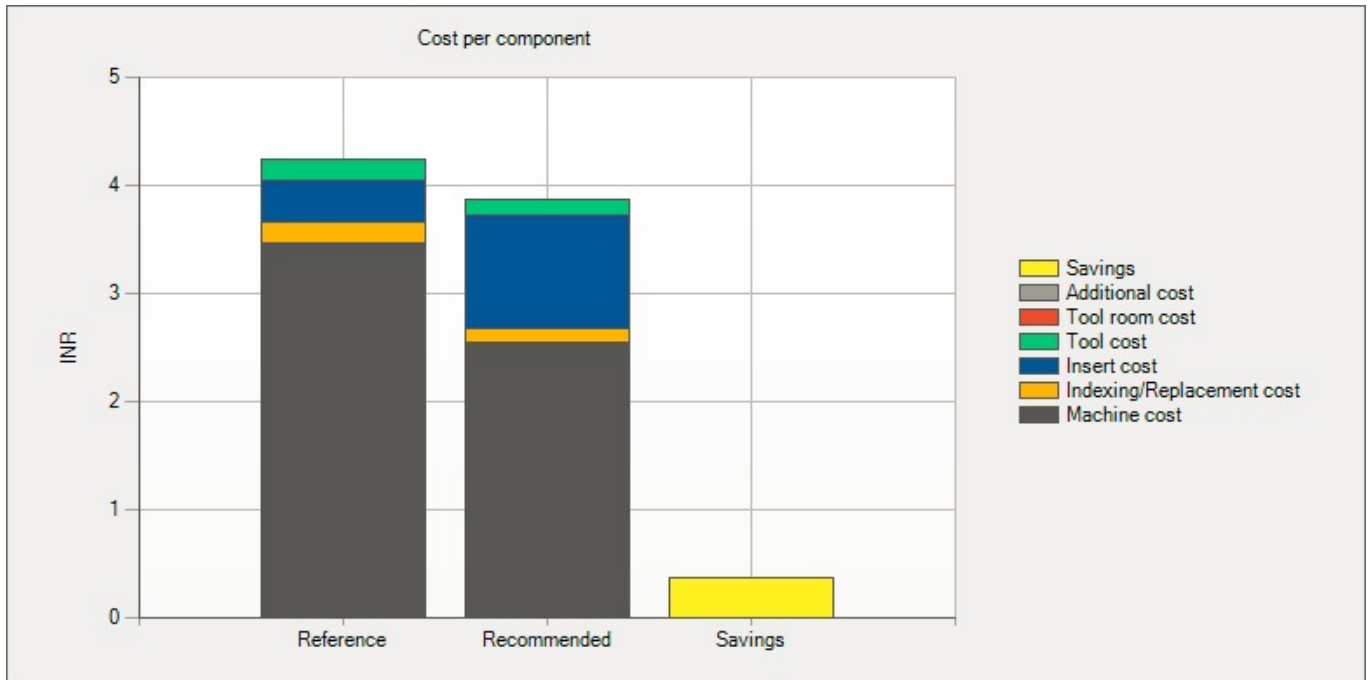
Group data

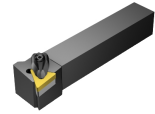




Charts

Recommendation





Reference

Recommended

Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	TaeguTec	TaeguTec
Code	DTJNL 2525M 16	DTJNL 2525M 16
Code (customer denomination)	DTJNL 2525M 16	DTJNL 2525M 16
Cost	Rs 3,000.00	Rs 3,000.00
No. of insert indexes	200	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	TaeguTec	Coromant
Code	TNMG 16 04 08FG	TNMG 160408-MM
Code (customer denomination)	TNMG 16 04 08FG	TNMG 160408-MM
Grade	CT 3000	1115
No. of edges per insert	6	6
Cost per insert	Rs 190.00	Rs 691.00
No. of inserts	1	1
Cutting data		
Cut	Roughing	Roughing

	Reference	Recommended
Spindle speed (n) (rev/min)	1500	1800
Diameter (Dm) (mm)	17.8	17.8
Cutting speed (vc) (m/min)	84	101
Feed (fn) (mm/rev)	0.22	0.25
Cutting depth (ap) (mm)	0.8	0.8
Length of cut (mm)	200	200
No. of passes	2	2
Time in cut per component (min)	1.16	0.85
Block time per set-up (min)	1.16	0.85
Tool life (no.of components)	80	110
Tool life (minutes)	92.61	93.38
Tool life (meter)	30.56	42.02
Tool change criteria	(13) Burr or spalling of workpiece	(13) Burr or spalling of workpiece