

Productivity Report

Vaishnavi Auto Pvt.Ltd.

Project	Niddle Turning
Component	NIDDLE
Test ID	ADMIN-19361141655
Created by	Vaikunth Panchal
Date created	27-12-2019
Your reference	Mr.Bhushan Sonar

Approved by



Test data

Component - NIDDLE

Component	NIDDLE
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 - T-SUGAMI

Machine brand	T-SUGAMI
Machine ID	
Machine cost per hour	Rs 350
Tool room cost per hour	Rs 0



Analysis per component

	Reference	Recommended
Machine cost	Rs 1.30 (+0.36)	Rs 0.93
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.27 (+0.08)	Rs 0.19
Insert cost	Rs 1.23 (+0.18)	Rs 1.05
Indexing/Replacement cost	Rs 0.12 (+0.03)	Rs 0.08
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 2.92 (+0.66)	Rs 2.26
Total cycle time per set-up	0.24 (+0.06)	0.17

-23%

cost per component

-29%

total cycle time per
component

Recommendation

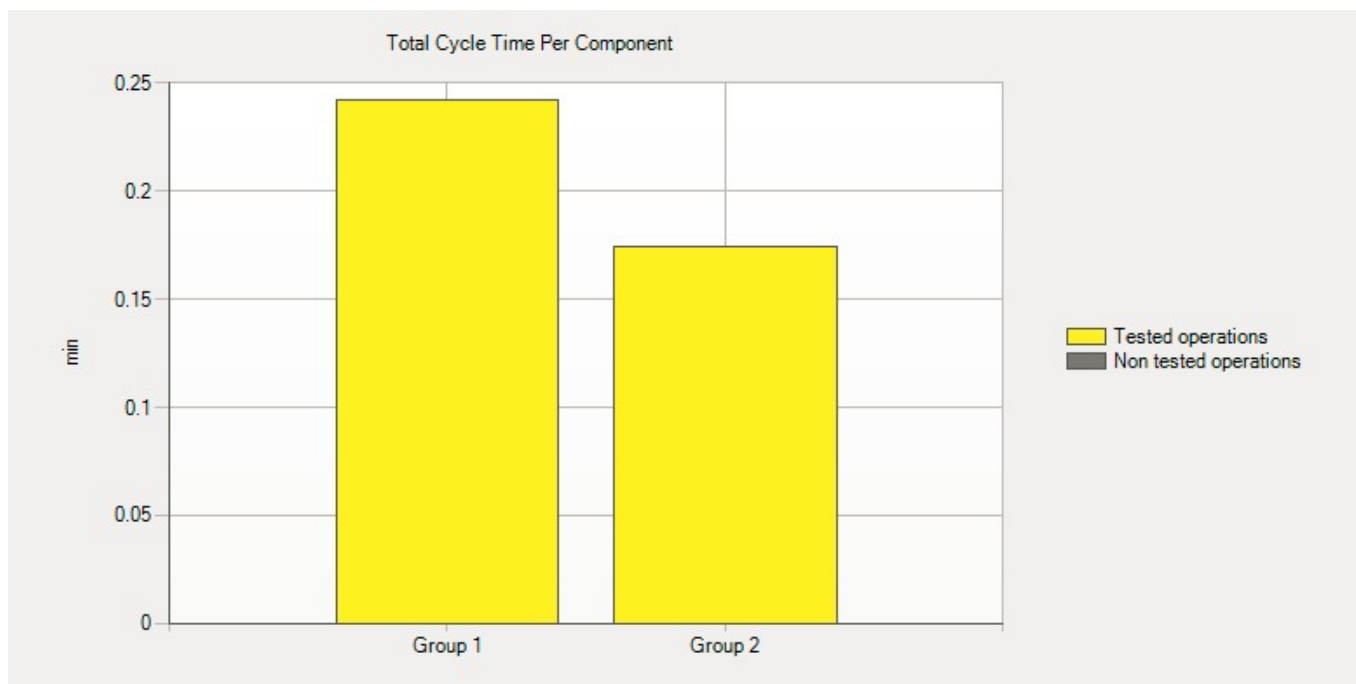
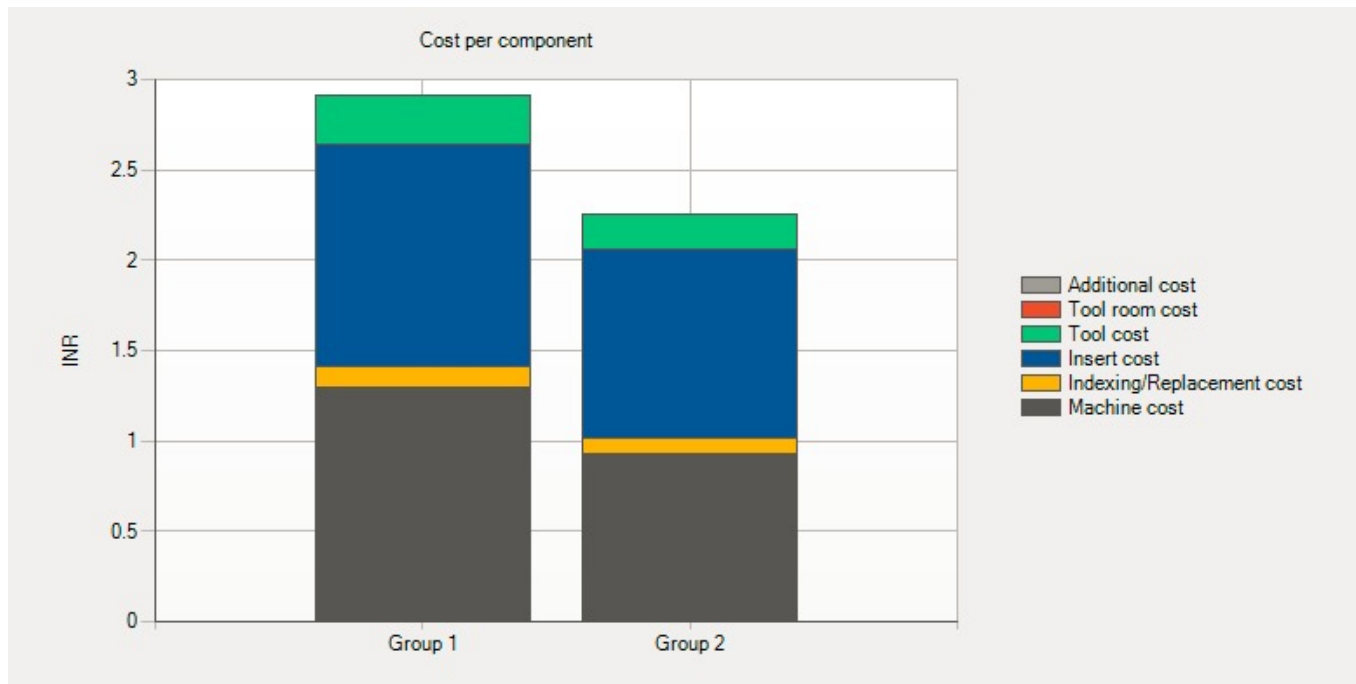
Productivity increase for recommended tools	39%
Productivity increase for total cycle time	39%
Savings in production time per year (h)	272
Savings per component	Rs 0.66
Savings per unit	Rs 13,165.93
Savings per year	Rs 1,57,991





Charts

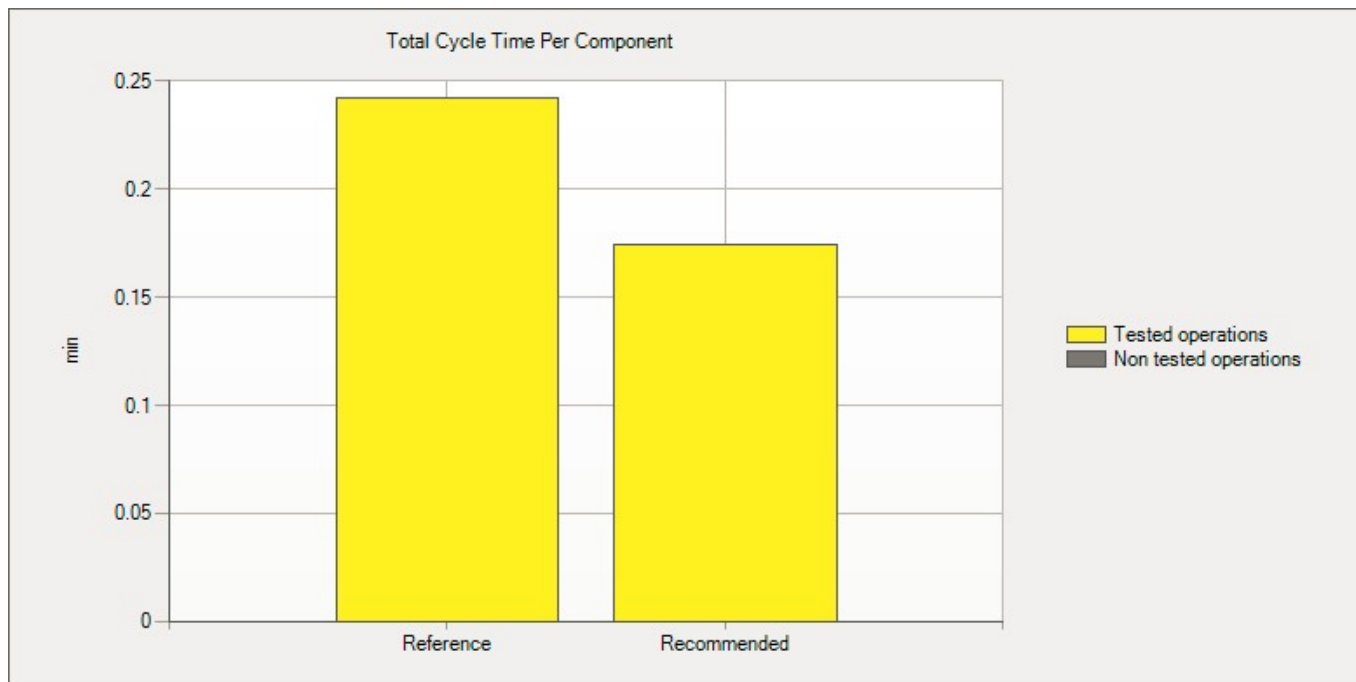
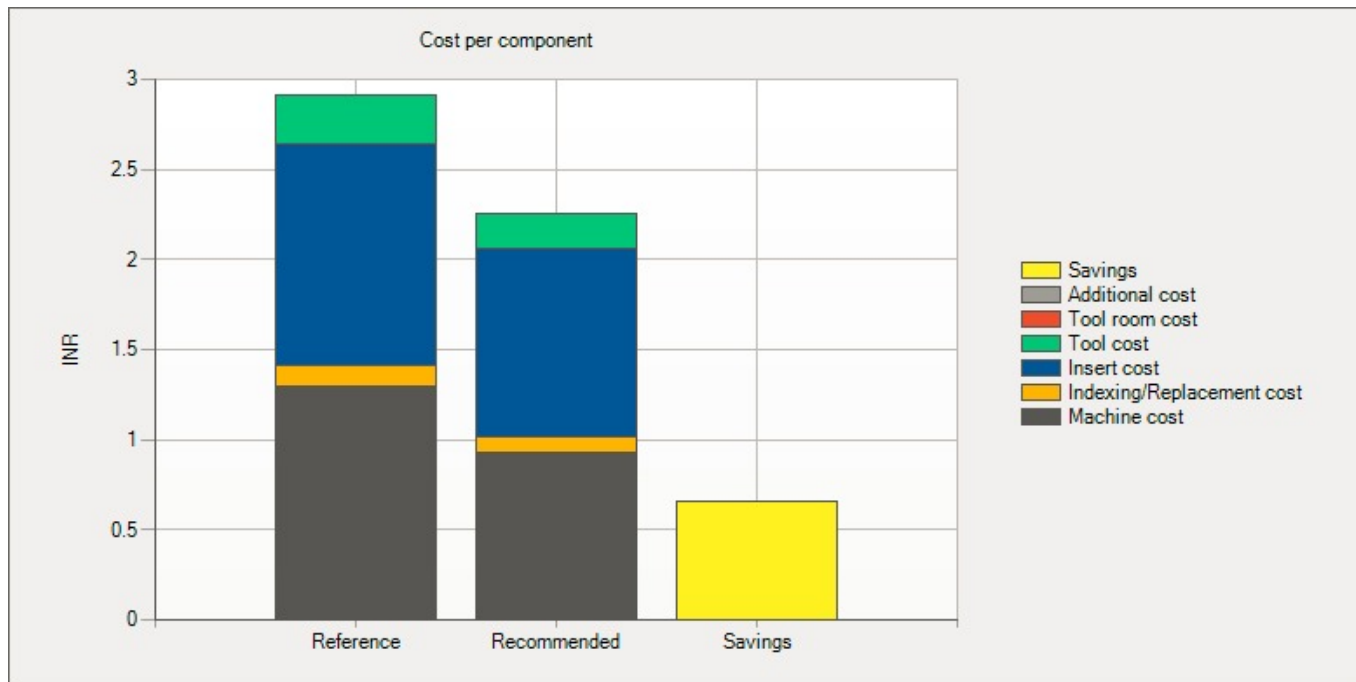
Group data

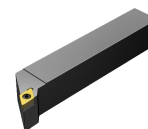
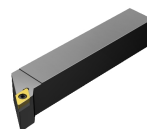




Charts

Recommendation





Reference

Recommended

Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Coromant	Coromant
Code	SDJCR 1212K 11-S	SDJCR 1212K 11-S
Code (customer denomination)	SDJCR 1212K 11-S	SDJCR 1212K 11-S
Cost	Rs 6,800.00	Rs 6,800.00
No. of insert indexes	100	100
Insert indexing time (min)	5	5
Insert		
Manufacturer	Iscar	Coromant
Code	DCMT 11T304-F3P	DCMT 11T304-MM
Code (customer denomination)	DCMT 11T304-F3P	DCMT 11T304-MM
Grade	IC 908	2220
No. of edges per insert	2	2
Cost per insert	Rs 615.00	Rs 732.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	1800	2000
Diameter (Dm) (mm)	5.2	5.2
Cutting speed (vc) (m/min)	29	33
Feed (fn) (mm/rev)	0.08	0.1
Cutting depth (ap) (mm)	0.35	0.35
Length of cut (mm)	32	32
No. of passes	1	1
Time in cut per component (min)	0.22	0.16
Block time per set-up (min)	0.22	0.16
Tool life (no.of components)	250	350
Tool life (minutes)	55.56	56
Tool life (meter)	8	11.2
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece