

Productivity Report

Bajaj Sons Ltd.

Project	RSV Link
Component	RSV LINK
Test ID	ADMIN-19111162317
Created by	Vaikunth Panchal
Date created	21-04-2019
Your reference	Mr.Santosh Rahane

Approved by



Test data

Component - RSV LINK

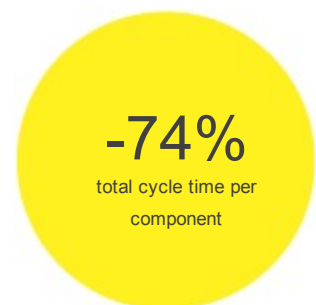
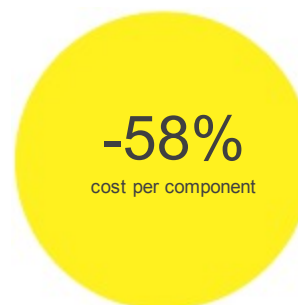
Component	RSV LINK
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	10000
No. of components per year	120000
Current situation	
Recommendation	

Machine - ACE Micromatics

Machine brand	ACE Micromatics
Machine ID	
Machine cost per hour	Rs 200
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 3.59 (+2.62)	Rs 0.97
Tool change cost	Rs 0.28 (+0.28)	Rs 0.00
Tool cost	Rs 0.18 (+0.1)	Rs 0.08
Insert cost	Rs 0.36 (-.31)	Rs 0.68
Indexing/Replacement cost	Rs 0.18 (+0.1)	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 4.31 (+2.51)	Rs 1.80
Total cycle time per set-up	1.21 (+0.87)	0.31



Recommendation

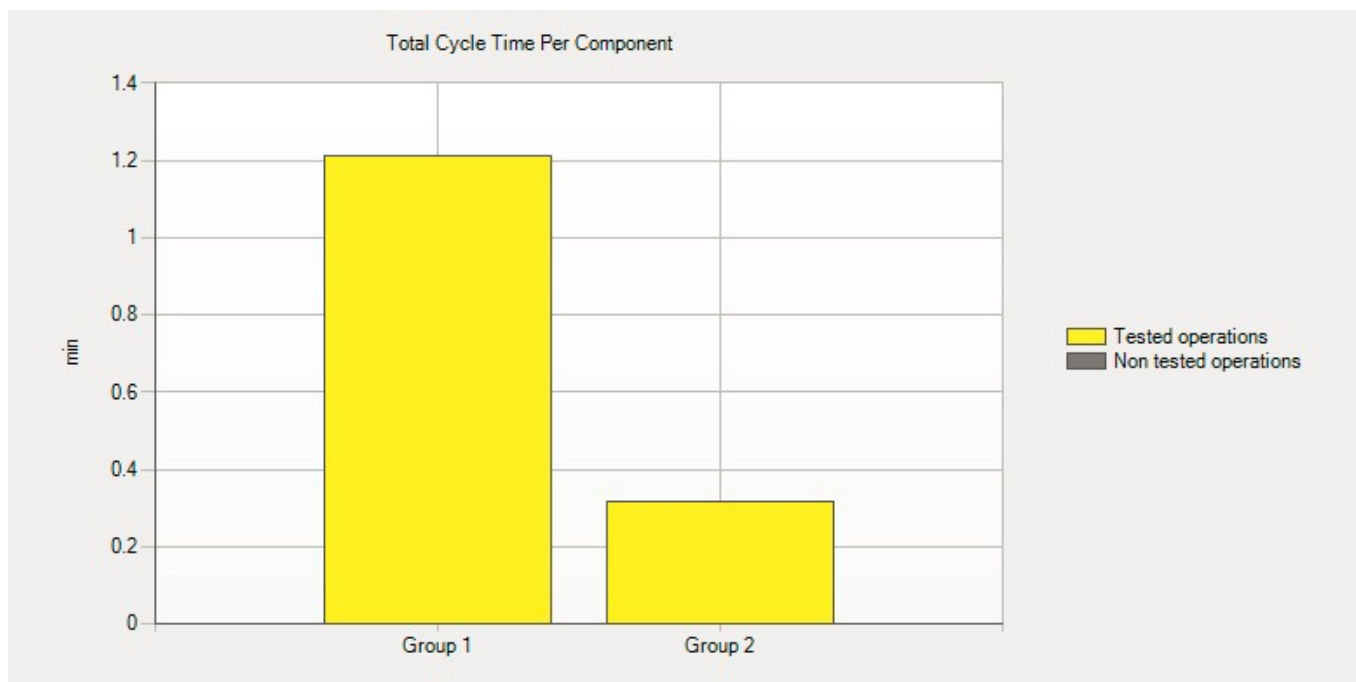
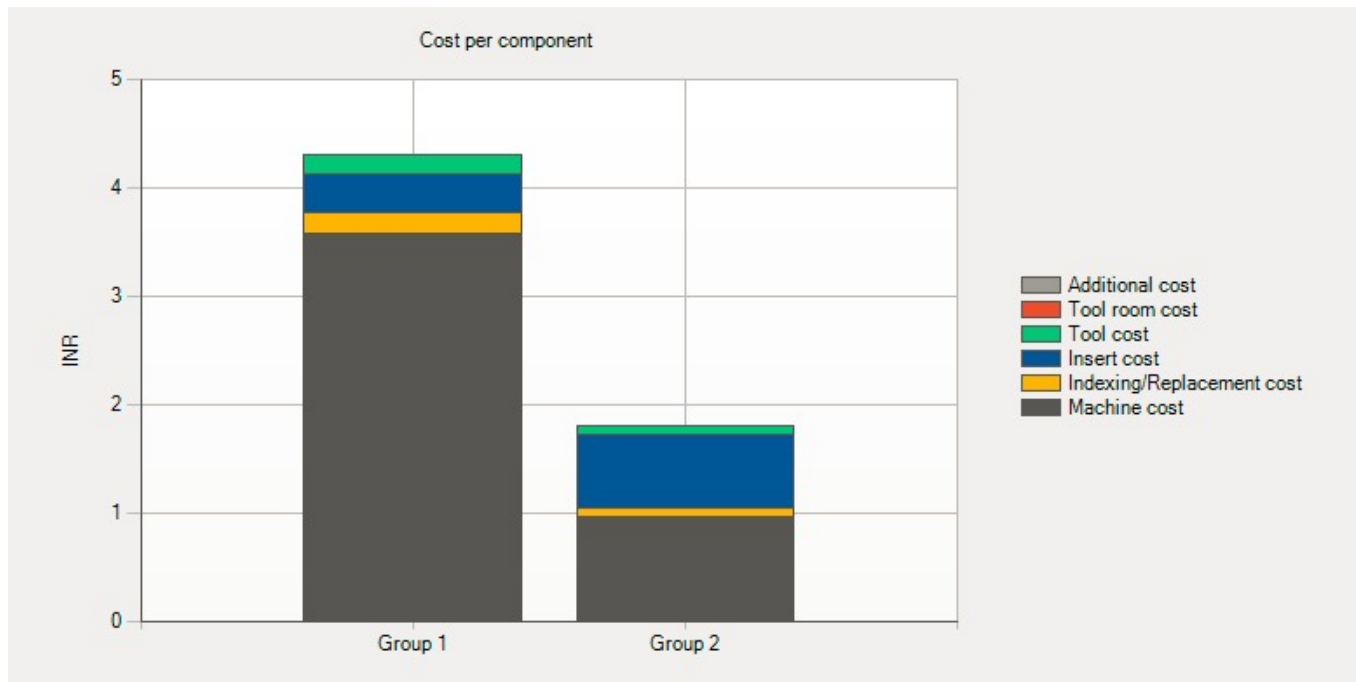
Productivity increase for recommended tools	286%
Productivity increase for total cycle time	286%
Savings in production time per year (h)	1799
Savings per component	Rs 2.51
Savings per unit	Rs 25,100.72
Savings per year	Rs 3,01,209





Charts

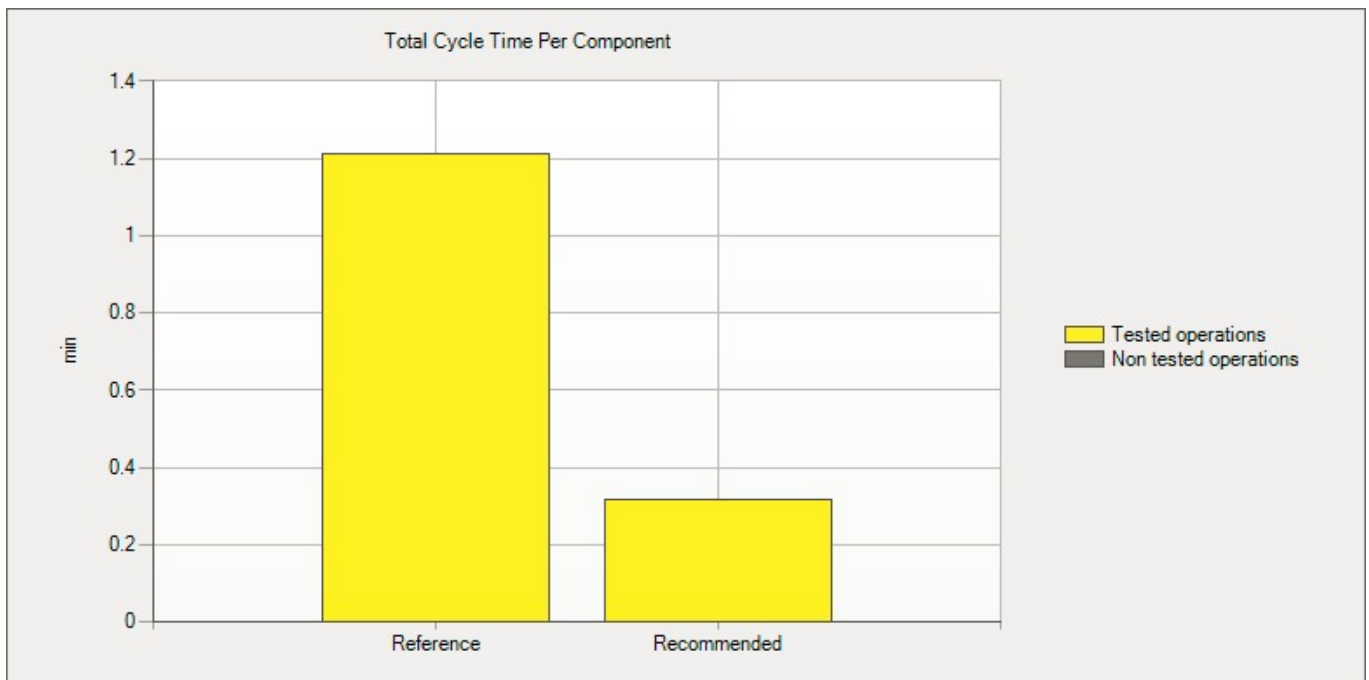
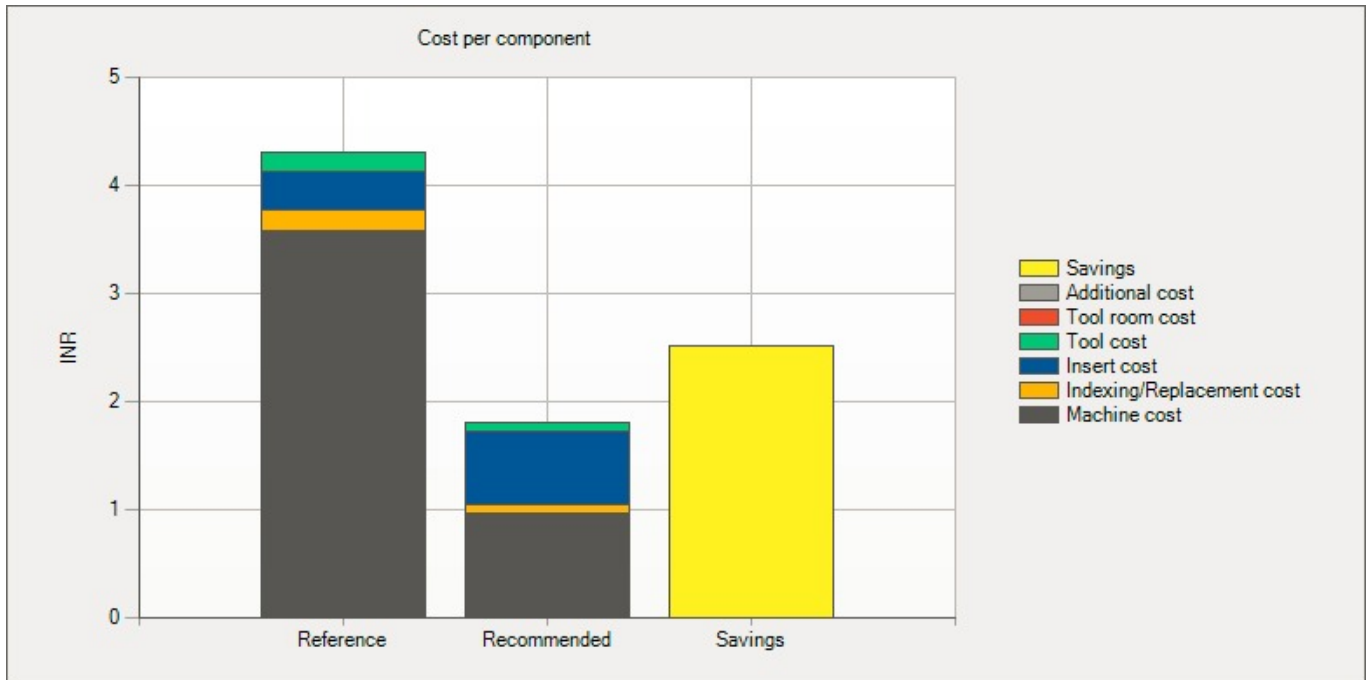
Group data





Charts

Recommendation





	Reference	Recommended
Sub-test name	Sub-test -2	Sub-test 2
Tool		
Manufacturer	TaeguTec	TaeguTec
Code	MTJNL 2525 M16	MWLN 2525M 08
Code (customer denomination)	MTJNL 2525 M16	MWLN 2525M 08
Cost	Rs 2,500.00	Rs 2,500.00
No. of insert indexes	150	150
Insert indexing time (min)	5	5
Insert		
Manufacturer	Ceratizit	Coromant
Code	TNMG 16 04 08	WNMG 08 04 08-PM
Code (customer denomination)	TNMG 16 04 08	WNMG 08 04 08-PM
Grade	CTS 18D	4335
No. of edges per insert	6	6
Cost per insert	Rs 200.00	Rs 885.00
No. of inserts	1	1
Cutting data		
Cut	Roughing	Roughing

	Reference	Recommended
Sub-test name	Sub-test -2	Sub-test 2
Spindle speed (n) (rev/min)	1000	1600
Diameter (Dm) (mm)	56	56
Cutting speed (vc) (m/min)	176	281
Feed (fn) (mm/rev)	0.08	0.16
Cutting depth (ap) (mm)	0.5	0.5
Length of cut (mm)	24	24
No. of passes	2	2
Time in cut per component (min)	0.59	0.19
Block time per set-up (min)	0.59	0.19
Tool life (no.of components)	208	400
Tool life (minutes)	123.69	74.33
Tool life (meter)	9.89	19.03
Tool change criteria	(13) Burr or spalling of workpiece	(25) Predetermined wear criterion



	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	TaeguTec	TaeguTec
Code	MTJNL 2525 M16	MWLN 2525M 08
Code (customer denomination)	MTJNL 2525 M16	MWLN 2525M 08
Cost	Rs 2,500.00	Rs 2,500.00
No. of insert indexes	150	150
Insert indexing time (min)	5	5
Insert		
Manufacturer	Ceratizit	Coromant
Code	TNMG 16 04 08	WNMG 08 04 08-PM
Code (customer denomination)	TNMG 16 04 08	WNMG 08 04 08-PM
Grade	CTS 18D	4335
No. of edges per insert	6	6
Cost per insert	Rs 200.00	Rs 885.00
No. of inserts	1	1
Cutting data		
Cut	Roughing	Roughing

	Reference	Recommended
Spindle speed (n) (rev/min)	1200	1600
Diameter (Dm) (mm)	27.7	27.7
Cutting speed (vc) (m/min)	104	139
Feed (fn) (mm/rev)	0.1	0.23
Cutting depth (ap) (mm)	0.5	0.75
Length of cut (mm)	20	20
No. of passes	3	2
Time in cut per component (min)	0.48	0.11
Block time per set-up (min)	0.48	0.11
Tool life (no.of components)	166	480
Tool life (minutes)	80	50.76
Tool life (meter)	9.6	18.68
Tool change criteria	(13) Burr or spalling of workpiece	(25) Predetermined wear criterion