

Productivity Report

MG INDUSTRIES

Project	CRI Nozzle
Component	CRI NOZZLE
Test ID	ADMIN-19361133847
Created by	Vaikunth Panchal
Date created	27-12-2019
Your reference	Mr.Sagar Changrani

Approved by



Component - CRI NOZZLE

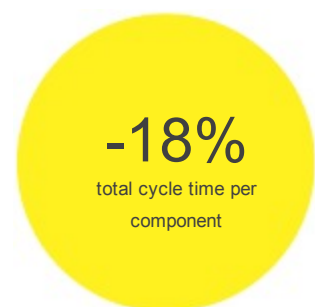
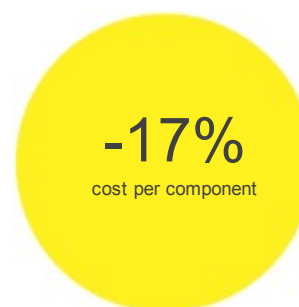
Component	CRI NOZZLE
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	200000
No. of components per year	2400000
Current situation	
Recommendation	

Machine - ACE MICROMATIC

Machine brand	ACE MICROMATIC
Machine ID	
Machine cost per hour	Rs 250
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 0.43 (+0.07)	Rs 0.36
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.09 (+0.03)	Rs 0.07
Insert cost	Rs 0.21 (+0.02)	Rs 0.19
Indexing/Replacement cost	Rs 0.04 (+0.01)	Rs 0.03
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 0.77 (+0.13)	Rs 0.64
Total cycle time per set-up	0.11 (+0.02)	0.09



Recommendation

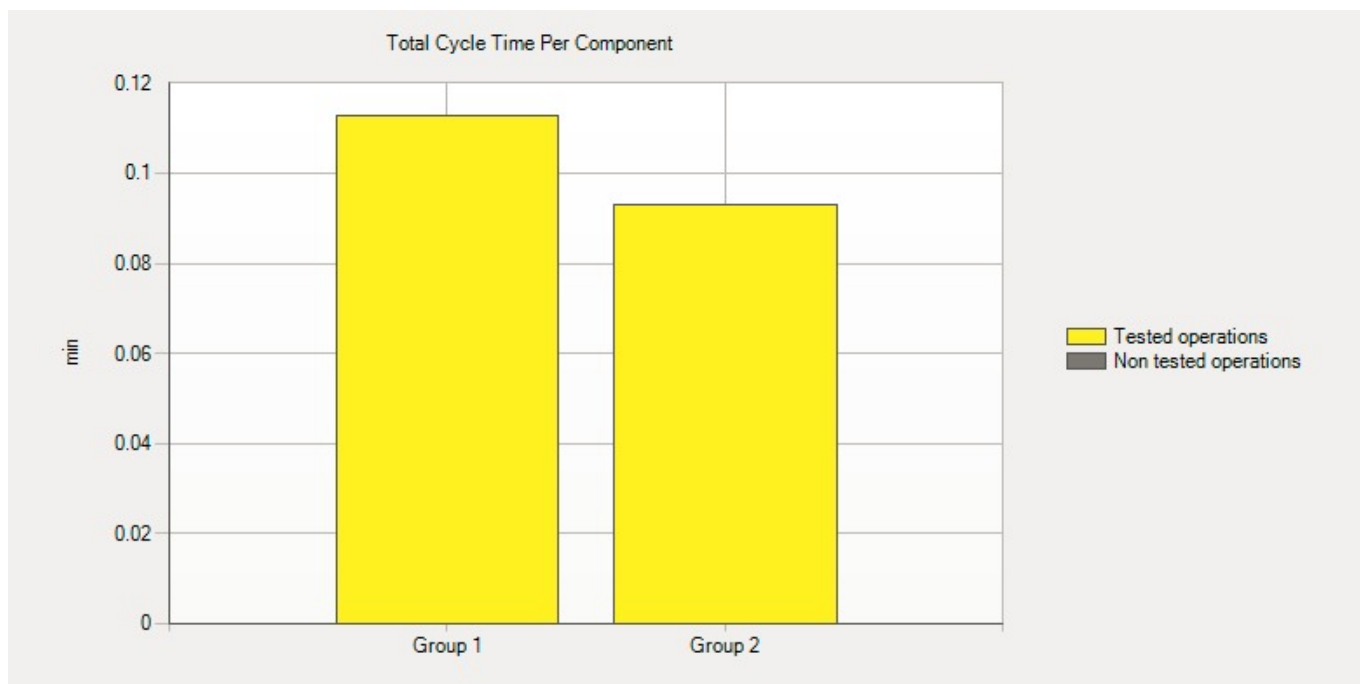
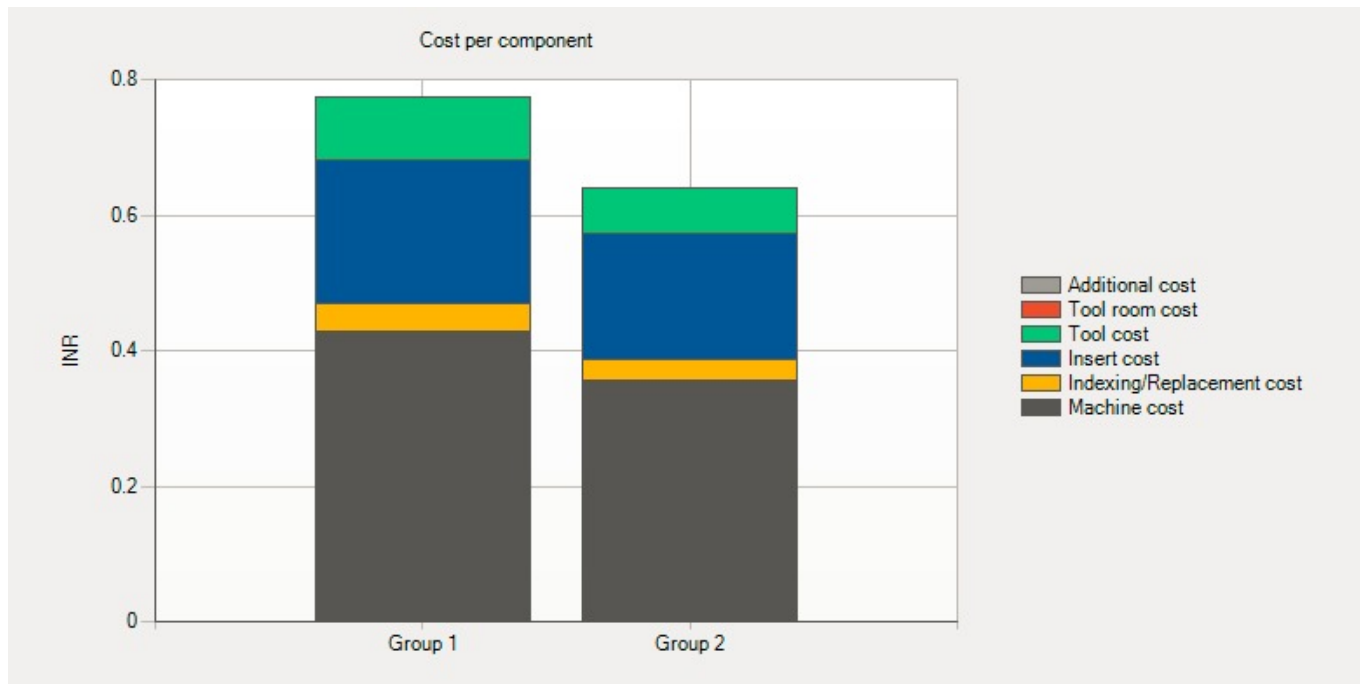
Productivity increase for recommended tools	22%
Productivity increase for total cycle time	22%
Savings in production time per year (h)	800
Savings per component	Rs 0.13
Savings per unit	Rs 26,925.71
Savings per year	Rs 3,23,109





Charts

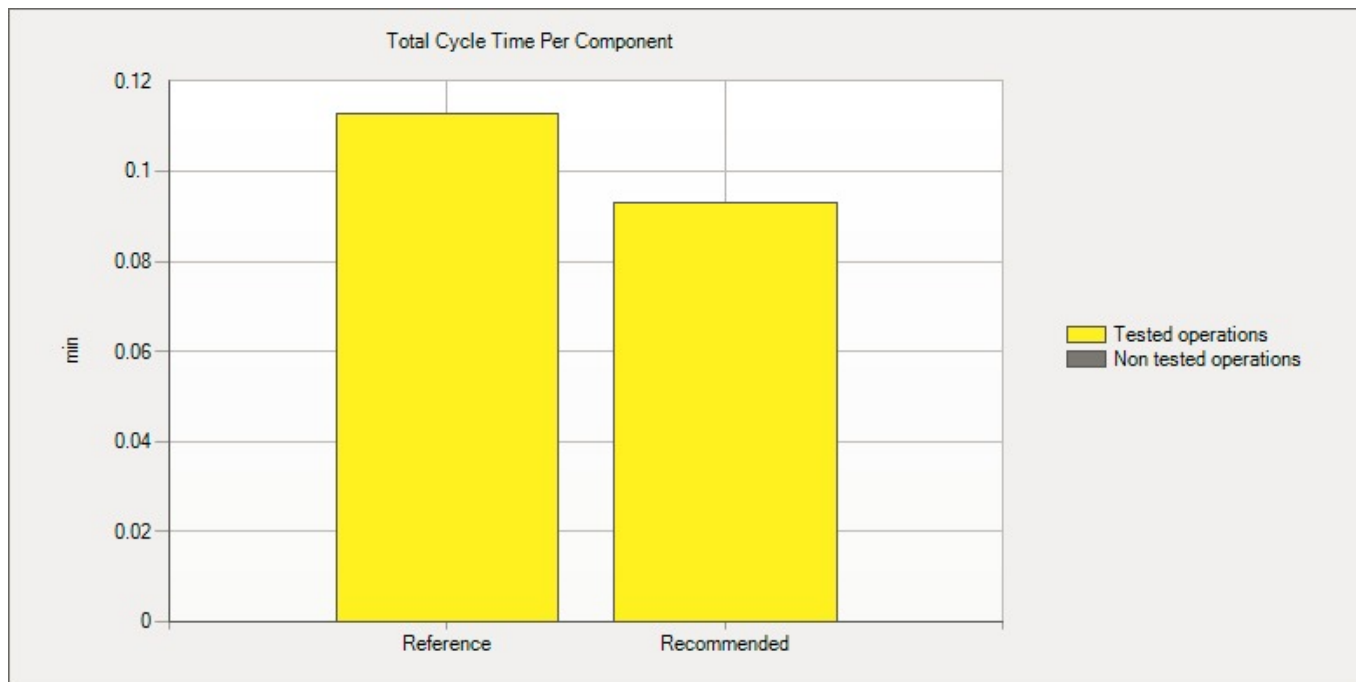
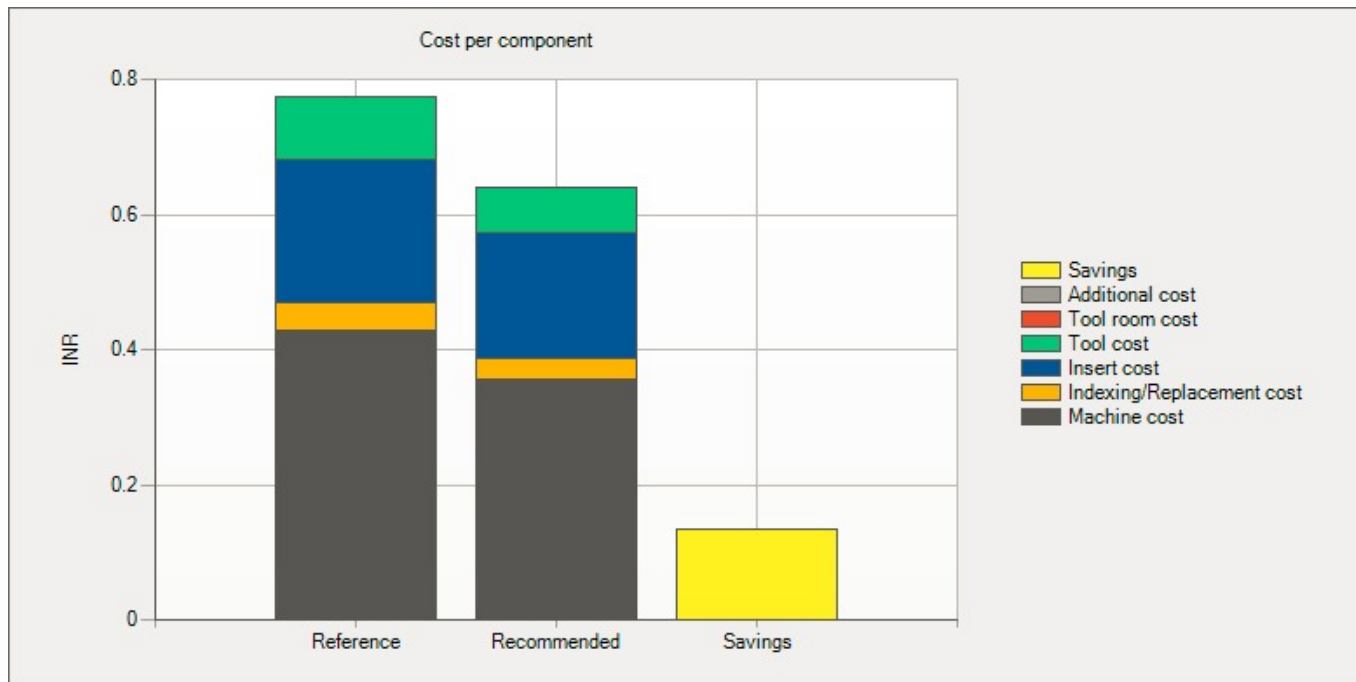
Group data

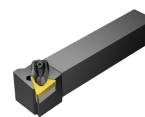
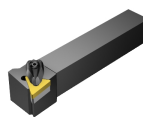




Charts

Recommendation





Reference

Recommended

Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Iscar
Code	DTJNL 2020K 16	DTJNL 2020K 16
Code (customer denomination)	DTJNL 2020K 16	DTJNL 2020K 16
Cost	Rs 4,600.00	Rs 4,600.00
No. of insert indexes	100	100
Insert indexing time (min)	5	5
Insert		
Manufacturer	Iscar	Coromant
Code	TNMG 160404-GN	TNMG 160404-MF
Code (customer denomination)	TNMG 160404-GN	TNMG 160404-MF
Grade	IC907	1115
No. of edges per insert	6	6
Cost per insert	Rs 634.00	Rs 783.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing

	Reference	Recommended
Spindle speed (n) (rev/min)	3500	3500
Diameter (Dm) (mm)	7.9	7.9
Cutting speed (vc) (m/min)	87	87
Feed (fn) (mm/rev)	0.1	0.12
Cutting depth (ap) (mm)	0.25	0.25
Length of cut (mm)	36	36
No. of passes	1	1
Time in cut per component (min)	0.1	0.09
Block time per set-up (min)	0.1	0.09
Tool life (no.of components)	500	700
Tool life (minutes)	51.43	60
Tool life (meter)	18	25.2
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece