Productivity Report

Sunbeam Industries

Project	Shaft
Component	Shaft
Test ID	ADMIN-19179151234
Created by	Vaikunth Panchal
Date created	28-06-2019
Your reference	Mr.Aniket Savaji

Approved by

Sunbeam Industries
Mr.Aniket Savaji

Sandvik Coromant
Vaikunth Panchal

SANDVIK Coromant

Test data

Component - Shaft

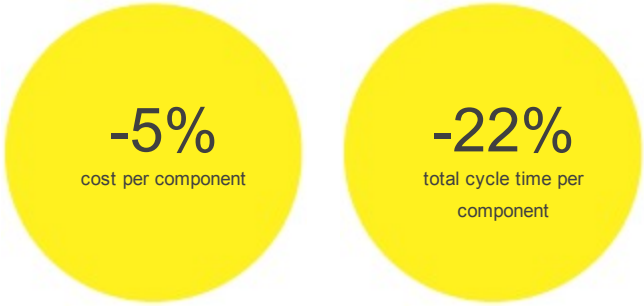
Component	Shaft
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	15000
No. of components per year	180000
Current situation	
Recommendation	

Machine - Haas

Machine brand	Haas
Machine ID	
Machine cost per hour	Rs 400
Tool room cost per hour	Rs 0

Analysis per component

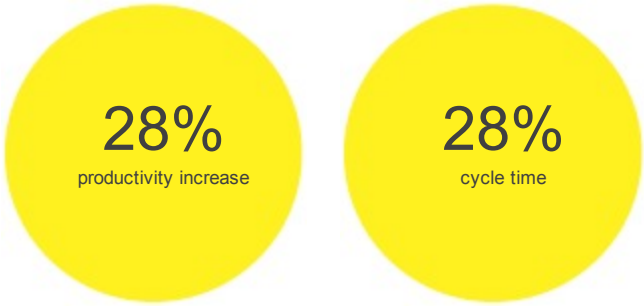
	Reference	Recommended
Machine cost	Rs 9.41 (+2.08)	Rs 7.33
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.42 (-.12)	Rs 0.54
Insert cost	Rs 3.33 (-1.21)	Rs 4.54
Indexing/Replacement cost	Rs 0.11 (-.02)	Rs 0.13
Tool room cost	Rs 0.00 (+0)	Rs 0.00
Scrap cost	Rs 0.00 (+0)	Rs 0.00
Rework cost	Rs 0.00 (+0)	Rs 0.00
Additional cost	Rs 0.00 (+0)	Rs 0.00
Total cost	Rs 13.27 (+0.72)	Rs 12.55
Total cycle time per set-up	1.43 (+0.31)	1.12



Productivity result

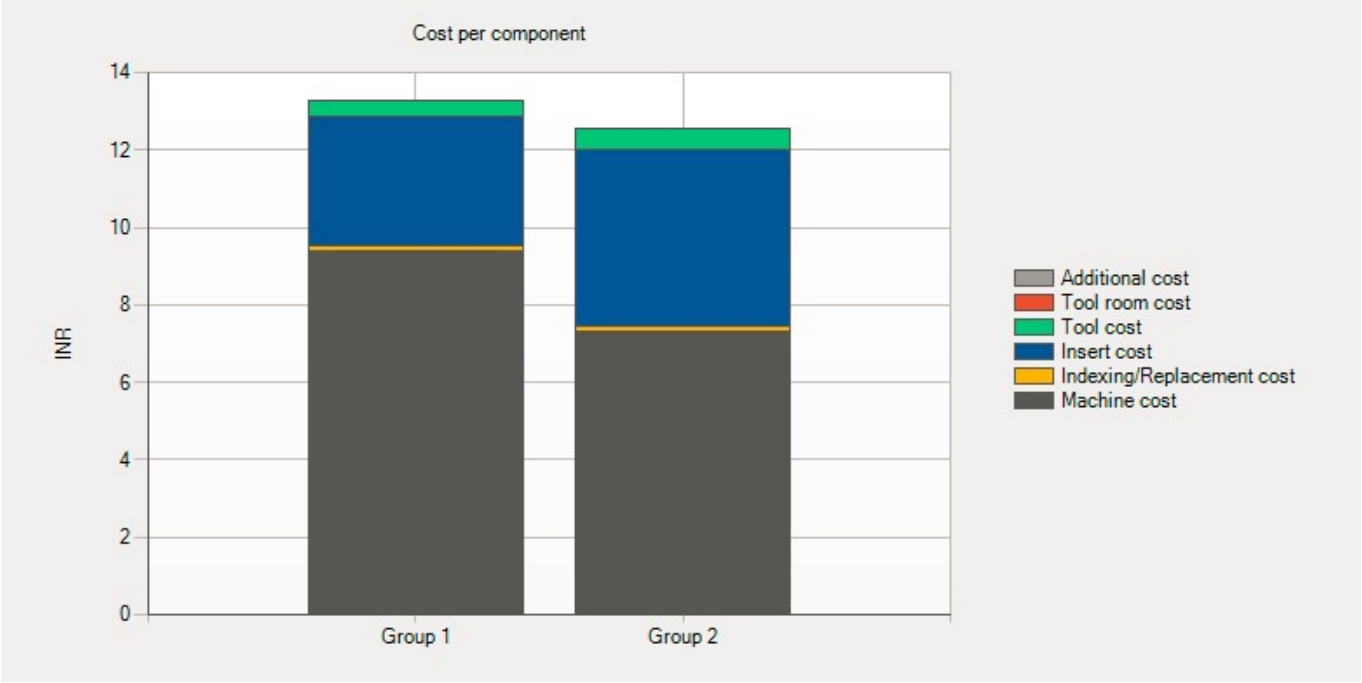
Recommendation

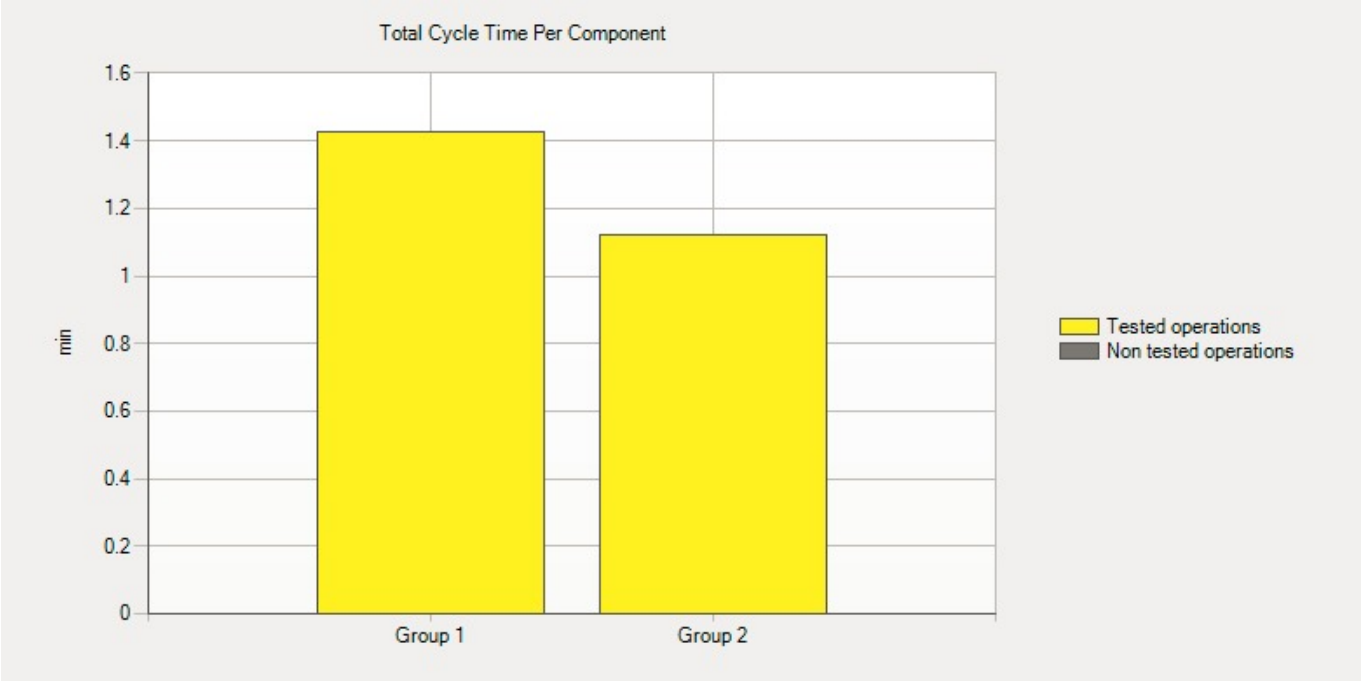
Productivity increase for recommended tools	28%
Productivity increase for total cycle time	28%
Savings in production time per year (h)	**925**
Savings per component	Rs 0.72
Savings per unit	Rs 10,832.47
Savings per year	**Rs 1,29,990**



Charts

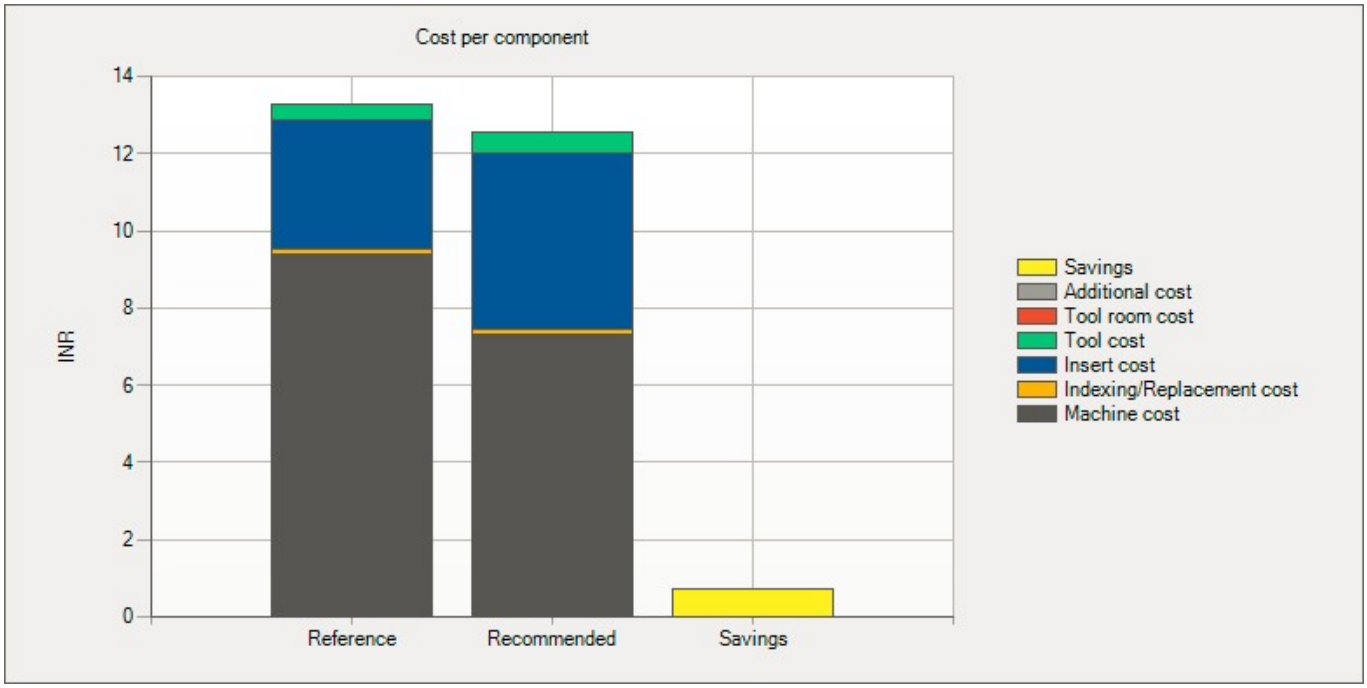
Group data

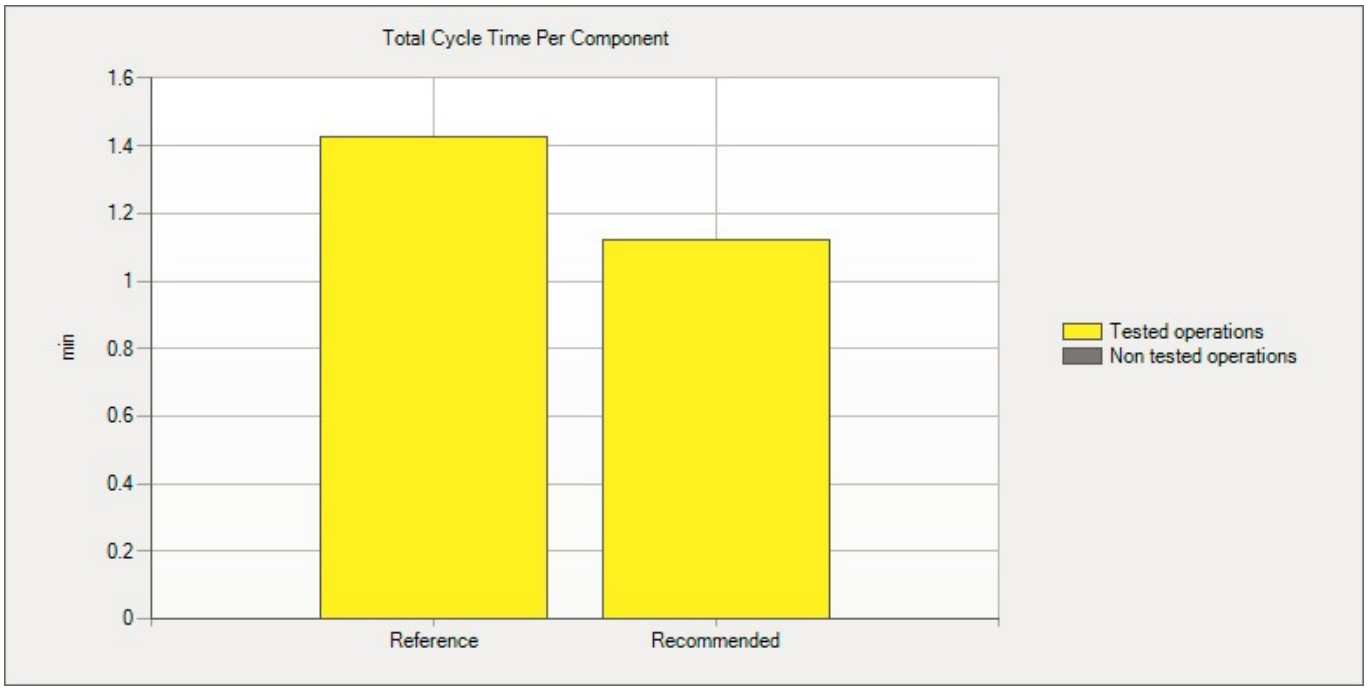




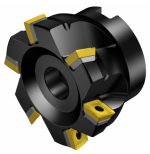
Charts

Recommendation





Sub-test



	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	HM390FTPD040-5-16-10	490-040Q16-08M
Code (customer denomination)	HM390FTPD040-5-16-10	490-040Q16-08M
No. of inserts (zn)	5	4
Cost	Rs 25,000.00	Rs 27,000.00
No. of insert indexes	200	200
Insert indexing time (min)	5	5
Insert		
Manufacturer	Iscar	Coromant
Code	TPKT 100308PDR	490R-08T308M-MM
Code (customer denomination)	TPKT 100308PDR	490R-08T308M-MM
Grade	IC 908	1040
No. of edges per insert	3	4
Cost per insert	Rs 600.00	Rs 1,136.00
No. of inserts	5	4
Cutting data		

Sub-test

	Reference	Recommended
Spindle speed (n) (rev/min)	1353	1432
Cutting speed (vc) (m/min)	170	180
Feed per cutting edge (fz) (mm)	0.22	0.16
Feed speed (vf) (mm/min)	907	900
Axial depth of cut (ap) (mm)	0.7	1
Working engagement (ae) (mm)	37	37
Time in cut per component (min)	1.41	1.1
Block time per set-up (min)	1.41	1.1
Tool life (no.of components)	300	250
Tool life (minutes)	423.53	275
Tool life (meter)	456	247.5
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece