

Productivity Report

SHALAKA SHAFT

Project	SHALAKA SHAFT
Component	SAHFT
Test ID	ADMIN-183209101
Created by	Sahebrao Shinde
Date created	16-08-2018
Your reference	MR VASANT
Distribution	MR JITU MR DEEPAK

Approved by

SHALAKA SHAFT
MR VASANT

Sandvik Coromant
Sahebrao Shinde



Component - SAHFT

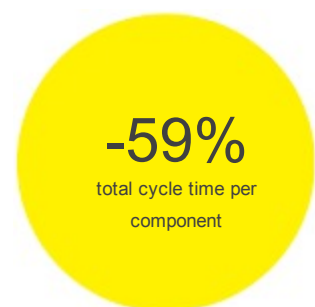
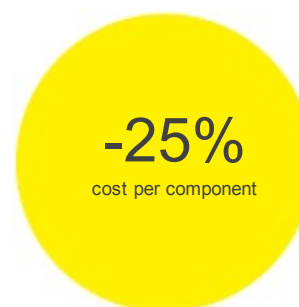
Component	SAHFT
CMC code	01.4
MC Code	
No. of components per set-up	1
no.of components (month)	300
No. of components per year	3600
Current situation	
Recommendation	

Machine - JYOTI

Machine brand	JYOTI
Machine ID	O1
Machine cost per hour	Rs 300
Tool room cost per hour	Rs 0

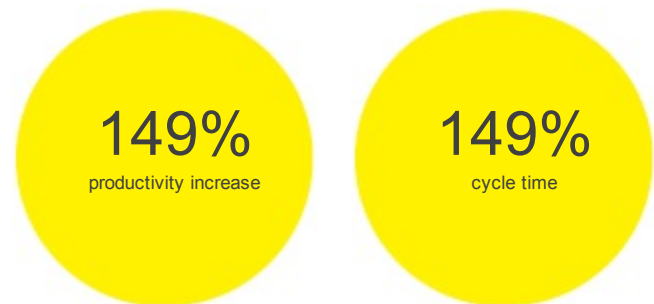
Analysis per component

	Reference	Recommended
Machine cost	Rs 9.42 (+5.65)	Rs 3.77
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.10 (+0.03)	Rs 0.07
Insert cost	Rs 2.67 (-2.61)	Rs 5.28
Indexing/Replacement cost	Rs 0.08 (+0.03)	Rs 0.06
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 12.28 (+3.1)	Rs 9.18
Total cycle time per set-up	1.90 (+1.13)	0.77



Recommendation

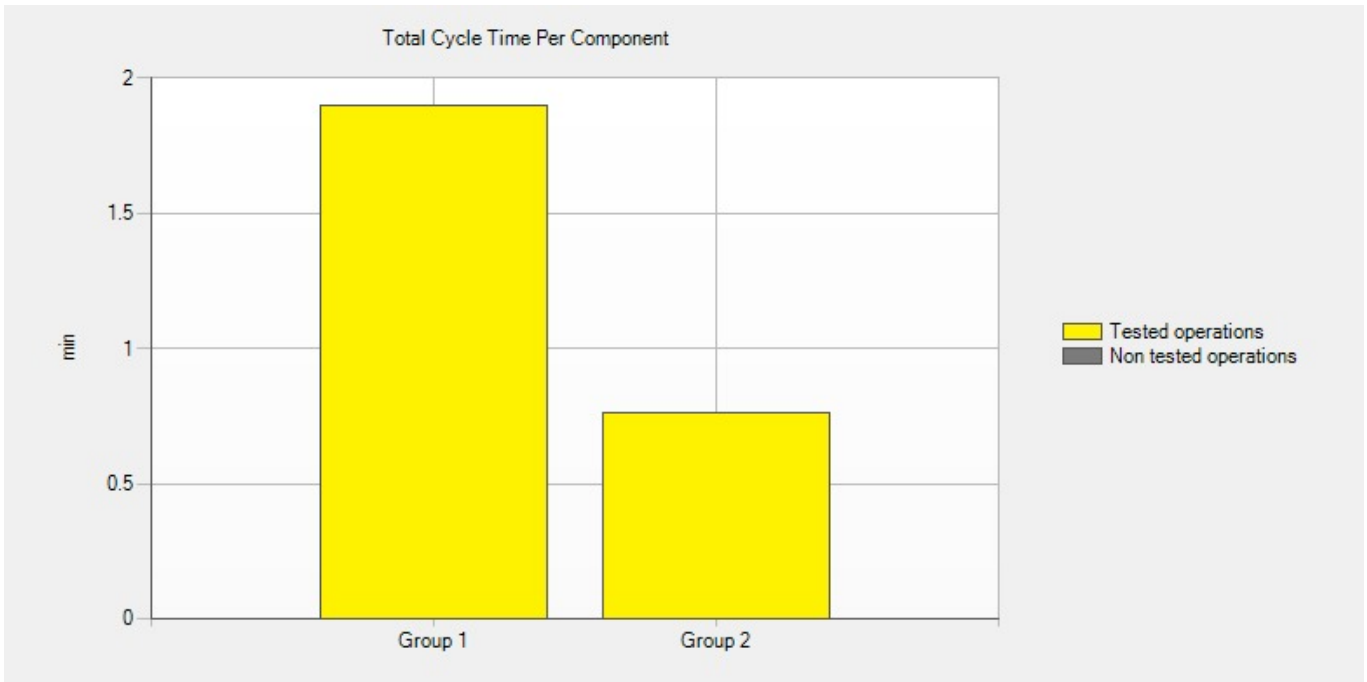
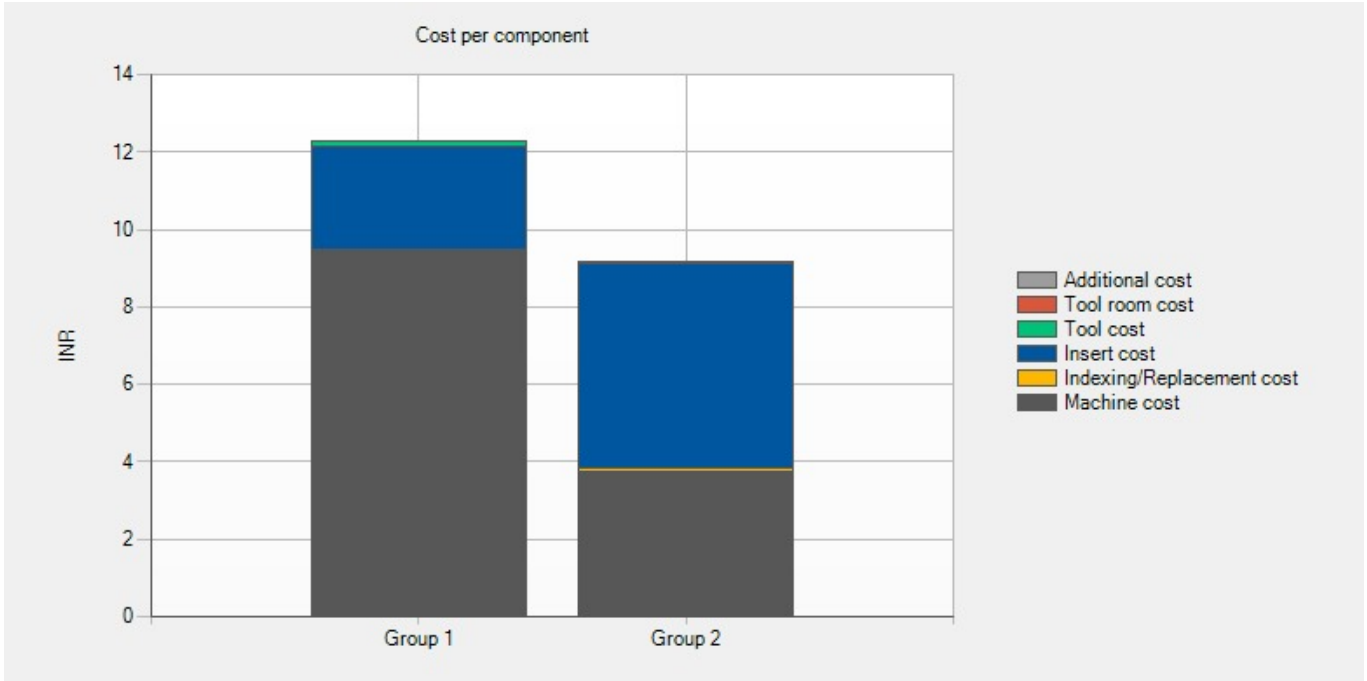
Productivity increase for recommended tools	149%
Productivity increase for total cycle time	149%
Savings in production time per year (h)	68
Savings per component	Rs 3.10
Savings per unit	Rs 930.27
Savings per year	Rs 11,163





Charts

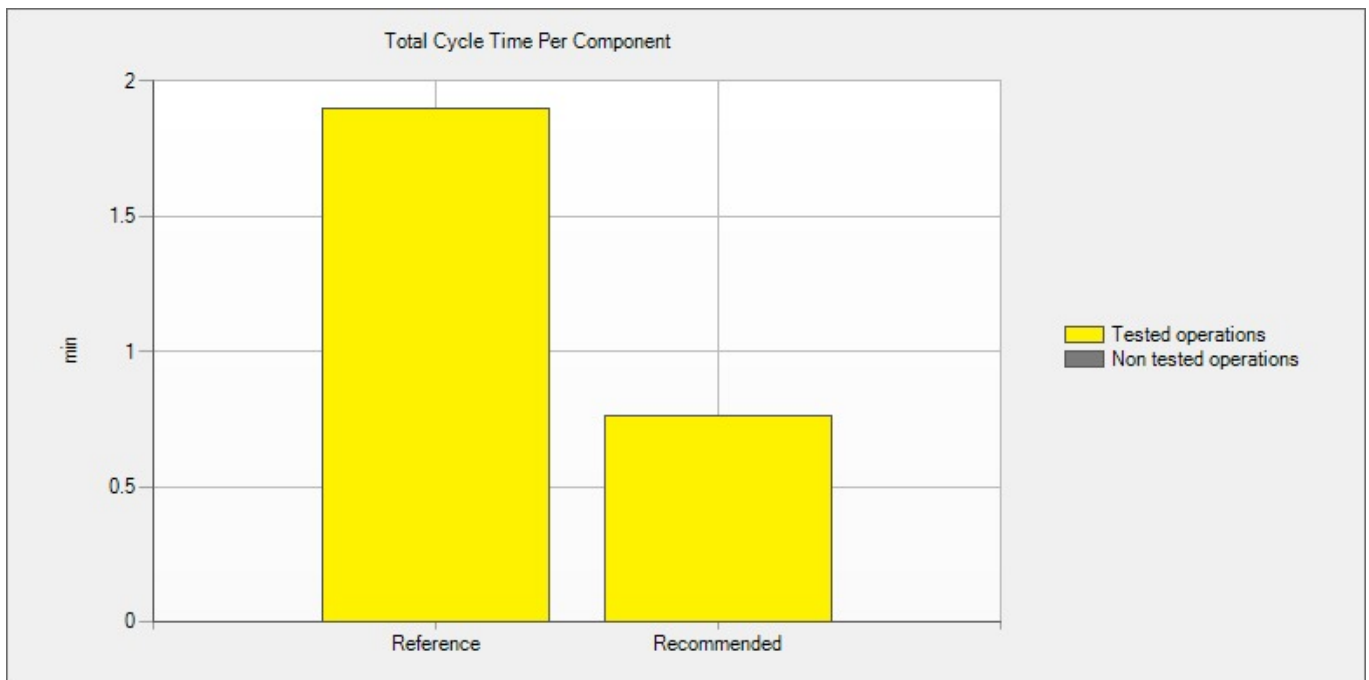
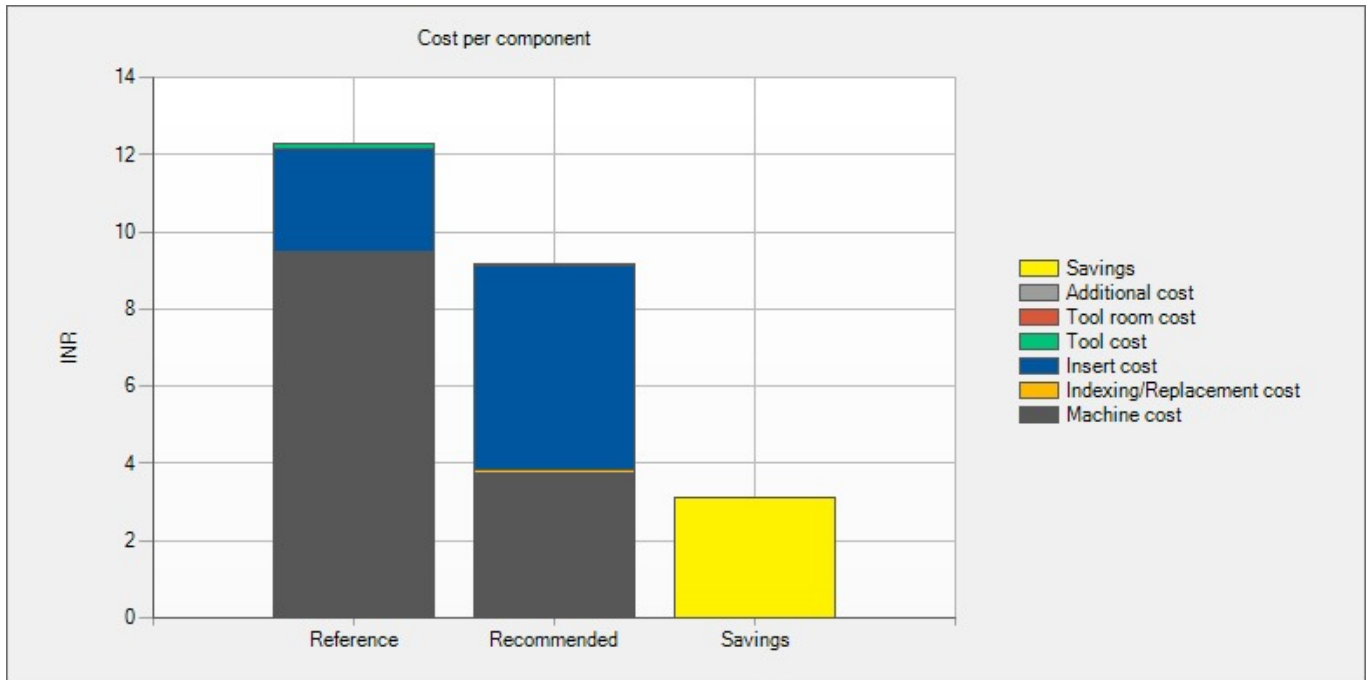
Group data





Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Coromant	Coromant
Code	SVJBL 2525 16	SVJBL 2525 M16
Cost	Rs 6,100.00	Rs 6,100.00
No. of insert indexes	1000	1000
Insert indexing time (min)	1	1
Insert		
Manufacturer	TaeguTec	Coromant
Code	VBMT 16 T3 02-	VBMT 16 T3 02-PF 5015
Grade	8125	5015
No. of edges per insert	2	2
Cost per insert	Rs 320.00	Rs 940.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing
Spindle speed (n) (rev/min)	1592	2387
Diameter (Dm) (mm)	28	28

	Reference	Recommended
Cutting speed (vc) (m/min)	140	210
Feed (fn) (mm/rev)	0.06	0.1
Cutting depth (ap) (mm)	0.4	0.4
Length of cut (mm)	180	180
No. of passes	1	1
Time in cut per component (min)	1.88	0.75
Block time per set-up (min)	1.88	0.75
Tool life (no.of components)	60	89
Tool life (minutes)	113.1	67.1
Tool life (meter)	10.8	16.02
Tool change criteria	(12) Workpiece out of tolerance	(11) Bad surface finish on workpiece