

# Productivity Report

## SMP AUTO

Project	SMP Auto
Component	PIN
Test ID	ADMIN-1832092432
Created by	Sahebrao Shinde
Date created	16-06-2018
Your reference	MR Avinash
Distribution	MR Bhushan

Approved by

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SMP AUTO  
MR Avinash

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Sandvik Coromant  
Sahebrao Shinde



## Test data

### Component - PIN

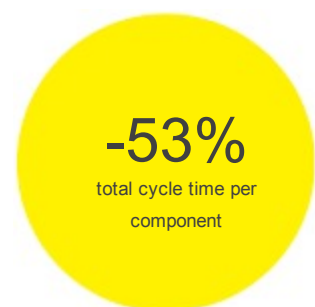
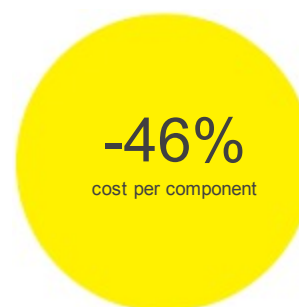
Component	PIN
CMC code	01.2
MC Code	
No. of components per set-up	1
no.of components (month)	4000
No. of components per year	48000
Current situation	
Recommendation	

### Machine - SUGAMI

Machine brand	SUGAMI
Machine ID	02
Machine cost per hour	Rs 1,000
Tool room cost per hour	Rs 0

## Analysis per component

	Reference	Recommended
Machine cost	Rs 2.80 (+1.49)	Rs 1.31
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.03 (+0.01)	Rs 0.02
Insert cost	Rs 0.18 (-.08)	Rs 0.27
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
<b>Total cost</b>	<b>Rs 3.10 (+1.44)</b>	<b>Rs 1.66</b>
<b>Total cycle time per set-up</b>	<b>0.17 (+0.09)</b>	<b>0.08</b>



## Recommendation

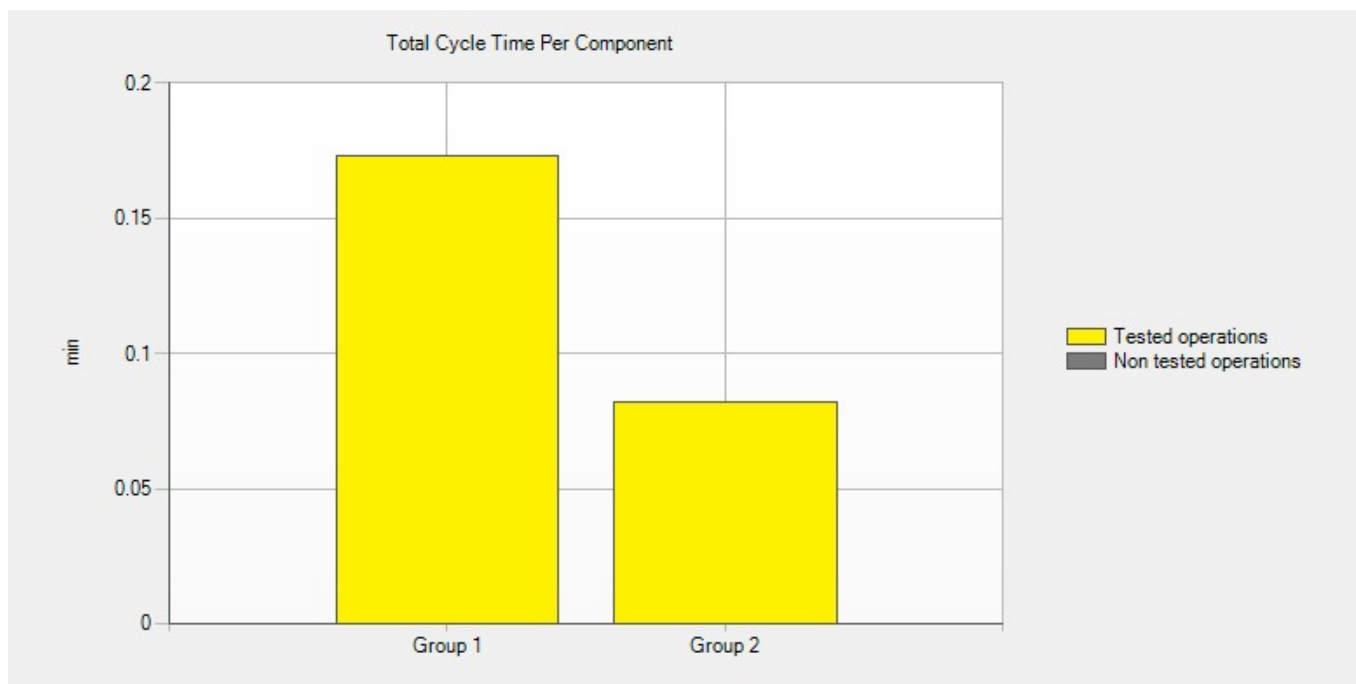
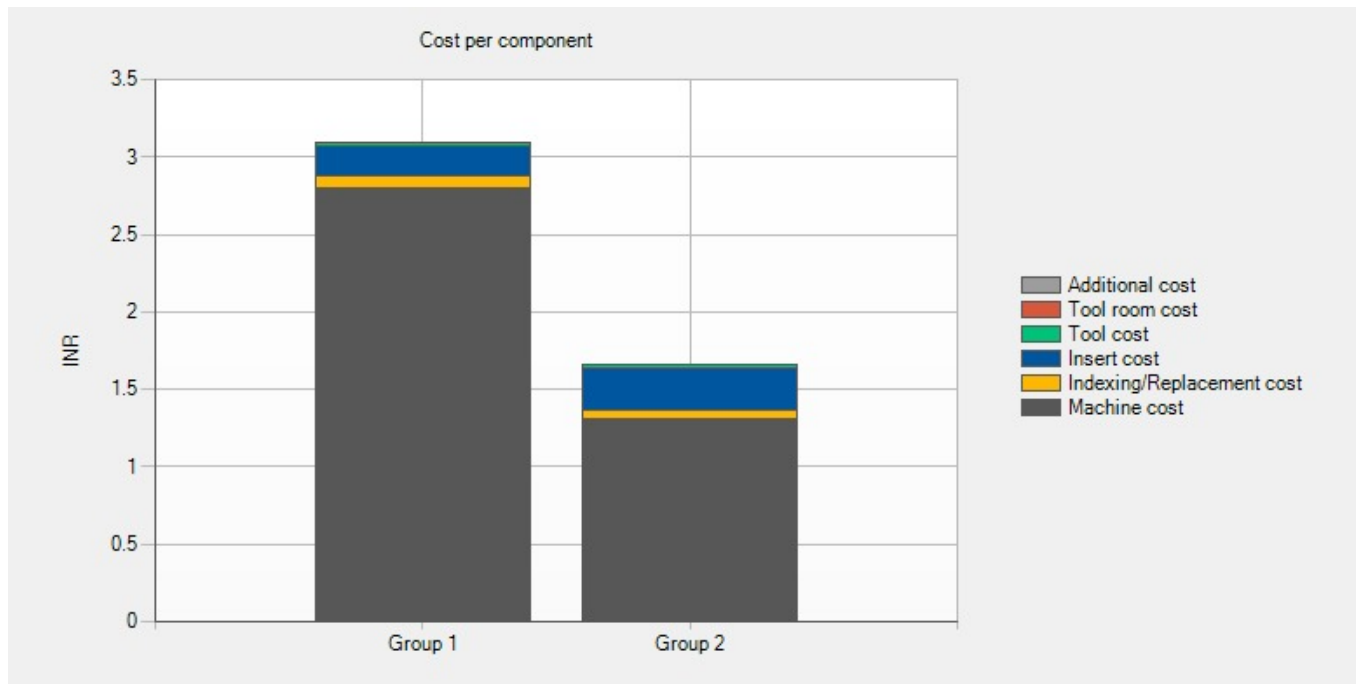
Productivity increase for recommended tools	110%
Productivity increase for total cycle time	110%
<b>Savings in production time per year (h)</b>	<b>73</b>
Savings per component	Rs 1.44
Savings per unit	Rs 5,760.52
<b>Savings per year</b>	<b>Rs 69,126</b>





# Charts

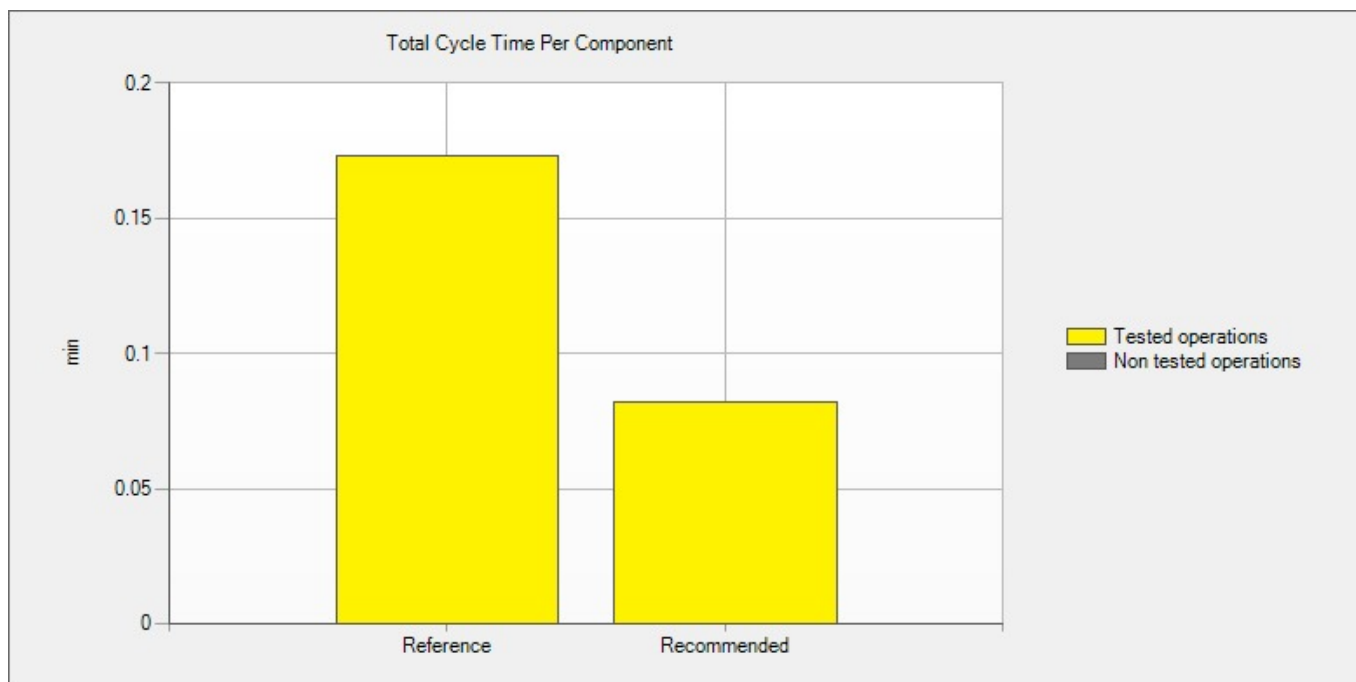
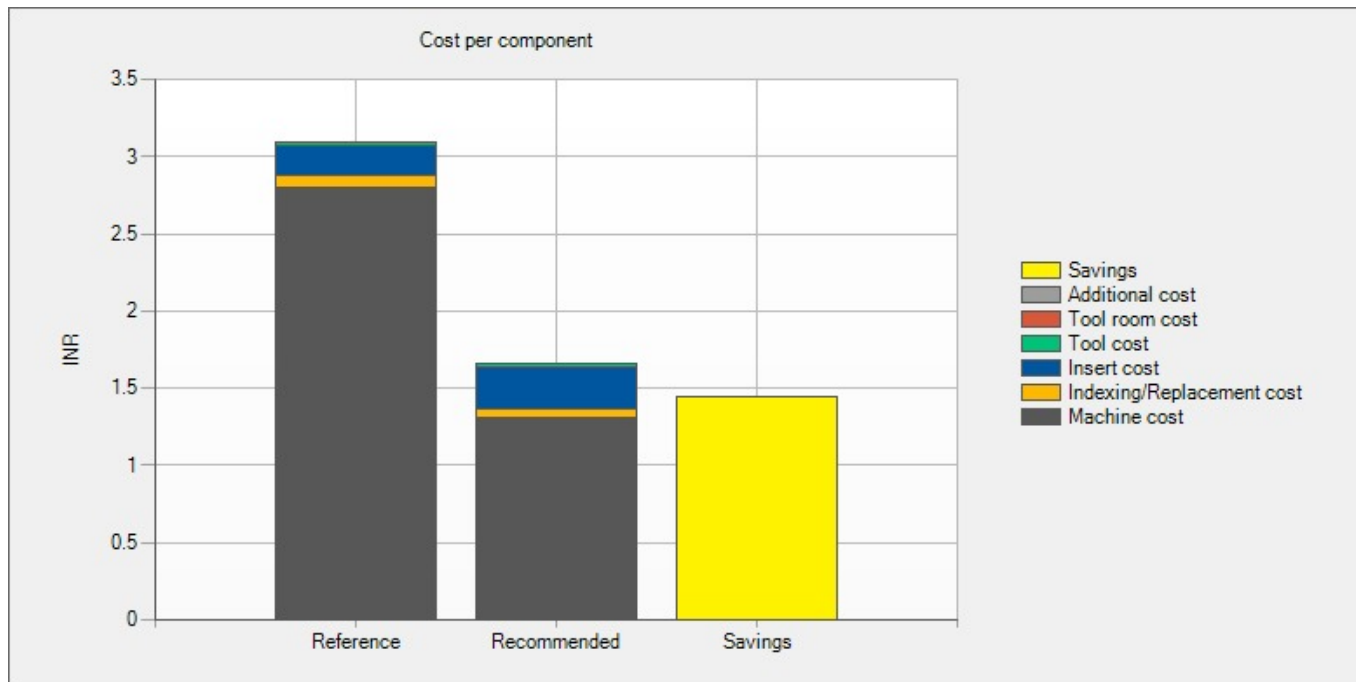
## Group data





# Charts

## Recommendation





## Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Coromant	Coromant
Code	MTJNL 2525 M16	MTJNL 2525M16
Cost	Rs 6,190.00	Rs 6,190.00
No. of insert indexes	1000	1000
Insert indexing time (min)	1	1
Insert		
Manufacturer	Iscar	Coromant
Code	TNMG 16 04 08 IC	TNMG 16 04 08-PM
Grade	908	4325
No. of edges per insert	6	6
Cost per insert	Rs 220.00	Rs 480.00
No. of inserts	1	1
Cutting data		
Cut	Roughing	Finishing
Spindle speed (n) (rev/min)	2728	3486
Diameter (Dm) (mm)	21	21

	Reference	Recommended
Cutting speed (vc) (m/min)	180	230
Feed (fn) (mm/rev)	0.15	0.25
Cutting depth (ap) (mm)	2	2
Length of cut (mm)	38	38
No. of passes	2	2
Time in cut per component (min)	0.17	0.08
Block time per set-up (min)	0.17	0.08
Tool life (no.of components)	200	300
Tool life (minutes)	33.6	23.67
Tool life (meter)	13.75	20.63
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece