

Productivity Report

SMP AUTO

Project	SMP AUTO
Component	PIN 20 Dia
Test ID	ADMIN-18293133313
Created by	Sahebrao Shinde
Date created	20-06-2018
Your reference	MR AVINASH
Distribution	MR BHUSHAN

Approved by

SMP AUTO
MR AVINASH

Sandvik Coromant
Sahebrao Shinde



Test data

Component - PIN 20 Dia

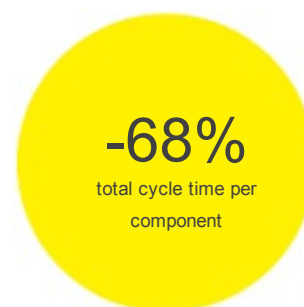
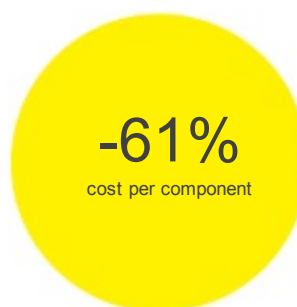
Component	PIN 20 Dia
CMC code	
MC Code	
No. of components per set-up	1
no.of components (month)	5000
No. of components per year	60000
Current situation	
Recommendation	

Machine - SUGAMI

Machine brand	SUGAMI
Machine ID	07
Machine cost per hour	Rs 500
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 2.81 (+1.9)	Rs 0.91
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.01 (+0.01)	Rs 0.00
Insert cost	Rs 0.22 (-.06)	Rs 0.28
Indexing/Replacement cost	Rs 0.02 (+0.01)	Rs 0.01
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 3.06 (+1.86)	Rs 1.20
Total cycle time per set-up	0.34 (+0.23)	0.11



Recommendation

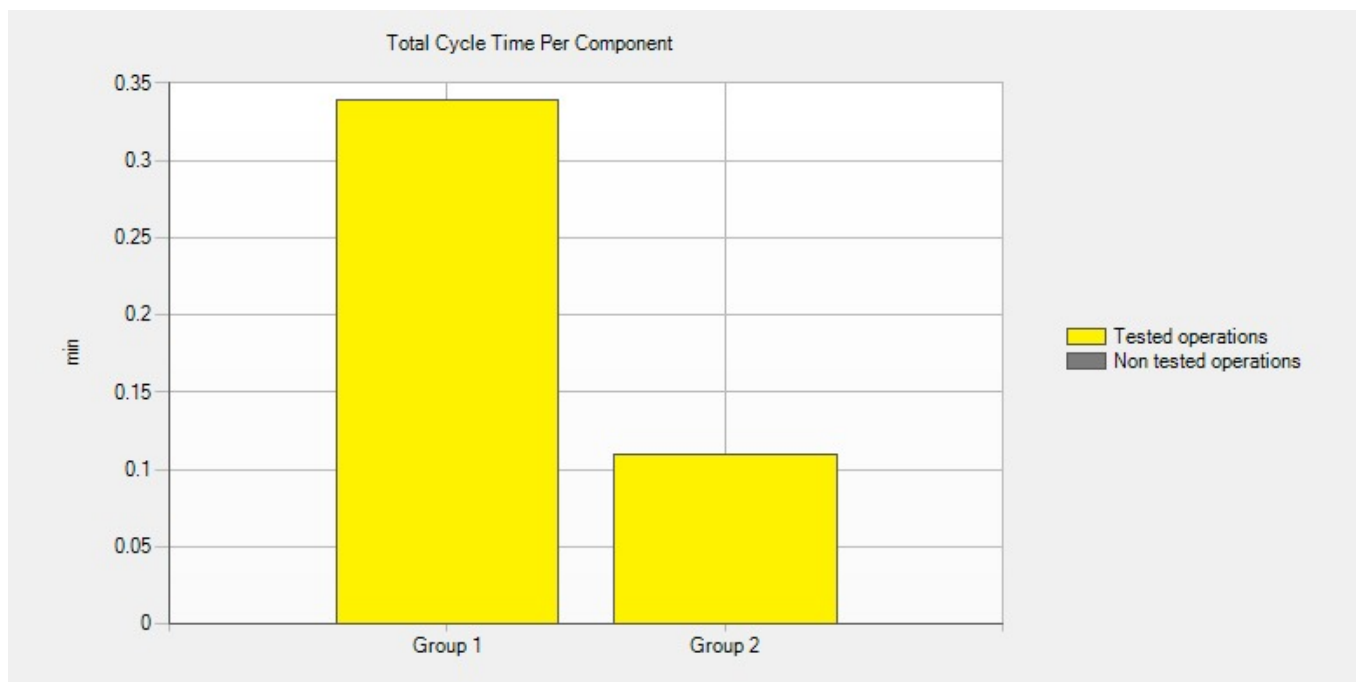
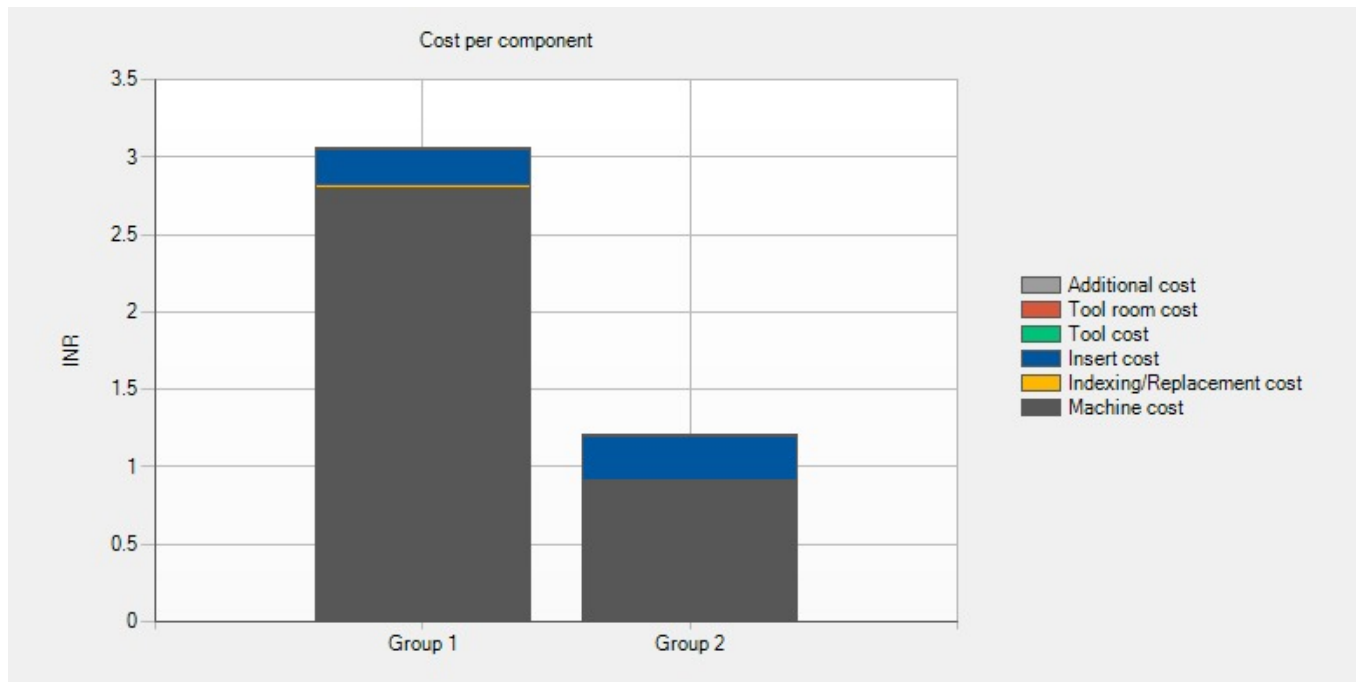
Productivity increase for recommended tools	208%
Productivity increase for total cycle time	208%
Savings in production time per year (h)	229
Savings per component	Rs 1.86
Savings per unit	Rs 9,293.84
Savings per year	Rs 1,11,526





Charts

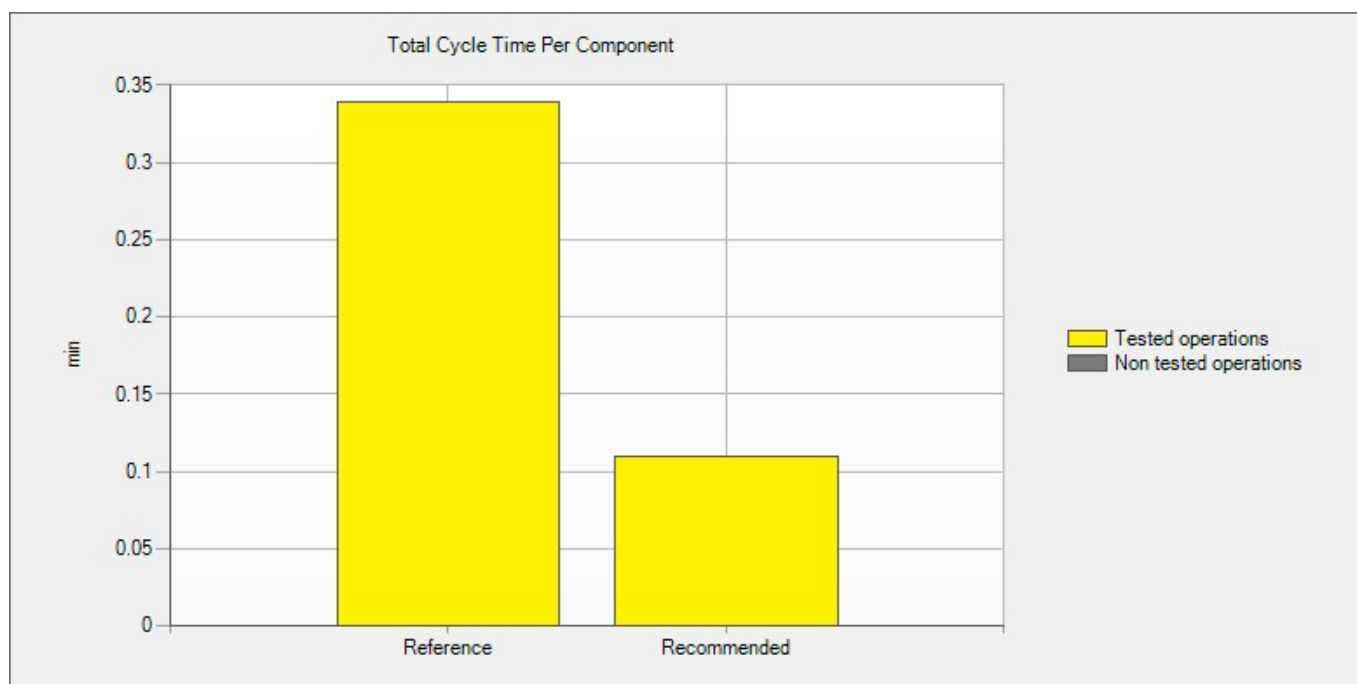
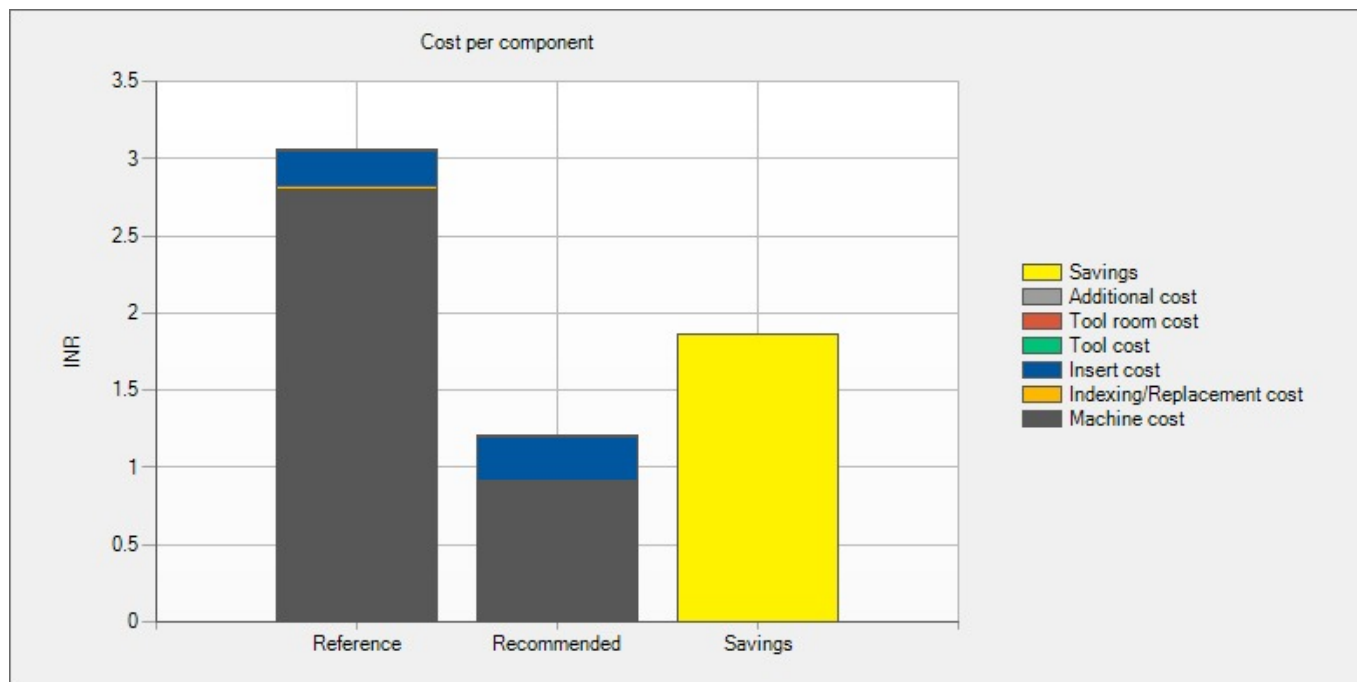
Group data





Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Coromant	Coromant
Code	PDJNL 2525-15	PDJNL 2525-15
Code (customer denomination)	PDJNL 2525-15	
Cost	Rs 4,300.00	Rs 4,300.00
No. of insert indexes	1000	1000
Insert indexing time (min)	1	1
Insert		
Manufacturer	TaeguTec	Coromant
Code	DNMG 15 06 08	DNMG 15 06 08-PM
Grade	8125	4325
No. of edges per insert	4	4
Cost per insert	Rs 350.00	Rs 1,090.00
No. of inserts	1	1
Cutting data		
Cut	Finishing	Finishing
Spindle speed (n) (rev/min)	2228	3820

	Reference	Recommended
Diameter (Dm) (mm)	20	20
Cutting speed (vc) (m/min)	140	240
Feed (fn) (mm/rev)	0.1	0.18
Cutting depth (ap) (mm)	1	1
Length of cut (mm)	75	75
No. of passes	1	1
Time in cut per component (min)	0.34	0.11
Block time per set-up (min)	0.34	0.11
Tool life (no.of components)	390	970
Tool life (minutes)	131.27	105.81
Tool life (meter)	29.25	72.75
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece