

Productivity Report

Tushar Pricocom

Project	TUSHAR Pricocom
Component	DR 4500
Test ID	ADMIN-183334758
Created by	Sahebrao Shinde
Date created	29-11-2018
Your reference	Mr Anil Patil
Distribution	Mr ASHISH Roy

Approved by

Tushar Pricocom
Mr Anil Patil

Sandvik Coromant
Sahebrao Shinde



Test data

Component - DR 4500

Component	DR 4500
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 - MAZAK

Machine brand	MAZAK
Machine ID	02
Machine cost per hour	Rs 500
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 2.12 (+1.54)	Rs 0.58
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.33 (+0.13)	Rs 0.20
Insert cost	Rs 23.33 (-11.04)	Rs 34.38
Indexing/Replacement cost	Rs 0.07 (+0.02)	Rs 0.05
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 25.85 (-9.35)	Rs 35.20
Total cycle time per set-up	0.26 (+0.18)	0.08

+36%

cost per component

-69%

total cycle time per
component

Recommendation

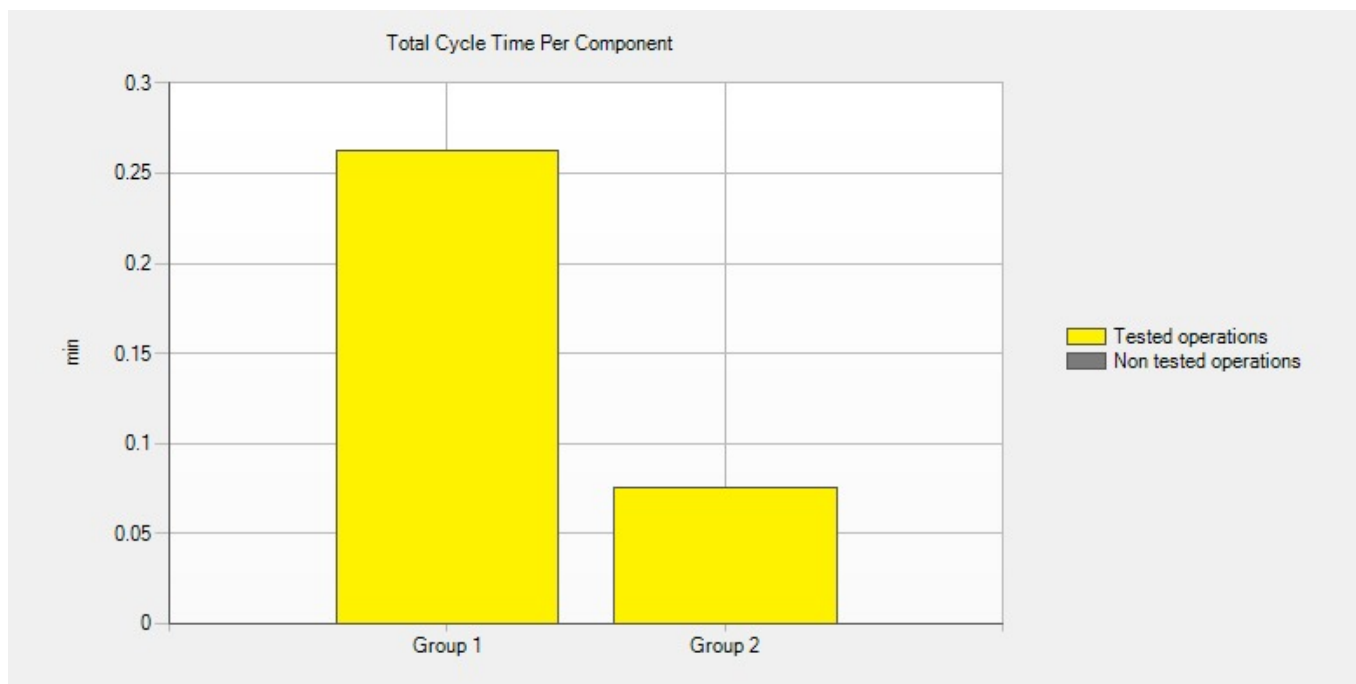
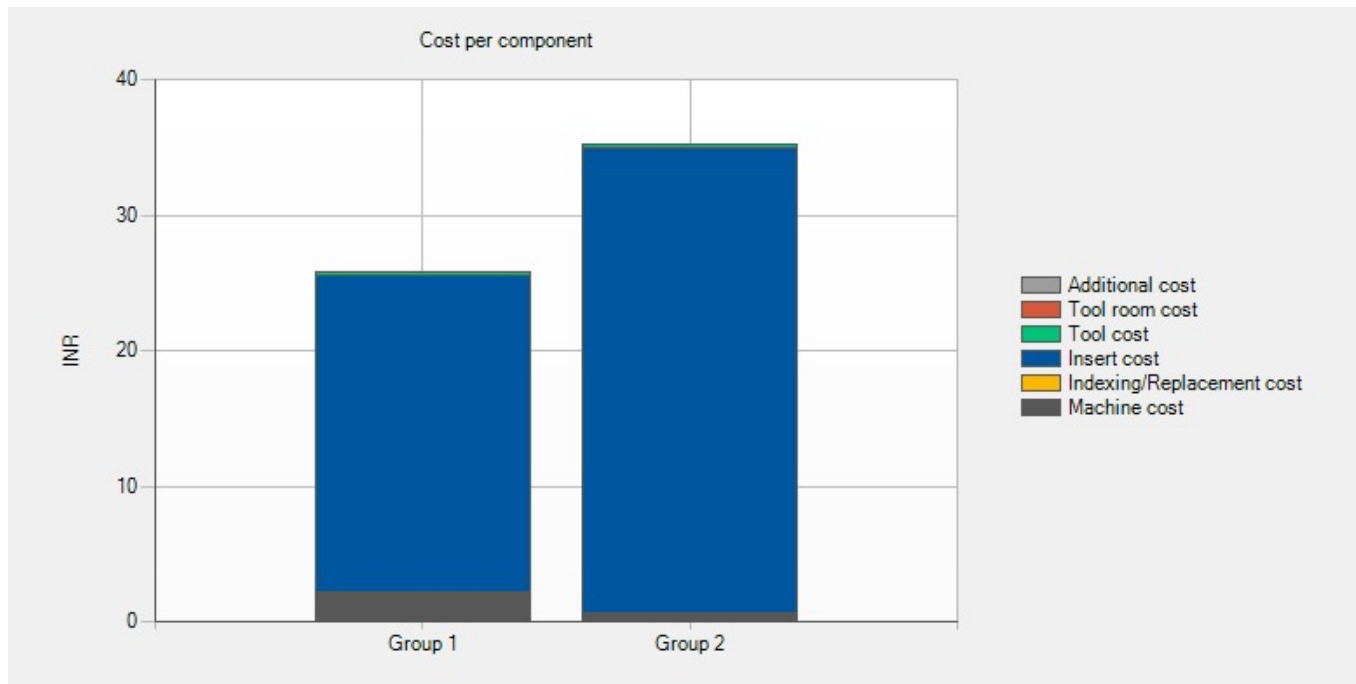
Productivity increase for recommended tools	247%
Productivity increase for total cycle time	247%
Savings in production time per year (h)	11
Savings per component	Rs -9.35
Savings per unit	Rs -2,805.26
Savings per year	Rs -33,663





Charts

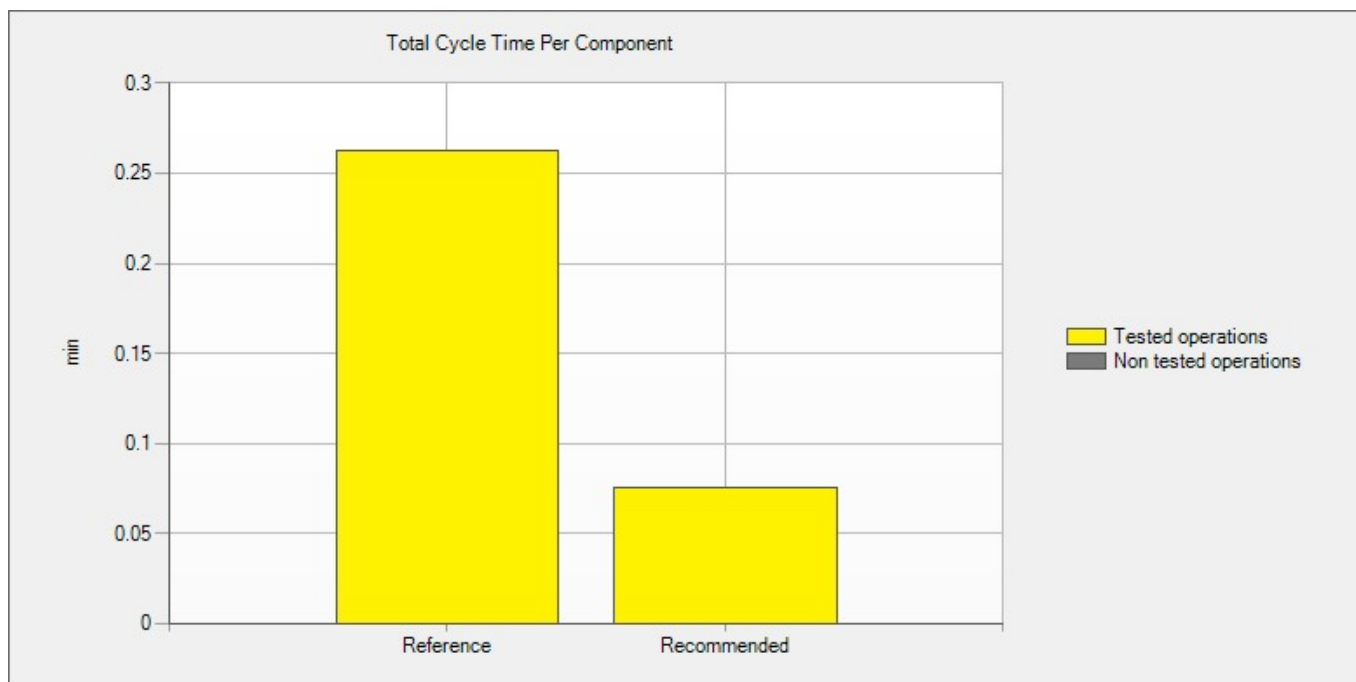
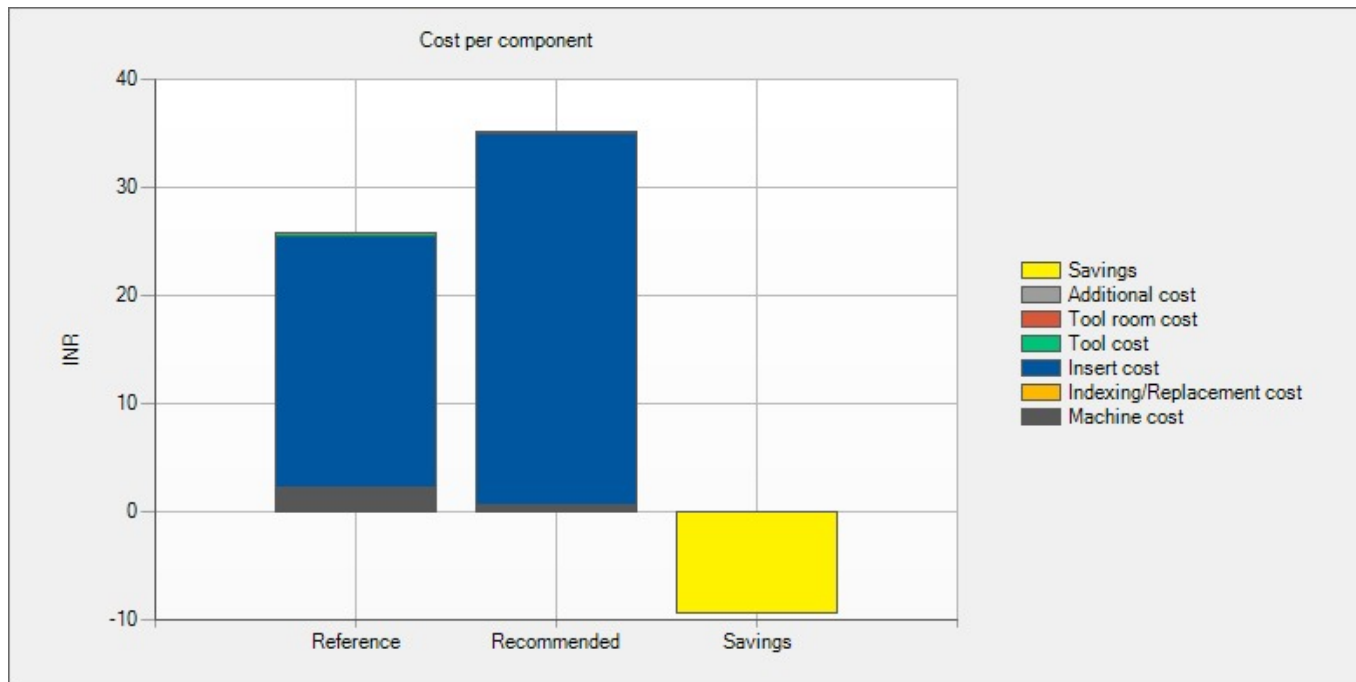
Group data





Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	Dril 11 x28x 25	870-1120
Code (customer denomination)	Drill 11.2 X 28 L25	870-1120
Cost	Rs 12,000.00	Rs 16,000.00
No. of insert indexes	300	500
Insert indexing time (min)	1	1
Insert		
Manufacturer	Iscar	Coromant
Code	DRILL DIA 11.20	870-1120
Code (customer denomination)	Drill Dia 11.2	870-1120
Grade	907	4234
Tip cost	Rs 2,800.00	Rs 5,500.00
Cutting data		
Spindle speed (n) (rev/min)	1705	3126
Cutting speed (vc) (m/min)	60	110
Feed (fn) (mm/rev)	0.06	0.12

	Reference	Recommended
Feed speed (vf) (mm/min)	102	375
Depth of hole (L) (mm)	26	26
Radial cutting depth (ap)	5.6	5.6
No. of passes	1	1
Time in cut per component (min)	0.25	0.07
Block time per set-up (min)	0.25	0.07
Tool life (no.of components)	120	160
Tool life (minutes)	30.49	11.09
Tool life (meter)	3.12	4.16
Tool change criteria	(13) Burr or spalling of workpiece	(11) Bad surface finish on workpiece