

# Productivity Report

## Tushar Pricicom

Project	Tushar Pricicom
Component	Dr 34
Test ID	ADMIN-1833342450
Created by	Sahebrao Shinde
Date created	29-11-2018
Your reference	MR Anil Patil
Distribution	MR ROY

Approved by

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Tushar Pricicom  
MR Anil Patil

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Sandvik Coromant  
Sahebrao Shinde



## Test data

### Component - Dr 34

Component	Dr 34
CMC code	01.4
MC Code	
No. of components per set-up	1
no.of components (month)	400
No. of components per year	4800
Current situation	
Recommendation	

### Machine - mazak

Machine brand	mazak
Machine ID	01
Machine cost per hour	Rs 500
Tool room cost per hour	Rs 0

## Analysis per component

	Reference	Recommended
Machine cost	Rs 1.80 (+1.17)	Rs 0.63
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.25 (+0.11)	Rs 0.14
Insert cost	Rs 18.75 (-7.65)	Rs 26.40
Indexing/Replacement cost	Rs 0.05 (+0.01)	Rs 0.04
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 20.85 (-6.36)</b>	<b>Rs 27.21</b>
<b>Total cycle time per set-up</b>	<b>0.22 (+0.14)</b>	<b>0.08</b>

**+31%**

cost per component

**-64%**

total cycle time per  
component



## Productivity result

### Recommendation

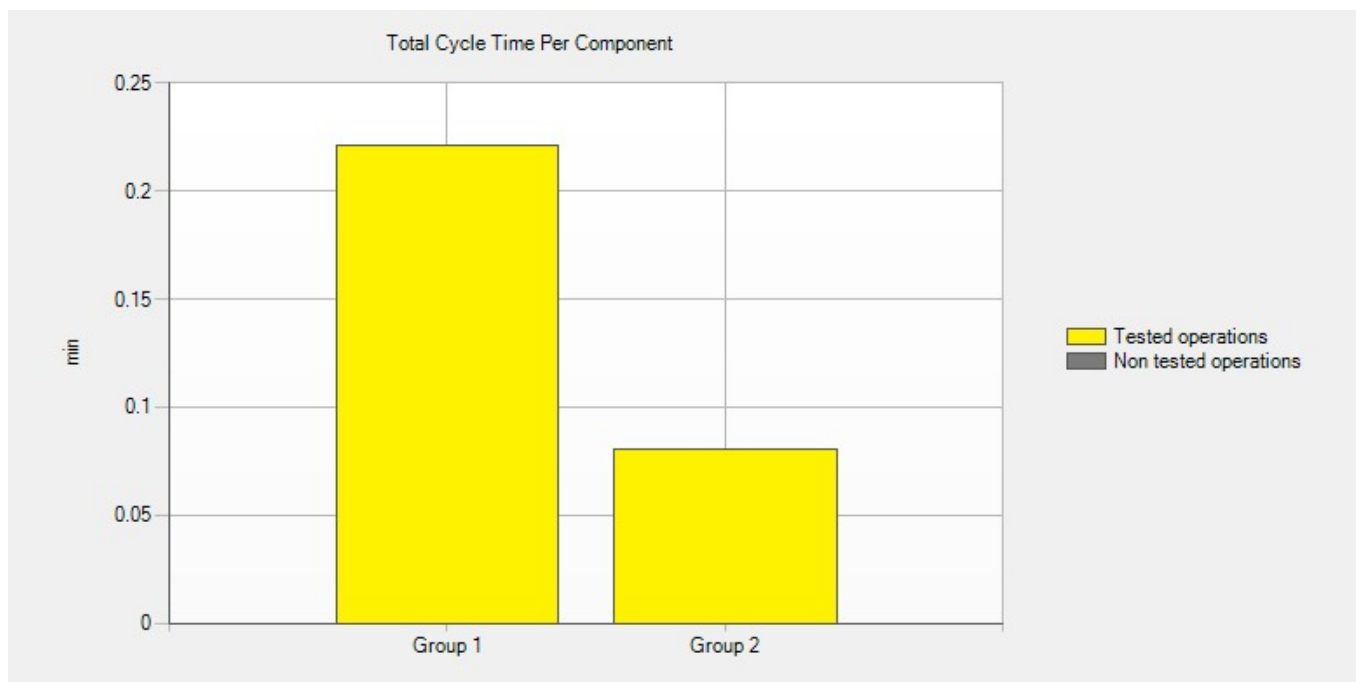
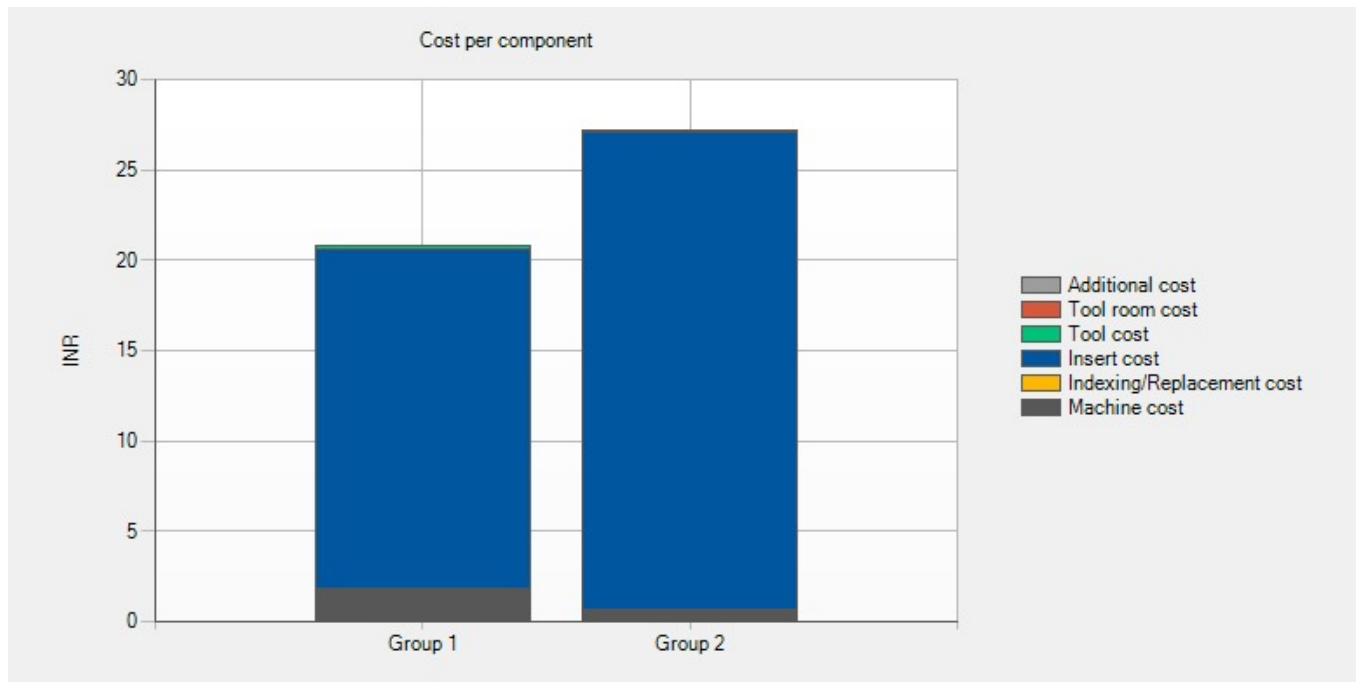
Productivity increase for recommended tools	175%
Productivity increase for total cycle time	175%
<b>Savings in production time per year (h)</b>	<b>11</b>
Savings per component	Rs -6.36
Savings per unit	Rs -2,544.56
<b>Savings per year</b>	<b>Rs -30,535</b>





# Charts

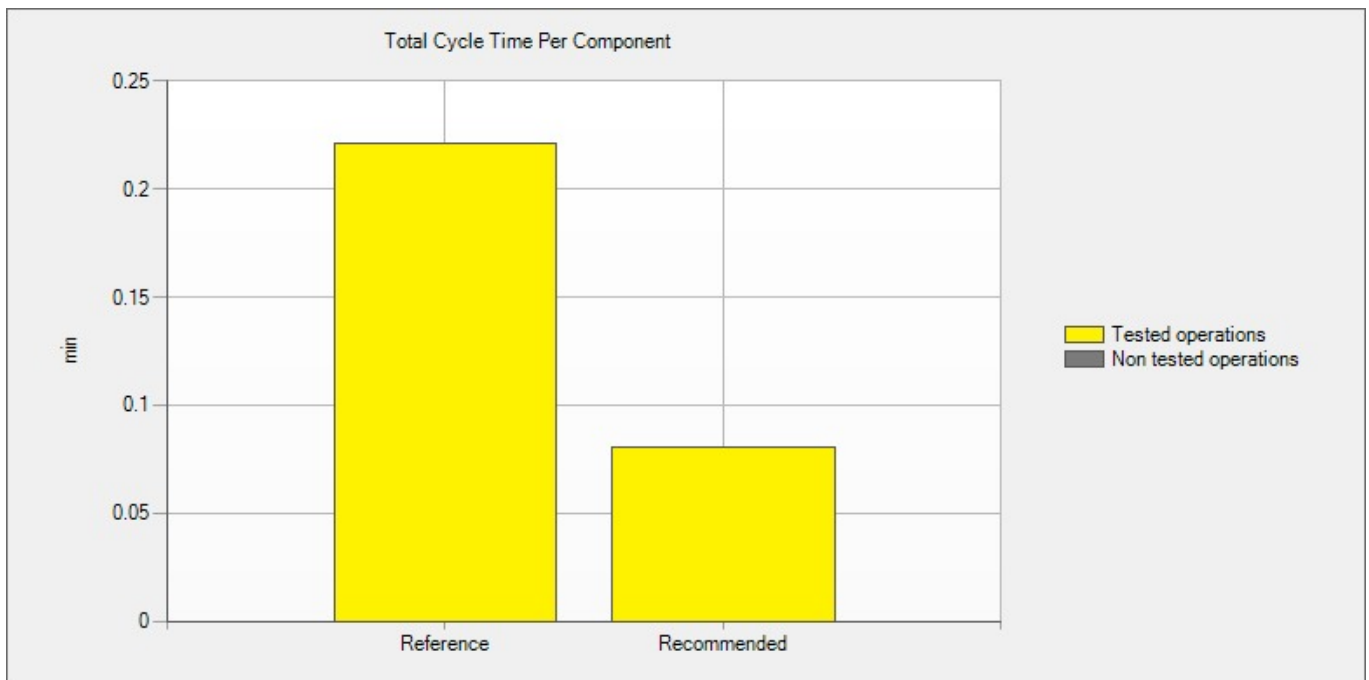
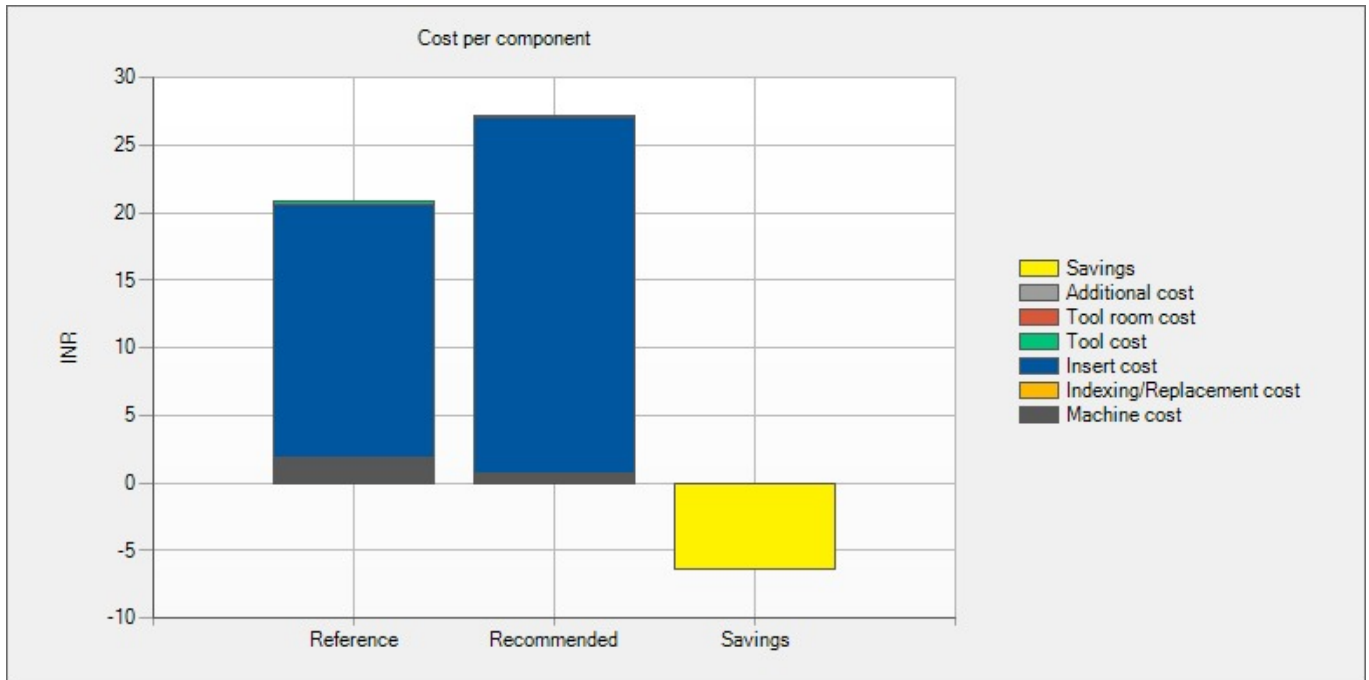
## Group data





# Charts

## Recommendation





## Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	Iscar	Coromant
Code	Drill Dia 12x 28I25	870-1200-10L25
Code (customer denomination)	Dril Dia 12 28 I25	870-1200-10L25
Cost	Rs 12,000.00	Rs 14,000.00
No. of insert indexes	300	500
Insert indexing time (min)	1	1
Insert		
Manufacturer	Iscar	Coromant
Code	DR1 DIA 12	870-1200
Code (customer denomination)	Drill Dia 12	870-1200
Grade	4234	4234
Tip cost	Rs 3,000.00	Rs 5,200.00
Cutting data		
Spindle speed (n) (rev/min)	1857	3183
Cutting speed (vc) (m/min)	70	120
Feed (fn) (mm/rev)	0.06	0.1

	Reference	Recommended
Feed speed (vf) (mm/min)	111	318
Depth of hole (L) (mm)	24	24
Radial cutting depth (ap)	6	6
No. of passes	1	1
Time in cut per component (min)	0.22	0.08
Block time per set-up (min)	0.22	0.08
Tool life (no.of components)	160	197
Tool life (minutes)	34.47	14.85
Tool life (meter)	3.84	4.73
Tool change criteria	(11) Bad surface finish on workpiece	(11) Bad surface finish on workpiece