

Productivity Report

TUSHAR INDUSTRIES

Project	TUHSAR INDUSTRIES
Component	CLAS SUPOOT
Test ID	ADMIN-1832294314
Created by	Sahebrao Shinde
Date created	18-11-2018
Your reference	MR Yogesh Patil
Distribution	MR Dhanesh Mr PATIL

Approved by



Component - CLAS SUPOOT

Component	CLAS SUPOOT
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 - AMS

Machine brand	AMS
Machine ID	09
Machine cost per hour	Rs 500
Tool room cost per hour	Rs 0

Analysis per component

	Reference	Recommended
Machine cost	Rs 7.57 (+5.8)	Rs 1.77
Tool change cost	Rs 0.00 (+0)	Rs 0.00
Tool cost	Rs 0.57 (+0.44)	Rs 0.13
Insert cost	Rs 2.88 (-18.72)	Rs 21.60
Indexing/Replacement cost	Rs 0.17 (+0.14)	Rs 0.03
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 11.19 (-12.34)	Rs 23.53
Total cycle time per set-up	0.93 (+0.7)	0.22

+110%
cost per component

-76%
total cycle time per
component

Recommendation

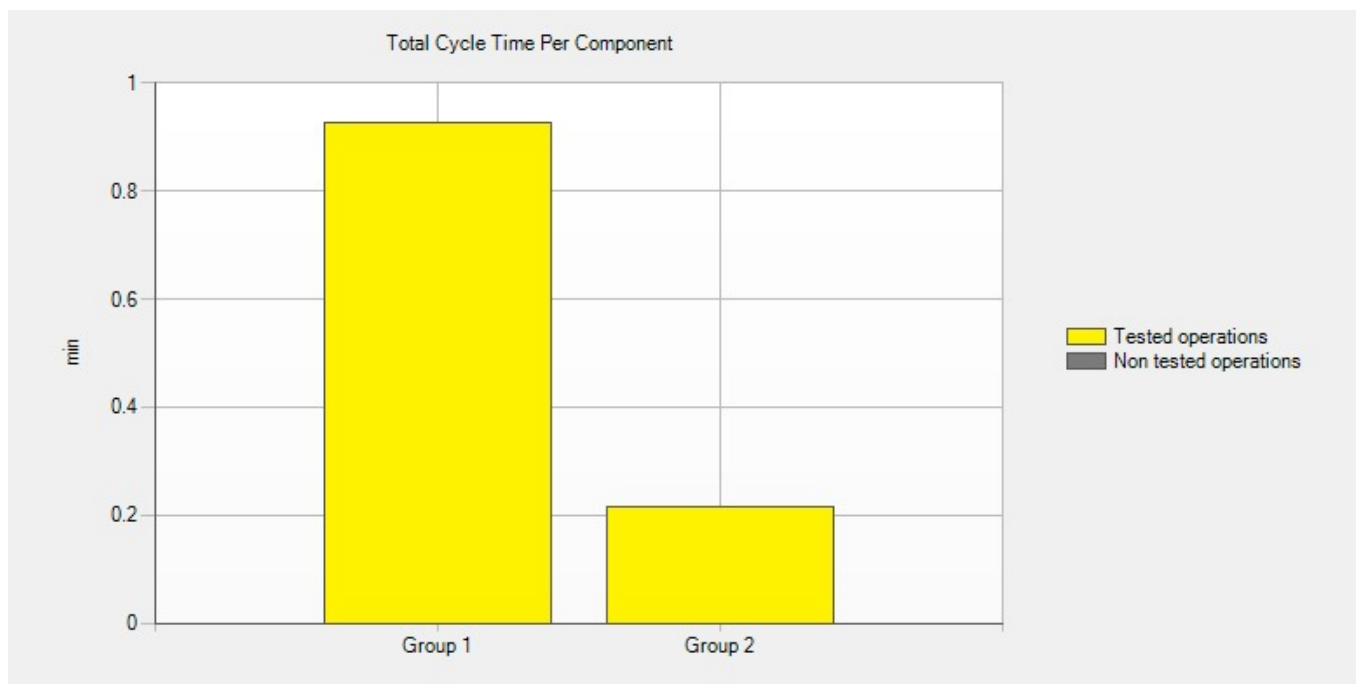
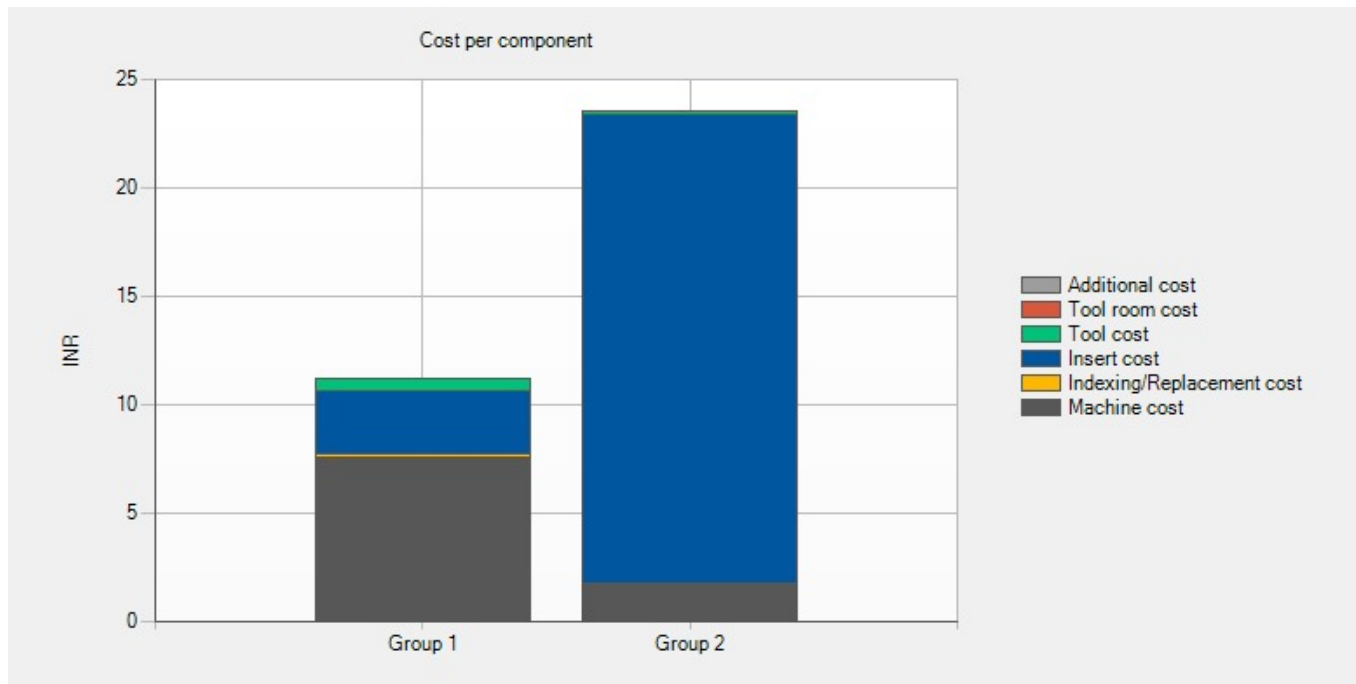
Productivity increase for recommended tools	330%
Productivity increase for total cycle time	330%
Savings in production time per year (h)	43
Savings per component	Rs -12.34
Savings per unit	Rs -3,702.17
Savings per year	Rs -44,426





Charts

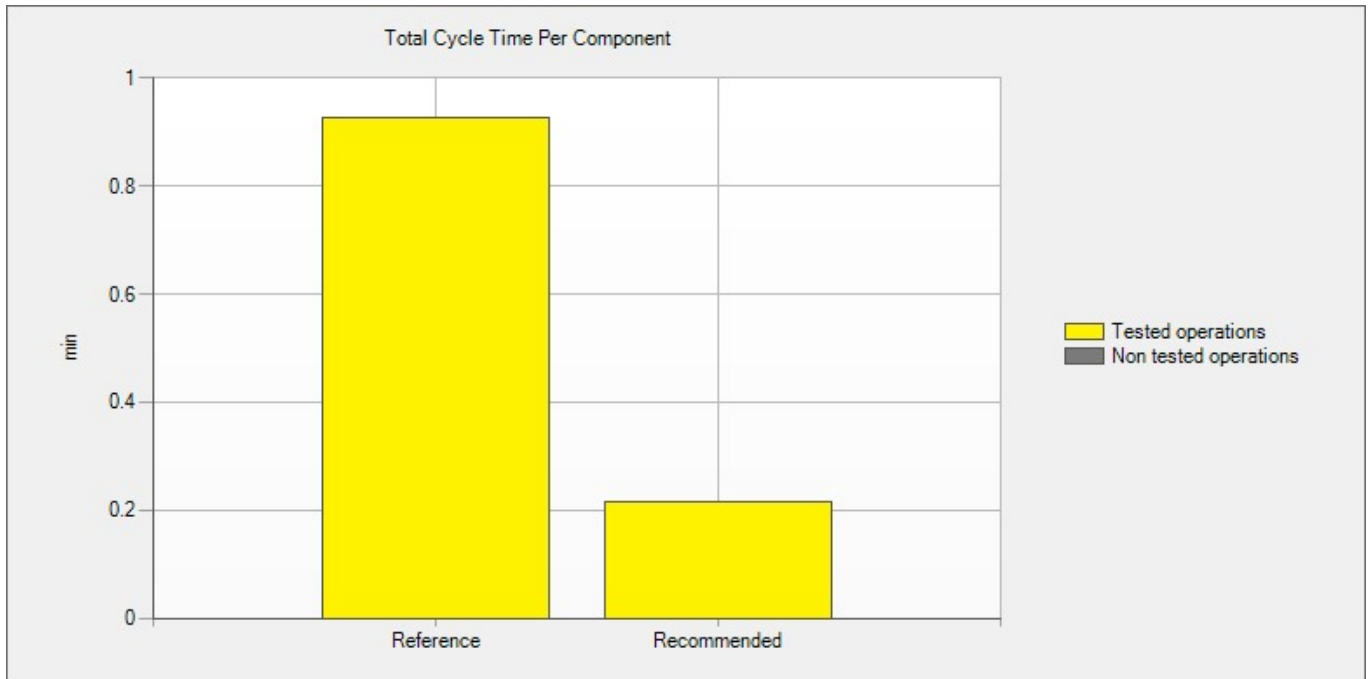
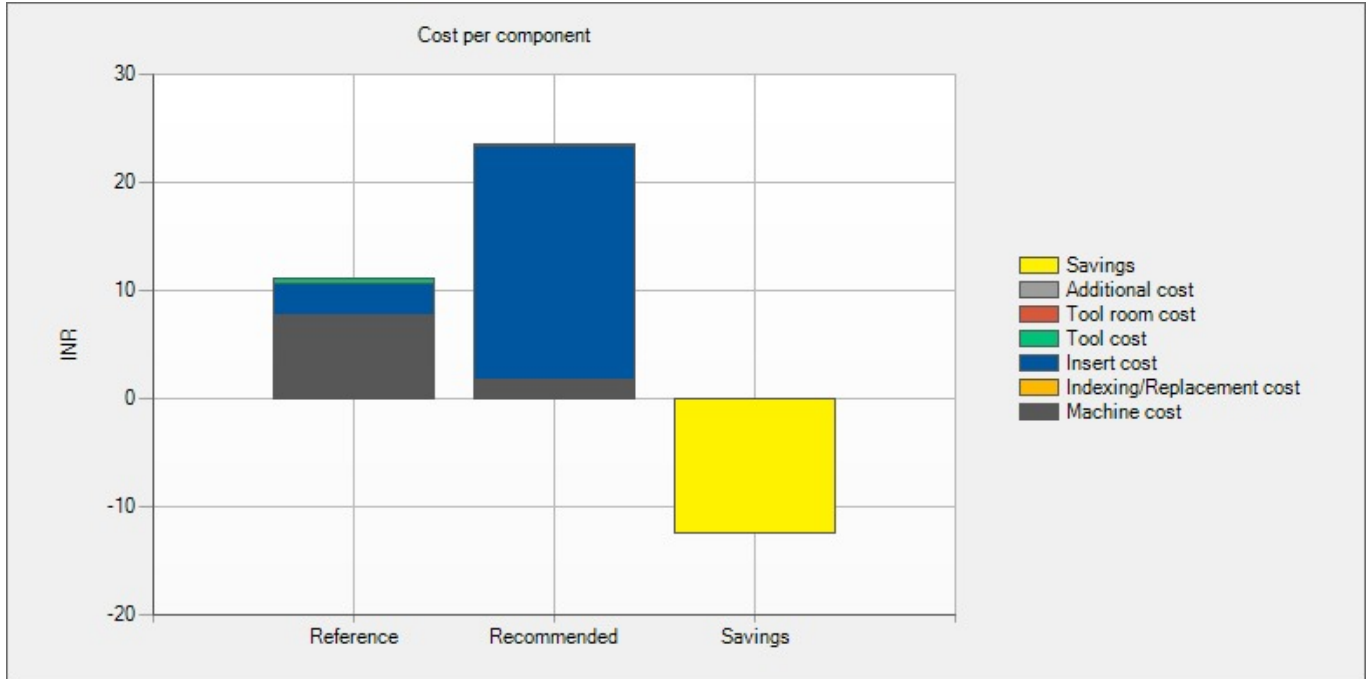
Group data





Charts

Recommendation





Sub-test

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Tool		
Manufacturer	TaeguTec	Coromant
Code	TCD -2380	870-2380
Code (customer denomination)	TCD 23,80	870-2380
Cost	Rs 14,000.00	Rs 16,500.00
No. of insert indexes	500	500
Insert indexing time (min)	1	1
Insert		
Manufacturer	TaeguTec	Coromant
Code	SPMG 05	870-2380
Code (customer denomination)	SPMG 05	870-23.80
Grade	TT8020	GC 34
No. of edges per insert	4	1
Cost per insert	Rs 555.00	Rs 5,400.00
No. of inserts	0	1
Manufacturer	TaeguTec	
Code	SPMG 05	

	Reference	Recommended
Sub-test name	Sub-test 1	Sub-test 1
Grade	TT8020	
No. of edges per insert	4	
Cost per insert	Rs 565.00	
No. of inserts	1	
Cutting data		
Cut		Finishing
Spindle speed (n) (rev/min)	936	1605
Diameter (Dm) (mm)		23.8
Cutting speed (vc) (m/min)	70	120
Feed (fn) (mm/rev)	0.1	0.25
Feed speed (vf) (mm/min)	94	
Depth of hole (L) (mm)	85	
Radial cutting depth (ap)	11.9	
Cutting depth (ap) (mm)		0
Length of cut (mm)		85
No. of passes	1	1
Time in cut per component (min)	0.91	0.21
Block time per set-up (min)	0.91	0.21



Sub-test

	Reference	Recommended
Tool life (no.of components)	49	250
Tool life (minutes)	44.49	52.96
Tool life (meter)	4.17	21.25
Tool change criteria	(11) Bad surface finish on workpiece	(12) Workpiece out of tolerance