



Machine	Haas	
Horse Power	20	
Taper	Cat 40	
Material	Powder Metal	
	Current	Tested Product

1. Cutting Costs

Tool Designation:	XXXX	H3120317-8
Tool Price:	\$40.00	\$55.00
Tool's Life - Number of Parts:	16	64
Annual Production - Pieces	1,000	1,000
Tool Cost Per Year:	\$2,500.00	\$859.38
Insert Cost Savings / Annual:		\$1,640.63

2. Machine Costs

Hourly Rate - Machine:	\$50.00	\$50.00
Current Supplier:		Creston
Tool Diameter - Decimal:	.315	.315
Number of Flutes:	4	4
Surface Feet Per Minute:	230	275
RPM:	2789	3335
Chip Load - Per Flute:	.0036	.0045
Inches Per Minute	40.16	60.03
Hole Depth:	18.00	18.00
Total Cutting Time (Minuntes):	0.45	0.30
Machining Cost / Component:	\$0.37	\$0.25
Annual Production / Pieces:	1,000	1,000
Machining Cost / Annual:	\$373.49	\$249.88
Machining Cost Savings / Annual:		\$123.62



	Current	Tested Product
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3. Tool Changing Costs

Tool Changing Time (Minutes):	3	3
Cost Per Tool Change:	\$2.50	\$2.50
Tool Changes - Annual:	63	16
Tool Changing Cost / Annual:	\$156.25	\$39.06
Tool Changing Cost Savings / Annual:		\$117.19

4. Tool Presetting Costs

Hourly Rate - Presetter:	\$0.00	\$0.00
Total Tool Presetting Time (Minutes):	0	0
Tool Presetting Cost:	\$0.00	\$0.00
Tool Presettings / Annual:	63	16
Costs Annual:	\$0.00	\$0.00
Tool Presetting Cost Savings / Annual:		\$0.00

5. Additional Free Machine Capacity

Tool Changes / Annual:	63	16
Machining Time /Annual (Minutes)	448	300
Tool Changing Time / Annual (Minutes):	188	47
Machine Capacity (Minutes): (168 Hrs Wk.)	636	347
Machine Time Gained / Min - Annual		\$ 240.80

Cost Comparison Total

	Current	Tested Product	Savings
1	\$2,500.00	\$859.38	\$1,640.63
2	\$373.49	\$249.88	\$123.62
3	\$156.25	\$39.06	\$117.19
4	\$0.00	\$0.00	\$0.00
SUM	\$3,029.74	\$1,148.31	\$1,881.43