

Analysis of Performance

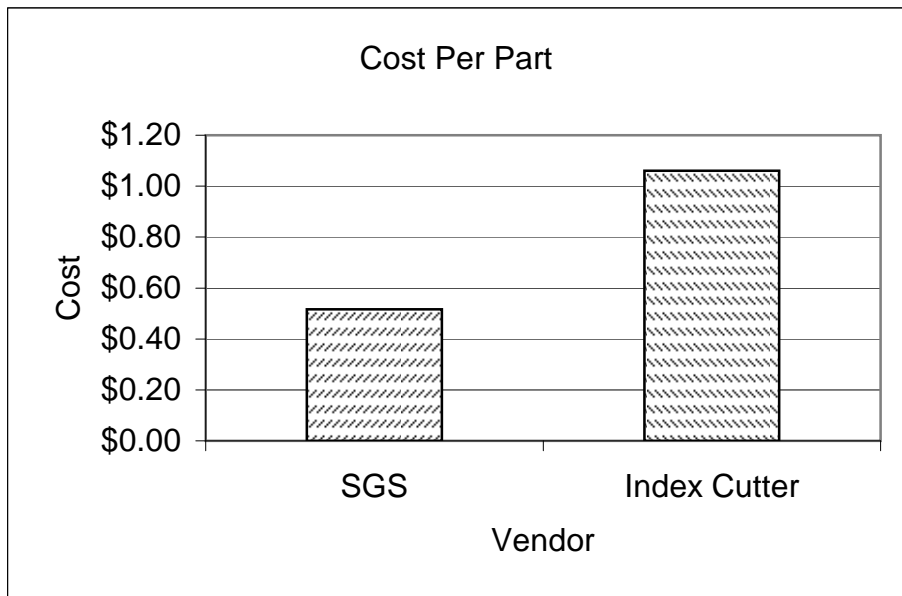
Supplied by SGS Tool Company

SGS Rep: Gene Delett
 Customer: ABC Mfg
 Contact: Joe Smith
 Phone: _____
 Distributor: Supply Company
 Test Date: 2/2/2006
 Test PO No.: _____
 SGS Product: 1/2" Z-Carb EDP 36432
 Comp. Product: INdexable 3 insert cutter
 Material Type: 1018
 Hardness: soft 20 Rc
 Coolant: Water Soluble

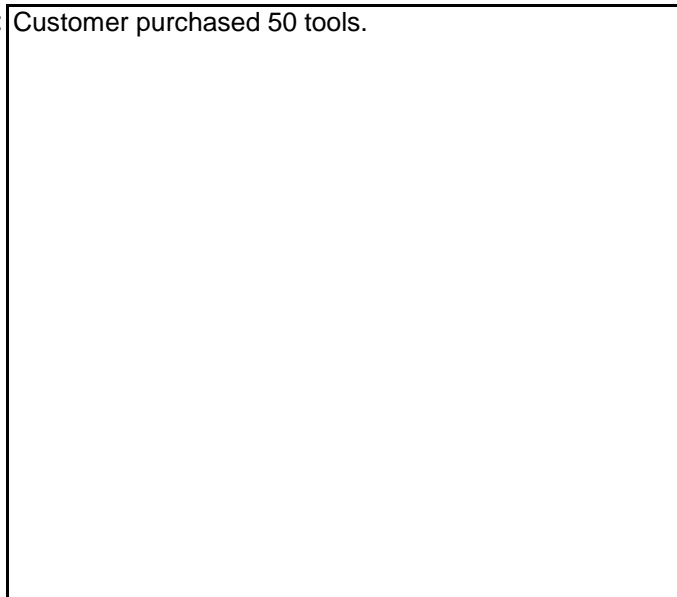


Vendors

		SGS	Index Cutter	
A	Enter the number of parts to produce	3000	3000	ENTER DATA
B	Enter the hourly shop rate (dollars)	\$65.00	\$65.00	
C	Enter the total milled or drilled length per part (inches)	12.0000	60.0000	
D	Enter the revolutions per minute (rpm)	4072	6000	
E	Enter the feed per revolution (inch)	0.0092	0.0117	
F	Enter the cost of a new tool	\$45.32	\$24.00	
G	Enter the time to change tool (minutes)	5	15	
H	Enter the regrind cost	\$0.00	\$0.00	
I	Enter the parts produced by a new tool	300	300	
J	Enter the parts produced by a regrind	0	0	
K	Enter the number of regrinds available per tool	0	0	
L	Enter axial depth per pass (milling) or per hole (drilling)	0.5150	0.1000	
M	Enter radial width per pass when milling (inch)	0.0850	0.2500	
N	Enter the drill or end mill diameter (inch)	0.5000	0.5000	
O	Surface speed - feet / minute (D x .262 x N)	533	786	
P	Feed - inches / minute (D x E)	37.5	70.2	
Q	Total parts available per tool (J x K) + I	300	300	
R	New tools required to complete job (A / Q)	10	10	
S	Regrinds required to compete job (A-(I x R) / J	0	0	
T	Total hours of machining time (C x A) / (P x 60)	16.01606	42.73505	
U	Total machining cost (T x B)	\$1,041.04	\$2,777.78	
V	Total new tool cost (F x R)	\$453.20	\$240.00	
W	Tool change cost (R + S) (G x B / 60)	\$54.17	\$162.50	
X	Regrind cost (S x H)	\$0.00	\$0.00	
Y	Total Cost (U + V + W + X)	\$1,548.41	\$3,180.28	
Z	Cost / Part (Y / A)	\$0.52	\$1.06	
	Material Removal Rate (in ³ / min) - Milling	1.64	1.76	
	MRR Difference - Milling	0	0.12	
	Material Removal Rate (in ³ / min) - Drilling	0.00	0.00	
	MRR Difference - Drilling	0	0	
	Cutting Time / Part - Minutes	0.32	0.85	
	Savings / Part - Dollars	\$0.54	0	
	Total Cost Savings / Job - Percentage	51.31%	0	
	Total Cost Savings / Job - Dollars	\$1,631.87	0	



Notes: Customer purchased 50 tools.



Sketch:

Password: SGSTool
Version 6 (8-10-04)