

MILLING PERFORMANCE REPORT

CUSTOMER:	DATE:	ENGINEER:		
LOCATION:	MATERIAL:	CUSTOMER ENGINEER:		
PART NUMBER: Connecting Rod	CONDITION: Good	OPERATOR: Ross		
OPERATION:	HARDNESS: 220 BHN	REPORT# 5	MACHINE TYPE: 50 Tapper Horz.	MACHINE HP: 30

NOTES:

PERFORMANCE / COST DATA	PRESENT	TEST 1	TEST 2	TEST 3
MANUFACTURER	Sumitomo	CGC/Gorilla Mill		
MILL CATALOG NUMBER	Solid Carbide	GM12FXL4		
END MILL	End Mill	End Mill		
COATING	Ticn	TiAln		
CUTTER DIAMETER (INCHES)	0.5	0.5		
CUTTING SPEED (RPM)	1776	1776		
CUTTING SPEED (SFM)	233	233		
NUMBER OF FLUTES PER CUTTER	4	4		
CHIP LOAD PER TOOTH (CLPT)	0.004	0.004		
FEED RATE (IPM)	28.416	28.416		
FEED PER REV. (IPR)	0.016	0.016		
FINISH (R.M.S.)	100	100		
MAX. WIDTH OF CUT(W.O.C.) INCH	0.03	0.03		
MAX DEPTH OF CUT (D.O.C.) INCH	1.875	1.875		
LENGTH OF CUT IN INCHES	16	16		
CUTTING TIME PER PIECE / MIN.	0.563	0.563		
PARTS PER TOOL	140	440		
TOOL LIFE PER MINUTE	79	248	ossible	
TOOLS TESTED	1	1		
PARTS PER TOOL	140	440		
REASON FOR CHANGING TOOL	Chipped	Chipped		
TYPE OF COOLANT	Semi. Syn.	Semi. Syn.		
TIME PER CUTTER CHANGE / MIN.	10	10		
CHANGE COST PER PIECE	\$0.12	\$0.04		
TOOL COST (PURCHASE QTY.)	\$64.65	\$67.48		
COST PER PART	\$1.85	\$0.61		
MACHINE HOURLY COST (BURDEN)	\$100.00	\$100.00		
MACHINE COST PER MINUTE	\$1.67	\$1.67		
MACHINE COST PER PIECE	\$0.94	\$0.94		
TOTAL COST PER PIECE	\$2.90	\$1.59		
EST. ANNUAL PRODUCTION	25,000	25,000		
EST. ANNUAL COST	\$72,615.72	\$39,744.29		
EST. ANNUAL SAVINGS		\$32,871.43		