

MILLING PERFORMANCE REPORT

CUSTOMER:	DATE:	ENGINEER:		
LOCATION:	MATERIAL:	CUSTOMER ENGINEER:		
PART NUMBER: Pattern	CONDITION: OK	OPERATOR: AJ		
OPERATION: 10	HARDNESS: 50 RC	REPORT# 2	MACHINE TYPE: VMC	MACHINE HP: 20

NOTES:

PERFORMANCE / COST DATA	PRESENT	TEST 1	TEST 2	TEST 3
MANUFACTURER	Hanita	Carbide Grinding		
MILL CATALOG NUMBER	Variable Helix	Gorilla Mill		
INSERT	End Mill	End Mill		
GRADE	TiALN	TiALN		
CUTTER DIAMETER (INCHES)	0.75	0.75		
CUTTING SPEED (RPM)	1528	1528		
CUTTING SPEED (SFM)	300	300		
NUMBER OF INSERTS PER CUTTER	4	4		
CHIP LOAD PER INSERT (CPT)	0.002	0.002		
FEED RATE (IPM)	12.224	12.224		
FEED PER REV. (IPR)	0.008	0.008		
FINISH (R.M.S.)	125	125		
MAX. WIDTH OF CUT(W.O.C.) INCH	0.75	0.75		
MAX DEPTH OF CUT (D.O.C.) INCH	0.75	0.75		
LENGTH OF CUT IN INCHES	60	60		
CUTTING TIME PER PIECE / MIN.	4.908	4.908		
PIECES PER EDGE	1	3		
TOOL LIFE PER EDGE / MIN.	5	15	#VALUE!	#VALUE!
CUTTING EDGES PER INSERT	1	1		
PIECES PER INSERT	1	3		
REASON FOR INDEXING INSERTS	Bad Finish	Bad Finish		
TYPE OF COOLANT	Semi Syn.	Semi Syn.		
TIME PER CUTTER CHANGE / MIN.	5	5		
CHANGE COST PER PIECE	\$6.67	\$2.22		
INSERT COST (PURCHASE QTY.)	\$124.54	\$99.63		
INSERT COST PER PIECE	\$124.54	\$33.21		
MACHINE HOURLY COST (BURDEN)	\$80.00	\$80.00		
MACHINE COST PER MINUTE	\$1.33	\$1.33		
MACHINE COST PER PIECE	\$6.54	\$6.54		
TOTAL COST PER PIECE	\$137.75	\$41.98		
EST. ANNUAL PRODUCTION	50	50		
EST. ANNUAL COST	\$6,887.56	\$2,098.84		
EST. ANNUAL SAVINGS		\$4,788.72		