



TUNGALOY TEST TOOL EVALUATION REPORT

DATE: **Aug. 1, 2008**

REPORT# : _____

COMPANY:	*****	SALESMAN:	<i>Butch Paschall</i>
CONTACT:		PART DESCRIPTION:	Battery Housing for ****
TEL:		WORK MATERIAL:	Inconel 718
FAX:		MAT'L HARDNESS:	28RC

TYPE OF OPERATION	OD Turning	MACHINING OPERATION (SKETCH)
MACHINE TOOL & TYPE	Mazak	
RIGIDITY	Good	
COOLANT TYPE	Trim	
COOLANT METHOD	Flood	

TOOLING REQUIRED	COMPANY / COMPETITOR	*****	TUNGALOY	TUNGALOY	TUNGALOY
		CURRENT	FIRST TEST	SECOND TEST	THIRD TEST
	TOOL DESCRIPTION	Negative	Negative		
	HOLDER/BODY TYPE	MCLNR	MCLNR		
	INSERT	CNMG432MS	CNMG432TM		
	INSERT GRADE	KC5010	AH120		
CUTTING PARAMETERS	WORKPIECE/CUTTER DIAMETER	2	2		
	FEED RATE (IPR = f)	0.012	0.012		
	CUTTING SPEED (RPM=R or SFM=V)	200	200		
	H.P. REQUIRED (% or ACTUAL)				
	DEPTH OF CUT (INCHES)	0.125	0.125		
TOOL PERFORMANCE	CYCLE TIME FOR TOOL (min)	1.500	1.500		
	PIECES PER EDGE	5	8		
	TOOL LIFE (min per edge)	5.000	8.000		
	EDGES USED PER INSERT	1	1		
	PIECES PER INSERT	5	8		
	SURFACE FINISH (RMS)	63	63		
	REASON FOR INDEXING	notching	normal wear		
	EST ANNUAL INSERT USAGE (pcs)	1000	625		
COST EVALUATION	INSERT COST	\$9.50	\$7.42		
	NUMBER OF INSERTS IN TOOL (multi)	1	1		
	INSERT COST PER PIECE	\$1.90	\$0.93		
	INSERT INDEX TIME (min)	2.00	2.00		
	HOURLY MACHINE DEPT. COST	\$85.00	\$85.00		
	TOTAL ANNUAL PIECES	5,000	5,000		
	MACH TIME + TOOL COST FOR TOOL	\$4.025	\$3.053		
	WON or LOST		WON		

COMMENTS:



TUNGALOY AMERICA, INC

COST ANALYSIS AND SAVINGS REPORT

Company: *****
Contact: 0

DATE: Aug. 1,2008
TTA Rep: Butch Paschall

TUNGALOY

HIGH OUTPUT TECHNOLOGY

Insert: CNMG432TM
Grade: AH120

	Competitor *****	TUNGALOY HIGH OUTPUT TECHNOLOGY
Cost of Insert	\$ 9.50	\$ 7.42
Number of Corners	1	1
Cost Per Corner	\$ 9.50	\$ 7.42
Number of Inserts In Tool	1	1
Cost Per Loaded Tool	\$ 9.50	\$ 7.42
Number of Parts Per Corner	5	8
Insert Cost Per Part	\$ 1.900	\$ 0.928
Number of Parts Run Per Year	5,000	5,000
Cost of Inserts Used Per Year	\$ 9,500.00	\$ 4,637.50

Down-Time Cost

Note: If Insert Change is Internal to Cycle Place 0 in Insert(s) Changing Time

	Competitor	TUNGALOY HIGH OUTPUT TECHNOLOGY
Machine Operating Cost per Hour	\$ 85.00	\$ 85.00
Minutes in 1 Hour	60	60
Operating Cost per Minute	\$ 1.42	\$ 1.42
Insert(s) Changing Time (in minutes)	2.00	2.00
Cost per Insert Change	\$ 2.83	\$ 2.83
Number of Insert Changes per Year	1,000	625
Cost of Yearly Downtime	\$ 2,833.33	\$ 1,770.83

Cycle Time Savings

	Competitor	TUNGALOY HIGH OUTPUT TECHNOLOGY
Machine Operating Cost per Hour	\$ 85.00	\$ 85.00
Minutes in 1 hour	60	60
Operating Cost per Minute	\$ 1.42	\$ 1.42
Cycle Time for Tool (in Minutes)	1.5000	1.5000
Operating Cost per Part	\$ 2.13	\$ 2.13
Number of Parts Ran per Year	5,000	5,000
Cost of Cycle Time per Year	\$ 10,625.00	\$ 10,625.00
Estimated Annual Cost	\$ 22,958.33	\$ 17,033.33

TOTAL SAVINGS PER YEAR

Cost of Inserts	\$ 4,862.50
Cost of Down Time	\$ 1,062.50
Cost of Cycle Time	\$ -

Total Savings \$5,925.00

WINNER



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TUNGALOY

HIGH OUTPUT TECHNOLOGY

