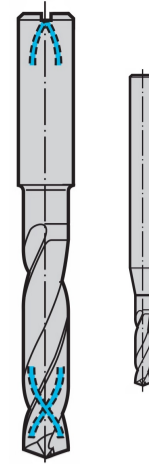




Tool Performance Report

Solid Carbide Drilling



Customer

Company:	
Contact:	
QTS Employee:	
Date:	

Machine

Machine Description:	Haas EC1600			
Spindle:	<input type="checkbox"/> CV40	<input checked="" type="checkbox"/> CV50	<input type="checkbox"/> Other:	
Condition:	<input checked="" type="checkbox"/> Good	<input type="checkbox"/> Medium	<input type="checkbox"/> Poor	

Material

Type:	<input checked="" type="checkbox"/> Steel	<input type="checkbox"/> Stainless Steel	<input type="checkbox"/> Hi Temp Alloy	<input type="checkbox"/> Aluminum Non-Ferrous
Material No.:	4145			
Condition:	<input checked="" type="checkbox"/> Clean	<input type="checkbox"/> Heavy Scale	<input type="checkbox"/> Flame Cut	<input type="checkbox"/> Casting
Hardness:	30 Rockwell C			

Workpiece

Description:	Actuator Shaft			
Drawing #:				
Rigidity:	<input checked="" type="checkbox"/> Good	<input type="checkbox"/> Medium	<input type="checkbox"/> Bad	
Operation:	<input type="checkbox"/> Rough	<input checked="" type="checkbox"/> Finish		
Dimensions:	Length	Width	Height	
Comments:				

Tool Data

	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Manufacturer:	Star Su	Walter				
Tool Type:	Carbide Tip Drill	Solid Carbide Drill				
Tool P/N:	J59933	A7595TTP-1/4"				
Tool Dia.:	0.250	0.250				
Tool Change Time:	15m	15m	0m	0m	0m	0m
Point Angle:	140	140				

Machining Data

	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Speed (SFM):	200	240				
RPM:	3056	3667				
IPR:	0.001	0.006				
IPM:	1.83	22.00				
Drill Depth:	10.50	10.50				
MRR cu in/min:	0.1	1.1	0.0	0.0	0.0	0.0

Machining Results

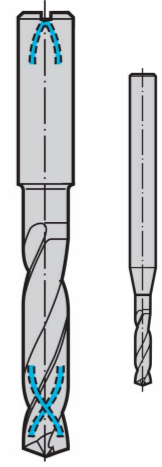
	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Part count:	3	50				
Cycle Time:	30m 0s	0m 27s	0m 0s	0m 0s	0m 0s	0m 0s
Surface Finish:	63	63				
Spindle Load:	5%	5%				
Failure Mode:	Flank wear	Flank wear				
Criteria for end of tool life:	Normal tool wear	Normal tool wear				

Comments



Tool Performance Report

Solid Carbide Drilling



Tool Costing

	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Manufacturer:	Star SU	Walter				
Tool P/N:	J59933	A7595TTP-1/4"				
Tool Price Ea:	77	\$867.00				
Parts Per Tool:	3	50	0	0	0	0
Annual Hole Production:	50	50				
Tooling Cost Per Part:	\$25.67	\$17.34				
Tooling Cost Annually:	\$1283.33	\$867.00				

Machining Cost

	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Machine Description:	Haas EC1600	Haas EC1600	Haas EC1600	Haas EC1600	Haas EC1600	Haas EC1600
Hourly Rate:	\$125.00	\$125.00	\$125.00	\$125.00	\$125.00	\$125.00
Cycle Time:	30m 0s	0m 27s	0m 0s	0m 0s	0m 0s	0m 0s
Index Time:	15m	15m	0m	0m	0m	0m
Machining Cost Per Part:	\$72.92	\$1.56				

Total Machine Time

	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Total Time Per Part:	35m 0s	0m 45s				
Total Annual Time:	29h 10m	0h 38m				
Total Time Savings:	0h 0m	-28h 33m				

Total Cost

	Current	Test 1	Test 2	Test 3	Test 4	Test 5
Total Cost Per Part:	\$98.58	\$18.90				
Total Annual Cost:	\$4929.17	\$945.13				
Total Savings:	\$0.00	\$3984.04				