

**TOOL COST ANALYSIS
DYNA BLUE TREATING**

DEPT. / OPER.:

1870 PROPSHAFTS / OP.90

TOOL : 2405863-T-7 BROACH
CODE : 86-150-0531

	BEFORE	AFTER
PURCHASE PRICE	\$109.00	\$117.86
# OF SHARPENINGS	10	10
TIME TO SHARPEN (HRS.)	1	1
TOTAL SHARPENING LABOR HOURS	10	10
LABOR RATE (\$ / HR.)	\$31.21	\$31.21
TOTAL LABOR COST	\$312.10	\$312.10
TOOL LIFE (NEW OR REGRIND)	1200	3600
# OF ADDITIONAL DYNA BLUE TREATMENTS PER TOOL	-----	1
DYNA BLUE TREATMENT COST	-----	\$8.86
TOTAL COST OF ADDITIONAL DYNA BLUE TREATMENTS	-----	\$8.86
TOTAL COST PER TOOL	\$421.10	\$438.82
TOTAL PIECES PER TOOL	13200	39600
COST PER PIECE	\$0.0319	\$0.0111
REQUIRED PCS. PER YEAR	365000	365000
REQUIRED TOOLS PER YEAR	28	9

TOTAL TOOL COST PER YEAR	\$11,644.05	\$4,044.68
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SAVINGS PER YEAR	\$7,599.37
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PERCENT OF SAVINGS	65.3%
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**TOOL COST ANALYSIS
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DEPT. / OPER.:

1850 PROPSHAFTS / OP.20

TOOL : 3578220-T-40 BROACH
CODE : 86-150-0725

	BEFORE	AFTER
PURCHASE PRICE	\$1,095.00	\$1,206.70
# OF SHARPENINGS	6	6
TIME TO SHARPEN (HRS.)	1.5	1.5
TOTAL SHARPENING LABOR HOURS	9	9
LABOR RATE (\$ / HR.)	\$31.21	\$31.21
TOTAL LABOR COST	\$280.89	\$280.89
TOOL LIFE (NEW OR REGRIND)	1000	3000
# OF ADDITIONAL DYNA BLUE TREATMENTS PER TOOL	-----	1
DYNA BLUE TREATMENT COST	-----	\$111.70
TOTAL COST OF ADDITIONAL DYNA BLUE TREATMENTS	-----	\$111.70
TOTAL COST PER TOOL	\$1,375.89	\$1,599.29
TOTAL PIECES PER TOOL	7000	21000
COST PER PIECE	\$0.1966	\$0.0762
REQUIRED PCS. PER YEAR	90000	90000
REQUIRED TOOLS PER YEAR	13	4

TOTAL TOOL COST PER YEAR	\$17,690.01	\$6,854.10
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SAVINGS PER YEAR	\$10,835.91	
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PERCENT OF SAVINGS	61.3%	
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**TOOL COST ANALYSIS
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DEPT. / OPER.:

1850 PROPSHAFTS / OP.20

TOOL : 3578220-T-41 BROACH
CODE : 86-150-0726

	BEFORE	AFTER
PURCHASE PRICE	\$1,235.00	\$1,346.70
# OF SHARPENINGS	6	6
TIME TO SHARPEN (HRS.)	1.5	1.5
TOTAL SHARPENING LABOR HOURS	9	9
LABOR RATE (\$ / HR.)	\$31.21	\$31.21
TOTAL LABOR COST	\$280.89	\$280.89
TOOL LIFE (NEW OR REGRIND)	1000	3000
# OF ADDITIONAL DYNA BLUE TREATMENTS PER TOOL	-----	1
DYNA BLUE TREATMENT COST	-----	\$111.70
TOTAL COST OF ADDITIONAL DYNA BLUE TREATMENTS	-----	\$111.70
TOTAL COST PER TOOL	\$1,515.89	\$1,739.29
TOTAL PIECES PER TOOL	7000	21000
COST PER PIECE	\$0.2166	\$0.0828
REQUIRED PCS. PER YEAR	180000	180000
REQUIRED TOOLS PER YEAR	26	9
TOTAL TOOL COST PER YEAR	\$38,980.03	\$14,908.20
SAVINGS PER YEAR	\$24,071.83	
PERCENT OF SAVINGS	61.8%	