


Tool Report Form

Tech:	Name:	Phone #	Date
Customer:	FLUKE METAL PRODUCTS		
Contact info:	LARRY FLUKE	425-485-9666	02/17/10
Part Name	BASE PLATE		
Drawing Number	???????	VERSION	CUTTER PATH
CAM SOFTWARE	SURFWARE	4	TRUEMILL
NOTES:	TRUEMILL PATH		
Material	ALUMINUM 6061		Load Meter
Hardness RC or BHN	T6	Horse power	% used load
Machine	KITAMURA	15	?
Operation	VERTICAL MILLING		
		SwiftCarb	Competitor
Data	Tools	Tested	
		RAMPMILL	DATAFLUTE
No. Parts to be Produced		300	300
Machining Rate (\$/Hr)		\$100.00	\$100.00
Cutter diameter		0.5	0.75
Axial Depth Of Cut		1	0.5
Radial Doc or Step over		0.310	0.300
Number of Flutes		3	3
Chip Load per tooth		IPT	0.012
Speed (RPM)		9300	8000
Surface feet per minute		SFM	1217.277487
Feed (IPM)		IPM	334.800
			72.000
Cubic inches per minute		MRR	103.788
			10.800
Tool Cost		\$67.00	\$110.00
Tool No parts/tool		78	25
Cycle time per part		22	35
Time saved per part in minutes		13	
Analysis			
Total Machining Time In hours		Hours	110.00
			175.00
Total Machining Cost (Time per part X \$xxx.xx per hour)		\$11,000.00	\$17,500.00
Total Tooling Cost		\$257.69	\$1,320.00
Cost Each Part		\$37.53	\$62.73
Total Costs		\$11,257.69	\$18,820.00
Total Savings....		\$7,562.31	
Customer Signature	X 		X
Yellow = fields to be filled in			
Orange = fields autocalculated			
Pink = Competitor calculations			