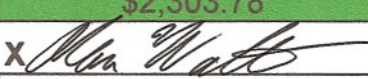


Tool Report Form

Tech:	Name:	Phone #	Date
Customer:	GENIE INDUSTRIES	425-498-7606	02/19/10
Contact info:	ALAN WALTER		
Part Name	BACK LASH (135 LINE)		
Drawing Number		VERSION	CUTTER PATH
CAM SOFTWARE	SURFWARE	4	TRUEMILL
NOTES:			
Material	A36		Load Meter
Hardness RC or BHN	STANDARD	Horse power	% used load
Machine	MAZAK H800 4500RPM	30	10.00%
Operation	MILLING		
		SwiftCarb	Competitor
Data	Tools Tested	RAMPMILL	METAL REMOVAL
No. Parts to be Produced		36	36
Machining Rate (\$/Hr)		\$100.00	\$100.00
Cutter diameter		0.5	0.875
Axial Depth Of Cut		1.2	1.2
Radial Doc or Step over		0.073	0.100
Number of Flutes		5	4
Chip Load per tooth	IPT	0.006	0.003
Speed (RPM)		4500	1500
Surface feet per minute	SFM	589.0052356	343.5863874
Feed (IPM)	IPM	81.000	11.250
Cubic inches per minute	MRR	11.826	1.800
Tool Cost		\$93.43	\$126.00
Tool No parts/tool		16	4
Cycle time per part		42	65
Time saved per part in minutes		23	
Analysis			
Total Machining Time In hours	Hours	25.20	39.00
Total Machining Cost (Time per part X \$xxx.xx per hour)		\$2,520.00	\$3,900.00
Total Tooling Cost		\$210.22	\$1,134.00
Cost Each Part		\$75.84	\$139.83
Total Costs		\$2,730.22	\$5,034.00
Total Savings....	\$2,303.78		
Customer Signature	X 	X 	
Yellow = fields to be filled in			
Orange = fields autocalculated			
Pink = Competitor calculations			