

## Tool Report Form

|                                                          |                       |                          |              |
|----------------------------------------------------------|-----------------------|--------------------------|--------------|
| Tech:                                                    | Name:                 | Phone #                  | Date         |
| Customer:                                                | PRECOR                | 425-4825626              | 02/17/10     |
| Contact info:                                            | MERRIL                |                          |              |
| Part Name                                                | 37736                 |                          |              |
| Drawing Number                                           |                       | VERSION                  | CUTTER PATH  |
| CAM SOFTWARE                                             | SURFWARE              | 4                        | TRUEMILL     |
| NOTES:                                                   | TRUEMILL PATH         |                          |              |
| Material                                                 | ALUMINUM 6061 T6      |                          | Load Meter   |
| Hardness RC or BHN                                       | T6                    | Horse power              | % used load  |
| Machine                                                  | TOYATA 550H           | 30                       | 10%????      |
| Operation                                                |                       |                          |              |
|                                                          |                       | SwiftCarb                | Competitor   |
| Data                                                     | Tools Tested          | RAMPMILL                 | XXXXXXXXXXXX |
| No. Parts to be Produced                                 | 14000 PER YEAR        | 14000                    | 14000        |
| Machining Rate (\$/Hr)                                   | 100                   | \$100.00                 | \$100.00     |
| Cutter diameter                                          | COOLANT THRU          | 0.75                     | 1            |
| Axial Depth Of Cut                                       |                       | 1.5                      | 1.5          |
| Radial Doc or Step over                                  |                       | 0.440                    | 0.032        |
| Number of Flutes                                         |                       | 3                        | 3            |
| Chip Load per tooth                                      | IPT                   | 0.008                    | 0.003        |
| Speed (RPM)                                              |                       | 12000                    | 8000         |
| Surface feet per minute                                  | SFM                   | 2356.020942              | 2094.240838  |
| Feed (IPM)                                               | IPM                   | 288.000                  | 50.000       |
|                                                          |                       |                          |              |
| Cubic inches per minute                                  | MRR                   | 190.080                  | 3.456        |
|                                                          |                       |                          |              |
| Tool Cost                                                |                       | \$179.52                 | \$800.00     |
| Tool No parts/tool                                       |                       | 7000                     | 7000         |
|                                                          |                       |                          |              |
| Cycle time per part                                      | 32 PARTS ON TOMESTONE | 1.56                     | 2.23         |
| Time saved per part in minutes                           |                       | 0.67                     |              |
| Analysis                                                 |                       |                          |              |
| Total Machining Time In hours                            | Hours                 | 364.00                   | 520.33       |
| Total Machining Cost (Time per part X \$xxx.xx per hour) |                       | \$36,400.00              | \$52,033.33  |
| Total Tooling Cost                                       |                       | \$359.04                 | \$1,600.00   |
| Cost Each Part                                           |                       | \$2.63                   | \$3.83       |
| Total Costs                                              |                       | \$36,759.04              | \$53,633.33  |
| Total Savings....                                        | \$16,874.29           |                          |              |
| Customer Signature                                       | X <i>Mark Kincade</i> | X <i>Merrill Kincade</i> |              |
| Yellow = fields to be filled in                          |                       |                          |              |
| Orange = fields autocalculated                           |                       |                          |              |
| Pink = Competitor calculations                           |                       |                          |              |