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Description:

Part Num:

Estimator:  Revision:  Date:  Scrap Allowance (%):

[Variable Costs \(Per-Part\)](#)

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|                  |      |                |      |
|------------------|------|----------------|------|
| Cycle Time (sec) | 75.2 | Gross Pcs/Hour | 45   |
| Cycle Time (min) | 1.3  | Pcs/8 Hours    | 363  |
| Cycle Time (hrs) | 0    | Pcs/40 Hours   | 1819 |
| Cost / Pc        | 1.32 | Pcs/160 Hours  | 7276 |

[Add Op](#)

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Estimator is in alpha test and has bugs; use carefully!

| Op                         | Description | Tool             | Op Time    | Cost | Add Time | Add Cost | Cut Depth | Cut Width | RF |
|----------------------------|-------------|------------------|------------|------|----------|----------|-----------|-----------|----|
| Rough OD to 3.015, len = 1 | OD Turning  | Turning: Carbide | 00:00:1.5  | 0.03 | 0        |          | 0.055     | 0         | 22 |
| Finish OD to 3, len = 1    | OD Turning  | Turning: Carbide | 00:00:7.8  | 0.13 | 0        |          | 0.015     | 0         | 19 |
| Rough OD to 2.015, len = 1 | OD Turning  | Turning: Carbide | 00:00:7.2  | 0.12 | 0        |          | 0.185     | 0         | 16 |
| Finish OD to 2, len = 1    | OD Turning  | Turning: Carbide | 00:00:5.2  | 0.09 | 0        |          | 0.015     | 0         | 29 |
| Rough OD to 1.015, len = 1 | OD Turning  | Turning: Carbide | 00:00:13.3 | 0.22 | 0        |          | 0.211     | 0         | 10 |
| Finish OD to 1, len = 1    | OD Turning  | Turning: Carbide | 00:00:2.6  | 0.04 | 0        |          | 0.015     | 0         | 58 |
| Rough OD to 3.015, len = 1 | OD Turning  | Turning: Carbide | 00:00:1.5  | 0.03 | 0        |          | 0.055     | 0         | 22 |
| Finish OD to 3, len = 1    | OD Turning  | Turning: Carbide | 00:00:7.8  | 0.13 | 0        |          | 0.015     | 0         | 19 |
| Rough OD to 2.015, len = 1 | OD Turning  | Turning: Carbide | 00:00:7.2  | 0.12 | 0        |          | 0.185     | 0         | 16 |
| Finish OD to 2, len = 1    | OD Turning  | Turning: Carbide | 00:00:5.2  | 0.09 | 0        |          | 0.015     | 0         | 29 |
| Rough OD to 1.015, len = 1 | OD Turning  | Turning: Carbide | 00:00:13.3 | 0.22 | 0        |          | 0.211     | 0         | 16 |
| Finish OD to 1, len = 1    | OD Turning  | Turning: Carbide | 00:00:2.6  | 0.04 | 0        |          | 0.015     | 0         | 58 |

# Machine Shop Estimating

**JL Elias**



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