M710 - Bolt Body Blank

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material								$ 3.15			$ 3.15
10	cutoff / internal dia / chamfer	turning center	$ 68,000.00	$ 800.00	8173	$ 15.89	397.98%	0.0140000		$ 0.22	$ 0.89	$ 1.11
		gage		$ 900.00								
20	drill .250 dia through	vmc	$ 65,000.00	$ 800.00	8173	$ 15.89	397.98%	0.0060000		$ 0.10	$ 0.38	$ 0.47
		quad indexer	$ 26,000.00									
		gage		$ 500.00								
30	mill cam cut and notch	vmc	$ 65,000.00	$ 800.00	8560	$ 15.40	285.31%	0.0110000		$ 0.17	$ 0.48	$ 0.65
	drill .250 dia hole	4th axis	$ 28,000.00									
		fixture	$ 3,500.00									
		gage	$ 2,800.00									
40	drill 94 rad X .45 deep 2X	vmc	$ 65,000.00	$ 800.00	8560	$ 15.40	285.31%	0.0080000		$ 0.12	$ 0.35	$ 0.47
		fixture	$ 1,800.00									
		gage	$ 1,500.00									
		material handling	$ 1,100.00									
	Totals		**$ 327,700.00**	**$ 4,600.00**				**0.039000**	**$ 3.15**	**$ 0.61**	**$ 2.10**	**$ 5.86**

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Williams v. Remington