M710-Bolt Body Blank-Threaded

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 thread 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	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		$ 200.00								
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									
		material handling	$ 1,100.00									
	Totals		**$ 259,400.00**	**$ 3,500 00**				**0.031000**	**$ 3.15**	**$ 0.49**	**$ 1.75**	**$ 5.39**

REV4-EST XLS

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Williams v. Remington