

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead
	Material (Blank 94523)						
10	Cutoff, Heat, Manual upset				8173	\$ 16.73	356.10%
		Dies & Rams	\$ 13,000.00	\$ 1,000.00			
20	Machine straighten				8173	\$ 16.73	356.10%
30	Drill bore - upset barrels	Gaging	\$ 3,500		8158	\$ 19.30	337.90%
40	Form Turn	Gaging	\$ 6,000	\$ 2,000	8158	\$ 19.30	337.90%
50	Bore ream to remove drill rings	Gaging	\$ 3,000		8158	\$ 19.30	337.90%
60	GFM form and finish	Gaging	\$ 10,000	\$ 500	8158	\$ 19.30	337.90%
70	Load furnace baskets				8105	\$ 15.99	358.40%
80	De-grease				8105	\$ 15.99	358.40%
90	Load work on furnace base				8105	\$ 15.99	358.40%
100	Stress relieve				8105	\$ 15.99	358.40%
110	Cool work				8105	\$ 15.99	358.40%
120	Unload work from furnace base				8105	\$ 15.99	358.40%

~AUTOFILE