

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material
	Blank Material								\$ 1.60
15	Mill Lugs Machine	Cian. 100	\$ 70,000.00		8560	\$ 15.40	285%		\$ -
	Fixtures		\$ 4,000.00				Time included in Mazak Run Time		
	Tools		\$ 4,000.00	\$ 500.00					
	Gaging		\$ 1,000.00						
25	Mazak				8560	\$ 15.40	285%	0.041000	\$ -
	Fixtures	New Tombstones/Collets	\$ 60,000.00						
	Gaging		\$4,000						
30	Chamfer Lugs				8560	\$ 15.40	285%	0.018860	\$ -
	Machine	Rem Spec.	\$ 45,000.00						
	Fixtures		\$ 5,000.00						
56	Ream Extractor Rivit Hole				8560	\$ 15.40	285%	0.006880	\$ -
	Fixtures		\$ 1,000.00						
57	Coin Anti-Rotation Dimple				8560	\$ 15.40	285%	0.006380	\$ -
	Fixtures		\$ 1,000.00						
60	Ream Ejt./Ejt. Retaining Hole				8560	\$ 15.40	285%	0.007100	\$ -
	Fixtures		\$ 1,000.00						
65	Ream & C' Sink Extractor				8560	\$ 15.40	285%	0.015110	\$ -
	Rivot Hole. Ream Ejt. Cross								

~AUTOFIL