

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$
	Material (Blank 97651)								\$ 2.44	
1	Issue from crib				9290					
5	Cut to length (need 26')			\$ 600.00	8173	\$ 15.89	397.98%	0.012437		\$ 0.2
16	Heat, Manual upset and trim			\$ 1,000.00	8173	\$ 15.89	397.98%	0.012437		\$ 0.2
18	Machine straighten				8173	\$ 15.89	397.98%	0.007991		\$ 0.1
20	Load furnace baskets				8105	\$ 15.38	333.86%	0.001680		\$ 0.0
22	Load furnace heat and quench				8105	\$ 15.38	333.86%	0.000001		\$ 0.0
23	Unload furnace and wash				8105	\$ 15.38	333.86%	0.001470		\$ 0.0
24	Load draw furnace and draw barrels				8105	\$ 15.38	333.86%	0.006667		\$ 0.1
25	Unload draw furnace				8105	\$ 15.38	333.86%	0.000850		\$ 0.0
29	Unload furnace baskets				8105	\$ 15.38	333.86%	0.000520		\$ 0.0
30	Tumblast				8105	\$ 15.38	333.86%	0.001600		\$ 0.0
31	Inspect for hardness				8105	\$ 15.38	333.86%	0.004900		\$ 0.0
	Crib							0.000001		

~AUTOFIL