

OPERATION	TOOL NAME	ESTIMATED TOOL COST	PLANT LABOR (\$/pc.)
Upset	Heading Ram Insert #1	\$ 600.00	
Upset	Heading Ram Insert #2	\$ 430.00	
Upset	Heading Ram Holder #1	\$ 500.00	
Upset	Heading Ram Holder #2	\$ 800.00	
Upset	Upper Die	\$ 4,500.00	
Upset	Lower Die	\$ 4,500.00	
Cutoff, Heat, Manual upset			\$ 2.66
Machine straighten			\$ 0.61
Drill Bore	Holding Cones	\$ 500.00	
Drill bore - upset barrels			\$ 1.81
Form Turn NFT form			\$ 2.95
Ream	Holders	\$ 500.00	
Bore ream to remove drill rings			\$ 0.88
GFM	Driver	\$ 1,600.00	
GFM	Counter Holder	\$ 1,200.00	
GFM	Hammers	\$ 2,000.00	
GFM	Mandrel	\$ 600.00	
GFM	Mandrel Rod	\$ 300.00	
GFM form and finish			\$ 2.20
Press Receiver to Barrel	REM Special	\$ 20,000.00	
Press Receiver onto barrel			\$ 1.98
	TOTALS:	\$ 38,030.00	\$ 13.09
	Total run lot (40 pcs.)	\$	523.60