M710 - Barrel Assembly

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
1	Issue from crib				9132							
10	Pick Chamber For Rings				8158	$ 15.76	359.44%	0.000277		$ 0.00	$ 0.02	$ 0.02
20	Press Receiver onto barrel		$ 20,000	$ 500	8158	$ 15.76	359.44%	0.023370		$ 0.37	$ 1.32	$ 1.69
30	Stake Receiver		$ 12,500	$ 500	8158	$ 15.76	359.44%	0.015034		$ 0.24	$ 0.85	$ ~~1.09~~ 2.21
40	Wash, Magnaflux & Stamp				8158	$ 15.76	359.44%	0.015499		$ 0.24	$ 0.88	$ ~~1.12~~
50	Inspect Runout & Straighten			$ 500	8158	$ 15.76	359.44%	0.005744		$ 0.09	$ 0.33	$ 0.42
60	Rollmark		$ 1,500	$ 500	8158	$ 15.76	359.44%	0.005187		$ 0.08	$ 0.29	$ 0.38
70	Angularity Straighten Muzzle			$ 500	8158	$ 15.76	359.44%	0.005187		$ 0.08	$ 0.29	$ 0.38
80	Drill & Tap		$ 125,000	$ 1,000	8158	$ 15.76	359.44%	0.013074		$ 0.21	$ 0.74	$ 0.95
90	Wipe Bore & Inspect				8158	$ 15.76	359.44%	0.005187		$ 0.08	$ 0.29	$ 0.38
100	Hand Spin Polish - 180 Grit				8158	$ 15.76	359.44%	0.007716		$ 0.12	$ 0.44	$ 0.56
110	Insert Screws into holes & Blast				8178	$ 16.28	353.98%	0.014061		$ 0.23	$ 0.81	$ 1.04
120	Black Oxide Color				8178	$ 16.28	353.98%	0.004377		$ 0.07	$ 0.25	$ 0.32
	Totals		**$ 159,000**	**$ 3,500**				**0.114713**	**$ -**	**$ 1.82**	**$ 6.52**	**$ 8.33**

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