M710 - Receiver

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
10	mill fire control slot/ bolt/taper	vmc	$ 65,000.00	$ 800.00	8154	$ 15.65	328.21%	0.017400	$ -	$ 0.27	$ 0.89	$ 1.17
		quad indexer	$ 26,000.00									
		fixture	$ 1,800.00									
		gages	$ 2,200.00									
20	mill ejection port/magbox	vmc	$ 65,000.00	$ 800.00	8154	$ 15.65	328.21%	0.050000	$ -	$ 0.78	$ 2.57	$ 3.35
		quad indexer	$ 26,000.00									
		fixture	$ 1,800.00									
		gages	$ 2,400.00									
30												
	Drill and tap scope holes	vmc	$ 65,000.00	$ 800.00	8154	$ 15.65	328.21%	0.013000	$ -	$ 0.20	$ 0.67	$ 0.87
	drill take down hole	quad indexer	$ 26,000.00									
		fixture	$ 1,800.00									
		gages	$ 2,800.00									
50	Metasilicate wash	material handling	$ 2,500.00	$ 600.00	8154	$ 15.65	328.21%	0.000002	$ -	$ 0.00	$ 0.00	$ 0.00
		racks	$ 1,000.00									
60	Finish File / burr	dyna file		$ 900.00	8154	$ 15.65	328.21%	0.005000	$ -	$ 0.08	$ 0.26	$ 0.34
70	Roll mark Remington & model	Schmidt	$ 8,000.00	$ 600.00	8154	$ 15.65	328.21%	0.003600	$ -	$ 0.06	$ 0.18	$ 0.24
		gage		$ 500.00								
80	Stamp serial number	Rem Special	$ 5,000.00	$ 600.00	8154	$ 15.65	328.21%	0.003600	$ -	$ 0.06	$ 0.18	$ 0.24
		gage		$ 500.00								
100	Fixture Finish - wet & destone	Almco	$ 15,000.00	$ 850.00	8154	$ 15.65	328.21%	0.012500	$ -	$ 0.20	$ 0.64	$ 0.84
		fixture		$ 900.00								
	Totals		**$ 317,300.00**	**$ 7,850.00**				**0.105102**	**$ -**	**$ 1.64**	**$ 5.40**	**$ 7.04**

REV4-EST.XLS