

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Blank Material											
10	MIM process part				8902				\$ 0.07	\$ 0.17	\$ 0.56	\$ 0.80
		mold	\$ 22,000.00	\$ 400.00								
		coining tool	\$ 4,000.00	\$ 400.00								
		furnace setters	\$ 3,000.00	\$ 400.00								
		development cost	\$ 5,500.00	\$ 400.00								
20	tap	tapmatic	\$ 5,500.00	\$ 400.00	8502	\$ 15.05	238%	0.0020000		\$ 0.03	\$ 0.07	\$ 0.10
		fixture	\$ 1,000.00									
		gages		\$ 500.00								
30	wash	materials handling		\$ 500.00	8562	\$ 15.05	238%	0.000118		\$ 0.00	\$ 0.00	\$ 0.01
40	heat treat micro carb	material handling		\$ 500.00	8551	\$ 15.78	278%	0.0002772		\$ 0.00	\$ 0.01	\$ 0.02
50	draw				8551	\$ 15.78	278%	0.0001260		\$ 0.00	\$ 0.01	\$ 0.01
60	inspect for hardness			\$ 500.00	8551	\$ 15.78	278%	0.0000100		\$ 0.00	\$ 0.00	\$ 0.00
70	tumble	materials handling		\$ 500.00	8551	\$ 15.78	278%	0.0003696		\$ 0.01	\$ 0.02	\$ 0.02
80	color	materials handling		\$ 800.00	8551	\$ 15.78	278%	0.0002770		\$ 0.00	\$ 0.01	\$ 0.02
	Totals		\$ 41,000.00	\$ 5,300.00				0.003178	\$ 0.07	\$ 0.22	\$ 0.68	\$ 0.97

REV4-EST vLS

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