

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper Cost
	Blank Material								\$ 1.60			\$ 1.60
15	Mill Lugs				8560	\$ 15.40	285.00%		\$ -	\$ -	\$ -	\$ -
	Machine	Cinn. 100	\$ 70,000.00									
	Fixtures		\$ 4,000.00									
	Tools		\$ 4,000.00	\$ 500.00								
	Gaging		\$ 1,000.00									
25	Mazak				8560	\$ 15.40	285.00%	0.041000	\$ -	\$ 0.63	\$ 1.80	\$ 2.43
	Fixtures	New Tombstones/Colllets	\$ 60,000.00									
	Gaging		\$ 4,000.00									
30	Chamfer Lugs				8560	\$ 15.40	285.00%	0.018860	\$ -	\$ 0.29	\$ 0.83	\$ 1.12
	Machine	Rem Spec.	\$ 45,000.00									
	Fixtures		\$ 5,000.00									
56	Ream Extractor Rivet Hole				8560	\$ 15.40	285.00%	0.006880	\$ -	\$ 0.11	\$ 0.30	\$ 0.41
	Fixtures		\$ 1,000.00									
57	Core Anti-Rotation Dimple				8560	\$ 15.40	285.00%	0.006380	\$ -	\$ 0.10	\$ 0.28	\$ 0.38
	Fixtures		\$ 1,000.00									
60	Ream Ejt./Ejt. Retaining Hole				8560	\$ 15.40	285.00%	0.007100	\$ -	\$ 0.11	\$ 0.31	\$ 0.42
	Fixtures		\$ 1,000.00									
65	Ream & C' Sink Extractor				8560	\$ 15.40	285.00%	0.015110	\$ -	\$ 0.23	\$ 0.66	\$ 0.90
	Rivet Hole. Ream Ejt. Cross											
	Pin Hole											
	Fixtures		\$ 1,000.00									
70	Deburr & Dimple				8560	\$ 15.40	285.00%	0.015110	\$ -	\$ 0.23	\$ 0.66	\$ 0.90
	Fixtures		\$ 1,000.00									
80	Drill Cross Pin Hole	Drill Press										
	Fixture		\$ 500.00	\$ 100.00	8560	\$ 15.40	285.31%	0.002121	\$ -	\$ 0.03	\$ 0.09	\$ 0.12
90	Drill Assembly Hole	Drill Press										
	Fixture		\$ 1,000.00	\$ 200.00	8560	\$ 15.40	285.31%	0.004166	\$ -	\$ 0.06	\$ 0.18	\$ 0.25
100	Ream Assembly Hole	Drill Press										
	Fixture		\$ 1,000.00	\$ 100.00	8560	\$ 15.40	285.31%	0.002777	\$ -	\$ 0.04	\$ 0.12	\$ 0.16
	Totals		\$ 200,500.00	\$ 900.00				0.119504	\$ 1.60	\$ 1.84	\$ 5.25	\$ 8.69