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M710 - Fire Control Assembly

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital	Ops.	Depart.	Depart.	Total %	Std. Run	Material	Labor	Over Head	Oper.
				\$	Number	Labor \$	Overhead	Hours	\$	\$	\$	Cost
1	Issue From Crib				9132							
10	Demagnetize Metal Components				8772	\$ 15 56	190.19%	0.000404		\$ 0 01	\$ 0 01	\$ 0 02
20	Assemble - Stage 1				8772	\$ 15 56	190.19%	0 018634		\$ 0 29	\$ 0 55	\$ 0 84
30	Assemble - Stage 2				8772	\$ 15 56	190.19%	0.031275		\$ 0 49	\$ 0 93	\$ 1 41
40	Adjust on Comparator				8772	\$ 15 56	190.19%	0.018929		\$ 0 29	\$ 0 56	\$ 0 85
50	Assemble - Stage 3				8772	\$ 15 56	190.19%	0.02412		\$ 0 38	\$ 0 71	\$ 1 09
60	Function Check Complete				8772	\$ 15 56	190.19%	0 009917		\$ 0 15	\$ 0 29	\$ 0 45
70	Stamp Identification			\$ 500.00	8772	\$ 15 56	190.19%	0.001908		\$ 0 03	\$ 0 06	\$ 0 09
	Deliver to Crib											
	Totals		\$ -	\$ 500.00				0.105187	\$ -	\$ 1.64	\$ 3.11	\$ 4.75

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M710 - Bolt Handle

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Blank Material - Screw Machine								\$ 1.47			\$ 1.47
	Gaging (vender and Remington)		\$ 1,000.00	\$ 500.00	Vendor							
	Totals		\$ 1,000.00	\$ 500.00				0.000000	\$ 1.47	\$ -	\$ -	\$ 1.47

Alper Base Material Cost

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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%		\$ -	\$ -	\$ -	\$ -
	Machine	Cinn 100	\$ 70,000.00									
	Fixtures		\$ 4,000.00					Time included in Mazak Run Time				
	Tools		\$ 4,000.00	\$ 500.00								
	Gaging		\$ 1,000.00									
25	Mazak				8560	\$ 15.40	285%	0.041000	\$ -	\$ 0.63	\$ 1.80	\$ 2.43
	Fixtures	New Tombstones/Collets	\$ 60,000.00									
	Gaging		\$ 4,000.00									
30	Chamfer Lugs (Chamfer To .000000)				8560	\$ 15.40	285%	0.018860	\$ -	\$ 0.27	\$ 0.83	\$ 1.12
	Machine	Rem Spec	\$ 45,000.00									
	Fixtures		\$ 5,000.00									
56	Ream Extractor Rivet Hole				8560	\$ 15.40	285%	0.006880	\$ -	\$ 0.11	\$ 0.30	\$ 0.41
	Fixtures		\$ 1,000.00									
57	Coin Anti-Rotation Dimple				8560	\$ 15.40	285%	0.006380	\$ -	\$ 0.10	\$ 0.28	\$ 0.38
	Fixtures		\$ 1,000.00									
60	Ream Ejt /Ejt Retaining Hole				8560	\$ 15.40	285%	0.007100	\$ -	\$ 0.11	\$ 0.31	\$ 0.42
	Fixtures		\$ 1,000.00									
65	Ream & C' Sink Extractor				8560	\$ 15.40	285%	0.015110	\$ -	\$ 0.23	\$ 0.66	\$ 0.90
	Rivet Hole Ream Ejt Cross											
	Pin Hole											
	Fixtures		\$ 1,000.00									
70	Deburr Extractor Rivet				8560	\$ 15.40	285%	0.015110	\$ -	\$ 0.23	\$ 0.66	\$ 0.90
	Dimple & Ejector Hole											
	Fixtures		\$ 1,000.00									
	Totals		\$ 198,000.00	\$ 500.00				0.110440	\$ 1.60	\$ 1.70	\$ 4.85	\$ 8.15

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M710 - Barrel Blank

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Material (Blank 94523)								\$ 3.35			\$3.35
16	Cutoff. Heat. Manual upset Tooling		\$ 13,000.00	\$ 1,000.00	8173	\$ 15.89	397.98%	0.034889		\$ 0.55	\$ 2.21	\$ 2.76
18	Machine straighten				8173	\$ 15.89	397.98%	0.007991		\$ 0.13	\$ 0.51	\$ 0.63
			\$ 13,000.00	\$ 1,000.00					\$ 3.35	\$ 0.68	\$ 2.71	\$6.74

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M710 - Stock Assy

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
10	Injection Mold Butt Plate				Vendor							\$ 0.17
20	Synthetic Stock (Mold/Assy)				Vendor							\$ 6.55
	Tooling		\$ 120,000.00									
	Fixtures		\$ 5,000.00									
	Stock Assy. with Butt Plate		\$ 125,000.00									\$ 6.72
10	Injection Mold Recoil Pad				Vendor							\$ 3.15
	Tooling (Recoil Pad/Backer)		\$ 35,000.00									
20	Synthetic Stock (Mold/Assy)				Vendor							\$ 7.15
	Tooling		\$ 120,000.00									
	Fixtures		\$ 5,000.00									
	Stock Assy. with Recoil Pad		\$ 160,000.00									\$ 10.30
	Totals		\$ 570,000.00	\$				0.000000	\$ -	\$ -	\$ -	\$ 34.04

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	XXXX	\$	15 80
	XXX	\$	15 80
	XXXX	\$	15 80
\$ 600.00	XXX	\$	15 80
\$ 600.00	XXXX	\$	15 80

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M710 - Barrel

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 crb (105550)				9132			0.000001				
5	Drill bore - upset barrels		\$ 3,500		8158	\$ 15.76	359.44%	0.021468		\$ 0.34	\$ 1.22	\$ 1.55
15	Form Turn NFT form		\$ 6,000	\$ 2,000	8158	\$ 15.76	359.44%	0.034860		\$ 0.55	\$ 1.97	\$ 2.52
20	Bore ream to remove drill rings		\$ 3,000		8158	\$ 15.76	359.44%	0.010416		\$ 0.16	\$ 0.59	\$ 0.75
30	GFM form and finish		\$ 10,000	\$ 500	8158	\$ 15.76	359.44%	0.025976		\$ 0.41	\$ 1.47	\$ 1.88
56	Load furnace baskets				8105	\$ 15.38	333.86%	0.001680		\$ 0.03	\$ 0.09	\$ 0.11
57	De-grease				8105	\$ 15.38	333.86%	0.001720		\$ 0.03	\$ 0.09	\$ 0.11
58	Load work on furnace base				8105	\$ 15.38	333.86%	0.002510		\$ 0.04	\$ 0.13	\$ 0.17
59	Stress relieve				8105	\$ 15.38	333.86%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
60	Cool work				8105	\$ 15.38	333.86%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
61	Unload work from furnace base				8105	\$ 15.38	333.86%	0.007590		\$ 0.12	\$ 0.39	\$ 0.51
63	Unload furnace baskets				8105	\$ 15.38	333.86%	0.001890		\$ 0.03	\$ 0.10	\$ 0.13
65	Cut-off muzzle end and crown				8158	\$ 15.76	359.44%	0.025000		\$ 0.30	\$ 1.42	\$ 1.81
85	Turn and face breech chamber, and polish chamber	CNC Chucker	\$ 450,000		8158	\$ 15.76	359.44%	0.091660		\$ 1.44	\$ 5.19	\$ 6.64
		Tooling		\$ 10,000								
		Gaging	\$ 12,000									

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	8158	\$	1
	8157	\$	1
	8157	\$	1
	8157	\$	1
	8157	\$	1
	8157	\$	1
12,500			

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