

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$
1	Issue from crib (103550)				9132			0.000001		
5	Drill bore - upset barrels		\$ 3,500		8158	\$ 15.76	359.44%	0.021468		\$ 0.3
15	Form Turn NFT form		\$ 6,000	\$ 2,000	8158	\$ 15.76	359.44%	0.034860		\$ 0.5
20	Bore ream to remove drill rings		\$ 3,000		8158	\$ 15.76	359.44%	0.010416		\$ 0.1
30	GFM form and finish		\$ 10,000	\$ 500	8158	\$ 15.76	359.44%	0.025976		\$ 0.4
56	Load furnace baskets				8105	\$ 15.38	333.86%	0.001680		\$ 0.0
57	De-grease				8105	\$ 15.38	333.86%	0.001720		\$ 0.0
58	Load work on furnace base				8105	\$ 15.38	333.86%	0.002510		\$ 0.0
59	Stress relieve				8105	\$ 15.38	333.86%	0.000001		\$ 0.0
60	Cool work				8105	\$ 15.38	333.86%	0.000001		\$ 0.0
61	Unload work from furnace base				8105	\$ 15.38	333.86%	0.007590		\$ 0.1
63	Unload furnace baskets				8105	\$ 15.38	333.86%	0.001890		\$ 0.0
65	Cut-off muzzle end and crown				8158	\$ 15.76	359.44%	0.025000		\$ 0.3
85	Turn and face breech	CNC Chucker	\$ 450,000		8158	\$ 15.76	359.44%	0.091660		\$ 1.4

~AUTOFIL