

THREADMILL CASE STUDY:



TOOL DATA:

STEINER:

OTHER:

| | | |
|--------------------------------|-----------|------------------------------------|
| Manufacturer: | JBO | Premier German Thread Mill Company |
| Tool Type: (GF/GFM/GFT) | GFT | 3-Row of Teeth |
| Tool Part #: | JBO312645 | Unknown |
| Tool Cost: | \$109.00 | \$180.00 |

PART DATA:

| | |
|---------------------------------|---|
| Part Name: | Optics Part |
| Part No.: | N/A |
| Thread Size | M2.5x0.45 |
| Thread Depth (in): | .295 |
| Material & Hardness: | Invar (Nickel-Iron Alloy Containing 36%-41% Nickel) |
| Quantity Holes Per Year: | 7500 |

MACHINE DATA:

| | |
|-------------------------------|----------|
| Make & Model: | Mill |
| Spindle Taper: | Ct40 |
| Overhead Rate (\$/hr): | \$120.00 |

MACHINING PARAMETERS:

STEINER

OTHER:

| | | |
|---------------------------------|------|------|
| Spindle Speed (RPM): | 5895 | 2728 |
| Feed Rate (IPM): | 6.06 | 7.60 |
| Number of Radial Passes: | 1 | 2 |
| Cut Time (Seconds): | 67 | 150 |
| Tool Life (# of Holes) | 696 | 300 |

RESULTS:

STEINER:

OTHER:

| | | | |
|--|--|-------------|-------------|
| Cycle Time Per Hole (sec): | (Cut Time (Sec/Hole)) | 67 | 150 |
| Machine Costs Per Hole: | (Cycle Time(Sec/Hole) x Overhead Rate (\$/hr) x (1hr/3600Sec)) | \$2.23 | \$5.00 |
| Tool Costs Per Hole: | (Tool Cost (\$) / Tool Life (holes)) | \$0.16 | \$0.60 |
| Total Costs Per Hole: | (Machine Cost (\$/hole) + Tool Cost (\$/hole)) | \$2.39 | \$5.60 |
| Annualized Manufacturing Cost: | (Total Cost (\$/hole) x Qty. Holes/Year) | \$17,924.57 | \$42,000.00 |
| Steiner Annualized Production Cost Savings: | (Steiner Annualized Mfg. Cost—Other Annualized Mfg Cost.) | \$24,075.43 | |
| Steiner Annualized Production Time Savings (hrs): | (Steiner Cycle Time (min/hole) - Other Cycle Time (min/hole)) x Qty. Holes/Year / (1hr/60min)) | 10.42 | |

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**REQUEST
A QUOTE**



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