

## Money Maker

**Machine:** Fanuc-0iT-18.5/22 kW  
**Job material:** Steel - very soft low carbon.

**Part number:** TG-6651  
**Part name:** Hub-LH

Sl. no.	Operation	Tool	Feed rate (mm/rev)	Cutting speed (m/min)	Depth of cut (mm)	Depth of cut max. (mm)	Power required (kW)	Power available (kW)	Torque required (Nm)	Torque available (Nm)	Time	% time	Cost
1	Plain face	DCLNL 3225P16 R0.8	0.200	220.0	3.000	10.56	7.1	14.8	43.4	90.9	00:00:14	5.6	1.2
2	Contour turn	DCLNL 3225P16 R0.8	0.200	220.0	2.000	10.56	4.7	14.8	36.6	115.0	00:00:14	5.8	1.2
3	Contour turn	DCLNL 3225P16 R0.8	0.200	220.0	3.000	10.56	7.1	14.8	54.9	115.0	00:00:12	4.9	1.0
4	Contour face	DCLNL 3225P16 R0.8	0.200	220.0	2.000	10.56	4.7	14.8	97.4	305.8	00:00:22	9.0	1.9
5	Contour face	DCLNL 3225P16 R0.8	0.200	220.0	2.000	10.56	4.7	14.8	57.4	180.4	00:00:19	7.7	1.6
6	Finish face	DCLNL 2525M16 R0.8	0.200	220.0	0.000	10.56	0.0	14.8	0.0	305.8	00:00:29	11.6	2.4
7	Finish face	DCLNL 2525M16 R0.8	0.200	220.0	0.000	10.56	0.0	14.8	0.0	98.9	00:00:03	1.2	0.3
8	Finish turn	DCLNL 2525M16 R0.8	0.200	220.0	0.000	10.56	0.0	14.8	0.0	180.4	00:00:23	9.2	1.9
9	Finish turn	DCLNL 2525M16 R0.8	0.200	200.0	0.000	10.56	0.0	14.0	0.0	321.1	00:00:09	3.8	0.8
10	Finish face	DCLNL 2525M16 R0.8	0.200	220.0	0.000	10.56	0.0	14.8	0.0	307.8	00:00:30	12.1	2.6
11	External groove	16x16, 2.00w, 0.20R, 15Depth, LH	0.050	150.0	0.000	0.00	5.7	14.8	57.1	147.9	00:00:13	5.4	1.1
12	Contour turn	S20S PCLNL 09 R0.4	0.150	160.0	2.000	5.94	2.8	14.8	26.7	141.3	00:00:13	5.3	1.1
13	Finish turn	S20S PTFNL 11 R0.4	0.200	280.0	0.000	5.50	0.0	14.2	0.0	58.0	00:00:12	4.9	1.0

Batch quantity

RMS power  kW

Scrap volume  cc

Machine rate  Rs./hr

Scrap rate  Rs./Kg

Machining time

Per piece

Per batch

Scrap weight

 kg

Machining cost

 Rs.

Scrap sale value

 Rs.

Net machining cost

 Rs.

## Cycle time sheet

Western  
Forge Ltd.

Machine name: Fanuc-0iT-18.5/22 kW  
Part number: TG-6651  
Part name: Hub-LH  
Date: 08-06-2015 16:13

Job material: Steel - very soft low carbon, purely ferritic  
Fixture: Chuck  
Programmer: Prakash TK  
Setup number: 1

Sl. no.	Operation	Tool	Tool no.	Cutting speed (m/min)	Spindle speed (RPM)	Feed rate (mm/min)	Feed rate (mm/rev)	Cut length (mm)	Cutting time	Rapid time	Tool change time	Total time
1	Plain face	DCLNL 3225P16 R0.8	1	220.0	CSS	0.000	0.200	15.66	00:00:03	00:00:01	00:00:10	00:00:14
2	Contour tum	DCLNL 3225P16 R0.8	1	220.0	CSS	0.000	0.200	51.13	00:00:13	00:00:01	00:00:00	00:00:14
3	Contour tum	DCLNL 3225P16 R0.8	1	220.0	CSS	0.000	0.200	47.83	00:00:11	00:00:01	00:00:00	00:00:12
4	Contour face	DCLNL 3225P16 R0.8	1	220.0	CSS	0.000	0.200	39.65	00:00:21	00:00:01	00:00:00	00:00:22
5	Contour face	DCLNL 3225P16 R0.8	1	220.0	CSS	0.000	0.200	55.05	00:00:17	00:00:01	00:00:00	00:00:19
6	Finish face	DCLNL 2525M16 R0.8	2	220.0	CSS	0.000	0.200	35.32	00:00:18	00:00:01	00:00:10	00:00:29
7	Finish face	DCLNL 2525M16 R0.8	2	220.0	CSS	0.000	0.200	12.50	00:00:02	00:00:01	00:00:00	00:00:03
8	Finish tum	DCLNL 2525M16 R0.8	2	220.0	CSS	0.000	0.200	88.07	00:00:21	00:00:01	00:00:00	00:00:23
9	Finish tum	DCLNL 2525M16 R0.8	2	200.0	CSS	0.000	0.200	12.95	00:00:09	00:00:00	00:00:00	00:00:09
10	Finish face	DCLNL 2525M16 R0.8	8	220.0	CSS	0.000	0.200	37.27	00:00:19	00:00:01	00:00:10	00:00:30
11	External groove	16x16, 2.00W, 0.20R, 15...	5	150.0	CSS	0.000	0.050	1.70	00:00:02	00:00:01	00:00:10	00:00:13

## Summary

Cutting time: 00:02:23  
Tool change time: 00:00:59  
Rapid motion time: 00:00:15  
Miscellaneous time: 00:00:34  
Cycle time: **00:04:12**

## Note

The cycle time calculated depends on the how accurately you have entered the machine parameters for the machine - rapid rate, axes and spindle acceleration times, tool change time, etc.

To view to milliseconds accuracy, set 'Show times to millsec. accuracy' in the Settings option.





# Tools list

Western  
Forge Ltd.

Machine name: Fanuc-0iT-18.5/22 kW  
Part number: TG-6651  
Part name: Hub-LH  
Setup number: 1

Date: 08-06-2015 16:13  
Fixture: Chuck  
Programmer: Prakash TK

Sl. no.	Operation	Tool	Tool no.	Tool offset no.	X offset	Z offset	Nose radius
2	Contour turn	DCLNL 3225P16 R0.8	1				
3	Contour turn	DCLNL 3225P16 R0.8	1				
4	Contour face	DCLNL 3225P16 R0.8	1				
5	Contour face	DCLNL 3225P16 R0.8	1				
6	Finish face	DCLNL 2525M16 R0.8	2				
7	Finish face	DCLNL 2525M16 R0.8	2				
8	Finish turn	DCLNL 2525M16 R0.8	2				
9	Finish turn	DCLNL 2525M16 R0.8	2				
10	Finish face	DCLNL 2525M16 R0.8	8				
11	External groove	16x16, 2.00W, 0.20R, 15Depth, LH	5				
12	Contour turn	S20S PCLNL 09 R0.4	6				

Help

Close