

Profitability Study



A - Number of Machines in facility	2	3	4	5	6	7	8	9
B - Tool Changes per shift	2	3	4	2	3	4	2	3
C - Est time(MINS) for tool change	4	4	4	4	4	4	4	4
D - Work days / year	250	250	250	250	250	250	250	250
E - Production Shifts	2	2	2	2	2	2	2	2
F - Hourly cost of Machine	\$125.00	\$125.00	\$125.00	\$125.00	\$125.00	\$125.00	\$125.00	\$125.00
G - Total time(MINS) needed changes during shift =A*B*C	16	36	64	40	72	112	64	108
H - Total time(HRS) needed changes per year = D*E*G/60 Lost hours/Gained Hours	133	300	533	333	600	933	533	900
I - Total money lost due to machine downtime per machine or Total money saved while machine is producing per machine.	\$8,333.33	\$12,500.00	\$16,666.67	\$8,333.33	\$12,500.00	\$16,666.67	\$8,333.33	\$12,500.00