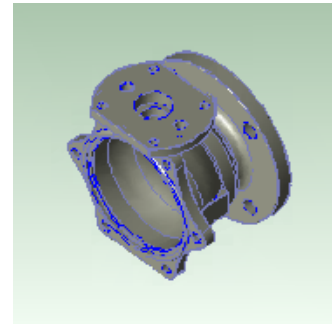


Part Name: BODY123
Description:
Scenario: Initial
Process Group: Casting
VPE: aPriori China



Fully Burdened Cost:	19.26	Total Planned Volume:	50,000
Cost Target:	Not specified	Material:	Aluminum AL380
Amount Variance:	-	Approx. CAD Rev/Ver:	-/0
Percent Variance:	-	Date part was costed:	11/29/2011
Projected Savings:	-	Date GCDs saved:	11/29/2011

Processes

	Part	Die Casting	3 Axis Mill
<u>Manufacturing Times:</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>
Labor Time	415.08	65.16	349.92
Cycle Time	415.08	65.16	349.92
<u>Variable Costs:</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>
Material Cost	9.68	9.68	0.00
Labor	2.86	0.01	2.84
Direct Overhead	4.80	0.66	4.14
Amortized Batch Setup	0.22	0.18	0.04
Logistics	0.00	0.00	0.00
Expendable Tooling	0.94	0.00	0.94
Additional Direct Costs	0.00	0.00	0.00
Extra Costs	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Other Direct Costs	0.94	0.00	0.94
Total Variable Costs	18.51	10.54	7.97
Period Overhead Allocations	0.00	0.00	0.00
Margin	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Piece Part Cost	18.51	10.54	7.97
<u>Fixed Costs:</u>			
Hard Tooling (amortized)	0.76	0.76	0.00
Fixture Cost (amortized)	0.00	0.00	0.00
Programming Cost	0.00	0.00	0.00
Additional Amortized	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Total Amortized	0.76	0.76	0.00
Fully Burdened Cost	19.26	11.29	7.97
Hard Tooling	37,794.19	37,794.19	0.00
Fixture Cost	0.00	0.00	0.00
Programming Cost	<u>106.81</u>	<u>0.00</u>	<u>106.81</u>
Total Capital Investments	37,901.00	37,794.19	106.81