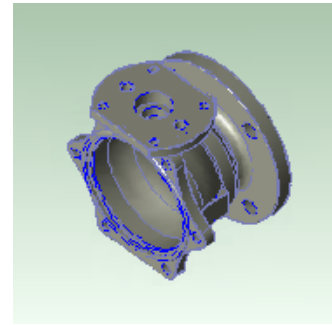


Part Name: BODY123
Description:
Scenario: Initial
Process Group: Casting
VPE: aPriori Mexico



Fully Burdened Cost:	23.11	Total Planned Volume:	50,000
Cost Target:	Not specified	Material:	Cast Iron A319
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

	<u>Part</u>	<u>Melting</u>	<u>Stock Core</u>	<u>Isocure Gas</u>	<u>Vertical Automatic</u>	<u>Shakeout</u>
<u>Manufacturing Times:</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>
Labor Time	997.93	0.00	0.00	24.00	7.22	35.85
Cycle Time	1,055.62	0.00	0.00	24.00	2.41	35.85
<u>Variable Costs:</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>
Material Cost	7.19	7.19	0.00	0.00	0.00	0.00
Labor	4.76	0.00	0.00	0.02	0.01	0.03
Direct Overhead	7.72	0.36	0.00	0.15	0.13	0.07
Amortized Batch Setup	0.21	0.00	0.00	0.03	0.11	0.01
Logistics	0.00	0.00	0.00	0.00	0.00	0.00
Expendable Tooling	3.00	0.00	0.47	0.82	0.28	0.00
Additional Direct Costs	0.00	0.00	0.00	0.00	0.00	0.00
Extra Costs	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Other Direct Costs	3.00	0.00	0.47	0.82	0.28	0.00
Total Variable Costs	22.87	7.55	0.47	1.02	0.52	0.11
Period Overhead Allocations	0.00	0.00	0.00	0.00	0.00	0.00
Margin	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Piece Part Cost	22.87	7.55	0.47	1.02	0.52	0.11
<u>Fixed Costs:</u>						
Hard Tooling (amortized)	0.23	0.00	0.00	0.08	0.16	0.00
Fixture Cost (amortized)	0.00	0.00	0.00	0.00	0.00	0.00
Programming Cost	0.00	0.00	0.00	0.00	0.00	0.00
Additional Amortized	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Total Amortized	0.24	0.00	0.00	0.08	0.16	0.00
Fully Burdened Cost	23.11	7.55	0.47	1.10	0.68	0.11
Hard Tooling	11,728.76	0.00	0.00	3,805.75	7,923.01	0.00
Fixture Cost	0.00	0.00	0.00	0.00	0.00	0.00
Programming Cost	<u>126.02</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Total Capital Investments	11,854.78	0.00	0.00	3,805.75	7,923.01	0.00

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

Fully Burdened Cost:	23.11	Total Planned Volume:	50,000
Cost Target:	Not specified	Material:	Cast Iron A319
Amount Variance:	-	Approx. CAD Rev/Ver:	-/0
Percent Variance:	-	Date part was costed:	11/29/2011
Projected Savings:	-	Date GCDs saved:	11/29/2011

	Part	Processes			
		Cleaning	Finishing	InLine Inspection	3 Axis Mill
<u>Manufacturing Times:</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>	<u>sec</u>
Labor Time	997.93	62.50	181.67	146.04	540.65
Cycle Time	1,055.62	125.00	181.67	146.04	540.65
<u>Variable Costs:</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>	<u>(USD)</u>
Material Cost	7.19	0.00	0.00	0.00	0.00
Labor	4.76	0.05	0.14	0.13	4.39
Direct Overhead	7.72	0.19	0.26	0.15	6.40
Amortized Batch Setup	0.21	0.00	0.00	0.00	0.04
Logistics	0.00	0.00	0.00	0.00	0.00
Expendable Tooling	3.00	0.00	0.00	0.00	1.44
Additional Direct Costs	0.00	0.00	0.00	0.00	0.00
Extra Costs	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Other Direct Costs	3.00	0.00	0.00	0.00	1.44
Total Variable Costs	22.87	0.24	0.41	0.29	12.27
Period Overhead Allocations	0.00	0.00	0.00	0.00	0.00
Margin	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Piece Part Cost	22.87	0.24	0.41	0.29	12.27
<u>Fixed Costs:</u>					
Hard Tooling (amortized)	0.23	0.00	0.00	0.00	0.00
Fixture Cost (amortized)	0.00	0.00	0.00	0.00	0.00
Programming Cost	0.00	0.00	0.00	0.00	0.00
Additional Amortized	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>
Total Amortized	0.24	0.00	0.00	0.00	0.00
Fully Burdened Cost	23.11	0.24	0.41	0.29	12.28
Hard Tooling	11,728.76	0.00	0.00	0.00	0.00
Fixture Cost	0.00	0.00	0.00	0.00	0.00
Programming Cost	<u>126.02</u>	<u>0.00</u>	<u>0.00</u>	<u>0.00</u>	<u>126.02</u>
Total Capital Investments	11,854.78	0.00	0.00	0.00	126.02