

American Manufacturing & Technologies, Inc - - Shrink Oven Analysis

Number of Connections to Shrink per cable	Time (Sec) for each Shrink	Labor cost at \$15.00/hr	Oven Production Rate for a single 12" cable length when run side by side @ 100"/min (1.67"/sec) six cables across One piece on and off every 1.67 Secs	Time allotted to place a cable on the oven belt Seconds	Oven cost** at \$7.00/hr loading labor at \$15.00/hr per piece	Savings/1k cables	Time to run 1000 cables * Minutes
1	7	\$ 0.03	1.67	1.67	\$ 0.0104	\$ 18.81	28
2	7	\$ 0.06	1.67	1.67	\$ 0.0104	\$ 47.98	28
3	7	\$ 0.09	1.67	1.67	\$ 0.0104	\$ 77.15	28
1	8	\$ 0.03	1.67	1.67	\$ 0.0104	\$ 22.98	28
2	8	\$ 0.07	1.67	1.67	\$ 0.0104	\$ 56.31	28
3	8	\$ 0.10	1.67	1.67	\$ 0.0104	\$ 89.65	28
1	9	\$ 0.04	1.67	1.67	\$ 0.0104	\$ 27.15	28
2	9	\$ 0.08	1.67	1.67	\$ 0.0104	\$ 64.65	28
3	9	\$ 0.11	1.67	1.67	\$ 0.0104	\$ 102.15	28

** Oven cost is based on 20 hours use per week and 3 year depreciation times 2 to cover power and overhead 12/1/2004

* Handling of materials may add to this time.

American Manufacturing & Technologies, Inc.
7540 Caldwell Ave, Niles, IL 60714
847-588-2280 fax 847-588-1920

www.amti-products.com