

clamping force	100	US ton	200,000	lbf
intensification pressure	10,000	psi		
maximum projected area	20.000	in^2		
part projected area	5.50000	in^2		
runner, venting & o-f projected areas multiplier	1.5			
approx. runner, venting & o-f projected areas	8.25000	in^2		
max. cavity #	2	cavity		

approx. production rate	4.5	cycles/min
	8	h/shift
	3	shift/day
	365	days/year
OEE	70	%
	3.2	set/min
	189	set/hour
	4,536	set/day
	31,752	set/week
	11,589,480	set/year

material	ASTM B85 A380.0, A360.0, A413
material price	\$ 0.7000 \$US/lb A380.1
part1 weight	0.110 lb
part2 weight	0.154 lb

die cast production	\$ 250.00 \$US/hr
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approximate die cost	\$ 50,000.00 \$US
approximate die life	500,000 cycles/die

secondary operations	30	s/set
secondary operations rate	\$ 30.00	\$US/hr

Unit price

secondary operations price	\$ 0.2500 \$/set
die price	\$ 0.1000 \$/set
material price	\$ 0.2772 \$/set
die cast production price	\$ 1.3228 \$/set

subtotal	\$ 1.9500 \$/set
profit margin	45 %

HPDC cost/sale price \$ 2.8274 \$/set (ready to tap)

clamping force	600	US ton	1,200,000	lbf
intensification pressure	10,000	psi		
maximum projected area	120.000	in^2		
part projected area	5.50000	in^2		
runner, venting & o-f projected areas multiplier	3.0			
approx. runner, venting & o-f projected areas	16.50000	in^2		
max. cavity #	18	cavity		

approx. production rate	1.5	cycles/min
	8	h/shift
	3	shift/day
	365	days/year
OEE	70	%
	9.5	set/min
	567	set/hour
	13,608	set/day
	95,256	set/week
	34,768,440	set/year

material	ASTM B85 A380.0, A360.0, A413
material price	\$ 0.7000 \$US/lb A380.1
part1 weight	0.110 lb
part2 weight	0.154 lb

die cast production	\$ 250.00 \$US/hr
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approximate die cost	\$ 250,000.00 \$US
approximate die life	500,000 cycles/die

secondary operations	30	s/set
secondary operations rate	\$ 30.00	\$US/hr

Unit price

secondary operations price	\$ 0.2500 \$/set
die price	\$ 0.5000 \$/set
material price	\$ 0.5544 \$/set
die cast production price	\$ 0.4409 \$/set

subtotal	\$ 1.7453 \$/set
profit margin	45 %

HPDC cost/sale price \$ 2.5307 \$/set (ready to tap)