

# BAILEIGH INDUSTRIAL WATER JET OPERATION COSTS

## Price Breakdown Per Hour

Orifices	\$14-25	Lasts 40 hrs	\$0.50/hr
Nozzles	\$85-150	Lasts 80 hrs	\$1.00/hr
Wet End Wear Parts		Lasts ~5000hrs	\$1.90/hr
Intermittent Seals		Lasts ~2000hrs	Included
Power	48 HP pump	\$0.10/kw hour	\$3.60/hr
Water	48 HP pump	Estimate based on avg.	\$0.27/hr
Abrasive	\$0.35 to \$0.18 per lb.		\$4.75 to \$9.25/hr
General Re- pairs	Grate Replacement, Dropped Nozzles (General Real World Issues)		\$4/hr
Total:	Parts, Consumables, Energy (not included in this sheet: cost of machine and employee oper- ator costs)		<b>\$17/hr</b>

## WATER JET FAST FACTS

Abrasive is *not* supplied by the waterjet company and is the largest consumable cost.

- You should plan on your ruby orifice lasting approx 40 hrs
- You should plan on a diamond orifice lasting approx 500 hrs

