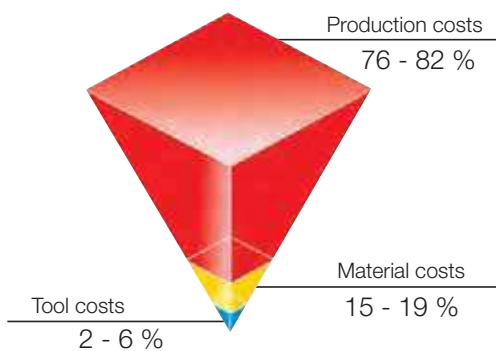
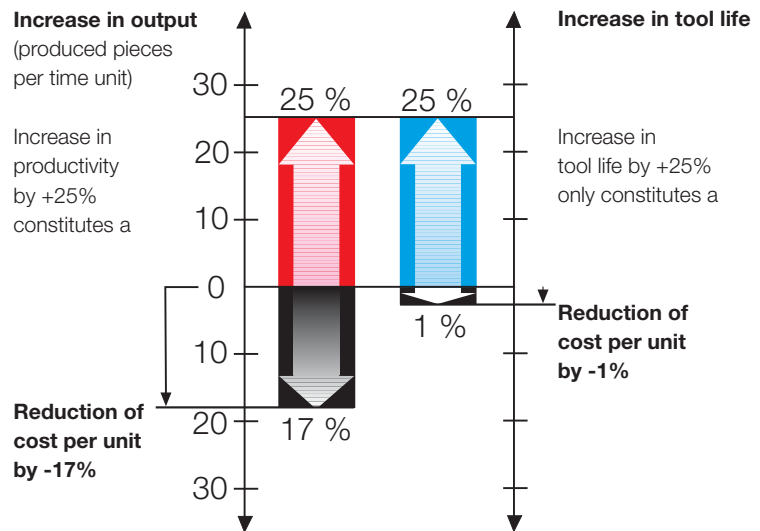


# H Profitability calculation

## Composition of cost per part



## Comparison



## Example: Milling of cylinder head faces with PCD

### Conventional face milling cutter

Tool = Ø 100mm  
**z = 6**  
 $v_c = 2.400 \text{ m/min}$   
 $f_z = 0.14 \text{ mm}$   
 **$v_f = 6.418 \text{ mm/min}$**   
 Cutting length = 700 mm  
**t = 0.109 min/unit**

### Hollfelder-Gühring face milling cutter

Tool = Ø 100mm  
**z = 13**  
 $v_c = 2.400 \text{ m/min}$   
 $f_z = 0.14 \text{ mm}$   
 **$v_f = 13.905 \text{ mm/min}$**   
 Cutting length = 700 mm  
**t = 0.05 min/unit**

Increase in productivity from to

Machine costs	0.8 € / min
Costs per unit	0.087 €
Units per day	2.000
<b>Costs per day</b>	<b>174.- €</b>

### Reduction of costs per unit

Machine costs	0.8 € / min
<b>Costs per unit</b>	<b>0.040 €</b>
Units per day	2.000
<b>Costs per day</b>	<b>80.- €</b>
<b>Saving per day</b>	<b>94.- €</b>