



Cycletime Tips - Automotive

Volume 7: What's A Second Worth?

As a custom molder, you sell machine time to your satisfied customers. Unless those customers have an ownership stake in your company, they probably don't care if you are profitable. The boss has continued to impress upon the associates the importance of producing quality parts as quickly as possible in order to maximize profits. When we consider the capability of assuring profitability at the production floor we often look at yield efficiency. This should be a factor involving scrap percentage and cycle time vs. plan on any given job. Any percent value below the efficiencies quoted would indicate that we aren't making the estimated profit margin for that particular job.

With careful process management coupled with material and tool handling, the subsequent profits can be used to reinvest in the company. Provided your floor associates are aware of what cycle times are expected we thought that a chart showing output would be of use for you in your daily success. This can also be used as an aid in helping everyone envision the additional machine capacity from a planned increase in output.

Seconds Per Cycle	Shots Per Hour	Seconds Per Cycle	Shots Per Hour
10	360	41	87.80
11	327.27	42	85.71
12	300	43	83.72
13	276.92	44	81.81
14	257.14	45	80
15	240	46	78.25
16	225	47	76.59
17	211.76	48	75
18	200	49	73.46
19	189.47	50	72
20	180	51	70.58
21	171.42	52	69.23
22	163.63	53	67.92
23	156.52	54	66.66
24	150	55	65.45
25	144	56	64.28

26	138.46	57	63.15
27	133.33	58	62.06
28	128.57	59	61.01
29	124.13	60	60
30	120	65	55.38
31	116.12	70	51.42
32	112.50	75	48
33	109.09	80	45
34	105.88	85	42.35
35	102.85	90	40
36	100	95	37.89
37	97.29	100	36
38	94.73	105	34.28
39	92.30	110	32.72
40	90	120	30

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