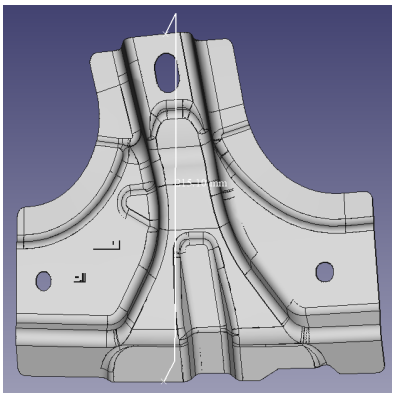
Estimate Name	**T Pillar Progressive Die Example**
Customer	OEM Corp
Estimate Date	01/31/2020 04:53 AM
Completed Date	
Estimated By	jeffb@toolplanners.com
Estimate Status	In-Progress
Die Spec	Auto Stamper Inc.
Labor Rate	Demo Company
Confirmed Price (USD)	
Confirmed Delivery (wks)	
Notes	



Cost Breakdown

Material, Labor, and Profit

Production Part

Part Name	Pillar B
Part Number	t-gussett model_01.igs
Rev/EC	A
Material Type	Steel - UHSS Ultra High Strength 140ksi (1000 Mpa)
Material Thickness	0.08 in

Operation

Part Annual Usage	200000
Die Type	Progressive Die
Parts Per Stroke	1

Die Stations

Cutting Stations	5
Draw/Crush/Stretch Stations	1
Idle Stations	2
Total Number of Stations	8

Die Size

Die Size L-R	79 in
Die Size F-B	28 in
Die Shut Height	9.4 in
Buildup Height	11 in
Shut Height	20 in
Step	in
Blank Size F-B	9.606 in
Blank Size L-R	9.134 in
Die Weight	6924 lb

Die Force

Cutting	
Bending	
Drawing	
Stripping	
Bending Pad	
Draw Pad	
Total Force	

Cost Estimate

Description	Material Cost	Labor Hours	Labor Cost	Total Cost	Percentage
Die Set (Shoe)	$ 6752	17	$ 1275	$ 8027	9 %
Build Up	$ 4046	20	$ 1500	$ 5546	6 %
Punch and Die	$ 630	211	$ 15825	$ 16455	18 %
Punch and Die Options	$ 660	59	$ 4403	$ 5063	5 %
Spring Pads	$ 4925	138	$ 10335	$ 15260	16 %
Stock Control	$ 780	89	$ 6675	$ 7455	8 %
Cams	$ -	-	$ -	$ -	-
Sensors	$ 300	8	$ 600	$ 900	1 %
Tool Steels	$ 7420	-	$ -	$ 7420	8 %
Wire EDM	$ -	75	$ 3975	$ 3975	4 %
Die Surface Machining	$ -	20	$ 1700	$ 1700	2 %
Custom Items	$ 130	12	$ 900	$ 1030	1 %
Design	$ -	94	$ 7520	$ 7520	8 %
Tryout	$ -	135	$ 10800	$ 10800	12 %
Part Approval	$ -	17	$ 1173	$ 1173	1 %
Die Approval	$ -	8	$ 600	$ 600	1 %
Total	**$ 25642**	**902**	**$ 67280**	**$ 92922**	

Material Profit	$ 2849
Labor Profit	$ 0
Subtotal	$ 95771
Adjustment	$ 1915
Total Cost Estimate	$ 97686
Labor Hours	902 hrs
Delivery	13 wks

Hours By Cost Center

Labor Rate	Hours
Design	94
Machine/Assembly	562
Die Surface Machining	20
Wire EDM	75
Tryout	135
Inspection	17

Die Spec

3d Design Required	Yes
Fully Detailed Design	Yes
Replaceable Details	Yes
Documentation Required	Yes
Document "As Built"	Yes

Heavy Duty Catalog Retainers	Yes
Hardened Backing Plates	Yes
Ball Lock Catalog Punches	No
Scrap Ejector Pins	Yes
Cutting Inserts	Yes
Die Buttons	Yes
Forming Inserts	Yes
Adjustable Forms	No
Punch Guiding	No
ID Die Details	Yes

Stripper & Pad Spring Type	Nitrogen Drop in Springs
Stripper & Pad Spring Retention	Spring Pockets
Stripper Retention	Spools
Stripper Guiding	No Stripper Guiding Required
Stripper Windows	No
Draw Pressure Type	Tankers Manifold

Die Set Type	Plate
Die Set Guide Type	Precision Ball
Die Set Bosses	No
Die Set Thrust Blocks	No
Setup Blocks	Yes
Build Up Type	Parallel Build Up
Change / Master Plate	No Quick Change
Die Handling	Tapped Holes Set of Four
Data Label	Yes

Die Set Steel	ANSI - A36
Cutting Steel	ANSI - D2
Forming Steel	ANSI - D2
Draw Die Steel	ANSI - D2
Draw Punch Steel	ANSI - D2
Stripper Steel	ANSI - 4140 HT
Form Pad Steel	ANSI - 4140 HT
Draw Binder Steel	ANSI - D2
Punch Plate Steel	ANSI - 4140 HT
Die Plate Steel	ANSI - 4140 HT
Backing Plate Steel	ANSI - A2
Riser Plate Steel	HRS
Pilot Punch Steel	ANSI - M4

Parts To Inspect 100%	6
Parts To Inspect Criticals Only	30
Number of Inspections	1
Process Capability Studies	Yes
Run Off Location	Run Off At Seller
Run Off Quantity	300
Run Off Time	8 hours