PRECISION
metal works

The Fusion of Quality and Innovation

ISO 9001:2000

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TO: HARRY COMPANY: RO Wheeler

FROM: Dave. FAX: 503-296-2074

RE: Breakdown. DATE: APRIL 2/04

TOTAL NUMBER OF PAGES 3 (Including this page)

Message

are attached

2/7/04

03-8083 Costing Breakdown: (as of March [illegible])

Deliverable		Material	Operation	Resource	Hours	Rate	Cost
Procedures	1		1	Tom Gilmore	230	$42.00	$9,660.00
	1		1	Gary Armstong	100	$42.00	$4,200.00
	1		1	Dave Rioux	25	$42.00	$1,050.00
Sub Total:							**$14,910.00**
Die A Manufacture	1		Project Management	Dave Rioux	80	$42.00	$3,360.00
	1		Engineering	Tom Gilmore	180	$42.00	$7,560.00
	3		QA	Gary Armstong	225	$42.00	$9,450.00
	4	Mild Steel Enclosure					$3,012.00
	4	Mild Steel Ribs					$14,000.00
	4	Inconel Scab Plate					$3,260.00
	2	Enclosure	Machining		105	$42.00	$4,410.00
	2	Rib	Machining		175	$42.00	$7,350.00
	2		Fabrication		110	$42.00	$4,620.00
	5	Consumables					$1,200.00
	5	Tooling					$200.00
Sub Total:							**$58,422.00**
Die A Forming	4	3/8" Inconel					$3,300.00
	1		Project Management	Dave Rioux	16	$42.00	$672.00
	1		Engineering	Tom Gilmore	20	$42.00	$840.00
	3		QA	Gary Armstong	40	$42.00	$1,680.00
	6		Pressing				$3,000.00
	6		Stress Reliving				$1,500.00
	7		Transportation				$700.00
Sub Total:							**$11,692.00**
Die B Manufacture	1		Project Management	Dave Rioux	50	$42.00	$2,100.00
	1		Engineering	Tom Gilmore	180	$42.00	$7,560.00
	3		QA	Gary Armstong	125	$42.00	$5,250.00
	4	Mild Steel Enclosure					$2,025.00
	4	Mild Steel Ribs					$15,400.00
	4	Inconel Scab Plate					$3,260.00
	2	Enclosure	Machining				$2,500.00
	2	Rib	Machining		175	$42.00	$7,350.00
	2		Fabrication		110	$42.00	$4,620.00
	5	Consumables					$1,200.00
	5	Tooling					$200.00
Sub Total:							**$51,465.00**
Die B Forming	4	3/8" Inconel					$3,600.00
	1		Project Management	Dave Rioux	20	$42.00	$840.00
	1		Engineering	Tom Gilmore	20	$42.00	$840.00
	6		Pressing				$3,000.00
	6		Stress Reliving				$750.00
	7		Transportation				$200.00
Sub Total:							**$9,230.00**
Die C Manufacture	1		Project Management	Dave Rioux	50	$42.00	$2,100.00
	1		Engineering	Tom Gilmore	120	$42.00	$5,040.00
	3		QA	Gary Armstong	100	$42.00	$4,200.00
	4	Mild Steel Enclosure					$2,025.00

	4	Mild Steel Ribs					$15,428.00
	4	Inconel Scab Plate					$3,260.00
	2	Enclosure	Machining				$2,300.00
	2	Flo	Machining		100	$42.00	$4,200.00
	2		Fabrication		45	$42.00	$1,890.00
	5	Consumables					$1,200.00
	5	Tooling					$200.00
ib Total:							$42,043.00
e C Forming	4	3/8" Inconel					$3,300.00
			Project Management	Dave Rioux	0	$42.00	$0.00
			Engineering	Tom Gilmore	0	$42.00	$0.00
			Pressing				$0.00
			Stress Reliving				$0.00
			Transportation				$0.00
ib Total:							$3,300.00
be	4	Material					$2,715.00
	4	Rolling					$135.00
ib Total:							$2,850.00
elding Qualification		Material					
	6	WPS/PQR		Weld Engineer			$1,200.00
	1		Project Management	Tom Gilmore	25	$42.00	$1,050.00
	2		Machining		30	$42.00	$1,260.00
	6		Welding				$2,900.00
	6		Testing				$700.00
ib Total:							$7,110.00

otal: **$201,022.00**

apital Costs	4	Pro E Software	11809
		Faro Arm	58200
		Welding Machine	5800
tal:			**$75,809.00**