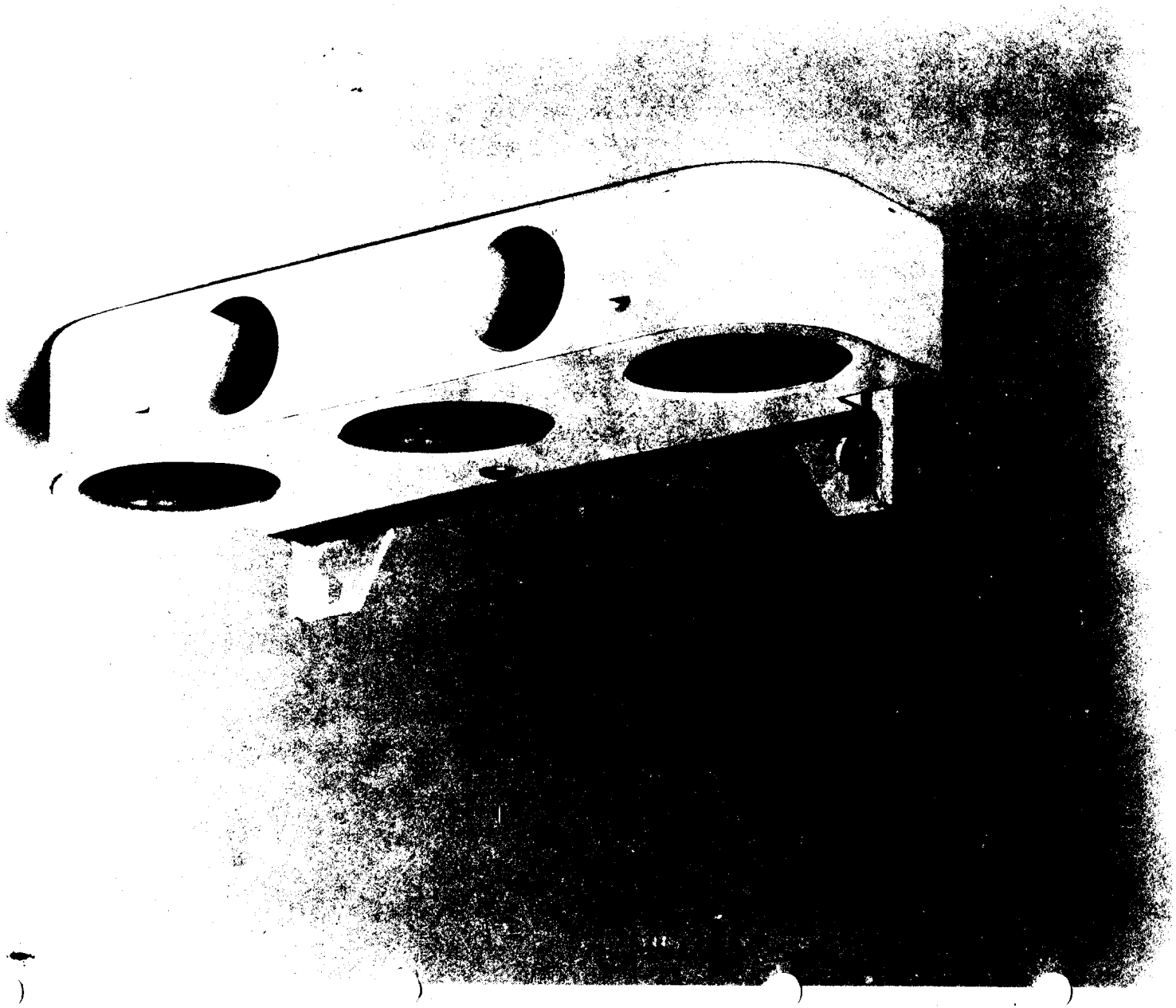
VALUE ANALYSIS

Turret Type Fluorescent Lamp Holders

Compiled by:
J. H. Lowndes



April 18, 1949

TURRET TYPE FLUORESCENT LAMP HOLDER VALUE ANALYSIS

Case and other parts
M-5417278, etc.
832,000 used per year

Present Cost: $378.96/M
Potential Cost: 337.50/M (see comments)

COMMENTS:

The Meriden Plastics Divisions have proposed a design for a molded case which will eliminate the need of some insulation and will combine parts, thus reducing the number of punch press and resistance welding operations.

The following summary shows the operations eliminated and the net saving possible through the use of the molded case:

Operations Eliminated By Molded Case and Cover

Blank and Deep Draw	$3.90/M
Pinch trim	.71
Pierce	.94
Pierce and Cut	.59
Pierce holes	1.31
Form Guide Brackets	.44
Wash Guide Brackets	.06
Wash case	.94
Weld	1.83
Weld	2.88
Weld	3.88
Rack Case	.94
Bonderize Case	1.25
Rack Case	2.54
Spray Case	3.37
Unrack	2.54
Unrack and Inspect, etc.	2.54
Blank Front	.56
Form, etc.	1.13
Rack	.94
Bond	1.25
Rack	1.34
Spray	1.78

Unrack	1.34
Unrack and Inspect	1.34
Wash Cont. Assembly	.12
Buff Case	2.12
Assembly Insulator to Starter Guides, etc.	5.57
	$45.15
Molded Base	$189.60
Molded Cover	117.90
	$307.50
10% Spoilage	30.00
	$337.50
Material	$208.92
Assem. Labor	170.04
Total operations eliminated	$378.96
New molded case	337.50
Save	$ 41.46/M

Assembly and "Machine" Labor Saved

$45.15
5.57 ∕ 11.8% & 8.5% increases = $ 6.74 assem.
$39.58 ∕ 11.8% & 8.5% increases = 47.80 "mach."

Assem. = $ 6.74 ∕ 10% unapplied = $ 7.41
"Mach." = $47.80 ∕ 35% unapplied = 64.70

∕ 100% overhead = $ 14.82 Assembly Shop Cost
∕ 200% overhead = 194.10 Machine Shop Cost

$208.92 Total Shop Cost Saved (Labor)

Material Saved

K-5440024	$ 2.84/M
K-5440025	1.70
K-5440027	2.84
K-5440034	15.09
K-5417278	55.30
K-5417279	25.82
K-5417282	5.07
K-5414952	45.92
	$154.58
10% Spoilage	15.46
	$170.04/M

Eliminate this:

Material	$208.92
Assembly Labor	170.04
Shop Cost	$378.96/M

By Making This:

Molded Base	$189.60
Molded Cover	117.90
	$307.50
+ 10% Spoilage	=$337.50/M

And Save This:

	$378.96
	337.50
	$ 41.46/M

EXPECTED EFFECTIVE DATE:

RECORD OF ACTUAL COST DECREASES:

Date	New Shop Cost	Reduction

IF NOT ADOPTED - why and by whom found unsuitable.

PURCHASING DEPARTMENT
Value Analysis Division

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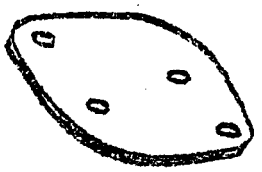
April 18, 1949

TURRET TYPE FLUORESCENT LAMP HOLDER VALUE ANALYSIS

Diso
V-5419612
1,976,000 used per year



Present Cost: $9.86/M
Potential Cost: 9.40/M

COMMENTS:

An insulation fabricator quotes $9.40/M with no mention of a tool charge.

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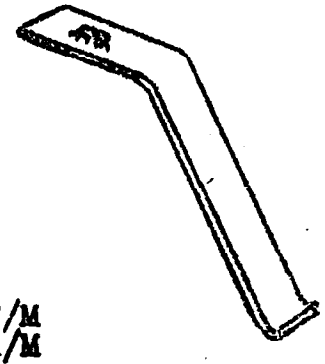
April 18, 1949

TURRET TYPE FLUORESCENT LAMP HOLDER VALUE ANALYSIS

Spring Contact
K-5440026
3,952,000 used per year



Present Cost: $4.17/M
Potential Cost: 2.71/M

COMMENTS:

A spring vendor quotes as follows:

1,000,000 pins	$2.71/M
2,000,000 pins	2.70/M

Tool Charge -- $200.00

EXPECTED EFFECTIVE DATE:

RECORD OF ACTUAL COST DECREASES:

Date	New Shop Cost	Reduction

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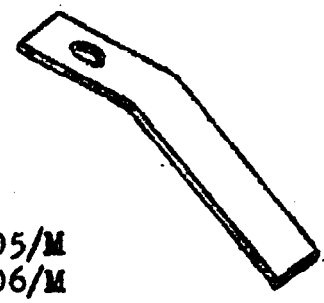
April 18, 1949

TURRET TYPE FLUORESCENT LAMP HOLDER VALUE ANALYSIS

Spring Blade
K-5440043
3,952,000 used per year



Present Cost: $3.05/M
Potential Cost 2.06/M

COMMENTS:

1. A spring vendor quotes as follows:

   1,000,000 pieces $2.06/M
   2,000,000 pieces 2.05/M

   Tool Charge -- $150.00

2. This part can be eliminated by using beryllium copper in K-5440080 as described on the next sheet.

EXPECTED EFFECTIVE DATE:

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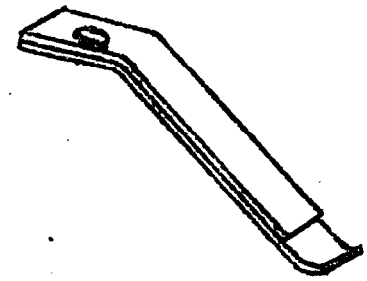
April 18, 1949

TURRET TYPE FLUORESCENT LAMP HOLDER VALUE ANALYSIS

Contact Assembly
K-5440080
3,952,000 used per year



Present Cost: $11.45/M
Potential Cost: 8.20/M

COMMENTS:

A beryllium copper specialist proposes a beryllium copper contact spring which will do what is required of the present bronze and spring steel assembly. He quotes as follows:

15,000 to 99,000 pcs. $8.90/M, plus $30 set-up
100,000 or more pieces $8.20/M, no set-up charge

Tool Cost--$1005

EXPECTED EFFECTIVE DATE:

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Date	New Shop Cost	Reduction

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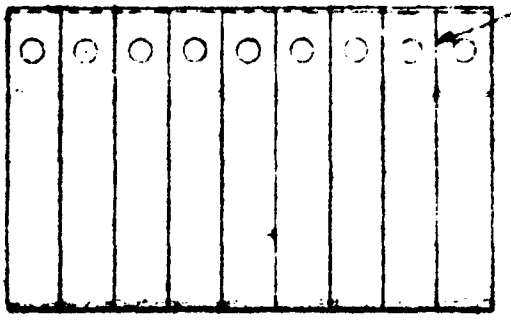
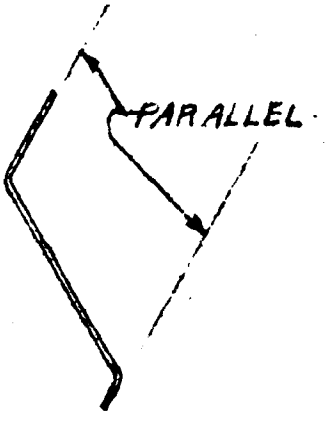
SK 1-3-49

PIECES MADE IN CONTINUOUS STRIP AND BREAK APART WITH FINGERS AT THIS POINT WITHOUT DISTORTION





HEAT TREAT IN FIXTURE

LIGHT SOCKET SPRING

K-5440080

MATERIAL: .0142 ±.001 X 1/8 ±.005 BERYLLIUM COPPER STRIP 4 NO HARD

INSTRUMENT SPECIALTIES COMPANY, Inc. LITTLE FALLS, NEW JERSEY					GENERAL ELECTRIC Ref. Dwg. ING. 11-16-48 First Order
DRAWN BY / DATE	APPROVED / DATE	SCALE	SUB	DWG. NO.	SK 1-3-49
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April 19, 1949

TURRET TYPE FLUORESCENT LAMP HOLDER VALUE ANALYSIS

Rivet
V-5419021
5,928,000 used per year

Present Cost: $1.52/M
Potential Cost: 1.26/M

COMMENTS:

A tubular rivet company quotes $1.26/M, cadmium plated, in lots of 500,000 or more, with full freight allowed on 100M or more rivets shipped.

EXPECTED EFFECTIVE DATE:

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Date	New Shop Cost	Reduction

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PURCHASING DEPARTMENT
Value Analysis Division

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