

Bridgeport
February, 1949

Mr. E. G. Hopkins
Wiring Device Division

Transmitted herewith is the Value Analysis
Report of the Triple Pole Receptacle (GE-3000).

The proposals contained in this report are
of the type that can be effected easily and without
delay. There is no tooling charges involved, and
the proposals can become effective as soon as
present inventories are used.

Only matters that fell into the above
described category were investigated, since a
redesign of this product is being contemplated.

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Value Analysis
Wiring Device Division

JRS:kvb

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49-18

VALUE ANALYSIS
of
TRIPLE POLE RECEPTACLE
GE-3000

Compiled by: C. R. Stahl

Date: February 2, 1949

SUMMARY

Present Shop Costs

Parts Cost	-	\$762.57/M
Assembly Costs	-	<u>\$133.17/M</u>
Total Shop Cost		\$895.74/M

Proposed Shop Costs

Parts Costs	-	\$629.62/M
Assembly Costs	-	<u>\$111.29/M</u>
		\$740.91/M

REDUCTION PER UNIT - \$.155 each

SAVING (At 250,000/yr. production) - \$775/week

There is no tooling charge involved in these proposals.

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SUMMARY OF PARTS COSTS

<u>Drawing No.</u>	<u>Item</u>	<u>No. Reqd.</u>	<u>Present Shop Cost/M Devices</u>	<u>Proposed Shop Cost/M Devices</u>
4196061-MP	Base	1	131.50	131.50
4196062-MP	Cover	1	120.00	120.00
43004	Contact Clip	3	97.29	54.00
4191021	Terminal	3	91.44	
4191022	Cap	3	69.33	Replace With Straight Connector - 32.25
4192100	Washer	3	11.52	
4192101	Strap	2	14.82	and Right and Left Connector 86.61
4192102	Strap	1	6.07	
4192764	Plate	1	108.68	108.68
4194941	Plate	1	7.25	7.25
4194942	Plate	1	7.25	7.25
4191344	Sleeve Nut	1	16.44	1.10
-	Clamps	2		
-	Misc. Screws	12	80.98	80.98
-	Misc. & Spoil	-		
			<u>\$762.57/M</u>	<u>\$629.62</u>

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SUMMARY OF ASSEMBLY COSTS

<u>Operations</u>	<u>Shop Cost</u>	<u>Operations</u>	<u>Shop Cost</u>
Spin Sleeve Nut to base	- 6.91	-	
Assemble binding posts	- 18.28	-	
Let up binding posts & clips in base	- 15.42	Let up connectors & clips on base	15.42
Assemble binding posts & clip to base	- 15.98	Assemble connectors & clips to base	15.98
Assemble upper & lower clamp & plate to base	- 21.27	Assemble upper & lower clamp & plate to base	21.27
Assemble cover to base	- 8.94	Assemble cover to base	11.00
Pitch 3 holes	- 6.75	Pitch 4 holes	8.00
Pack 1/box incl. 2 plates & 5 screws in envelope	- 22.25	Pack 1/box incl. 2 plates & 5 screws in envelope	22.25
Pack in carton	- 17.37	Pack in carton	17.37
	\$133.17/M		\$111.29

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CONTACT CLIP (3 Req'd.)
432014



PRESENT COST

Material	-	\$16.92/M
Labor	-	3.61
I.H.E. (330%)	-	<u>11.90</u>
		\$32.43/M

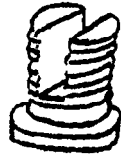
PROPOSED COST

Purchase Vendors Standard	-	\$18.00/M
(In 50,000 lots)		
No tooling cost		

COMMENT: A vendor's standard is practically identical to this piece. This reduction in cost is brought about by the vendors use of a less expensive, but suitable material. Phosphor Bronze is presently called for on the drawing. Tooling for high production also makes this reduction feasible.

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TERMINAL
4191021



PRESENT COST

Material	-	10.53/M
Labor	-	4.64
I.M.E. (330%)	-	<u>15.31</u>
		\$30.48/M

PROPOSED COST

Eliminate - Replace with Connector Assembly

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CAP (3 Req'd.)
4191022



PRESENT COST

Material	-	\$10.99/M
Labor	-	2.82
I.M.E. (330%)	-	<u>9.10</u>
		\$22.91/M

PROPOSED COST

Eliminate - Replace with connector assembly.

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WASHER
4192100



PRESENT COST

Material	-	\$3.45/M
Labor	-	.09
I.M.E. (330%)	-	<u>.30</u>
		\$3.84/M

PROPOSED COST

Eliminate - Replace with connector assembly.

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STRAP (2 Req'd.)
4192101



PRESENT COST

Material	-	\$7.02/M
Labor	-	.09
I.M.E. (330%)	-	<u>.30</u>
		\$7.41/M

PROPOSED COST

Eliminate - Replace with connector assembly.
#45026 - Left Connector and
#45027 - Right Connector

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STRAP (1 Req'd.)
4192102



PRESENT COSTS

Material	-	\$5.68/M
Labor	-	.09
I.M.E. (330%)	-	1.20
		\$6.07/M

PROPOSED COSTS

Eliminate - Replace with connector assembly.
#45025 Straight Connector

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SLEEVE NUT (1 Req'd.)
4191344



PRESENT COST

Material	-	\$2.43
Labor	-	3.25
I.M.E. (330%)	-	<u>10.76</u>
		\$16.44/M

PROPOSED COST

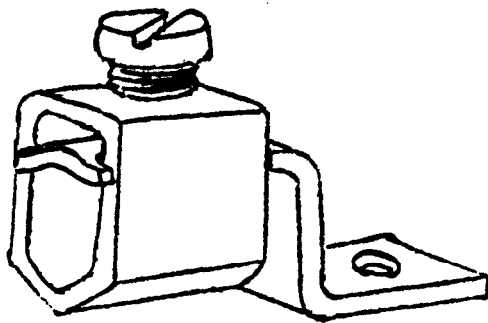
Eliminate
Use standard 6/32 square nut - \$1.10/M

COMMENT: This change brings about a necessity for a change in the length of the 6/32 x 1½" steel screw used to hold the cover in place. This screw should be 1/8" longer or 6/32 x 1-5/8".

In order to hold the square nut in place when the cover is removed, it is proposed that the nut be covered with pitch at the same time that three other holes are filled.

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STRAIGHT CONNECTOR (1 Req'd.)
(Vendors #45025)



Replaces center terminal, cap, washer, and strap.

COST

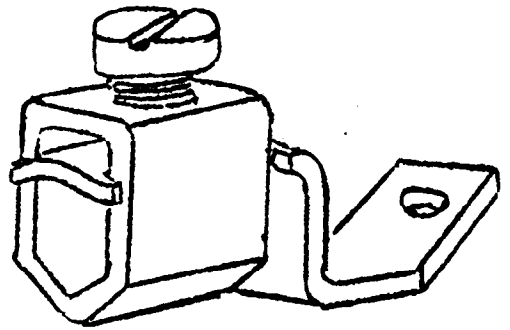
Purchase	--	\$32.35/M
(Lots of 10,000)		

COMMENT: This connector can be purchased with a tapped hole for \$4.71/M additional. It is proposed that a self-tapping screw be used.

A similar connector is made by General Electric (GE-3239). This connector is available for \$42.92/M.

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RIGHT CONNECTOR
(Vendor #45027)



Replaces right terminal, cap, washer, & strap.

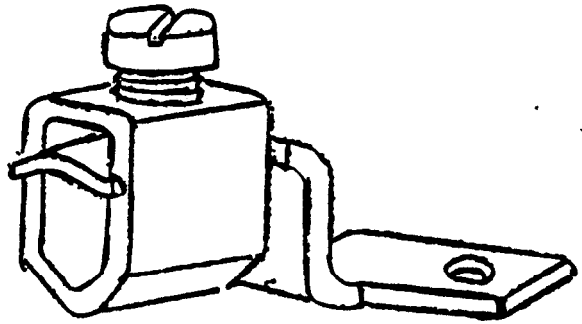
COST

Purchase in lots of 10,000 - \$43.08/M

COMMENT: This connector can be purchased with a tapped hole for \$4.71/M additional. It is proposed to use a self-tapping screw.

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LEFT CONNECTOR
(Vendor #A5026)



Replaces left terminal, cap, washer, and strap.

COST

Purchased in lot of 10,000 - \$43.08/M

COMMENT: This connector can be purchased with a tapped hole for \$4.71/M additional. It is proposed to use a self-tapping screw.

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