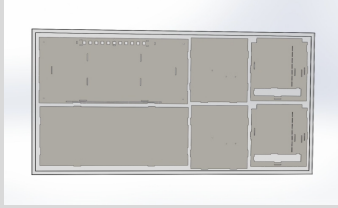
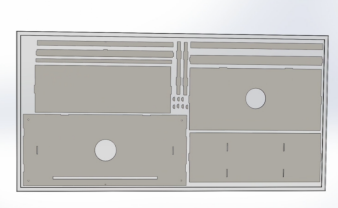
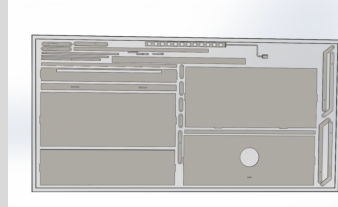

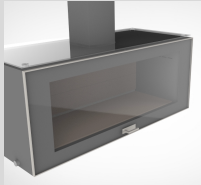


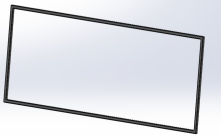
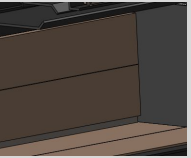
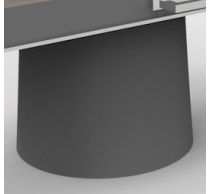


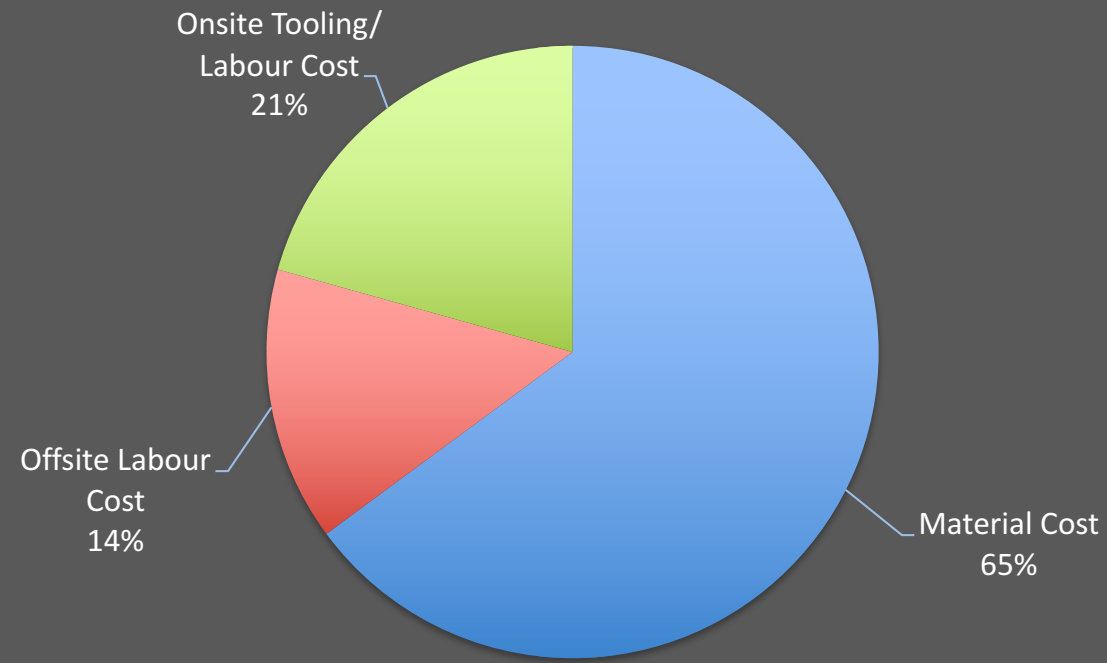
Item Description	Parts Per Unit	Image	Material/ Supplied Part Name	Material Cost	Offsite Processes	Time (Hours)	Process Cost	Onsite Tooling/ Labour	Time (Hours)	Tooling Cost	Total Tooling	Total Part Cost
Sheet 1	6		6mm Steel Sheet 2400 x 1200	\$ 160.00	Waterjet Cutter	0.25	\$ 15.00	Robotic Welding	0.2	\$ 12.00	\$ 45.00	\$ 220.00
								Manual Welding	0.2	\$ 12.00		
								Grinding	0.15	\$ 9.00		
								Assembly	0.1	\$ 6.00		
								Jig Set Up	0.1	\$ 6.00		
Sheet 2	20		6mm Steel Sheet 2400 x 1200	\$ 160.00	Waterjet Cutter	0.40	\$ 24.00	Robotic Welding	0.3	\$ 18.00	\$ 60.00	\$ 256.00
								Bending	0.20	\$ 12.00		
								Manual Welding	0.3	\$ 18.00		
								Grinding	0.2	\$ 12.00		
								Assembly	0.1	\$ 6.00		
Jig Set Up	0.1	\$ 6.00										
Sheet 3	30		6mm Steel Sheet 2400 x 1200	\$ 160.00	Waterjet Cutter	0.50	\$ 30.00	Robotic Welding	0.3	\$ 18.00	\$ 60.00	\$ 256.00
								Bending	0.10	\$ 6.00		
								Manual Welding	0.3	\$ 18.00		
								Grinding	0.2	\$ 12.00		
								Assembly	0.1	\$ 6.00		
Jig Set Up	0.1	\$ 6.00										
Handle	2		10mm Stainless Steel Billet (w x h)	\$ 2.50	Bandsaw	0.25	\$ 15.00	Sanding/ Polishing	0.25	\$ 15.00	\$ 30.00	\$ 34.00
			2mm Stanless Steel Sheet (w x h)	\$ 1.50	Mill	0.15	\$ 9.00	Manual Welding	0.25	\$ 15.00		

Glass	2		5mm Toughened Glass (1250 x 550)	\$ 422.65	Waterjet Cutter	0.45	\$ 27.00	Gluing	0.25	\$ 15.00	\$ 15.00	\$ 464.65
Top Plugs	4		4 x 30mm Steel Rod (1.2m)	\$ 9.85	Lathe	0.30	\$ 18.00	Sanding/ Polishing	0.33	\$ 19.80	\$ 19.80	\$ 47.65
Flue	1		Steel	\$ 14.95	Made to order	0.00	\$ -	Robotic Welding	0.18	\$ 10.80	\$ 10.80	\$ 25.75
Fibreglass Rope	1		8mm Fibreglass Rope (3000mm)	\$ 0.80	n/a	0.00	\$ -	Gluing	0.05	\$ 3.00	\$ 3.00	\$ 3.80
Firebricks	24		24 x Firebricks (230 x 78 x 23)	\$ 8.90	n/a	0.00	\$ -	n/a	0	\$ -	\$ -	\$ 8.90
Base	6		1 x Concrete (30 kgs)	\$ 12.38	Mixing	0.22	\$ 13.20	Moulds	0.2	\$ 12.00	\$ 21.00	\$ 46.58
			5 x 8mm Steel Support Rod	\$ 1.12	Bansaw	0.05	\$ 3.00	Polishing	0.15	\$ 9.00		

Vent Controller	2		25mm Stainless Steel Rod (Length)	\$ 11.80	Lathe	0.11	\$ 6.60	Sanding/ Polishing	0.1	\$ 6.00	\$ 12.00	\$ 30.40
			10mm Stainless Steel Tube	\$ 3.20	Bending	0.10	\$ 6.00	Jig Set Up	0.1	\$ 6.00		
Top Grille	1		2mm Sheet Steel	\$ 1.20	Waterjet	0.20	\$ 12.00	Manual Welding	0.1	\$ 6.00	\$ 6.00	\$ 19.20
Door Trimmings	2		Steel U-Extrusion (3m)	\$ 0.50	Bansaw	0.10	\$ 6.00	Sanding/ Polishing	0.2	\$ 12.00	\$ 12.00	\$ 18.50
Door Backing	1		2mm Stainless Steel Sheet (1250 x 550)	\$ 1.35	Waterjet Cutter	0.17	\$ 10.20	Assembly	0.1	\$ 6.00	\$ 6.00	\$ 17.55
Counterweight	1		Steel Billet (300 x 250 x 30)	\$ 8.94	Bansaw	0.05	\$ 3.00	Assembly	0.1	\$ 6.00	\$ 6.00	\$ 17.94
Locking Anchors	2		4mm Steel Tube	\$ 0.20	Bansaw	0.05	\$ 3.00	Robotic Welding	0.1	\$ 6.00	\$ 6.00	\$ 9.20

Totals	105 parts		Material Cost	\$ 981.84	Offside Labour Cost	\$ 219.00	Onsite Tooling/ Labour	5.21 hours	\$ 312.60	\$ 1,476.12
---------------	------------------	--	----------------------	------------------	----------------------------	------------------	-------------------------------	-------------------	------------------	--------------------

Cost per unit break-down



Overall Assembly Component Costing

