

<b>Label</b>	DeLorean	<b>Auto ID</b>	19950-2
<b>Part No.</b>	DMC	<b>Manual ID</b>	
<b>Drawing No.</b>		<b>Version No.</b>	2
<b>Drawing Rev. Idx</b>		<b>Owner</b>	arslan@facton.com
<b>Drawing Date</b>		<b>Version Created by</b>	arslan@facton.com
<b>Currency</b>	CNY	<b>Version Created at</b>	30.05.2018 14:01:44
<b>Active Exchange Rates</b>	Global	<b>Version Modified by</b>	arslan@facton.com
		<b>Version Modified at</b>	30.05.2018 14:01:44
<b>Reference Date</b>	07.05.2018		



<b>Industrial Sector</b>	Manufacture of rubber and plastic products
<b>Production Location</b>	World » Europe » Germany

<b>Reference Company Revenue</b>	150m EUR
<b>Reference Company Material Share</b>	40 %
<b>Reference Company Degree of Automation</b>	Low

<b>SoP</b>	07.05.2018
<b>EoP</b>	
<b>Production Lifetime</b>	10.000 a

<b>Relevant Production Quantity Rate incl. Scrap</b>	5,000.000 pc/a
<b>Lifetime Production Quantity incl. Scrap</b>	50,000.000 pc
<b># Production Batches</b>	10.000 lot/a
<b>Batch Size</b>	500.000 pc/lot
<b>Number of Shifts</b>	2.000 shift/d
<b>Shift Capacity</b>	8.000 h/shift

<b>Conditions of Delivery</b>	EXW - EX Works -
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<b>Calculation Maturity Degree</b>	Initial Cost Indication
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<b>Measure Evaluation Scenario</b>	Without Measures
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<b>Calculation Status</b>	Release Requested
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<b>Comment</b>	
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<b>Material Overhead Rate</b>	5.710 %
<b>Manufacturing Overhead Rate</b>	30.000 %
<b>Administrative Overhead Rate</b>	6.500 %
<b>Sales Overhead Rate</b>	2.620 %
<b>Development Overhead Rate</b>	3.190 %
<b>Logistics Overhead Rate</b>	2.510 %
<b>Material Scrap Rate</b>	4.000 %
<b>Manufacturing Scrap Rate</b>	4.000 %

<b>Target Profit Rate on Prime Cost</b>	
<b>Target Profit Rate on Raw Material</b>	10.000 %
<b>Target Profit Rate on Purchased Material</b>	10.000 %
<b>Target Profit Rate on Manufacturing</b>	10.000 %

<b>Current Purchase Price</b>	
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<b>Target SP</b>	
<b>Imp. SP</b>	421.507 CNY/pc
<b>Target PrimeC</b>	
<b>PrimeC</b>	397.554 CNY/pc

<b>Imp. Profit</b>	23.953 CNY/pc
<b>Actual Profit</b>	



ProdC	G&A OHD	Sales OHD Cost	R&D OHD	Log. OHD	OHD Cost	SDSC	PrimeC	Imp. Profit	Imp. CSP	Imp. Intr. for Terms of Payment	Cash Discount	Imp. SP EXW	Transport Costs	Customs Duty	Imp. SP
351.987 CNY/pc	19.986 CNY/pc	8.056 CNY/pc	9.808 CNY/pc	7.718 CNY/pc	45.567 CNY/pc		397.554 CNY/pc	23.953 CNY/pc	421.507 CNY/pc			421.507 CNY/pc			421.507 CNY/pc

BOM Structure				Material Cost					Manufacturing Cost I					Manufacturing Cost II					
Auto ID	Label	Signature Name	Relevant Qty.	DMatC	Mat. OHD	Mat. Refund	Mat. ScrapC	MatC	MachC	LabC	MachC Setup	LabC Setup	Alloc. MaintC. Tools + Fixtures	ManC I	Man. OHD	Man. ScrapC	SD ManC	Alloc. Investment Cost Tools + Fixtures	Alloc. Imp. Interest Tools + Fixtures
19950-2	DeLorean	Should Cost Calculation		40.490 CNY/pc	2.312 CNY/pc		1.712 CNY/pc	44.514 CNY/pc	52.229 CNY/pc	123.923 CNY/pc	7.801 CNY/pc	15.088 CNY/pc		199.040 CNY/pc	61.826 CNY/pc	7.046 CNY/pc	8.846 CNY/pc	26.040 CNY/pc	4.674 CNY/pc
19851	Assembly and Cleaning	Grouping							4.388 CNY/pc	8.866 CNY/pc				13.254 CNY/pc	4.135 CNY/pc	0.530 CNY/pc			
19895	Assembly	Process	1.000 cycle/pc						4.388 CNY/cycle	8.866 CNY/cycle				13.254 CNY/pc	4.135 CNY/pc	0.530 CNY/pc			
20001	Worker, EG04	Worker	220.000 s/cycle							8.866 CNY/cycle									
19644	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Manufacturing Cell							4.388 CNY/cycle										
63	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Machine	11.000 min/cycle						1.463 CNY/cycle										
63	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Machine	11.000 min/cycle						1.463 CNY/cycle										
63	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Machine	11.000 min/cycle						1.463 CNY/cycle										
19963	Powertrain / Mr. Fusion	Assembly	1.000 pc/pc	0.176 CNY/pc	0.010 CNY/pc		0.007 CNY/pc	0.194 CNY/pc	1.258 CNY/pc	6.184 CNY/pc				7.441 CNY/pc	2.322 CNY/pc	0.298 CNY/pc		1.500 CNY/pc	0.269 CNY/pc
19975	Line Section Mr. Fusion	Part	1.000 pc/pc	0.030 CNY/pc	0.002 CNY/pc		0.001 CNY/pc	0.033 CNY/pc	0.261 CNY/pc	1.415 CNY/pc				1.676 CNY/pc	0.523 CNY/pc	0.067 CNY/pc		0.300 CNY/pc	0.054 CNY/pc
19898	Injection Molding	Process	0.500 cycle/pc	0.060 CNY/cycle	0.003 CNY/cycle		0.003 CNY/cycle	0.033 CNY/pc	0.140 CNY/cycle	0.815 CNY/cycle				0.478 CNY/pc	0.149 CNY/pc	0.019 CNY/pc		0.300 CNY/pc	0.054 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.674 min/cycle						0.140 CNY/cycle										
19836	Worker, EG04	Worker	40.464 s/cycle							0.815 CNY/cycle									
19649	Tool	Tool																0.600 CNY/cycle	0.108 CNY/cycle
687	ABS - Regrind	Material	0.011 kg/cycle	0.060 CNY/cycle	0.003 CNY/cycle		0.003 CNY/cycle	0.066 CNY/cycle											
19738	Painting	Process	1.000 cycle/pc						0.191 CNY/cycle	1.007 CNY/cycle				1.198 CNY/pc	0.374 CNY/pc	0.048 CNY/pc			
19648	Worker, EG04	Worker	25.000 s/cycle							1.007 CNY/cycle									
19964	Air brush and Painting workstation	Machine	0.417 min/cycle						0.191 CNY/cycle										
18140	Handpaint medium parts	Work Step	25.000 s/cycle																
19633	Control Unit	Part	1.000 pc/pc	0.012 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	0.014 CNY/pc	0.127 CNY/pc	0.687 CNY/pc				0.814 CNY/pc	0.254 CNY/pc	0.033 CNY/pc		0.200 CNY/pc	0.036 CNY/pc
19802	Injection Molding	Process	0.250 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.014 CNY/pc	0.140 CNY/cycle	0.815 CNY/cycle				0.239 CNY/pc	0.074 CNY/pc	0.010 CNY/pc		0.200 CNY/pc	0.036 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.674 min/cycle						0.140 CNY/cycle										
20017	Worker, EG04	Worker	40.464 s/cycle							0.815 CNY/cycle									
19970	Tool	Tool																0.800 CNY/cycle	0.144 CNY/cycle
687	ABS - Regrind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.054 CNY/cycle											
19892	Painting	Process	1.000 cycle/pc						0.092 CNY/cycle	0.484 CNY/cycle				0.575 CNY/pc	0.179 CNY/pc	0.023 CNY/pc			
20049	Worker, EG04	Worker	12.000 s/cycle							0.484 CNY/cycle									
20030	Air brush and Painting workstation	Machine	0.200 min/cycle						0.092 CNY/cycle										
18142	Airbrush small parts	Work Step	12.000 s/cycle																
19709	Tank Mr. Fusion	Part	1.000 pc/pc	0.019 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	0.021 CNY/pc	0.041 CNY/pc	0.238 CNY/pc				0.279 CNY/pc	0.087 CNY/pc	0.011 CNY/pc		0.300 CNY/pc	0.054 CNY/pc
19885	Injection Molding	Process	0.500 cycle/pc	0.038 CNY/cycle	0.002 CNY/cycle		0.002 CNY/cycle	0.021 CNY/pc	0.082 CNY/cycle	0.476 CNY/cycle				0.279 CNY/pc	0.087 CNY/pc	0.011 CNY/pc		0.300 CNY/pc	0.054 CNY/pc

ManC II	ProdC
307.473 CNY / pc	351.987 CNY / pc
17.919 CNY / pc	17.919 CNY / pc
17.919 CNY / pc	17.919 CNY / pc

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11.830 CNY / pc	12.024 CNY / pc
2.620 CNY / pc	2.653 CNY / pc
0.999 CNY / pc	1.033 CNY / pc

0.708 CNY / cycle	
	0.066 CNY / cycle
1.620 CNY / pc	1.620 CNY / pc

1.336 CNY / pc	1.350 CNY / pc
0.559 CNY / pc	0.572 CNY / pc

0.944 CNY / cycle	
	0.054 CNY / cycle
0.778 CNY / pc	0.778 CNY / pc

0.731 CNY / pc	0.752 CNY / pc
0.731 CNY / pc	0.752 CNY / pc

6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle							
20002	Worker, EG04	Worker	23.636 s/cycle					0.476 CNY/cycle							
20043	Tool	Tool												0.600 CNY/cycle	
687	ABS - Re grind	Material	0.007 kg/cycle	0.038 CNY/cycle	0.002 CNY/cycle		0.002 CNY/cycle	<b>0.042 CNY/cycle</b>							
19984	Exhaust System	Part	1.000 pc/pc	0.025 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	<b>0.027 CNY/pc</b>	0.261 CNY/pc	1.415 CNY/pc		<b>1.676 CNY/pc</b>	0.523 CNY/pc	0.067 CNY/pc	0.300 CNY/pc
20056	Injection Molding	Process	0.500 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.027 CNY/pc</b>	0.140 CNY/cycle	0.815 CNY/cycle		<b>0.478 CNY/pc</b>	0.149 CNY/pc	0.019 CNY/pc	0.300 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.674 min/cycle					0.140 CNY/cycle							
19911	Worker, EG04	Worker	40.464 s/cycle					0.815 CNY/cycle							
19928	Tool	Tool												0.600 CNY/cycle	
687	ABS - Re grind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.054 CNY/cycle</b>							
19635	Painting	Process	1.000 cycle/pc						0.191 CNY/cycle	1.007 CNY/cycle		<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19673	Worker, EG04	Worker	25.000 s/cycle							1.007 CNY/cycle					
19939	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle							
18140	Handpaint medium parts	Work Step	25.000 s/cycle												
19713	Mr. Fusion Power Unit	Part	1.000 pc/pc	0.077 CNY/pc	0.004 CNY/pc		0.003 CNY/pc	<b>0.085 CNY/pc</b>	0.343 CNY/pc	1.216 CNY/pc		<b>1.560 CNY/pc</b>	0.487 CNY/pc	0.062 CNY/pc	0.200 CNY/pc
19768	Injection Molding	Process	0.250 cycle/pc	0.310 CNY/cycle	0.018 CNY/cycle		0.013 CNY/cycle	<b>0.085 CNY/pc</b>	0.609 CNY/cycle	0.836 CNY/cycle		<b>0.361 CNY/pc</b>	0.113 CNY/pc	0.014 CNY/pc	0.200 CNY/pc
19619	Worker, EG04	Worker	41.464 s/cycle							0.836 CNY/cycle					
19679	Tool	Tool												0.800 CNY/cycle	
687	ABS - Re grind	Material	0.057 kg/cycle	0.310 CNY/cycle	0.018 CNY/cycle		0.013 CNY/cycle	<b>0.341 CNY/cycle</b>							
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine	0.691 min/cycle					0.609 CNY/cycle							
20053	Painting	Process	1.000 cycle/pc						0.191 CNY/cycle	1.007 CNY/cycle		<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19704	Worker, EG04	Worker	25.000 s/cycle							1.007 CNY/cycle					
19969	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle							
18140	Handpaint medium parts	Work Step	25.000 s/cycle												
19652	Cooling Device Mr. Fusion	Part	1.000 pc/pc	0.012 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	<b>0.014 CNY/pc</b>	0.226 CNY/pc	1.211 CNY/pc		<b>1.437 CNY/pc</b>	0.448 CNY/pc	0.057 CNY/pc	0.200 CNY/pc
20006	Injection Molding	Process	0.250 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.014 CNY/pc</b>	0.140 CNY/cycle	0.815 CNY/cycle		<b>0.239 CNY/pc</b>	0.074 CNY/pc	0.010 CNY/pc	0.200 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.674 min/cycle					0.140 CNY/cycle							
19731	Worker, EG04	Worker	40.464 s/cycle					0.815 CNY/cycle							
19711	Tool	Tool												0.800 CNY/cycle	
687	ABS - Re grind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.054 CNY/cycle</b>							
19894	Painting	Process	1.000 cycle/pc						0.191 CNY/cycle	1.007 CNY/cycle		<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19896	Worker, EG04	Worker	25.000 s/cycle							1.007 CNY/cycle					
19751	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle							
18140	Handpaint medium parts	Work Step	25.000 s/cycle												
19881	Exterior / Lighting	Assembly	1.000 pc/pc	0.356 CNY/pc	0.020 CNY/pc		0.015 CNY/pc	<b>0.391 CNY/pc</b>	0.985 CNY/pc	4.997 CNY/pc		<b>5.982 CNY/pc</b>	1.866 CNY/pc	0.239 CNY/pc	2.700 CNY/pc
19878	Lighting	Assembly	1.000 pc/pc	0.267 CNY/pc	0.015 CNY/pc		0.011 CNY/pc	<b>0.294 CNY/pc</b>	0.118 CNY/pc	0.637 CNY/pc		<b>0.755 CNY/pc</b>	0.236 CNY/pc	0.030 CNY/pc	0.600 CNY/pc
19722	Rear Lamp	Part	1.000 pc/pc	0.257 CNY/pc	0.015 CNY/pc		0.011 CNY/pc	<b>0.283 CNY/pc</b>	0.108 CNY/pc	0.579 CNY/pc		<b>0.687 CNY/pc</b>	0.214 CNY/pc	0.027 CNY/pc	0.200 CNY/pc
20064	Injection Molding	Process	0.500 cycle/pc	0.014 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.008 CNY/pc</b>	0.033 CNY/cycle	0.191 CNY/cycle		<b>0.112 CNY/pc</b>	0.035 CNY/pc	0.004 CNY/pc	0.200 CNY/pc

0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	
		<b>0.042 CNY/cycle</b>
0.054 CNY/pc	<b>2.620 CNY/pc</b>	<b>2.647 CNY/pc</b>
0.054 CNY/pc	<b>0.999 CNY/pc</b>	<b>1.027 CNY/pc</b>

0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	
		<b>0.054 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

0.036 CNY/pc	<b>2.344 CNY/pc</b>	<b>2.430 CNY/pc</b>
0.036 CNY/pc	<b>0.724 CNY/pc</b>	<b>0.809 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.341 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

0.036 CNY/pc	<b>2.179 CNY/pc</b>	<b>2.192 CNY/pc</b>
0.036 CNY/pc	<b>0.559 CNY/pc</b>	<b>0.572 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.054 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

0.485 CNY/pc	<b>11.272 CNY/pc</b>	<b>11.664 CNY/pc</b>
0.108 CNY/pc	<b>1.729 CNY/pc</b>	<b>2.023 CNY/pc</b>
0.036 CNY/pc	<b>1.165 CNY/pc</b>	<b>1.447 CNY/pc</b>
0.036 CNY/pc	<b>0.387 CNY/pc</b>	<b>0.395 CNY/pc</b>

# BoM-Report | Structure

6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.158 min/cycle					0.033 CNY/cycle						
19850	Worker, EG04	Worker	9.465 s/cycle					0.191 CNY/cycle						
19658	Tool	Tool											0.400 CNY/cycle	
974	PVC-h - Re grind	Material	0.003 kg/cycle	0.014 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.015 CNY/cycle</b>						
19863	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle		<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc	
19960	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle					
19687	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle						
18142	Airbrush small parts	Work Step	12.000 s/cycle											
19920	Sticker Tag	Material	1.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>0.275 CNY/pc</b>						
19826	Head Lamp	Part	4.000 pc/pc	0.002 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.009 CNY/pc</b>	0.002 CNY/pc	0.010 CNY/pc	<b>0.046 CNY/pc</b>	0.004 CNY/pc	0.000 CNY/pc	0.200 CNY/pc
19639	Injection Molding	Process	0.125 cycle/pc	0.016 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.002 CNY/pc</b>	0.013 CNY/cycle	0.078 CNY/cycle	<b>0.011 CNY/pc</b>	0.004 CNY/pc	0.000 CNY/pc	0.050 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.064 min/cycle						0.013 CNY/cycle					
19718	Worker, EG04	Worker	3.866 s/cycle						0.078 CNY/cycle					
19988	Tool	Tool											0.400 CNY/cycle	
974	PVC-h - Re grind	Material	0.004 kg/cycle	0.016 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.017 CNY/cycle</b>						
20003	Turn light	Part	2.000 pc/pc	0.001 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.003 CNY/pc</b>	0.002 CNY/pc	0.010 CNY/pc	<b>0.023 CNY/pc</b>	0.004 CNY/pc	0.000 CNY/pc	0.200 CNY/pc
19869	Injection Molding	Process	0.125 cycle/pc	0.010 CNY/cycle	0.001 CNY/cycle		0.000 CNY/cycle	<b>0.001 CNY/pc</b>	0.013 CNY/cycle	0.078 CNY/cycle	<b>0.011 CNY/pc</b>	0.004 CNY/pc	0.000 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.064 min/cycle						0.013 CNY/cycle					
19897	Worker, EG04	Worker	3.866 s/cycle						0.078 CNY/cycle					
19693	Tool	Tool											0.800 CNY/cycle	
974	PVC-h - Re grind	Material	0.003 kg/cycle	0.010 CNY/cycle	0.001 CNY/cycle		0.000 CNY/cycle	<b>0.011 CNY/cycle</b>						
20073	Exterior	Assembly	1.000 pc/pc	0.088 CNY/pc	0.005 CNY/pc		0.004 CNY/pc	<b>0.097 CNY/pc</b>	0.867 CNY/pc	4.360 CNY/pc	<b>5.227 CNY/pc</b>	1.631 CNY/pc	0.209 CNY/pc	2.100 CNY/pc
19691	Mirror	Part	2.000 pc/pc	0.002 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.004 CNY/pc</b>	0.020 CNY/pc	0.119 CNY/pc	<b>0.279 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.200 CNY/pc
19650	Injection Molding	Process	0.250 cycle/pc	0.007 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.002 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle	<b>0.139 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle						0.082 CNY/cycle					
19833	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle					
19733	Tool	Tool											0.400 CNY/cycle	
687	ABS - Re grind	Material	0.001 kg/cycle	0.007 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.008 CNY/cycle</b>						
19616	Air inlet	Part	2.000 pc/pc	0.001 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.002 CNY/pc</b>	0.005 CNY/pc	0.029 CNY/pc	<b>0.069 CNY/pc</b>	0.011 CNY/pc	0.001 CNY/pc	0.200 CNY/pc
19737	Injection Molding	Process	0.125 cycle/pc	0.007 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.001 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.034 CNY/pc</b>	0.011 CNY/pc	0.001 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle						0.040 CNY/cycle					
20025	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle					
19996	Tool	Tool											0.800 CNY/cycle	
687	ABS - Re grind	Material	0.001 kg/cycle	0.007 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.008 CNY/cycle</b>						
19904	Bumper side piece	Part	2.000 pc/pc	0.003 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.006 CNY/pc</b>	0.097 CNY/pc	0.513 CNY/pc	<b>1.219 CNY/pc</b>	0.190 CNY/pc	0.024 CNY/pc	0.200 CNY/pc
19714	Injection Molding	Process	0.125 cycle/pc	0.023 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.003 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.034 CNY/pc</b>	0.011 CNY/pc	0.001 CNY/pc	0.100 CNY/pc

0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.015 CNY/cycle</b>
	<b>0.778 CNY/pc</b>	<b>0.778 CNY/pc</b>

		<b>0.275 CNY/pc</b>
0.036 CNY/pc	<b>0.298 CNY/pc</b>	<b>0.306 CNY/pc</b>
0.009 CNY/pc	<b>0.074 CNY/pc</b>	<b>0.077 CNY/pc</b>

0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.017 CNY/cycle</b>
0.036 CNY/pc	<b>0.267 CNY/pc</b>	<b>0.270 CNY/pc</b>
0.018 CNY/pc	<b>0.133 CNY/pc</b>	<b>0.135 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.011 CNY/cycle</b>
0.377 CNY/pc	<b>9.543 CNY/pc</b>	<b>9.641 CNY/pc</b>
0.036 CNY/pc	<b>0.613 CNY/pc</b>	<b>0.617 CNY/pc</b>
0.018 CNY/pc	<b>0.307 CNY/pc</b>	<b>0.308 CNY/pc</b>

0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.008 CNY/cycle</b>
0.036 CNY/pc	<b>0.329 CNY/pc</b>	<b>0.331 CNY/pc</b>
0.018 CNY/pc	<b>0.164 CNY/pc</b>	<b>0.165 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.008 CNY/cycle</b>
0.036 CNY/pc	<b>1.884 CNY/pc</b>	<b>1.890 CNY/pc</b>
0.018 CNY/pc	<b>0.164 CNY/pc</b>	<b>0.167 CNY/pc</b>



# BoM-Report | Structure

6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle							
20031	Worker, EG04	Worker	11.616 s/cycle					0.234 CNY/cycle							
20046	Tool	Tool											0.800 CNY/cycle		
687	ABS - Regrind	Material	0.004 kg/cycle	0.023 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.025 CNY/cycle</b>							
19998	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle		<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc		
19783	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle						
19972	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19965	Bumper front upper part	Part	1.000 pc/pc	0.025 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	<b>0.027 CNY/pc</b>	0.041 CNY/pc	0.238 CNY/pc		<b>0.279 CNY/pc</b>	0.087 CNY/pc	0.011 CNY/pc	0.200 CNY/pc
19893	Injection Molding	Process	0.500 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.027 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle		<b>0.279 CNY/pc</b>	0.087 CNY/pc	0.011 CNY/pc	0.200 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle							
19645	Worker, EG04	Worker	23.636 s/cycle					0.476 CNY/cycle							
19696	Tool	Tool											0.400 CNY/cycle		
687	ABS - Regrind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.054 CNY/cycle</b>							
19665	Radiator grill	Part	1.000 pc/pc	0.006 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.006 CNY/pc</b>	0.102 CNY/pc	0.542 CNY/pc		<b>0.644 CNY/pc</b>	0.201 CNY/pc	0.026 CNY/pc	0.200 CNY/pc
19685	Injection Molding	Process	0.250 cycle/pc	0.023 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.006 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle		<b>0.069 CNY/pc</b>	0.021 CNY/pc	0.003 CNY/pc	0.200 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle							
19705	Worker, EG04	Worker	11.616 s/cycle					0.234 CNY/cycle							
19766	Tool	Tool											0.800 CNY/cycle		
687	ABS - Regrind	Material	0.004 kg/cycle	0.023 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.025 CNY/cycle</b>							
19839	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle		<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc		
19843	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle						
19856	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19861	Wiper	Part	2.000 pc/pc	0.001 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.001 CNY/pc</b>	0.002 CNY/pc	0.011 CNY/pc		<b>0.026 CNY/pc</b>	0.004 CNY/pc	0.001 CNY/pc	0.200 CNY/pc
19809	Injection Molding	Process	0.125 cycle/pc	0.005 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.001 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle		<b>0.013 CNY/pc</b>	0.004 CNY/pc	0.001 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle							
19706	Worker, EG04	Worker	4.404 s/cycle					0.089 CNY/cycle							
19891	Tool	Tool											0.800 CNY/cycle		
687	ABS - Regrind	Material	0.001 kg/cycle	0.005 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.005 CNY/cycle</b>							
19815	Windscreen	Part	1.000 pc/pc	0.023 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	<b>0.026 CNY/pc</b>	0.169 CNY/pc	0.589 CNY/pc		<b>0.758 CNY/pc</b>	0.236 CNY/pc	0.030 CNY/pc	0.400 CNY/pc
19681	Injection Molding	Process	0.500 cycle/pc	0.047 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.026 CNY/pc</b>	0.154 CNY/cycle	0.211 CNY/cycle		<b>0.182 CNY/pc</b>	0.057 CNY/pc	0.007 CNY/pc	0.400 CNY/pc
19762	Worker, EG04	Worker	10.465 s/cycle						0.211 CNY/cycle						
19661	Tool	Tool											0.800 CNY/cycle		
974	PVC-h - Regrind	Material	0.011 kg/cycle	0.047 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.052 CNY/cycle</b>							

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.025 CNY/cycle</b>
	<b>0.778 CNY/pc</b>	<b>0.778 CNY/pc</b>

0.036 CNY/pc	<b>0.613 CNY/pc</b>	<b>0.640 CNY/pc</b>
0.036 CNY/pc	<b>0.613 CNY/pc</b>	<b>0.640 CNY/pc</b>

0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.054 CNY/cycle</b>
0.036 CNY/pc	<b>1.106 CNY/pc</b>	<b>1.113 CNY/pc</b>
0.036 CNY/pc	<b>0.329 CNY/pc</b>	<b>0.335 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.025 CNY/cycle</b>
	<b>0.778 CNY/pc</b>	<b>0.778 CNY/pc</b>

0.036 CNY/pc	<b>0.271 CNY/pc</b>	<b>0.272 CNY/pc</b>
0.018 CNY/pc	<b>0.136 CNY/pc</b>	<b>0.136 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.005 CNY/cycle</b>
0.072 CNY/pc	<b>1.496 CNY/pc</b>	<b>1.522 CNY/pc</b>
0.072 CNY/pc	<b>0.718 CNY/pc</b>	<b>0.744 CNY/pc</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.052 CNY/cycle</b>

# BoM-Report | Structure

6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine	0.174 min/cycle					0.154 CNY/cycle							
19995	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle	<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc			
19943	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle						
19959	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19924	Bumper front lower part	Part	1.000 pc/pc	0.008 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.009 CNY/pc</b>	0.112 CNY/pc	0.601 CNY/pc	<b>0.712 CNY/pc</b>	0.222 CNY/pc	0.028 CNY/pc	0.200 CNY/pc		
19758	Injection Molding	Process	0.500 cycle/pc	0.017 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.009 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.137 CNY/pc</b>	0.043 CNY/pc	0.005 CNY/pc	0.200 CNY/pc		
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle							
19666	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle						
20004	Tool	Tool											0.400 CNY/cycle		
687	ABS - Regrind	Material	0.003 kg/cycle	0.017 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.018 CNY/cycle</b>								
19791	Copy of Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle	<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc			
19622	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle						
19767	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19790	Window	Part	2.000 pc/pc	0.007 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.015 CNY/pc</b>	0.098 CNY/pc	0.523 CNY/pc	<b>1.242 CNY/pc</b>	0.194 CNY/pc	0.025 CNY/pc	0.300 CNY/pc		
19702	Injection Molding	Process	0.500 cycle/pc	0.014 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.008 CNY/pc</b>	0.013 CNY/cycle	0.078 CNY/cycle	<b>0.046 CNY/pc</b>	0.014 CNY/pc	0.002 CNY/pc	0.150 CNY/pc		
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.064 min/cycle					0.013 CNY/cycle							
19819	Worker, EG04	Worker	3.866 s/cycle						0.078 CNY/cycle						
19677	Tool	Tool											0.300 CNY/cycle		
974	PVC-h - Regrind	Material	0.003 kg/cycle	0.014 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.015 CNY/cycle</b>								
19632	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle	<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc			
19798	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle						
19933	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19865	Interior	Assembly	1.000 pc/pc	2.864 CNY/pc	0.164 CNY/pc	0.121 CNY/pc	<b>3.149 CNY/pc</b>	7.083 CNY/pc	21.256 CNY/pc	<b>28.339 CNY/pc</b>	8.842 CNY/pc	1.134 CNY/pc	0.000 CNY/pc	4.100 CNY/pc	
19862	Holder door cover	Part	2.000 pc/pc	0.006 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.013 CNY/pc</b>	0.112 CNY/pc	0.603 CNY/pc	<b>1.429 CNY/pc</b>	0.223 CNY/pc	0.029 CNY/pc	0.200 CNY/pc		
19641	Injection Molding	Process	0.250 cycle/pc	0.024 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.006 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle	<b>0.139 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.100 CNY/pc		
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle							
19934	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle						
19755	Tool	Tool											0.400 CNY/cycle		
687	ABS - Regrind	Material	0.004 kg/cycle	0.024 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.026 CNY/cycle</b>								
19987	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle	<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc			
20037	Worker, EG04	Worker	12.000 s/cycle						0.484 CNY/cycle						
19730	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												

	<b>0.778 CNY / pc</b>	<b>0.778 CNY / pc</b>

0.036 CNY / pc	<b>1.199 CNY / pc</b>	<b>1.208 CNY / pc</b>
0.036 CNY / pc	<b>0.421 CNY / pc</b>	<b>0.430 CNY / pc</b>

0.072 CNY / cycle	<b>0.472 CNY / cycle</b>	
		<b>0.018 CNY / cycle</b>
	<b>0.778 CNY / pc</b>	<b>0.778 CNY / pc</b>

0.054 CNY / pc	<b>2.033 CNY / pc</b>	<b>2.048 CNY / pc</b>
0.027 CNY / pc	<b>0.239 CNY / pc</b>	<b>0.246 CNY / pc</b>

0.054 CNY / cycle	<b>0.354 CNY / cycle</b>	
		<b>0.015 CNY / cycle</b>
	<b>0.778 CNY / pc</b>	<b>0.778 CNY / pc</b>

0.736 CNY / pc	<b>43.151 CNY / pc</b>	<b>46.300 CNY / pc</b>
0.036 CNY / pc	<b>2.168 CNY / pc</b>	<b>2.181 CNY / pc</b>
0.018 CNY / pc	<b>0.307 CNY / pc</b>	<b>0.313 CNY / pc</b>

0.072 CNY / cycle	<b>0.472 CNY / cycle</b>	
		<b>0.026 CNY / cycle</b>
	<b>0.778 CNY / pc</b>	<b>0.778 CNY / pc</b>

# BoM-Report | Structure

19953	Driver Seat	Part	1.000 pc/pc	0.038 CNY/pc	0.002 CNY/pc	0.002 CNY/pc	<b>0.042 CNY/pc</b>	0.269 CNY/pc	1.443 CNY/pc	<b>1.712 CNY/pc</b>	0.534 CNY/pc	0.068 CNY/pc	0.000 CNY/pc	0.400 CNY/pc
19774	Injection Molding	Process	1.000 cycle/pc	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	<b>0.042 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.274 CNY/pc</b>	0.086 CNY/pc	0.011 CNY/pc		0.400 CNY/pc
687	ABS - Regrind	Material	0.007 kg/cycle	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	<b>0.042 CNY/cycle</b>							
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle						
19609	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle					
20074	Tool	Tool												0.400 CNY/cycle
19821	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.209 CNY/cycle	<b>1.438 CNY/pc</b>	0.449 CNY/pc	0.058 CNY/pc		
20020	Worker, EG04	Worker	30.000 s/cycle						1.209 CNY/cycle					
19672	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle						
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
19900	Glue	Special Direct Cost	0.000 CNY/pc										0.000 CNY/pc	
19877	Gear shift	Part	1.000 pc/pc	0.002 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.002 CNY/pc</b>	0.004 CNY/pc	0.022 CNY/pc	<b>0.026 CNY/pc</b>	0.008 CNY/pc	0.001 CNY/pc		0.200 CNY/pc
20055	Injection Molding	Process	0.250 cycle/pc	0.008 CNY/cycle	0.000 CNY/cycle	0.000 CNY/cycle	<b>0.002 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle	<b>0.026 CNY/pc</b>	0.008 CNY/pc	0.001 CNY/pc		0.200 CNY/pc
687	ABS - Regrind	Material	0.001 kg/cycle	0.008 CNY/cycle	0.000 CNY/cycle	0.000 CNY/cycle	<b>0.008 CNY/cycle</b>							
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle						
19935	Worker, EG04	Worker	4.404 s/cycle						0.089 CNY/cycle					
19954	Tool	Tool												0.800 CNY/cycle
20050	Base plate interior	Part	1.000 pc/pc	0.142 CNY/pc	0.008 CNY/pc	0.006 CNY/pc	<b>0.156 CNY/pc</b>	0.742 CNY/pc	3.891 CNY/pc	<b>4.632 CNY/pc</b>	1.445 CNY/pc	0.185 CNY/pc		0.500 CNY/pc
19690	Injection Molding	Process	0.500 cycle/pc	0.283 CNY/cycle	0.016 CNY/cycle	0.012 CNY/cycle	<b>0.156 CNY/pc</b>	0.185 CNY/cycle	0.254 CNY/cycle	<b>0.220 CNY/pc</b>	0.069 CNY/pc	0.009 CNY/pc		0.500 CNY/pc
20009	Worker, EG04	Worker	12.616 s/cycle						0.254 CNY/cycle					
19980	Tool	Tool												1.000 CNY/cycle
687	ABS - Regrind	Material	0.052 kg/cycle	0.283 CNY/cycle	0.016 CNY/cycle	0.012 CNY/cycle	<b>0.311 CNY/cycle</b>							
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine	0.210 min/cycle					0.185 CNY/cycle						
19638	Painting	Process	1.000 cycle/pc					0.649 CNY/cycle	3.764 CNY/cycle	<b>4.413 CNY/pc</b>	1.377 CNY/pc	0.177 CNY/pc		
19700	Worker, EG06	Worker	85.000 s/cycle						3.764 CNY/cycle					
20051	Air brush and Painting workstation	Machine	1.417 min/cycle					0.649 CNY/cycle						
18139	Polish or clean medium parts	Work Step	30.000 s/cycle											
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19636	Rear Mirror	Part	1.000 pc/pc	0.202 CNY/pc	0.012 CNY/pc	0.009 CNY/pc	<b>0.222 CNY/pc</b>	0.001 CNY/pc	0.003 CNY/pc	<b>0.004 CNY/pc</b>	0.001 CNY/pc	0.000 CNY/pc		0.200 CNY/pc
20023	Injection Molding	Process	0.036 cycle/pc	0.051 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.002 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle	<b>0.004 CNY/pc</b>	0.001 CNY/pc	0.000 CNY/pc		0.200 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle						
19923	Worker, EG04	Worker	4.404 s/cycle						0.089 CNY/cycle					
19605	Tool	Tool												5.600 CNY/cycle
687	ABS - Regrind	Material	0.009 kg/cycle	0.051 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.057 CNY/cycle</b>							
19789	Sticker Mirror	Material	1.000 pc/pc	0.200 CNY/pc	0.011 CNY/pc	0.008 CNY/pc	<b>0.220 CNY/pc</b>							
19940	Cover roof	Part	1.000 pc/pc	0.304 CNY/pc	0.017 CNY/pc	0.013 CNY/pc	<b>0.335 CNY/pc</b>	2.641 CNY/pc	4.632 CNY/pc	<b>7.273 CNY/pc</b>	2.269 CNY/pc	0.291 CNY/pc		0.700 CNY/pc
19678	Grouping (Piece)	Grouping		0.304 CNY/pc	0.017 CNY/pc	0.013 CNY/pc	<b>0.335 CNY/pc</b>	2.641 CNY/pc	4.632 CNY/pc	<b>7.273 CNY/pc</b>	2.269 CNY/pc	0.291 CNY/pc		0.700 CNY/pc
19765	Control panel	Part	1.000 pc/pc	0.006 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.007 CNY/pc</b>	0.199 CNY/pc	1.052 CNY/pc	<b>1.250 CNY/pc</b>	0.390 CNY/pc	0.050 CNY/pc		0.200 CNY/pc
19867	Molding	Process	0.500 cycle/pc	0.013 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.007 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle	<b>0.052 CNY/pc</b>	0.016 CNY/pc	0.002 CNY/pc		0.200 CNY/pc

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0.072 CNY/pc	<b>2.787 CNY/pc</b>	<b>2.829 CNY/pc</b>
0.072 CNY/pc	<b>0.842 CNY/pc</b>	<b>0.885 CNY/pc</b>
		<b>0.042 CNY/cycle</b>

0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
	<b>1.944 CNY/pc</b>	<b>1.944 CNY/pc</b>

	<b>0.000 CNY/pc</b>	
0.036 CNY/pc	<b>0.271 CNY/pc</b>	<b>0.273 CNY/pc</b>
0.036 CNY/pc	<b>0.271 CNY/pc</b>	<b>0.273 CNY/pc</b>
		<b>0.008 CNY/cycle</b>

0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
0.090 CNY/pc	<b>6.853 CNY/pc</b>	<b>7.009 CNY/pc</b>
0.090 CNY/pc	<b>0.887 CNY/pc</b>	<b>1.043 CNY/pc</b>

0.180 CNY/cycle	<b>1.180 CNY/cycle</b>	
		<b>0.311 CNY/cycle</b>

	<b>5.966 CNY/pc</b>	<b>5.966 CNY/pc</b>
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0.036 CNY/pc	<b>0.241 CNY/pc</b>	<b>0.463 CNY/pc</b>
0.036 CNY/pc	<b>0.241 CNY/pc</b>	<b>0.243 CNY/pc</b>

1.005 CNY/cycle	<b>6.605 CNY/cycle</b>	
		<b>0.057 CNY/cycle</b>
		<b>0.220 CNY/pc</b>

0.126 CNY/pc	<b>10.659 CNY/pc</b>	<b>10.994 CNY/pc</b>
0.126 CNY/pc	<b>10.659 CNY/pc</b>	<b>10.994 CNY/pc</b>
0.036 CNY/pc	<b>1.926 CNY/pc</b>	<b>1.933 CNY/pc</b>
0.036 CNY/pc	<b>0.306 CNY/pc</b>	<b>0.313 CNY/pc</b>

6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle							
19747	Worker, EG04	Worker	4.404 s/cycle					0.089 CNY/cycle							
19949	Tool	Tool											0.400 CNY/cycle		
687	ABS - Regrind	Material	0.002 kg/cycle	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.014 CNY/cycle</b>							
19720	Painting	Process	1.000 cycle/pc					0.191 CNY/cycle	1.007 CNY/cycle		<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc		
19745	Worker, EG04	Worker	25.000 s/cycle						1.007 CNY/cycle						
19845	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle							
18140	Handpaint medium parts	Work Step	25.000 s/cycle												
19966	Roof frame	Part	1.000 pc/pc	0.298 CNY/pc	0.017 CNY/pc		0.013 CNY/pc	<b>0.328 CNY/pc</b>	2.443 CNY/pc	3.580 CNY/pc		<b>6.023 CNY/pc</b>	1.879 CNY/pc	0.241 CNY/pc	0.500 CNY/pc
19728	Die Casting	Process	0.500 cycle/pc	0.596 CNY/cycle	0.034 CNY/cycle		0.025 CNY/cycle	<b>0.328 CNY/pc</b>	3.970 CNY/cycle	1.847 CNY/cycle		<b>2.908 CNY/pc</b>	0.907 CNY/pc	0.116 CNY/pc	0.500 CNY/pc
19870	Worker, EG04	Worker	45.828 s/cycle						1.847 CNY/cycle						
19876	Copy of Tool	Tool												1.000 CNY/cycle	
362	Al 99,9	Material	0.033 kg/cycle	0.596 CNY/cycle	0.034 CNY/cycle		0.025 CNY/cycle	<b>0.655 CNY/cycle</b>							
19750	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							3.970 CNY/cycle						
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.382 min/cycle					0.612 CNY/cycle							
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.382 min/cycle					3.358 CNY/cycle							
19948	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.328 CNY/cycle		<b>1.557 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc		
19694	Worker, EG06	Worker	30.000 s/cycle						1.328 CNY/cycle						
19741	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle							
18138	Airbrush medium parts	Work Step	30.000 s/cycle												
19794	Polishing	Process	1.000 cycle/pc					0.229 CNY/cycle	1.328 CNY/cycle		<b>1.557 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc		
20021	Worker, EG06	Worker	30.000 s/cycle						1.328 CNY/cycle						
19741	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle							
18139	Polish or clean medium parts	Work Step	30.000 s/cycle												
19655	Door cover lower part	Part	2.000 pc/pc	0.012 CNY/pc	0.001 CNY/pc		0.001 CNY/pc	<b>0.027 CNY/pc</b>	0.239 CNY/pc	1.268 CNY/pc		<b>3.013 CNY/pc</b>	0.470 CNY/pc	0.060 CNY/pc	0.200 CNY/pc
20067	Injection Molding	Process	0.250 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.014 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle		<b>0.069 CNY/pc</b>	0.021 CNY/pc	0.003 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle							
19701	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle						
20062	Tool	Tool												0.400 CNY/cycle	
687	ABS - Regrind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.054 CNY/cycle</b>							
19956	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.209 CNY/cycle		<b>1.438 CNY/pc</b>	0.449 CNY/pc	0.058 CNY/pc		

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0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.014 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

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0.090 CNY/pc	<b>8.733 CNY/pc</b>	<b>9.060 CNY/pc</b>
0.090 CNY/pc	<b>4.522 CNY/pc</b>	<b>4.849 CNY/pc</b>
0.180 CNY/cycle	<b>1.180 CNY/cycle</b>	
		<b>0.655 CNY/cycle</b>

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	<b>2.106 CNY/pc</b>	<b>2.106 CNY/pc</b>
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	<b>2.106 CNY/pc</b>	<b>2.106 CNY/pc</b>
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0.036 CNY/pc	<b>4.310 CNY/pc</b>	<b>4.337 CNY/pc</b>
0.018 CNY/pc	<b>0.211 CNY/pc</b>	<b>0.224 CNY/pc</b>

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0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.054 CNY/cycle</b>
	<b>1.944 CNY/pc</b>	<b>1.944 CNY/pc</b>



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19710	Worker, EG04	Worker	30.000 s/cycle							1.209 CNY/cycle				
20028	Air brush and Painting workstation	Machine	0.500 min/cycle						0.229 CNY/cycle					
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
19853	Cover trunk	Part	1.000 pc/pc	0.055 CNY/pc	0.003 CNY/pc	0.002 CNY/pc	<b>0.060 CNY/pc</b>	0.082 CNY/pc	0.476 CNY/pc	<b>0.558 CNY/pc</b>	0.174 CNY/pc	0.022 CNY/pc	0.300 CNY/pc	
19777	Injection Molding	Process	1.000 cycle/pc	0.055 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.060 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle	<b>0.558 CNY/pc</b>	0.174 CNY/pc	0.022 CNY/pc	0.300 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle						
19659	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle					
19849	Tool	Tool											0.300 CNY/cycle	
687	ABS - Re grind	Material	0.010 kg/cycle	0.055 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.060 CNY/cycle</b>							
19874	Pedal	Part	1.000 pc/pc	0.003 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.003 CNY/pc</b>	0.002 CNY/pc	0.012 CNY/pc	<b>0.014 CNY/pc</b>	0.004 CNY/pc	0.001 CNY/pc	0.200 CNY/pc	
19817	Injection Molding	Process	0.050 cycle/pc	0.060 CNY/cycle	0.003 CNY/cycle	0.003 CNY/cycle	<b>0.003 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.014 CNY/pc</b>	0.004 CNY/pc	0.001 CNY/pc	0.200 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle						
20070	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle					
19773	Tool	Tool											4.000 CNY/cycle	
687	ABS - Re grind	Material	0.011 kg/cycle	0.060 CNY/cycle	0.003 CNY/cycle	0.003 CNY/cycle	<b>0.066 CNY/cycle</b>							
19612	Passenger Seat	Part	1.000 pc/pc	0.038 CNY/pc	0.002 CNY/pc	0.002 CNY/pc	<b>0.042 CNY/pc</b>	0.269 CNY/pc	1.443 CNY/pc	<b>1.712 CNY/pc</b>	0.534 CNY/pc	0.068 CNY/pc	0.000 CNY/pc	0.400 CNY/pc
19785	Injection Molding	Process	1.000 cycle/pc	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	<b>0.042 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.274 CNY/pc</b>	0.086 CNY/pc	0.011 CNY/pc	0.400 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle						
19838	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle					
19961	Tool	Tool											0.400 CNY/cycle	
687	ABS - Re grind	Material	0.007 kg/cycle	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	<b>0.042 CNY/cycle</b>							
19829	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.209 CNY/cycle	<b>1.438 CNY/pc</b>	0.449 CNY/pc	0.058 CNY/pc		
19886	Worker, EG04	Worker	30.000 s/cycle						1.209 CNY/cycle					
19866	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle						
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
19947	Copy of Glue	Special Direct Cost	0.000 CNY/pc										0.000 CNY/pc	
19919	Cockpit	Part	1.000 pc/pc	0.068 CNY/pc	0.004 CNY/pc	0.003 CNY/pc	<b>0.075 CNY/pc</b>	2.071 CNY/pc	3.943 CNY/pc	<b>6.014 CNY/pc</b>	1.877 CNY/pc	0.241 CNY/pc	0.200 CNY/pc	
19618	Injection Molding	Process	0.500 cycle/pc	0.136 CNY/cycle	0.008 CNY/cycle	0.006 CNY/cycle	<b>0.075 CNY/pc</b>	3.577 CNY/cycle	4.905 CNY/cycle	<b>4.241 CNY/pc</b>	1.323 CNY/pc	0.170 CNY/pc	0.200 CNY/pc	
19732	Worker, EG04	Worker	243.403 s/cycle						4.905 CNY/cycle					
19634	Tool	Tool											0.400 CNY/cycle	
687	ABS - Re grind	Material	0.025 kg/cycle	0.136 CNY/cycle	0.008 CNY/cycle	0.006 CNY/cycle	<b>0.150 CNY/cycle</b>							
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine	4.057 min/cycle					3.577 CNY/cycle						
19727	Painting	Process	1.000 cycle/pc					0.283 CNY/cycle	1.491 CNY/cycle	<b>1.774 CNY/pc</b>	0.553 CNY/pc	0.071 CNY/pc		
19882	Worker, EG04	Worker	37.000 s/cycle						1.491 CNY/cycle					
19941	Air brush and Painting workstation	Machine	0.617 min/cycle					0.283 CNY/cycle						
18142	Airbrush small parts	Work Step	12.000 s/cycle											
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19905	Park brake	Part	1.000 pc/pc	0.002 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.002 CNY/pc</b>	0.001 CNY/pc	0.003 CNY/pc	<b>0.004 CNY/pc</b>	0.001 CNY/pc	0.000 CNY/pc	0.200 CNY/pc	
19983	Injection Molding	Process	0.036 cycle/pc	0.051 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.002 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle	<b>0.004 CNY/pc</b>	0.001 CNY/pc	0.000 CNY/pc	0.200 CNY/pc	

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0.054 CNY/pc	<b>1.108 CNY/pc</b>	<b>1.168 CNY/pc</b>
0.054 CNY/pc	<b>1.108 CNY/pc</b>	<b>1.168 CNY/pc</b>

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0.054 CNY/cycle	<b>0.354 CNY/cycle</b>	
		<b>0.060 CNY/cycle</b>

0.036 CNY/pc	<b>0.254 CNY/pc</b>	<b>0.258 CNY/pc</b>
0.036 CNY/pc	<b>0.254 CNY/pc</b>	<b>0.258 CNY/pc</b>

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0.718 CNY/cycle	<b>4.718 CNY/cycle</b>	
		<b>0.066 CNY/cycle</b>

0.072 CNY/pc	<b>2.787 CNY/pc</b>	<b>2.829 CNY/pc</b>
0.072 CNY/pc	<b>0.842 CNY/pc</b>	<b>0.885 CNY/pc</b>

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0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.042 CNY/cycle</b>
	<b>1.944 CNY/pc</b>	<b>1.944 CNY/pc</b>

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	<b>0.000 CNY/pc</b>	
0.036 CNY/pc	<b>8.367 CNY/pc</b>	<b>8.442 CNY/pc</b>
0.036 CNY/pc	<b>5.970 CNY/pc</b>	<b>6.044 CNY/pc</b>

0.072 CNY/cycle	<b>0.472 CNY/cycle</b>	
		<b>0.150 CNY/cycle</b>

	<b>2.398 CNY/pc</b>	<b>2.398 CNY/pc</b>

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0.036 CNY/pc	<b>0.241 CNY/pc</b>	<b>0.243 CNY/pc</b>
0.036 CNY/pc	<b>0.241 CNY/pc</b>	<b>0.243 CNY/pc</b>

6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle							
20013	Worker, EG04	Worker	4.404 s/cycle					0.089 CNY/cycle							
19852	Tool	Tool											5.600 CNY/cycle		
687	ABS - Regrind	Material	0.009 kg/cycle	0.051 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	<b>0.057 CNY/cycle</b>							
19936	Screw Interior	Part	7.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>1.924 CNY/pc</b>							
19792	Screw PT	Material	1.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>0.275 CNY/pc</b>							
19883	Steering wheel	Part	1.000 pc/pc	0.207 CNY/pc	0.012 CNY/pc		0.009 CNY/pc	<b>0.227 CNY/pc</b>	0.035 CNY/pc	0.204 CNY/pc		<b>0.239 CNY/pc</b>	0.074 CNY/pc	0.010 CNY/pc	0.200 CNY/pc
19640	Injection Molding	Process	0.250 cycle/pc	0.028 CNY/cycle	0.002 CNY/cycle		0.001 CNY/cycle	<b>0.008 CNY/pc</b>	0.140 CNY/cycle	0.815 CNY/cycle		<b>0.239 CNY/pc</b>	0.074 CNY/pc	0.010 CNY/pc	0.200 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.674 min/cycle					0.140 CNY/cycle							
19680	Worker, EG04	Worker	40.464 s/cycle					0.815 CNY/cycle							
20027	Tool	Tool											0.800 CNY/cycle		
687	ABS - Regrind	Material	0.005 kg/cycle	0.028 CNY/cycle	0.002 CNY/cycle		0.001 CNY/cycle	<b>0.030 CNY/cycle</b>							
20014	Sticker	Material	1.000 pc/pc	0.200 CNY/pc	0.011 CNY/pc		0.008 CNY/pc	<b>0.220 CNY/pc</b>							
19664	Door Cover upper part	Part	2.000 pc/pc	0.008 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.018 CNY/pc</b>	0.132 CNY/pc	0.722 CNY/pc		<b>1.708 CNY/pc</b>	0.266 CNY/pc	0.034 CNY/pc	0.200 CNY/pc
19668	Injection Molding	Process	0.500 cycle/pc	0.017 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.009 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle		<b>0.279 CNY/pc</b>	0.087 CNY/pc	0.011 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle							
19902	Worker, EG04	Worker	23.636 s/cycle					0.476 CNY/cycle							
19604	Tool	Tool											0.200 CNY/cycle		
687	ABS - Regrind	Material	0.003 kg/cycle	0.017 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.018 CNY/cycle</b>							
19858	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.484 CNY/cycle			<b>0.575 CNY/pc</b>	0.179 CNY/pc	0.023 CNY/pc	
19979	Worker, EG04	Worker	12.000 s/cycle					0.484 CNY/cycle							
20061	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19625	Electronic	Assembly	1.000 pc/pc	0.056 CNY/pc	0.003 CNY/pc		0.002 CNY/pc	<b>0.061 CNY/pc</b>	2.619 CNY/pc	13.985 CNY/pc		<b>16.604 CNY/pc</b>	5.180 CNY/pc	0.664 CNY/pc	2.400 CNY/pc
19818	Wiring Harness right	Part	1.000 pc/pc	0.003 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.003 CNY/pc</b>	0.195 CNY/pc	1.030 CNY/pc		<b>1.224 CNY/pc</b>	0.382 CNY/pc	0.049 CNY/pc	0.300 CNY/pc
19651	Molding	Process	0.250 cycle/pc	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.003 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle		<b>0.026 CNY/pc</b>	0.008 CNY/pc	0.001 CNY/pc	0.300 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle							
19776	Worker, EG04	Worker	4.404 s/cycle					0.089 CNY/cycle							
19899	Tool	Tool											1.200 CNY/cycle		
687	ABS - Regrind	Material	0.002 kg/cycle	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.014 CNY/cycle</b>							
19784	Painting	Process	1.000 cycle/pc					0.191 CNY/cycle	1.007 CNY/cycle			<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19918	Worker, EG04	Worker	25.000 s/cycle					1.007 CNY/cycle							
20034	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle							
18140	Handpaint medium parts	Work Step	25.000 s/cycle												
19654	Wiring Harness left	Part	1.000 pc/pc	0.003 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.003 CNY/pc</b>	0.195 CNY/pc	1.030 CNY/pc		<b>1.224 CNY/pc</b>	0.382 CNY/pc	0.049 CNY/pc	0.300 CNY/pc
19786	Injection Molding	Process	0.250 cycle/pc	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.003 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle		<b>0.026 CNY/pc</b>	0.008 CNY/pc	0.001 CNY/pc	0.300 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle							
20063	Worker, EG04	Worker	4.404 s/cycle					0.089 CNY/cycle							
19712	Tool	Tool											1.200 CNY/cycle		
687	ABS - Regrind	Material	0.002 kg/cycle	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.014 CNY/cycle</b>							
20060	Painting	Process	1.000 cycle/pc					0.191 CNY/cycle	1.007 CNY/cycle			<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19832	Worker, EG04	Worker	25.000 s/cycle					1.007 CNY/cycle							

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1.005 CNY/cycle	<b>6.605 CNY/cycle</b>	
		<b>0.057 CNY/cycle</b>
		<b>1.924 CNY/pc</b>
		<b>0.275 CNY/pc</b>
0.036 CNY/pc	<b>0.559 CNY/pc</b>	<b>0.786 CNY/pc</b>
0.036 CNY/pc	<b>0.559 CNY/pc</b>	<b>0.566 CNY/pc</b>

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0.144 CNY/cycle	<b>0.944 CNY/cycle</b>	
		<b>0.030 CNY/cycle</b>
		<b>0.220 CNY/pc</b>
0.036 CNY/pc	<b>2.546 CNY/pc</b>	<b>2.564 CNY/pc</b>
0.018 CNY/pc	<b>0.495 CNY/pc</b>	<b>0.504 CNY/pc</b>

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0.036 CNY/cycle	<b>0.236 CNY/cycle</b>	
		<b>0.018 CNY/cycle</b>
	<b>0.778 CNY/pc</b>	<b>0.778 CNY/pc</b>

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0.431 CNY/pc	<b>25.279 CNY/pc</b>	<b>25.340 CNY/pc</b>
0.054 CNY/pc	<b>2.009 CNY/pc</b>	<b>2.013 CNY/pc</b>
0.054 CNY/pc	<b>0.389 CNY/pc</b>	<b>0.392 CNY/pc</b>

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0.215 CNY/cycle	<b>1.415 CNY/cycle</b>	
		<b>0.014 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

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0.054 CNY/pc	<b>2.009 CNY/pc</b>	<b>2.013 CNY/pc</b>
0.054 CNY/pc	<b>0.389 CNY/pc</b>	<b>0.392 CNY/pc</b>

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0.215 CNY/cycle	<b>1.415 CNY/cycle</b>	
		<b>0.014 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

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# BoM-Report | Structure

19746	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle										
19630	Control Time Machine	Part	1.000 pc/pc	0.006 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.006 CNY/pc</b>	0.211 CNY/pc	1.127 CNY/pc	<b>1.338 CNY/pc</b>	0.417 CNY/pc	0.054 CNY/pc	0.300 CNY/pc
19925	Injection Molding	Process	0.250 cycle/pc	0.024 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.006 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle	<b>0.139 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.300 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle					
19868	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle				
19667	Tool	Tool											1.200 CNY/cycle
687	ABS - Re grind	Material	0.004 kg/cycle	0.024 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.026 CNY/cycle</b>						
19824	Painting	Process	1.000 cycle/pc					0.191 CNY/cycle	1.007 CNY/cycle	<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
20054	Worker, EG04	Worker	25.000 s/cycle						1.007 CNY/cycle				
19908	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle										
19795	Panel Time Machine	Part	1.000 pc/pc	0.006 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.007 CNY/pc</b>	0.344 CNY/pc	1.900 CNY/pc	<b>2.243 CNY/pc</b>	0.700 CNY/pc	0.090 CNY/pc	0.300 CNY/pc
19842	Injection Molding	Process	0.500 cycle/pc	0.013 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.007 CNY/pc</b>	0.306 CNY/cycle	1.784 CNY/cycle	<b>1.045 CNY/pc</b>	0.326 CNY/pc	0.042 CNY/pc	0.300 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	1.476 min/cycle					0.306 CNY/cycle					
19717	Worker, EG04	Worker	88.545 s/cycle						1.784 CNY/cycle				
19698	Tool	Tool											0.600 CNY/cycle
687	ABS - Re grind	Material	0.002 kg/cycle	0.013 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.014 CNY/cycle</b>						
19901	Painting	Process	1.000 cycle/pc					0.191 CNY/cycle	1.007 CNY/cycle	<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19945	Worker, EG04	Worker	25.000 s/cycle						1.007 CNY/cycle				
19834	Air brush and Painting workstation	Machine	0.417 min/cycle					0.191 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle										
19606	Assy Flux Compensator	Part	1.000 pc/pc	0.023 CNY/pc	0.001 CNY/pc	0.001 CNY/pc	<b>0.025 CNY/pc</b>	0.461 CNY/pc	2.455 CNY/pc	<b>2.915 CNY/pc</b>	0.910 CNY/pc	0.117 CNY/pc	0.300 CNY/pc
19689	Injection Molding	Process	0.500 cycle/pc	0.045 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.025 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle	<b>0.279 CNY/pc</b>	0.087 CNY/pc	0.011 CNY/pc	0.300 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle					
20008	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle				
20029	Tool	Tool											0.600 CNY/cycle
687	ABS - Re grind	Material	0.008 kg/cycle	0.045 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.050 CNY/cycle</b>						
19986	Painting	Process	1.000 cycle/pc					0.420 CNY/cycle	2.216 CNY/cycle	<b>2.636 CNY/pc</b>	0.823 CNY/pc	0.105 CNY/pc	
19962	Worker, EG04	Worker	55.000 s/cycle						2.216 CNY/cycle				
19847	Air brush and Painting workstation	Machine	0.917 min/cycle					0.420 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle										
18138	Airbrush medium parts	Work Step	30.000 s/cycle										
19697	Wiring Harness Drive rear	Part	2.000 pc/pc	0.002 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.005 CNY/pc</b>	0.195 CNY/pc	1.030 CNY/pc	<b>2.449 CNY/pc</b>	0.382 CNY/pc	0.049 CNY/pc	0.300 CNY/pc
20019	Injection Molding	Process	0.250 cycle/pc	0.008 CNY/cycle	0.000 CNY/cycle	0.000 CNY/cycle	<b>0.002 CNY/pc</b>	0.015 CNY/cycle	0.089 CNY/cycle	<b>0.026 CNY/pc</b>	0.008 CNY/pc	0.001 CNY/pc	0.150 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.073 min/cycle					0.015 CNY/cycle					
19806	Worker, EG04	Worker	4.404 s/cycle						0.089 CNY/cycle				
19656	Tool	Tool											0.600 CNY/cycle
687	ABS - Re grind	Material	0.002 kg/cycle	0.008 CNY/cycle	0.000 CNY/cycle	0.000 CNY/cycle	<b>0.009 CNY/cycle</b>						
19721	Painting	Process	1.000 cycle/pc					0.191 CNY/cycle	1.007 CNY/cycle	<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	

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0.054 CNY/pc	<b>2.163 CNY/pc</b>	<b>2.169 CNY/pc</b>
0.054 CNY/pc	<b>0.542 CNY/pc</b>	<b>0.549 CNY/pc</b>

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0.215 CNY/cycle	<b>1.415 CNY/cycle</b>	
		<b>0.026 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

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0.054 CNY/pc	<b>3.387 CNY/pc</b>	<b>3.394 CNY/pc</b>
0.054 CNY/pc	<b>1.767 CNY/pc</b>	<b>1.774 CNY/pc</b>

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0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	
		<b>0.014 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

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0.054 CNY/pc	<b>4.295 CNY/pc</b>	<b>4.320 CNY/pc</b>
0.054 CNY/pc	<b>0.731 CNY/pc</b>	<b>0.756 CNY/pc</b>

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0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	
		<b>0.050 CNY/cycle</b>
	<b>3.564 CNY/pc</b>	<b>3.564 CNY/pc</b>

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0.054 CNY/pc	<b>3.665 CNY/pc</b>	<b>3.669 CNY/pc</b>
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0.027 CNY/pc	<b>0.212 CNY/pc</b>	<b>0.214 CNY/pc</b>
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0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	
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		<b>0.009 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

# BoM-Report | Structure

19958	Worker, EG04	Worker	25.000 s/cycle						1.007 CNY/cycle					
20058	Air brush and Painting workstation	Machine	0.417 min/cycle						0.191 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19688	Wiring Harness Drive front	Part	2.000 pc/pc	0.002 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.005 CNY/pc</b>	0.201 CNY/pc	1.066 CNY/pc	<b>2.534 CNY/pc</b>	0.395 CNY/pc	0.051 CNY/pc	0.300 CNY/pc
19846	Injection Molding	Process	0.250 cycle/pc	0.008 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.002 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.069 CNY/pc</b>	0.021 CNY/pc	0.003 CNY/pc	0.150 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle						0.040 CNY/cycle					
20040	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle					
19748	Tool	Tool												0.600 CNY/cycle
687	ABS - Regrind	Material	0.002 kg/cycle	0.008 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.009 CNY/cycle</b>						
19974	Painting	Process	1.000 cycle/pc						0.191 CNY/cycle	1.007 CNY/cycle	<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19822	Worker, EG04	Worker	25.000 s/cycle							1.007 CNY/cycle				
19779	Air brush and Painting workstation	Machine	0.417 min/cycle						0.191 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19615	Wiring Harness Drive side	Part	2.000 pc/pc	0.003 CNY/pc	0.000 CNY/pc		0.000 CNY/pc	<b>0.007 CNY/pc</b>	0.211 CNY/pc	1.127 CNY/pc	<b>2.676 CNY/pc</b>	0.417 CNY/pc	0.054 CNY/pc	0.300 CNY/pc
19931	Injection Molding	Process	0.250 cycle/pc	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.003 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle	<b>0.139 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.150 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle						0.082 CNY/cycle					
20072	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle					
19743	Tool	Tool												0.600 CNY/cycle
687	ABS - Regrind	Material	0.002 kg/cycle	0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	<b>0.014 CNY/cycle</b>						
19646	Painting	Process	1.000 cycle/pc						0.191 CNY/cycle	1.007 CNY/cycle	<b>1.198 CNY/pc</b>	0.374 CNY/pc	0.048 CNY/pc	
19991	Worker, EG04	Worker	25.000 s/cycle							1.007 CNY/cycle				
19775	Air brush and Painting workstation	Machine	0.417 min/cycle						0.191 CNY/cycle					
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19916	Body in white	Assembly	1.000 pc/pc	11.819 CNY/pc	0.675 CNY/pc		0.500 CNY/pc	<b>12.994 CNY/pc</b>	13.971 CNY/pc	27.532 CNY/pc	<b>41.503 CNY/pc</b>	12.949 CNY/pc	1.660 CNY/pc	10.300 CNY/pc
19978	Chassis	Part	1.000 pc/pc	7.872 CNY/pc	0.449 CNY/pc		0.333 CNY/pc	<b>8.654 CNY/pc</b>	4.567 CNY/pc	11.444 CNY/pc	<b>16.011 CNY/pc</b>	4.995 CNY/pc	0.640 CNY/pc	3.000 CNY/pc
19631	Die Casting	Process	0.500 cycle/pc	15.424 CNY/cycle	0.881 CNY/cycle		0.652 CNY/cycle	<b>8.478 CNY/pc</b>	5.838 CNY/cycle	2.716 CNY/cycle	<b>4.277 CNY/pc</b>	1.335 CNY/pc	0.171 CNY/pc	3.000 CNY/pc
19827	Worker, EG04	Worker	67.403 s/cycle							2.716 CNY/cycle				
19871	Tool	Tool												6.000 CNY/cycle
362	Al 99.9	Material	0.846 kg/cycle	15.424 CNY/cycle	0.881 CNY/cycle		0.652 CNY/cycle	<b>16.956 CNY/cycle</b>						
19725	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							5.838 CNY/cycle					
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.562 min/cycle						0.900 CNY/cycle					
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.562 min/cycle						4.939 CNY/cycle					
19707	Drilling	Process	1.000 cycle/pc	0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.000 CNY/pc</b>	0.999 CNY/cycle	6.322 CNY/cycle	<b>7.321 CNY/pc</b>	2.284 CNY/pc	0.293 CNY/pc	
19977	Worker, EG04	Worker	156.876 s/cycle							6.322 CNY/cycle				

0.054 CNY/pc	<b>3.780 CNY/pc</b>	<b>3.784 CNY/pc</b>
0.027 CNY/pc	<b>0.270 CNY/pc</b>	<b>0.272 CNY/pc</b>

0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	<b>0.009 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

0.054 CNY/pc	<b>3.971 CNY/pc</b>	<b>3.978 CNY/pc</b>
0.027 CNY/pc	<b>0.365 CNY/pc</b>	<b>0.369 CNY/pc</b>

0.108 CNY/cycle	<b>0.708 CNY/cycle</b>	<b>0.014 CNY/cycle</b>
	<b>1.620 CNY/pc</b>	<b>1.620 CNY/pc</b>

1.849 CNY/pc	<b>68.261 CNY/pc</b>	<b>81.255 CNY/pc</b>
0.539 CNY/pc	<b>25.185 CNY/pc</b>	<b>33.840 CNY/pc</b>
0.539 CNY/pc	<b>9.321 CNY/pc</b>	<b>17.800 CNY/pc</b>

1.077 CNY/cycle	<b>7.077 CNY/cycle</b>	<b>16.956 CNY/cycle</b>
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	<b>9.898 CNY/pc</b>	<b>9.898 CNY/pc</b>
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# BoM-Report | Structure

6720	CNC Vertical Machining Center   Rotaion speed: < 10,000.00 1/min   parts weight: < 150.00 kg	Machine	2.615 min/cycle					0.999 CNY/cycle						
19927	Drill	Machining Unit												
362	Al 99,9	Material	0.000 kg/cycle	0.000 CNY/cycle	0.000 CNY/cycle									
19759	Polishing	Process	1.000 cycle/pc					0.229 CNY/cycle	1.328 CNY/cycle		<b>1.557 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc	
19754	Worker, EG06	Worker	30.000 s/cycle						1.328 CNY/cycle					
19674	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle						
18139	Polish or clean medium parts	Work Step	30.000 s/cycle											
19907	Painting	Process	1.000 cycle/pc	0.160 CNY/cycle	0.009 CNY/cycle			0.420 CNY/cycle	2.435 CNY/cycle		<b>2.855 CNY/pc</b>	0.891 CNY/pc	0.114 CNY/pc	
19906	Worker, EG06	Worker	55.000 s/cycle						2.435 CNY/cycle					
19997	Air brush and Painting workstation	Machine	0.917 min/cycle					0.420 CNY/cycle						
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19825	Color	Material	0.002 kg/cycle	0.160 CNY/cycle	0.009 CNY/cycle			0.420 CNY/cycle	2.435 CNY/cycle		<b>2.855 CNY/pc</b>	0.891 CNY/pc	0.114 CNY/pc	
19952	Hood	Part	1.000 pc/pc	1.334 CNY/pc	0.076 CNY/pc			2.513 CNY/pc	4.631 CNY/pc		<b>7.144 CNY/pc</b>	2.229 CNY/pc	0.286 CNY/pc	3.000 CNY/pc
19929	Die Casting	Process	0.500 cycle/pc	2.668 CNY/cycle	0.152 CNY/cycle			3.728 CNY/cycle	1.734 CNY/cycle		<b>2.731 CNY/pc</b>	0.852 CNY/pc	0.109 CNY/pc	3.000 CNY/pc
19857	Worker, EG04	Worker	43.038 s/cycle						1.734 CNY/cycle					
19951	Tool	Tool												6.000 CNY/cycle
362	Al 99,9	Material	0.146 kg/cycle	2.668 CNY/cycle	0.152 CNY/cycle			0.420 CNY/cycle	2.435 CNY/cycle		<b>2.855 CNY/pc</b>	0.891 CNY/pc	0.114 CNY/pc	
19909	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell						3.728 CNY/cycle						
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.359 min/cycle					0.574 CNY/cycle						
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.359 min/cycle					3.154 CNY/cycle						
20032	Painting	Process	1.000 cycle/pc					0.420 CNY/cycle	2.435 CNY/cycle		<b>2.855 CNY/pc</b>	0.891 CNY/pc	0.114 CNY/pc	
19797	Worker, EG06	Worker	55.000 s/cycle						2.435 CNY/cycle					
19642	Air brush and Painting workstation	Machine	0.917 min/cycle					0.420 CNY/cycle						
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
18140	Handpaint medium parts	Work Step	25.000 s/cycle											
19803	Polishing	Process	1.000 cycle/pc					0.229 CNY/cycle	1.328 CNY/cycle		<b>1.557 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc	
19781	Worker, EG06	Worker	30.000 s/cycle						1.328 CNY/cycle					
20007	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle						
18139	Polish or clean medium parts	Work Step	30.000 s/cycle											
19708	Hinge hood	Part	1.000 pc/pc	0.097 CNY/pc	0.006 CNY/pc			1.204 CNY/pc	1.330 CNY/pc		<b>2.534 CNY/pc</b>	0.791 CNY/pc	0.101 CNY/pc	0.300 CNY/pc
19855	Die Casting	Process	0.250 cycle/pc	0.389 CNY/cycle	0.022 CNY/cycle			4.256 CNY/cycle	1.980 CNY/cycle		<b>1.559 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc	0.300 CNY/pc
19617	Worker, EG04	Worker	49.140 s/cycle						1.980 CNY/cycle					
19760	Copy of Tool	Tool												1.200 CNY/cycle
362	Al 99,9	Material	0.021 kg/cycle	0.389 CNY/cycle	0.022 CNY/cycle			0.420 CNY/cycle	2.435 CNY/cycle		<b>2.855 CNY/pc</b>	0.891 CNY/pc	0.114 CNY/pc	

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	<b>0.000 CNY/cycle</b>
<b>2.106 CNY/pc</b>	<b>2.106 CNY/pc</b>

<b>3.860 CNY/pc</b>	<b>4.036 CNY/pc</b>

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	<b>0.176 CNY/cycle</b>
0.539 CNY/pc	<b>13.197 CNY/pc</b>
0.539 CNY/pc	<b>14.663 CNY/pc</b>
	<b>7.231 CNY/pc</b>
	<b>8.698 CNY/pc</b>

1.077 CNY/cycle	<b>7.077 CNY/cycle</b>
	<b>2.933 CNY/cycle</b>

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<b>3.860 CNY/pc</b>	<b>3.860 CNY/pc</b>

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<b>2.106 CNY/pc</b>	<b>2.106 CNY/pc</b>
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0.054 CNY/pc	<b>3.780 CNY/pc</b>
0.054 CNY/pc	<b>3.887 CNY/pc</b>
	<b>2.462 CNY/pc</b>
	<b>2.569 CNY/pc</b>

0.215 CNY/cycle	<b>1.415 CNY/cycle</b>
	<b>0.428 CNY/cycle</b>

20065	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell						4.256 CNY/cycle						
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.410 min/cycle					0.656 CNY/cycle						
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.410 min/cycle					3.601 CNY/cycle						
19675	Drilling	Process	1.000 cycle/pc	0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.000 CNY/pc</b>	0.048 CNY/cycle	0.304 CNY/cycle		<b>0.352 CNY/pc</b>	0.110 CNY/pc	0.014 CNY/pc
19647	Worker, EG04	Worker	7.540 s/cycle							0.304 CNY/cycle				
6720	CNC Vertical Machining Center   Rotaion speed: < 10,000.00 1/min   parts weight: < 150.00 kg	Machine	0.126 min/cycle					0.048 CNY/cycle						
19805	Drill	Machining Unit												
362	Al 99,9	Material	0.000 kg/cycle	0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.000 CNY/cycle</b>						
19976	Painting	Process	1.000 cycle/pc						0.092 CNY/cycle	0.531 CNY/cycle		<b>0.623 CNY/pc</b>	0.194 CNY/pc	0.025 CNY/pc
19793	Worker, EG06	Worker	12.000 s/cycle							0.531 CNY/cycle				
20041	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle						
18142	Airbrush small parts	Work Step	12.000 s/cycle											
19621	Under body	Part	1.000 pc/pc	0.285 CNY/pc	0.016 CNY/pc		0.012 CNY/pc	<b>0.314 CNY/pc</b>	0.305 CNY/pc	0.418 CNY/pc		<b>0.722 CNY/pc</b>	0.225 CNY/pc	0.029 CNY/pc
19830	Injection Molding	Process	0.500 cycle/pc	0.571 CNY/cycle	0.033 CNY/cycle		0.024 CNY/cycle	<b>0.314 CNY/pc</b>	0.609 CNY/cycle	0.836 CNY/cycle		<b>0.722 CNY/pc</b>	0.225 CNY/pc	0.029 CNY/pc
19613	Worker, EG04	Worker	41.464 s/cycle							0.836 CNY/cycle				1.000 CNY/pc
19780	Tool													2.000 CNY/cycle
687	ABS - Re grind	Material	0.105 kg/cycle	0.571 CNY/cycle	0.033 CNY/cycle		0.024 CNY/cycle	<b>0.627 CNY/cycle</b>						
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine	0.691 min/cycle						0.609 CNY/cycle					
19614	Swing door	Part	2.000 pc/pc	1.115 CNY/pc	0.064 CNY/pc		0.047 CNY/pc	<b>2.453 CNY/pc</b>	2.691 CNY/pc	4.855 CNY/pc		<b>15.092 CNY/pc</b>	2.354 CNY/pc	0.302 CNY/pc
19676	Die Casting	Process	0.500 cycle/pc	2.230 CNY/cycle	0.127 CNY/cycle		0.094 CNY/cycle	<b>1.226 CNY/pc</b>	4.036 CNY/cycle	1.878 CNY/cycle		<b>2.957 CNY/pc</b>	0.923 CNY/pc	0.118 CNY/pc
19810	Worker, EG04	Worker	46.600 s/cycle							1.878 CNY/cycle				1.500 CNY/pc
19749	Tool													3.000 CNY/cycle
362	Al 99,9	Material	0.122 kg/cycle	2.230 CNY/cycle	0.127 CNY/cycle		0.094 CNY/cycle	<b>2.452 CNY/cycle</b>						
19915	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							4.036 CNY/cycle					
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.388 min/cycle						0.622 CNY/cycle					
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.388 min/cycle						3.414 CNY/cycle					
20075	Drilling	Process	1.000 cycle/pc	0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.000 CNY/pc</b>	0.024 CNY/cycle	0.152 CNY/cycle		<b>0.176 CNY/pc</b>	0.055 CNY/pc	0.007 CNY/pc
19820	Worker, EG04	Worker	3.770 s/cycle							0.152 CNY/cycle				
6720	CNC Vertical Machining Center   Rotaion speed: < 10,000.00 1/min   parts weight: < 150.00 kg	Machine	0.063 min/cycle						0.024 CNY/cycle					

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**0.476 CNY / pc**    **0.476 CNY / pc**

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**0.842 CNY / pc**    **0.842 CNY / pc**

**0.000 CNY / cycle**

**0.180 CNY / pc**    **2.156 CNY / pc**    **2.470 CNY / pc**  
**0.180 CNY / pc**    **2.156 CNY / pc**    **2.470 CNY / pc**

**0.359 CNY / cycle**    **2.359 CNY / cycle**    **0.627 CNY / cycle**

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**0.539 CNY / pc**    **23.942 CNY / pc**    **26.395 CNY / pc**  
**0.269 CNY / pc**    **5.767 CNY / pc**    **6.993 CNY / pc**

**0.539 CNY / cycle**    **3.539 CNY / cycle**    **2.452 CNY / cycle**

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**0.238 CNY / pc**    **0.238 CNY / pc**

19729	Drill	Machining Unit																	
362	Al 99,9	Material	0.000 kg/cycle	0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	<b>0.000 CNY/cycle</b>											
19889	Polishing	Process	1.000 cycle/pc				0.229 CNY/cycle	1.328 CNY/cycle											
19669	Worker, EG06	Worker	30.000 s/cycle					1.328 CNY/cycle											
19761	Air brush and Painting workstation	Machine	0.500 min/cycle				0.229 CNY/cycle												
18139	Polish or clean medium parts	Work Step	30.000 s/cycle																
19607	Painting	Process	1.000 cycle/pc				0.420 CNY/cycle	2.435 CNY/cycle											
19860	Worker, EG06	Worker	55.000 s/cycle					2.435 CNY/cycle											
19752	Air brush and Painting workstation	Machine	0.917 min/cycle				0.420 CNY/cycle												
18138	Airbrush medium parts	Work Step	30.000 s/cycle																
18140	Handpaint medium parts	Work Step	25.000 s/cycle																
20045	Underbody	Assembly	1.000 pc/pc	6.609 CNY/pc	0.377 CNY/pc		0.279 CNY/pc	<b>7.266 CNY/pc</b>	21.084 CNY/pc	37.426 CNY/pc									
19627	Screw base plate	Part	6.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>1.649 CNY/pc</b>											
19823	Screw PT	Material	1.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>0.275 CNY/pc</b>											
19884	Screw under body	Part	8.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>2.199 CNY/pc</b>											
19875	Screw PT	Material	1.000 pc/pc	0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	<b>0.275 CNY/pc</b>											
19990	Fixation axle front	Part	1.000 pc/pc	0.316 CNY/pc	0.018 CNY/pc		0.013 CNY/pc	<b>0.348 CNY/pc</b>	2.378 CNY/pc	3.550 CNY/pc									
19657	Die Casting	Process	0.500 cycle/pc	0.632 CNY/cycle	0.036 CNY/cycle		0.027 CNY/cycle	<b>0.348 CNY/pc</b>	3.839 CNY/cycle	1.786 CNY/cycle									
20066	Worker, EG04	Worker	44.318 s/cycle							1.786 CNY/cycle									
19957	Copy of Tool	Tool																	0.600 CNY/cycle
362	Al 99,9	Material	0.035 kg/cycle	0.632 CNY/cycle	0.036 CNY/cycle		0.027 CNY/cycle	<b>0.695 CNY/cycle</b>											
19788	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							3.839 CNY/cycle										
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.369 min/cycle						0.591 CNY/cycle										
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.369 min/cycle						3.247 CNY/cycle										
19756	Painting	Process	1.000 cycle/pc				0.229 CNY/cycle	1.328 CNY/cycle											
19812	Worker, EG06	Worker	30.000 s/cycle					1.328 CNY/cycle											
19946	Air brush and Painting workstation	Machine	0.500 min/cycle				0.229 CNY/cycle												
18138	Airbrush medium parts	Work Step	30.000 s/cycle																
19859	Polishing	Process	1.000 cycle/pc				0.229 CNY/cycle	1.328 CNY/cycle											
19837	Worker, EG06	Worker	30.000 s/cycle					1.328 CNY/cycle											
19801	Air brush and Painting workstation	Machine	0.500 min/cycle				0.229 CNY/cycle												
18139	Polish or clean medium parts	Work Step	30.000 s/cycle																
19715	Fixation axle rear	Part	1.000 pc/pc	0.316 CNY/pc	0.018 CNY/pc		0.013 CNY/pc	<b>0.348 CNY/pc</b>	2.378 CNY/pc	3.550 CNY/pc									
19692	Die Casting	Process	0.500 cycle/pc	0.632 CNY/cycle	0.036 CNY/cycle		0.027 CNY/cycle	<b>0.348 CNY/pc</b>	3.839 CNY/cycle	1.786 CNY/cycle									
19611	Worker, EG04	Worker	44.318 s/cycle							1.786 CNY/cycle									
19684	Copy of Tool	Tool																	0.600 CNY/cycle
362	Al 99,9	Material	0.035 kg/cycle	0.632 CNY/cycle	0.036 CNY/cycle		0.027 CNY/cycle	<b>0.695 CNY/cycle</b>											
19967	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							3.839 CNY/cycle										

		<b>0.000 CNY / cycle</b>
<b>2.106 CNY / pc</b>		<b>2.106 CNY / pc</b>

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<b>3.860 CNY / pc</b>		<b>3.860 CNY / pc</b>
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0.689 CNY / pc	<b>83.634 CNY / pc</b>	<b>90.900 CNY / pc</b>
		<b>1.649 CNY / pc</b>
		<b>0.275 CNY / pc</b>
		<b>2.199 CNY / pc</b>
		<b>0.275 CNY / pc</b>
0.054 CNY / pc	<b>8.367 CNY / pc</b>	<b>8.715 CNY / pc</b>
0.054 CNY / pc	<b>4.156 CNY / pc</b>	<b>4.504 CNY / pc</b>
0.108 CNY / cycle	<b>0.708 CNY / cycle</b>	
		<b>0.695 CNY / cycle</b>

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<b>2.106 CNY / pc</b>		<b>2.106 CNY / pc</b>
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<b>2.106 CNY / pc</b>		<b>2.106 CNY / pc</b>
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0.054 CNY / pc	<b>8.367 CNY / pc</b>	<b>8.715 CNY / pc</b>
0.054 CNY / pc	<b>4.156 CNY / pc</b>	<b>4.504 CNY / pc</b>
0.108 CNY / cycle	<b>0.708 CNY / cycle</b>	
		<b>0.695 CNY / cycle</b>

# BoM-Report | Structure

83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.369 min/cycle					0.591 CNY/cycle						
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.369 min/cycle					3.247 CNY/cycle						
20018	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.328 CNY/cycle		<b>1.557 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc	
19723	Worker, EG06	Worker	30.000 s/cycle						1.328 CNY/cycle					
19938	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle						
18138	Airbrush medium parts	Work Step	30.000 s/cycle											
19804	Polishing	Process	1.000 cycle/pc					0.229 CNY/cycle	1.328 CNY/cycle		<b>1.557 CNY/pc</b>	0.486 CNY/pc	0.062 CNY/pc	
20033	Worker, EG06	Worker	30.000 s/cycle						1.328 CNY/cycle					
19848	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle						
18139	Polish or clean medium parts	Work Step	30.000 s/cycle											
19854	Wheel suspension	Part	2.000 pc/pc	0.012 CNY/pc	0.001 CNY/pc	0.001 CNY/pc	<b>0.027 CNY/pc</b>	0.010 CNY/pc	0.059 CNY/pc		<b>0.137 CNY/pc</b>	0.021 CNY/pc	0.003 CNY/pc	0.200 CNY/pc
19716	Injection Molding	Process	0.250 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.014 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle		<b>0.069 CNY/pc</b>	0.021 CNY/pc	0.003 CNY/pc	0.100 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle						
19626	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle					
19813	Tool	Tool												0.400 CNY/cycle
687	ABS - Regrind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.054 CNY/cycle</b>							
19726	Shifter hover mode	Part	1.000 pc/pc	0.034 CNY/pc	0.002 CNY/pc	0.001 CNY/pc	<b>0.037 CNY/pc</b>	0.152 CNY/pc	0.209 CNY/pc		<b>0.361 CNY/pc</b>	0.113 CNY/pc	0.014 CNY/pc	0.300 CNY/pc
19699	Injection Molding	Process	0.250 cycle/pc	0.136 CNY/cycle	0.008 CNY/cycle	0.006 CNY/cycle	<b>0.037 CNY/pc</b>	0.609 CNY/cycle	0.836 CNY/cycle		<b>0.361 CNY/pc</b>	0.113 CNY/pc	0.014 CNY/pc	0.300 CNY/pc
19994	Worker, EG04	Worker	41.464 s/cycle						0.836 CNY/cycle					
20057	Tool	Tool												1.200 CNY/cycle
687	ABS - Regrind	Material	0.025 kg/cycle	0.136 CNY/cycle	0.008 CNY/cycle	0.006 CNY/cycle	<b>0.150 CNY/cycle</b>							
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine	0.691 min/cycle					0.609 CNY/cycle						
19663	Assy wheel Suspension	Part	4.000 pc/pc	0.487 CNY/pc	0.028 CNY/pc	0.021 CNY/pc	<b>2.140 CNY/pc</b>	3.304 CNY/pc	5.469 CNY/pc		<b>35.091 CNY/pc</b>	2.737 CNY/pc	0.351 CNY/pc	1.100 CNY/pc
20059	Grouping (Piece)	Grouping		0.487 CNY/pc	0.028 CNY/pc	0.021 CNY/pc	<b>0.535 CNY/pc</b>	3.304 CNY/pc	5.469 CNY/pc		<b>8.773 CNY/pc</b>	2.737 CNY/pc	0.351 CNY/pc	0.275 CNY/pc
20022	Wheel joint	Part	1.000 pc/pc	0.004 CNY/pc	0.000 CNY/pc	0.000 CNY/pc	<b>0.005 CNY/pc</b>	0.020 CNY/pc	0.119 CNY/pc		<b>0.139 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.050 CNY/pc
19736	Injection Molding	Process	0.250 cycle/pc	0.017 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.005 CNY/pc</b>	0.082 CNY/cycle	0.476 CNY/cycle		<b>0.139 CNY/pc</b>	0.044 CNY/pc	0.006 CNY/pc	0.050 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.394 min/cycle					0.082 CNY/cycle						
19831	Worker, EG04	Worker	23.636 s/cycle						0.476 CNY/cycle					
19764	Tool	Tool												0.200 CNY/cycle
687	ABS - Regrind	Material	0.003 kg/cycle	0.017 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	<b>0.018 CNY/cycle</b>							
20024	Connector	Part	1.000 pc/pc	0.300 CNY/pc	0.017 CNY/pc	0.013 CNY/pc	<b>0.330 CNY/pc</b>							
19653	Connector	Material	1.000 pc/pc	0.300 CNY/pc	0.017 CNY/pc	0.013 CNY/pc	<b>0.330 CNY/pc</b>							
19930	Drive shaft	Part	1.000 pc/pc	0.024 CNY/pc	0.001 CNY/pc	0.001 CNY/pc	<b>0.027 CNY/pc</b>	1.045 CNY/pc	0.975 CNY/pc		<b>2.020 CNY/pc</b>	0.630 CNY/pc	0.081 CNY/pc	0.075 CNY/pc
19841	Die Casting	Process	0.250 cycle/pc	0.097 CNY/cycle	0.006 CNY/cycle	0.004 CNY/cycle	<b>0.027 CNY/pc</b>	3.812 CNY/cycle	1.774 CNY/cycle		<b>1.397 CNY/pc</b>	0.436 CNY/pc	0.056 CNY/pc	0.075 CNY/pc
19872	Worker, EG04	Worker	44.014 s/cycle						1.774 CNY/cycle					
19807	Copy of Tool	Tool												0.300 CNY/cycle
362	AI 99,9	Material	0.005 kg/cycle	0.097 CNY/cycle	0.006 CNY/cycle	0.004 CNY/cycle	<b>0.107 CNY/cycle</b>							

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<b>2.106 CNY / pc</b>	<b>2.106 CNY / pc</b>
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<b>2.106 CNY / pc</b>	<b>2.106 CNY / pc</b>
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0.036 CNY / pc	<b>0.421 CNY / pc</b>	<b>0.448 CNY / pc</b>
0.018 CNY / pc	<b>0.211 CNY / pc</b>	<b>0.224 CNY / pc</b>

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0.072 CNY / cycle	<b>0.472 CNY / cycle</b>	
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0.054 CNY / pc	<b>0.842 CNY / pc</b>	<b>0.880 CNY / pc</b>
0.054 CNY / pc	<b>0.842 CNY / pc</b>	<b>0.880 CNY / pc</b>

0.215 CNY / cycle	<b>1.415 CNY / cycle</b>	
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	<b>0.150 CNY / cycle</b>
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0.197 CNY / pc	<b>48.740 CNY / pc</b>	<b>50.880 CNY / pc</b>
0.049 CNY / pc	<b>12.185 CNY / pc</b>	<b>12.720 CNY / pc</b>
0.009 CNY / pc	<b>0.248 CNY / pc</b>	<b>0.252 CNY / pc</b>
0.009 CNY / pc	<b>0.248 CNY / pc</b>	<b>0.252 CNY / pc</b>

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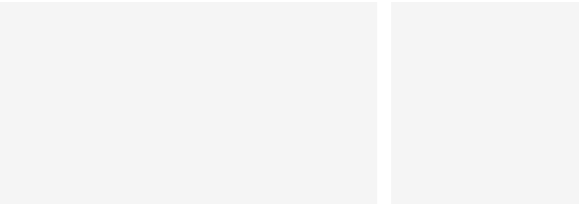
0.036 CNY / cycle	<b>0.236 CNY / cycle</b>	
	<b>0.018 CNY / cycle</b>	
	<b>0.330 CNY / pc</b>	
	<b>0.330 CNY / pc</b>	

0.013 CNY / pc	<b>2.819 CNY / pc</b>	<b>2.846 CNY / pc</b>
0.013 CNY / pc	<b>1.977 CNY / pc</b>	<b>2.003 CNY / pc</b>

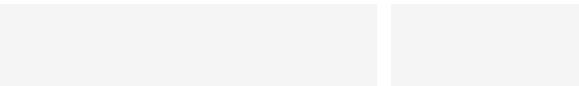
0.054 CNY / cycle	<b>0.354 CNY / cycle</b>	
	<b>0.107 CNY / cycle</b>	



19932	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							3.812 CNY/cycle					
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.367 min/cycle						0.587 CNY/cycle					
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.367 min/cycle						3.225 CNY/cycle					
20000	Painting	Process	1.000 cycle/pc						0.092 CNY/cycle	0.531 CNY/cycle	<b>0.623 CNY/pc</b>	0.194 CNY/pc	0.025 CNY/pc	
19757	Worker, EG06	Worker	12.000 s/cycle							0.531 CNY/cycle				
19910	Air brush and Painting workstation	Machine	0.200 min/cycle						0.092 CNY/cycle					
18142	Airbrush small parts	Work Step	12.000 s/cycle											
19769	Lower strut	Part	1.000 pc/pc	0.061 CNY/pc	0.003 CNY/pc	0.003 CNY/pc	<b>0.067 CNY/pc</b>	1.000 CNY/pc	0.954 CNY/pc		<b>1.954 CNY/pc</b>	0.610 CNY/pc	0.078 CNY/pc	0.075 CNY/pc
19662	Die Casting	Process	0.250 cycle/pc	0.243 CNY/cycle	0.014 CNY/cycle	0.010 CNY/cycle	<b>0.067 CNY/pc</b>	3.634 CNY/cycle	1.691 CNY/cycle		<b>1.331 CNY/pc</b>	0.415 CNY/pc	0.053 CNY/pc	0.075 CNY/pc
19787	Worker, EG04	Worker	41.954 s/cycle						1.691 CNY/cycle					
19811	Copy of Tool	Tool												0.300 CNY/cycle
362	Al 99,9	Material	0.013 kg/cycle	0.243 CNY/cycle	0.014 CNY/cycle	0.010 CNY/cycle	<b>0.267 CNY/cycle</b>							
19942	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							3.634 CNY/cycle					
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.350 min/cycle						0.560 CNY/cycle					
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.350 min/cycle						3.074 CNY/cycle					
19981	Painting	Process	1.000 cycle/pc						0.092 CNY/cycle	0.531 CNY/cycle	<b>0.623 CNY/pc</b>	0.194 CNY/pc	0.025 CNY/pc	
19982	Worker, EG06	Worker	12.000 s/cycle							0.531 CNY/cycle				
19944	Air brush and Painting workstation	Machine	0.200 min/cycle						0.092 CNY/cycle					
18142	Airbrush small parts	Work Step	12.000 s/cycle											
19643	Upper strut	Part	1.000 pc/pc	0.097 CNY/pc	0.006 CNY/pc	0.004 CNY/pc	<b>0.107 CNY/pc</b>	1.106 CNY/pc	1.003 CNY/pc		<b>2.109 CNY/pc</b>	0.658 CNY/pc	0.084 CNY/pc	0.075 CNY/pc
20039	Die Casting	Process	0.250 cycle/pc	0.389 CNY/cycle	0.022 CNY/cycle	0.016 CNY/cycle	<b>0.107 CNY/pc</b>	4.056 CNY/cycle	1.887 CNY/cycle		<b>1.486 CNY/pc</b>	0.464 CNY/pc	0.059 CNY/pc	0.075 CNY/pc
19800	Worker, EG04	Worker	46.822 s/cycle						1.887 CNY/cycle					
19985	Copy of Tool	Tool												0.300 CNY/cycle
362	Al 99,9	Material	0.021 kg/cycle	0.389 CNY/cycle	0.022 CNY/cycle	0.016 CNY/cycle	<b>0.428 CNY/cycle</b>							

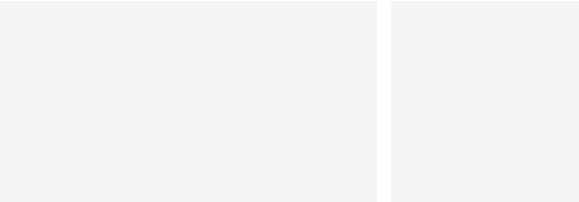


0.842 CNY/pc    0.842 CNY/pc



0.013 CNY/pc    **2.730 CNY/pc**    2.797 CNY/pc  
0.013 CNY/pc    **1.888 CNY/pc**    1.955 CNY/pc

0.054 CNY/cycle    **0.354 CNY/cycle**  
0.267 CNY/cycle



0.842 CNY/pc    0.842 CNY/pc



0.013 CNY/pc    **2.939 CNY/pc**    3.046 CNY/pc  
0.013 CNY/pc    **2.097 CNY/pc**    2.204 CNY/pc

0.054 CNY/cycle    **0.354 CNY/cycle**  
0.428 CNY/cycle

19989	Cold chamber die-casting machine (Mg; Al)   clamp force: 2.600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell						4.056 CNY/cycle							
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2.600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine	0.390 min/cycle					0.625 CNY/cycle							
6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine	0.390 min/cycle					3.431 CNY/cycle							
19682	Painting	Process	1.000 cycle/pc					0.092 CNY/cycle	0.531 CNY/cycle	<b>0.623 CNY/pc</b>	0.194 CNY/pc	0.025 CNY/pc			
19828	Worker, EG06	Worker	12.000 s/cycle						0.531 CNY/cycle						
19816	Air brush and Painting workstation	Machine	0.200 min/cycle					0.092 CNY/cycle							
18142	Airbrush small parts	Work Step	12.000 s/cycle												
19740	Assembly	Process	1.000 cycle/pc					0.133 CNY/cycle	2.418 CNY/cycle	<b>2.551 CNY/pc</b>	0.796 CNY/pc	0.102 CNY/pc			
19670	Worker, EG04	Worker	60.000 s/cycle						2.418 CNY/cycle						
63	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Machine	1.000 min/cycle					0.133 CNY/cycle							
19799	Rim front	Part	2.000 pc/pc	0.019 CNY/pc	0.001 CNY/pc	0.001 CNY/pc	<b>0.042 CNY/pc</b>	0.249 CNY/pc	1.326 CNY/pc	<b>3.150 CNY/pc</b>	0.491 CNY/pc	0.063 CNY/pc	0.000 CNY/pc	0.400 CNY/pc	
20005	Injection Molding	Process	0.500 cycle/pc	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	<b>0.021 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.137 CNY/pc</b>	0.043 CNY/pc	0.005 CNY/pc		0.200 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle							
19814	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle						
19770	Tool	Tool												0.400 CNY/cycle	
687	ABS - Regrind	Material	0.007 kg/cycle	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	<b>0.042 CNY/cycle</b>								
19955	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.209 CNY/cycle	<b>1.438 CNY/pc</b>	0.449 CNY/pc	0.058 CNY/pc			
19734	Worker, EG04	Worker	30.000 s/cycle						1.209 CNY/cycle						
19912	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle							
18138	Airbrush medium parts	Work Step	30.000 s/cycle												
19771	Glue	Special Direct Cost	0.000 CNY/pc										0.000 CNY/pc		
19695	Rim rear	Part	2.000 pc/pc	0.025 CNY/pc	0.001 CNY/pc	0.001 CNY/pc	<b>0.054 CNY/pc</b>	0.249 CNY/pc	1.326 CNY/pc	<b>3.150 CNY/pc</b>	0.491 CNY/pc	0.063 CNY/pc	0.000 CNY/pc	0.400 CNY/pc	
19890	Injection Molding	Process	0.500 cycle/pc	0.049 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.027 CNY/pc</b>	0.040 CNY/cycle	0.234 CNY/cycle	<b>0.137 CNY/pc</b>	0.043 CNY/pc	0.005 CNY/pc		0.200 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine	0.194 min/cycle					0.040 CNY/cycle							
20044	Worker, EG04	Worker	11.616 s/cycle						0.234 CNY/cycle						
19782	Tool	Tool												0.400 CNY/cycle	
687	ABS - Regrind	Material	0.009 kg/cycle	0.049 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	<b>0.054 CNY/cycle</b>								
20035	Painting	Process	1.000 cycle/pc					0.229 CNY/cycle	1.209 CNY/cycle	<b>1.438 CNY/pc</b>	0.449 CNY/pc	0.058 CNY/pc			
19608	Worker, EG04	Worker	30.000 s/cycle						1.209 CNY/cycle						
19835	Air brush and Painting workstation	Machine	0.500 min/cycle					0.229 CNY/cycle							
18138	Airbrush medium parts	Work Step	30.000 s/cycle												

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0.842 CNY / pc    0.842 CNY / pc

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3.449 CNY / pc    3.449 CNY / pc

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0.072 CNY / pc	<b>4.731 CNY / pc</b>	<b>4.773 CNY / pc</b>
0.036 CNY / pc	<b>0.421 CNY / pc</b>	<b>0.442 CNY / pc</b>

0.072 CNY / cycle	<b>0.472 CNY / cycle</b>	
		<b>0.042 CNY / cycle</b>
	<b>1.944 CNY / pc</b>	<b>1.944 CNY / pc</b>

	<b>0.000 CNY / pc</b>

0.072 CNY / pc	<b>4.731 CNY / pc</b>	<b>4.785 CNY / pc</b>
0.036 CNY / pc	<b>0.421 CNY / pc</b>	<b>0.448 CNY / pc</b>

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0.072 CNY / cycle	<b>0.472 CNY / cycle</b>	
		<b>0.054 CNY / cycle</b>
	<b>1.944 CNY / pc</b>	<b>1.944 CNY / pc</b>

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**BoM-Report | Structure**

	<b>0.000 CNY / pc</b>	
0.072 CNY / pc	<b>3.233 CNY / pc</b>	<b>3.374 CNY / pc</b>
		<b>0.070 CNY / pc</b>
0.036 CNY / pc	<b>1.617 CNY / pc</b>	<b>1.617 CNY / pc</b>
0.072 CNY / cycle	<b>0.472 CNY / cycle</b>	
0.079 CNY / pc	<b>4.201 CNY / pc</b>	<b>4.482 CNY / pc</b>
		<b>0.141 CNY / pc</b>
0.039 CNY / pc	<b>2.100 CNY / pc</b>	<b>2.100 CNY / pc</b>
0.079 CNY / cycle	<b>0.519 CNY / cycle</b>	
	<b>29.755 CNY / pc</b>	<b>29.755 CNY / pc</b>
	<b>16.790 CNY / pc</b>	<b>16.790 CNY / pc</b>
	<b>2.574 CNY / pc</b>	<b>2.574 CNY / pc</b>
	<b>9.994 CNY / pc</b>	<b>9.994 CNY / pc</b>
	<b>0.398 CNY / pc</b>	<b>0.398 CNY / pc</b>
0.215 CNY / pc	<b>7.525 CNY / pc</b>	<b>27.983 CNY / pc</b>
	<b>4.359 CNY / pc</b>	<b>4.359 CNY / pc</b>
		<b>17.590 CNY / pc</b>
		<b>1.319 CNY / pc</b>
0.215 CNY / pc	<b>3.166 CNY / pc</b>	<b>3.836 CNY / pc</b>
0.215 CNY / pc	<b>3.166 CNY / pc</b>	<b>3.836 CNY / pc</b>



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0.215 CNY/cycle	1.415 CNY/cycle	
		0.670 CNY/cycle
		0.880 CNY/pc
8.846 CNY/pc		



Auto ID	Mat. Type	Label	Procurem. Type	Ext. Provided	Direct. Buy	Price/Unit	Ref.Price/Unit	Gross Quantity	Net Quantity	% Mat. Scrap	DMatC RM	DMatC PM	DMatC	Mat. OHD	Mat. Refund	Mat. ScrapC	MatC
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.011 kg/cycle	0.010 kg/cycle	4.000 %	0.060 CNY/cycle		0.060 CNY/cycle	0.003 CNY/cycle		0.003 CNY/cycle	0.066 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle		0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.054 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.007 kg/cycle	0.006 kg/cycle	4.000 %	0.038 CNY/cycle		0.038 CNY/cycle	0.002 CNY/cycle		0.002 CNY/cycle	0.042 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle		0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.054 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.057 kg/cycle	0.056 kg/cycle	4.000 %	0.310 CNY/cycle		0.310 CNY/cycle	0.018 CNY/cycle		0.013 CNY/cycle	0.341 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle		0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.054 CNY/cycle
974	Raw Material	PVC-h - Regrind	External Buy			0.530 EUR/kg		0.003 kg/cycle	0.002 kg/cycle	4.000 %	0.014 CNY/cycle		0.014 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.015 CNY/cycle
19920	Raw Material	Sticker Tag	External Buy			0.250 CNY/pc		1.000 pc/pc	1.000 pc/pc	4.000 %	0.250 CNY/pc		0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	0.275 CNY/pc
974	Raw Material	PVC-h - Regrind	External Buy			0.530 EUR/kg		0.004 kg/cycle	0.002 kg/cycle	4.000 %	0.016 CNY/cycle		0.016 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.017 CNY/cycle
974	Raw Material	PVC-h - Regrind	External Buy			0.530 EUR/kg		0.003 kg/cycle	0.002 kg/cycle	4.000 %	0.010 CNY/cycle		0.010 CNY/cycle	0.001 CNY/cycle		0.000 CNY/cycle	0.011 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.001 kg/cycle	0.001 kg/cycle	4.000 %	0.007 CNY/cycle		0.007 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.008 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.001 kg/cycle	0.001 kg/cycle	4.000 %	0.007 CNY/cycle		0.007 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.008 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.004 kg/cycle	0.004 kg/cycle	4.000 %	0.023 CNY/cycle		0.023 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.025 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle		0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.054 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.004 kg/cycle	0.004 kg/cycle	4.000 %	0.023 CNY/cycle		0.023 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.025 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.001 kg/cycle	0.001 kg/cycle	4.000 %	0.005 CNY/cycle		0.005 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.005 CNY/cycle
974	Raw Material	PVC-h - Regrind	External Buy			0.530 EUR/kg		0.011 kg/cycle	0.010 kg/cycle	4.000 %	0.047 CNY/cycle		0.047 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.052 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.003 kg/cycle	0.002 kg/cycle	4.000 %	0.017 CNY/cycle		0.017 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.018 CNY/cycle
974	Raw Material	PVC-h - Regrind	External Buy			0.530 EUR/kg		0.003 kg/cycle	0.002 kg/cycle	4.000 %	0.014 CNY/cycle		0.014 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.015 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.004 kg/cycle	0.004 kg/cycle	4.000 %	0.024 CNY/cycle		0.024 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.026 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.007 kg/cycle	0.006 kg/cycle	4.000 %	0.038 CNY/cycle		0.038 CNY/cycle	0.002 CNY/cycle		0.002 CNY/cycle	0.042 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.001 kg/cycle	0.001 kg/cycle	4.000 %	0.008 CNY/cycle		0.008 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.008 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.052 kg/cycle	0.050 kg/cycle	4.000 %	0.283 CNY/cycle		0.283 CNY/cycle	0.016 CNY/cycle		0.012 CNY/cycle	0.311 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.051 CNY/cycle		0.051 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.057 CNY/cycle
19789	Raw Material	Sticker Mirror	External Buy			0.200 CNY/pc		1.000 pc/pc	1.000 pc/pc	4.000 %	0.200 CNY/pc		0.200 CNY/pc	0.011 CNY/pc		0.008 CNY/pc	0.220 CNY/pc
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.002 kg/cycle	4.000 %	0.013 CNY/cycle		0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.014 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.033 kg/cycle	0.030 kg/cycle	4.000 %	0.596 CNY/cycle		0.596 CNY/cycle	0.034 CNY/cycle		0.025 CNY/cycle	0.655 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle		0.049 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.054 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.010 kg/cycle	0.009 kg/cycle	4.000 %	0.055 CNY/cycle		0.055 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.060 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.011 kg/cycle	0.010 kg/cycle	4.000 %	0.060 CNY/cycle		0.060 CNY/cycle	0.003 CNY/cycle		0.003 CNY/cycle	0.066 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.007 kg/cycle	0.006 kg/cycle	4.000 %	0.038 CNY/cycle		0.038 CNY/cycle	0.002 CNY/cycle		0.002 CNY/cycle	0.042 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.025 kg/cycle	0.024 kg/cycle	4.000 %	0.136 CNY/cycle		0.136 CNY/cycle	0.008 CNY/cycle		0.006 CNY/cycle	0.150 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.051 CNY/cycle		0.051 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.057 CNY/cycle
19792	Raw Material	Screw PT	External Buy			0.250 CNY/pc		1.000 pc/pc	1.000 pc/pc	4.000 %	0.250 CNY/pc		0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	0.275 CNY/pc
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.005 kg/cycle	0.004 kg/cycle	4.000 %	0.028 CNY/cycle		0.028 CNY/cycle	0.002 CNY/cycle		0.001 CNY/cycle	0.030 CNY/cycle
20014	Raw Material	Sticker	External Buy			0.200 CNY/pc		1.000 pc/pc	1.000 pc/pc	4.000 %	0.200 CNY/pc		0.200 CNY/pc	0.011 CNY/pc		0.008 CNY/pc	0.220 CNY/pc
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.003 kg/cycle	0.002 kg/cycle	4.000 %	0.017 CNY/cycle		0.017 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.018 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.002 kg/cycle	4.000 %	0.013 CNY/cycle		0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.014 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.002 kg/cycle	4.000 %	0.013 CNY/cycle		0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.014 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.004 kg/cycle	0.004 kg/cycle	4.000 %	0.024 CNY/cycle		0.024 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.026 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.002 kg/cycle	4.000 %	0.013 CNY/cycle		0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.014 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.008 kg/cycle	0.008 kg/cycle	4.000 %	0.045 CNY/cycle		0.045 CNY/cycle	0.003 CNY/cycle		0.002 CNY/cycle	0.050 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.001 kg/cycle	4.000 %	0.008 CNY/cycle		0.008 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.009 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.001 kg/cycle	4.000 %	0.008 CNY/cycle		0.008 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.009 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.002 kg/cycle	0.002 kg/cycle	4.000 %	0.013 CNY/cycle		0.013 CNY/cycle	0.001 CNY/cycle		0.001 CNY/cycle	0.014 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.846 kg/cycle	0.814 kg/cycle	4.000 %	15.424 CNY/cycle		15.424 CNY/cycle	0.881 CNY/cycle		0.652 CNY/cycle	16.956 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.000 kg/cycle	0.000 kg/cycle	4.000 %	0.000 CNY/cycle		0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.000 CNY/cycle
19825	Raw Material	Color	External Buy			80.000 CNY/kg		0.002 kg/cycle	2.000 g/cycle	4.000 %	0.160 CNY/cycle		0.160 CNY/cycle	0.009 CNY/cycle		0.007 CNY/cycle	0.176 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.146 kg/cycle	0.114 kg/cycle	4.000 %	2.668 CNY/cycle		2.668 CNY/cycle	0.152 CNY/cycle		0.113 CNY/cycle	2.933 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.021 kg/cycle	0.020 kg/cycle	4.000 %	0.389 CNY/cycle		0.389 CNY/cycle	0.022 CNY/cycle		0.016 CNY/cycle	0.428 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.000 kg/cycle	0.000 kg/cycle	4.000 %	0.000 CNY/cycle		0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.000 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy			0.700 EUR/kg		0.105 kg/cycle	0.104 kg/cycle	4.000 %	0.571 CNY/cycle		0.571 CNY/cycle	0.033 CNY/cycle		0.024 CNY/cycle	0.627 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.122 kg/cycle	0.090 kg/cycle	4.000 %	2.230 CNY/cycle		2.230 CNY/cycle	0.127 CNY/cycle		0.094 CNY/cycle	2.452 CNY/cycle
362	Raw Material	Al 99,9	External Buy			2.349 EUR/kg		0.000 kg/cycle	0.000 kg/cycle	4.000 %	0.000 CNY/cycle		0.000 CNY/cycle	0.000 CNY/cycle		0.000 CNY/cycle	0.000 CNY/cycle
19823	Raw Material	Screw PT	External Buy			0.250 CNY/pc		1.000 pc/pc	1.000 pc/pc	4.000 %	0.250 CNY/pc		0.250 CNY/pc	0.014 CNY/pc		0.011 CNY/pc	0.275 CNY/pc



19875	Raw Material	Screw PT	External Buy	0.250 CNY/pc	1.000 pc/pc	1.000 pc/pc	4.000 %	0.250 CNY/pc	0.250 CNY/pc	0.014 CNY/pc	0.011 CNY/pc	0.275 CNY/pc
362	Raw Material	Al 99,9	External Buy	2.349 EUR/kg	0.035 kg/cycle	0.032 kg/cycle	4.000 %	0.632 CNY/cycle	0.632 CNY/cycle	0.036 CNY/cycle	0.027 CNY/cycle	0.695 CNY/cycle
362	Raw Material	Al 99,9	External Buy	2.349 EUR/kg	0.035 kg/cycle	0.032 kg/cycle	4.000 %	0.632 CNY/cycle	0.632 CNY/cycle	0.036 CNY/cycle	0.027 CNY/cycle	0.695 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy	0.700 EUR/kg	0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle	0.049 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	0.054 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy	0.700 EUR/kg	0.025 kg/cycle	0.024 kg/cycle	4.000 %	0.136 CNY/cycle	0.136 CNY/cycle	0.008 CNY/cycle	0.006 CNY/cycle	0.150 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy	0.700 EUR/kg	0.003 kg/cycle	0.002 kg/cycle	4.000 %	0.017 CNY/cycle	0.017 CNY/cycle	0.001 CNY/cycle	0.001 CNY/cycle	0.018 CNY/cycle
19653	Raw Material	Connector	External Buy	0.300 CNY/pc	1.000 pc/pc	1.000 pc/pc	4.000 %	0.300 CNY/pc	0.300 CNY/pc	0.017 CNY/pc	0.013 CNY/pc	0.330 CNY/pc
362	Raw Material	Al 99,9	External Buy	2.349 EUR/kg	0.005 kg/cycle	0.004 kg/cycle	4.000 %	0.097 CNY/cycle	0.097 CNY/cycle	0.006 CNY/cycle	0.004 CNY/cycle	0.107 CNY/cycle
362	Raw Material	Al 99,9	External Buy	2.349 EUR/kg	0.013 kg/cycle	0.012 kg/cycle	4.000 %	0.243 CNY/cycle	0.243 CNY/cycle	0.014 CNY/cycle	0.010 CNY/cycle	0.267 CNY/cycle
362	Raw Material	Al 99,9	External Buy	2.349 EUR/kg	0.021 kg/cycle	0.020 kg/cycle	4.000 %	0.389 CNY/cycle	0.389 CNY/cycle	0.022 CNY/cycle	0.016 CNY/cycle	0.428 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy	0.700 EUR/kg	0.007 kg/cycle	0.006 kg/cycle	4.000 %	0.038 CNY/cycle	0.038 CNY/cycle	0.002 CNY/cycle	0.002 CNY/cycle	0.042 CNY/cycle
687	Raw Material	ABS - Regrind	External Buy	0.700 EUR/kg	0.009 kg/cycle	0.008 kg/cycle	4.000 %	0.049 CNY/cycle	0.049 CNY/cycle	0.003 CNY/cycle	0.002 CNY/cycle	0.054 CNY/cycle
20011	Raw Material	Rubber	External Buy	16.000 CNY/kg	0.004 kg/pc	4.000 g/pc	4.000 %	0.064 CNY/pc	0.064 CNY/pc	0.004 CNY/pc	0.003 CNY/pc	0.070 CNY/pc
19753	Raw Material	Rubber	External Buy	16.000 CNY/kg	0.008 kg/pc	8.000 g/pc	4.000 %	0.128 CNY/pc	0.128 CNY/pc	0.007 CNY/pc	0.005 CNY/pc	0.141 CNY/pc
19879	Raw Material	Box	External Buy	16.000 CNY/pc	1.000 pc/pc	1.000 pc/pc	4.000 %	16.000 CNY/pc	16.000 CNY/pc	0.914 CNY/pc	0.677 CNY/pc	17.590 CNY/pc
19603	Raw Material	Screw PT	External Buy	0.300 CNY/pc	4.000 pc/pc	4.000 pc/pc	4.000 %	1.200 CNY/pc	1.200 CNY/pc	0.069 CNY/pc	0.051 CNY/pc	1.319 CNY/pc
687	Raw Material	ABS - Regrind	External Buy	0.700 EUR/kg	0.112 kg/cycle	0.110 kg/cycle	4.000 %	0.609 CNY/cycle	0.609 CNY/cycle	0.035 CNY/cycle	0.026 CNY/cycle	0.670 CNY/cycle
19660	Raw Material	Sticker	External Buy	0.800 CNY/pc	1.000 pc/pc	1.000 pc/pc	4.000 %	0.800 CNY/pc	0.800 CNY/pc	0.046 CNY/pc	0.034 CNY/pc	0.880 CNY/pc



Auto ID	Label	Signature Name	Cycle Time	Output / Cycle	Setup Time	Relevant Batch Size	# Workers	Labor Rate	LabC	MachCR	MachCR Setup	MachC	MachC Setup	Alloc. MaintC. Tools + Fixtures	ManC I	Man. OHD	Man. Scrap Rate	Man. ScrapC
19895	Assembly	Process	11.000 min/cycle	1.000 pc/cycle					8.866 CNY/cycle			4.388 CNY/cycle			13.254 CNY/pc	4.135 CNY/pc	4.000 %	0.530 CNY/pc
19644	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Manufacturing Cell										4.388 CNY/cycle						
20001	Worker, EG04	Worker					1	145.079 CNY/h	8.866 CNY/cycle									
19898	Injection Molding	Process	40.464 s/cycle	2.000 pc/cycle					0.815 CNY/cycle			0.140 CNY/cycle			0.478 CNY/pc	0.149 CNY/pc	4.000 %	0.019 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine								12.427 CNY/h	12.427 CNY/h	0.140 CNY/cycle						
687	ABS - Re grind	Material																
19649	Tool	Tool																
19836	Worker, EG04	Worker					0,5	145.079 CNY/h	0.815 CNY/cycle									
19738	Painting	Process	25.000 s/cycle	1.000 pc/cycle					1.007 CNY/cycle			0.191 CNY/cycle			1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19964	Air brush and Painting workstation	Machine								27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle						
19648	Worker, EG04	Worker					1	145.079 CNY/h	1.007 CNY/cycle									
18140	Handpaint medium parts	Work Step																
19802	Injection Molding	Process	40.464 s/cycle	4.000 pc/cycle					0.815 CNY/cycle			0.140 CNY/cycle			0.239 CNY/pc	0.074 CNY/pc	4.000 %	0.010 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine								12.427 CNY/h	12.427 CNY/h	0.140 CNY/cycle						
687	ABS - Re grind	Material																
19970	Tool	Tool																
20017	Worker, EG04	Worker					0,5	145.079 CNY/h	0.815 CNY/cycle									
19892	Painting	Process	12.000 s/cycle	1.000 pc/cycle					0.484 CNY/cycle			0.092 CNY/cycle			0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
20030	Air brush and Painting workstation	Machine								27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle						
20049	Worker, EG04	Worker					1	145.079 CNY/h	0.484 CNY/cycle									
18142	Airbrush small parts	Work Step																
19885	Injection Molding	Process	23.636 s/cycle	2.000 pc/cycle					0.476 CNY/cycle			0.082 CNY/cycle			0.279 CNY/pc	0.087 CNY/pc	4.000 %	0.011 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine								12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle						
687	ABS - Re grind	Material																
20043	Tool	Tool																
20002	Worker, EG04	Worker					0,5	145.079 CNY/h	0.476 CNY/cycle									
20056	Injection Molding	Process	40.464 s/cycle	2.000 pc/cycle					0.815 CNY/cycle			0.140 CNY/cycle			0.478 CNY/pc	0.149 CNY/pc	4.000 %	0.019 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine								12.427 CNY/h	12.427 CNY/h	0.140 CNY/cycle						
687	ABS - Re grind	Material																
19928	Tool	Tool																
19911	Worker, EG04	Worker					0,5	145.079 CNY/h	0.815 CNY/cycle									
19635	Painting	Process	25.000 s/cycle	1.000 pc/cycle					1.007 CNY/cycle			0.191 CNY/cycle			1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19939	Air brush and Painting workstation	Machine								27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle						
19673	Worker, EG04	Worker					1	145.079 CNY/h	1.007 CNY/cycle									
18140	Handpaint medium parts	Work Step																
19768	Injection Molding	Process	41.464 s/cycle	4.000 pc/cycle					0.836 CNY/cycle			0.609 CNY/cycle			0.361 CNY/pc	0.113 CNY/pc	4.000 %	0.014 CNY/pc
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine								52.908 CNY/h	52.908 CNY/h	0.609 CNY/cycle						
687	ABS - Re grind	Material																
19679	Tool	Tool																
19619	Worker, EG04	Worker					0,5	145.079 CNY/h	0.836 CNY/cycle									

SD ManC	Alloc. Investment Cost Tools + Fixtures	Alloc. Imp. Interest Tools + Fixtures	ManC II
			17.919 CNY/pc
	0.300 CNY/pc	0.054 CNY/pc	0.999 CNY/pc
	0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle
			1.620 CNY/pc
	0.200 CNY/pc	0.036 CNY/pc	0.559 CNY/pc
	0.800 CNY/cycle	0.144 CNY/cycle	0.944 CNY/cycle
			0.778 CNY/pc
	0.300 CNY/pc	0.054 CNY/pc	0.731 CNY/pc
	0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle
	0.300 CNY/pc	0.054 CNY/pc	0.999 CNY/pc
	0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle
			1.620 CNY/pc
	0.200 CNY/pc	0.036 CNY/pc	0.724 CNY/pc
	0.800 CNY/cycle	0.144 CNY/cycle	0.944 CNY/cycle

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20053	Painting	Process	25.000 s/cycle	1.000 pc/cycle		1.007 CNY/cycle		0.191 CNY/cycle	1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19969	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle			
19704	Worker, EG04	Worker			1	145.079 CNY/h	1.007 CNY/cycle					
18140	Handpaint medium parts	Work Step										
20006	Injection Molding	Process	40.464 s/cycle	4.000 pc/cycle		0.815 CNY/cycle		0.140 CNY/cycle	0.239 CNY/pc	0.074 CNY/pc	4.000 %	0.010 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.140 CNY/cycle			
687	ABS - Re grind	Material										
19711	Tool	Tool										
19731	Worker, EG04	Worker			0,5	145.079 CNY/h	0.815 CNY/cycle					
19894	Painting	Process	25.000 s/cycle	1.000 pc/cycle		1.007 CNY/cycle		0.191 CNY/cycle	1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19751	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle			
19896	Worker, EG04	Worker			1	145.079 CNY/h	1.007 CNY/cycle					
18140	Handpaint medium parts	Work Step										
20064	Injection Molding	Process	9.465 s/cycle	2.000 pc/cycle		0.191 CNY/cycle		0.033 CNY/cycle	0.112 CNY/pc	0.035 CNY/pc	4.000 %	0.004 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.033 CNY/cycle			
974	PVC-h - Re grind	Material										
19658	Tool	Tool										
19850	Worker, EG04	Worker			0,5	145.079 CNY/h	0.191 CNY/cycle					
19863	Painting	Process	12.000 s/cycle	1.000 pc/cycle		0.484 CNY/cycle		0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
19687	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle			
19960	Worker, EG04	Worker			1	145.079 CNY/h	0.484 CNY/cycle					
18142	Airbrush small parts	Work Step										
19639	Injection Molding	Process	3.866 s/cycle	8.000 pc/cycle		0.078 CNY/cycle		0.013 CNY/cycle	0.011 CNY/pc	0.004 CNY/pc	4.000 %	0.000 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.013 CNY/cycle			
974	PVC-h - Re grind	Material										
19988	Tool	Tool										
19718	Worker, EG04	Worker			0,5	145.079 CNY/h	0.078 CNY/cycle					
19869	Injection Molding	Process	3.866 s/cycle	8.000 pc/cycle		0.078 CNY/cycle		0.013 CNY/cycle	0.011 CNY/pc	0.004 CNY/pc	4.000 %	0.000 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.013 CNY/cycle			
974	PVC-h - Re grind	Material										
19693	Tool	Tool										
19897	Worker, EG04	Worker			0,5	145.079 CNY/h	0.078 CNY/cycle					
19650	Injection Molding	Process	23.636 s/cycle	4.000 pc/cycle		0.476 CNY/cycle		0.082 CNY/cycle	0.139 CNY/pc	0.044 CNY/pc	4.000 %	0.006 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle			
687	ABS - Re grind	Material										
19733	Tool	Tool										
19833	Worker, EG04	Worker			0,5	145.079 CNY/h	0.476 CNY/cycle					
19737	Injection Molding	Process	11.616 s/cycle	8.000 pc/cycle		0.234 CNY/cycle		0.040 CNY/cycle	0.034 CNY/pc	0.011 CNY/pc	4.000 %	0.001 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle			
687	ABS - Re grind	Material										
19996	Tool	Tool										
20025	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle					
19714	Injection Molding	Process	11.616 s/cycle	8.000 pc/cycle		0.234 CNY/cycle		0.040 CNY/cycle	0.034 CNY/pc	0.011 CNY/pc	4.000 %	0.001 CNY/pc

1.620 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.559 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

1.620 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.387 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

0.778 CNY/pc

0.050 CNY/pc 0.009 CNY/pc 0.074 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

0.100 CNY/pc 0.018 CNY/pc 0.133 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.100 CNY/pc 0.018 CNY/pc 0.307 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

0.100 CNY/pc 0.018 CNY/pc 0.164 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.100 CNY/pc 0.018 CNY/pc 0.164 CNY/pc



6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle					
687	ABS - Re grind	Material												
20046	Tool	Tool												
20031	Worker, EG04	Worker				0,5	145.079 CNY/h	0.234 CNY/cycle						
19998	Painting	Process	12.000 s/cycle	1.000 pc/cycle				0.484 CNY/cycle		0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
19972	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle					
19783	Worker, EG04	Worker				1	145.079 CNY/h	0.484 CNY/cycle						
18142	Airbrush small parts	Work Step												
19893	Injection Molding	Process	23.636 s/cycle	2.000 pc/cycle				0.476 CNY/cycle		0.082 CNY/cycle	0.279 CNY/pc	0.087 CNY/pc	4.000 %	0.011 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle					
687	ABS - Re grind	Material												
19696	Tool	Tool												
19645	Worker, EG04	Worker				0,5	145.079 CNY/h	0.476 CNY/cycle						
19685	Injection Molding	Process	11.616 s/cycle	4.000 pc/cycle				0.234 CNY/cycle		0.040 CNY/cycle	0.069 CNY/pc	0.021 CNY/pc	4.000 %	0.003 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle					
687	ABS - Re grind	Material												
19766	Tool	Tool												
19705	Worker, EG04	Worker				0,5	145.079 CNY/h	0.234 CNY/cycle						
19839	Painting	Process	12.000 s/cycle	1.000 pc/cycle				0.484 CNY/cycle		0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
19856	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle					
19843	Worker, EG04	Worker				1	145.079 CNY/h	0.484 CNY/cycle						
18142	Airbrush small parts	Work Step												
19809	Injection Molding	Process	4.404 s/cycle	8.000 pc/cycle				0.089 CNY/cycle		0.015 CNY/cycle	0.013 CNY/pc	0.004 CNY/pc	4.000 %	0.001 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.015 CNY/cycle					
687	ABS - Re grind	Material												
19891	Tool	Tool												
19706	Worker, EG04	Worker				0,5	145.079 CNY/h	0.089 CNY/cycle						
19681	Injection Molding	Process	10.465 s/cycle	2.000 pc/cycle				0.211 CNY/cycle		0.154 CNY/cycle	0.182 CNY/pc	0.057 CNY/pc	4.000 %	0.007 CNY/pc
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine					52.908 CNY/h	52.908 CNY/h	0.154 CNY/cycle					
974	PVC-h - Re grind	Material												
19661	Tool	Tool												
19762	Worker, EG04	Worker				0,5	145.079 CNY/h	0.211 CNY/cycle						
19995	Painting	Process	12.000 s/cycle	1.000 pc/cycle				0.484 CNY/cycle		0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
19959	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle					
19943	Worker, EG04	Worker				1	145.079 CNY/h	0.484 CNY/cycle						
18142	Airbrush small parts	Work Step												
19758	Injection Molding	Process	11.616 s/cycle	2.000 pc/cycle				0.234 CNY/cycle		0.040 CNY/cycle	0.137 CNY/pc	0.043 CNY/pc	4.000 %	0.005 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle					
687	ABS - Re grind	Material												
20004	Tool	Tool												
19666	Worker, EG04	Worker				0,5	145.079 CNY/h	0.234 CNY/cycle						
19791	Copy of Painting	Process	12.000 s/cycle	1.000 pc/cycle				0.484 CNY/cycle		0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.778 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.613 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

0.200 CNY/pc 0.036 CNY/pc 0.329 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.778 CNY/pc

0.100 CNY/pc 0.018 CNY/pc 0.136 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.400 CNY/pc 0.072 CNY/pc 0.718 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.778 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.421 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

0.778 CNY/pc

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19767	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle					
19622	Worker, EG04	Worker			1	145.079 CNY/h	0.484 CNY/cycle							
18142	Airbrush small parts	Work Step												
19702	Injection Molding	Process	3.866 s/cycle	2.000 pc/cycle			0.078 CNY/cycle			0.013 CNY/cycle	0.046 CNY/pc	0.014 CNY/pc	4.000 %	0.002 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.013 CNY/cycle				
974	PVC-h - Regrind	Material												
19677	Tool	Tool												
19819	Worker, EG04	Worker			0,5	145.079 CNY/h	0.078 CNY/cycle							
19632	Painting	Process	12.000 s/cycle	1.000 pc/cycle			0.484 CNY/cycle			0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
19933	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle				
19798	Worker, EG04	Worker			1	145.079 CNY/h	0.484 CNY/cycle							
18142	Airbrush small parts	Work Step												
19641	Injection Molding	Process	23.636 s/cycle	4.000 pc/cycle			0.476 CNY/cycle			0.082 CNY/cycle	0.139 CNY/pc	0.044 CNY/pc	4.000 %	0.006 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle				
687	ABS - Regrind	Material												
19755	Tool	Tool												
19934	Worker, EG04	Worker			0,5	145.079 CNY/h	0.476 CNY/cycle							
19987	Painting	Process	12.000 s/cycle	1.000 pc/cycle			0.484 CNY/cycle			0.092 CNY/cycle	0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
19730	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle				
20037	Worker, EG04	Worker			1	145.079 CNY/h	0.484 CNY/cycle							
18142	Airbrush small parts	Work Step												
19774	Injection Molding	Process	11.616 s/cycle	1.000 pc/cycle			0.234 CNY/cycle			0.040 CNY/cycle	0.274 CNY/pc	0.086 CNY/pc	4.000 %	0.011 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle				
687	ABS - Regrind	Material												
20074	Tool	Tool												
19609	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle							
19821	Painting	Process	30.000 s/cycle	1.000 pc/cycle			1.209 CNY/cycle			0.229 CNY/cycle	1.438 CNY/pc	0.449 CNY/pc	4.000 %	0.058 CNY/pc
19672	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle				
20020	Worker, EG04	Worker			1	145.079 CNY/h	1.209 CNY/cycle							
18138	Airbrush medium parts	Work Step												
20055	Injection Molding	Process	4.404 s/cycle	4.000 pc/cycle			0.089 CNY/cycle			0.015 CNY/cycle	0.026 CNY/pc	0.008 CNY/pc	4.000 %	0.001 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.015 CNY/cycle				
687	ABS - Regrind	Material												
19954	Tool	Tool												
19935	Worker, EG04	Worker			0,5	145.079 CNY/h	0.089 CNY/cycle							
19690	Injection Molding	Process	12.616 s/cycle	2.000 pc/cycle			0.254 CNY/cycle			0.185 CNY/cycle	0.220 CNY/pc	0.069 CNY/pc	4.000 %	0.009 CNY/pc
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine						52.908 CNY/h	52.908 CNY/h	0.185 CNY/cycle				
687	ABS - Regrind	Material												
19980	Tool	Tool												
20009	Worker, EG04	Worker			0,5	145.079 CNY/h	0.254 CNY/cycle							
19638	Painting	Process	85.000 s/cycle	1.000 pc/cycle			3.764 CNY/cycle			0.649 CNY/cycle	4.413 CNY/pc	1.377 CNY/pc	4.000 %	0.177 CNY/pc
20051	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.649 CNY/cycle				
19700	Worker, EG06	Worker			1	159.400 CNY/h	3.764 CNY/cycle							

0.150 CNY/pc	0.027 CNY/pc	0.239 CNY/pc	

0.300 CNY/cycle	0.054 CNY/cycle	0.354 CNY/cycle	
		0.778 CNY/pc	

0.100 CNY/pc	0.018 CNY/pc	0.307 CNY/pc	

0.400 CNY/cycle	0.072 CNY/cycle	0.472 CNY/cycle	
		0.778 CNY/pc	

0.400 CNY/pc	0.072 CNY/pc	0.842 CNY/pc	

0.400 CNY/cycle	0.072 CNY/cycle	0.472 CNY/cycle	
		1.944 CNY/pc	

0.200 CNY/pc	0.036 CNY/pc	0.271 CNY/pc	

0.800 CNY/cycle	0.144 CNY/cycle	0.944 CNY/cycle	
		0.500 CNY/pc	

1.000 CNY/cycle	0.180 CNY/cycle	1.180 CNY/cycle	
		5.966 CNY/pc	

18139	Polish or clean medium parts	Work Step																								
18138	Airbrush medium parts	Work Step																								
18140	Handpaint medium parts	Work Step																								
20023	Injection Molding	Process	4.404 s/cycle	28.000 pc/cycle								0.089 CNY/cycle					0.015 CNY/cycle		0.004 CNY/pc	0.001 CNY/pc	4.000 %	0.000 CNY/pc				
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine											12.427 CNY/h	12.427 CNY/h			0.015 CNY/cycle									
687	ABS - Re grind	Material																								
19605	Tool	Tool																								
19923	Worker, EG04	Worker					0,5	145.079 CNY/h	0.089 CNY/cycle																	
19867	Molding	Process	4.404 s/cycle	2.000 pc/cycle																0.015 CNY/cycle		0.052 CNY/pc	0.016 CNY/pc	4.000 %	0.002 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine											12.427 CNY/h	12.427 CNY/h			0.015 CNY/cycle									
687	ABS - Re grind	Material																								
19949	Tool	Tool																								
19747	Worker, EG04	Worker					0,5	145.079 CNY/h	0.089 CNY/cycle																	
19720	Painting	Process	25.000 s/cycle	1.000 pc/cycle																						
19845	Air brush and Painting workstation	Machine											27.490 CNY/h	27.490 CNY/h			0.191 CNY/cycle						1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19745	Worker, EG04	Worker					1	145.079 CNY/h	1.007 CNY/cycle																	
18140	Handpaint medium parts	Work Step																								
19728	Die Casting	Process	22.914 s/cycle	2.000 pc/cycle																						
19750	Cold chamber die-casting machine (Mg; Al)   clamp force: 2.600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell																								
362	Al 99,9	Material																								
19876	Copy of Tool	Tool																								
19870	Worker, EG04	Worker					1	145.079 CNY/h	1.847 CNY/cycle																	
19948	Painting	Process	30.000 s/cycle	1.000 pc/cycle																						
19741	Air brush and Painting workstation	Machine											27.490 CNY/h	27.490 CNY/h			0.229 CNY/cycle						1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19694	Worker, EG06	Worker					1	159.400 CNY/h	1.328 CNY/cycle																	
18138	Airbrush medium parts	Work Step																								
19794	Polishing	Process	30.000 s/cycle	1.000 pc/cycle																						
19741	Air brush and Painting workstation	Machine											27.490 CNY/h	27.490 CNY/h			0.229 CNY/cycle						1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
20021	Worker, EG06	Worker					1	159.400 CNY/h	1.328 CNY/cycle																	
18139	Polish or clean medium parts	Work Step																								
20067	Injection Molding	Process	11.616 s/cycle	4.000 pc/cycle																						
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine											12.427 CNY/h	12.427 CNY/h			0.040 CNY/cycle						0.069 CNY/pc	0.021 CNY/pc	4.000 %	0.003 CNY/pc
687	ABS - Re grind	Material																								
20062	Tool	Tool																								
19701	Worker, EG04	Worker					0,5	145.079 CNY/h	0.234 CNY/cycle																	
19956	Painting	Process	30.000 s/cycle	1.000 pc/cycle																						
20028	Air brush and Painting workstation	Machine											27.490 CNY/h	27.490 CNY/h			0.229 CNY/cycle						1.438 CNY/pc	0.449 CNY/pc	4.000 %	0.058 CNY/pc
19710	Worker, EG04	Worker					1	145.079 CNY/h	1.209 CNY/cycle																	
18138	Airbrush medium parts	Work Step																								
19777	Injection Molding	Process	23.636 s/cycle	1.000 pc/cycle																						
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine											12.427 CNY/h	12.427 CNY/h			0.082 CNY/cycle						0.558 CNY/pc	0.174 CNY/pc	4.000 %	0.022 CNY/pc
687	ABS - Re grind	Material																								
19849	Tool	Tool																								

[Redacted]

0.200 CNY/pc 0.036 CNY/pc 0.241 CNY/pc

[Redacted]

5.600 CNY/cycle 1.005 CNY/cycle 6.605 CNY/cycle

0.200 CNY/pc 0.036 CNY/pc 0.306 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

1.620 CNY/pc

[Redacted]

0.500 CNY/pc 0.090 CNY/pc 4.522 CNY/pc

[Redacted]

1.000 CNY/cycle 0.180 CNY/cycle 1.180 CNY/cycle

2.106 CNY/pc

2.106 CNY/pc

[Redacted]

0.100 CNY/pc 0.018 CNY/pc 0.211 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

1.944 CNY/pc

[Redacted]

0.300 CNY/pc 0.054 CNY/pc 1.108 CNY/pc

[Redacted]

0.300 CNY/cycle 0.054 CNY/cycle 0.354 CNY/cycle

19659	Worker, EG04	Worker			0,5	145.079 CNY/h	0.476 CNY/cycle								
19817	Injection Molding	Process	11.616 s/cycle	20.000 pc/cycle			0.234 CNY/cycle			0.040 CNY/cycle		0.014 CNY/pc	0.004 CNY/pc	4.000 %	0.001 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle					
687	ABS - Regrind	Material													
19773	Tool	Tool													
20070	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle								
19785	Injection Molding	Process	11.616 s/cycle	1.000 pc/cycle			0.234 CNY/cycle			0.040 CNY/cycle		0.274 CNY/pc	0.086 CNY/pc	4.000 %	0.011 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle					
687	ABS - Regrind	Material													
19961	Tool	Tool													
19838	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle								
19829	Painting	Process	30.000 s/cycle	1.000 pc/cycle			1.209 CNY/cycle			0.229 CNY/cycle		1.438 CNY/pc	0.449 CNY/pc	4.000 %	0.058 CNY/pc
19866	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle					
19886	Worker, EG04	Worker			1	145.079 CNY/h	1.209 CNY/cycle								
18138	Airbrush medium parts	Work Step													
19618	Injection Molding	Process	243.403 s/cycle	2.000 pc/cycle			4.905 CNY/cycle			3.577 CNY/cycle		4.241 CNY/pc	1.323 CNY/pc	4.000 %	0.170 CNY/pc
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine						52.908 CNY/h	52.908 CNY/h	3.577 CNY/cycle					
687	ABS - Regrind	Material													
19634	Tool	Tool													
19732	Worker, EG04	Worker			0,5	145.079 CNY/h	4.905 CNY/cycle								
19727	Painting	Process	37.000 s/cycle	1.000 pc/cycle			1.491 CNY/cycle			0.283 CNY/cycle		1.774 CNY/pc	0.553 CNY/pc	4.000 %	0.071 CNY/pc
19941	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.283 CNY/cycle					
19882	Worker, EG04	Worker			1	145.079 CNY/h	1.491 CNY/cycle								
18142	Airbrush small parts	Work Step													
18140	Handpaint medium parts	Work Step													
19983	Injection Molding	Process	4.404 s/cycle	28.000 pc/cycle			0.089 CNY/cycle			0.015 CNY/cycle		0.004 CNY/pc	0.001 CNY/pc	4.000 %	0.000 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.015 CNY/cycle					
687	ABS - Regrind	Material													
19852	Tool	Tool													
20013	Worker, EG04	Worker			0,5	145.079 CNY/h	0.089 CNY/cycle								
19640	Injection Molding	Process	40.464 s/cycle	4.000 pc/cycle			0.815 CNY/cycle			0.140 CNY/cycle		0.239 CNY/pc	0.074 CNY/pc	4.000 %	0.010 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.140 CNY/cycle					
687	ABS - Regrind	Material													
20027	Tool	Tool													
19680	Worker, EG04	Worker			0,5	145.079 CNY/h	0.815 CNY/cycle								
19668	Injection Molding	Process	23.636 s/cycle	2.000 pc/cycle			0.476 CNY/cycle			0.082 CNY/cycle		0.279 CNY/pc	0.087 CNY/pc	4.000 %	0.011 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle					
687	ABS - Regrind	Material													
19604	Tool	Tool													
19902	Worker, EG04	Worker			0,5	145.079 CNY/h	0.476 CNY/cycle								
19858	Painting	Process	12.000 s/cycle	1.000 pc/cycle			0.484 CNY/cycle			0.092 CNY/cycle		0.575 CNY/pc	0.179 CNY/pc	4.000 %	0.023 CNY/pc
20061	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle					
19979	Worker, EG04	Worker			1	145.079 CNY/h	0.484 CNY/cycle								

0.200 CNY/pc 0.036 CNY/pc 0.254 CNY/pc

4.000 CNY/cycle 0.718 CNY/cycle 4.718 CNY/cycle

0.400 CNY/pc 0.072 CNY/pc 0.842 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

1.944 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 5.970 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

2.398 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.241 CNY/pc

5.600 CNY/cycle 1.005 CNY/cycle 6.605 CNY/cycle

0.200 CNY/pc 0.036 CNY/pc 0.559 CNY/pc

0.800 CNY/cycle 0.144 CNY/cycle 0.944 CNY/cycle

0.100 CNY/pc 0.018 CNY/pc 0.495 CNY/pc

0.200 CNY/cycle 0.036 CNY/cycle 0.236 CNY/cycle

0.778 CNY/pc





0.300 CNY/pc	0.054 CNY/pc	0.389 CNY/pc
1.200 CNY/cycle	0.215 CNY/cycle	1.415 CNY/cycle
		1.620 CNY/pc
0.300 CNY/pc	0.054 CNY/pc	0.389 CNY/pc
1.200 CNY/cycle	0.215 CNY/cycle	1.415 CNY/cycle
		1.620 CNY/pc
0.300 CNY/pc	0.054 CNY/pc	0.542 CNY/pc
1.200 CNY/cycle	0.215 CNY/cycle	1.415 CNY/cycle
		1.620 CNY/pc
0.300 CNY/pc	0.054 CNY/pc	1.767 CNY/pc
0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle
		1.620 CNY/pc
0.300 CNY/pc	0.054 CNY/pc	0.731 CNY/pc
0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle
		3.564 CNY/pc

19962	Worker, EG04	Worker			1	145.079 CNY/h	2.216 CNY/cycle							
18140	Handpaint medium parts	Work Step												
18138	Airbrush medium parts	Work Step												
20019	Injection Molding	Process	4.404 s/cycle	4.000 pc/cycle			0.089 CNY/cycle			0.015 CNY/cycle	0.026 CNY/pc	0.008 CNY/pc	4.000 %	0.001 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.015 CNY/cycle				
687	ABS - Regrind	Material												
19656	Tool	Tool												
19806	Worker, EG04	Worker			0,5	145.079 CNY/h	0.089 CNY/cycle							
19721	Painting	Process	25.000 s/cycle	1.000 pc/cycle			1.007 CNY/cycle			0.191 CNY/cycle	1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
20058	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle				
19958	Worker, EG04	Worker			1	145.079 CNY/h	1.007 CNY/cycle							
18140	Handpaint medium parts	Work Step												
19846	Injection Molding	Process	11.616 s/cycle	4.000 pc/cycle			0.234 CNY/cycle			0.040 CNY/cycle	0.069 CNY/pc	0.021 CNY/pc	4.000 %	0.003 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle				
687	ABS - Regrind	Material												
19748	Tool	Tool												
20040	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle							
19974	Painting	Process	25.000 s/cycle	1.000 pc/cycle			1.007 CNY/cycle			0.191 CNY/cycle	1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19779	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle				
19822	Worker, EG04	Worker			1	145.079 CNY/h	1.007 CNY/cycle							
18140	Handpaint medium parts	Work Step												
19931	Injection Molding	Process	23.636 s/cycle	4.000 pc/cycle			0.476 CNY/cycle			0.082 CNY/cycle	0.139 CNY/pc	0.044 CNY/pc	4.000 %	0.006 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle				
687	ABS - Regrind	Material												
19743	Tool	Tool												
20072	Worker, EG04	Worker			0,5	145.079 CNY/h	0.476 CNY/cycle							
19646	Painting	Process	25.000 s/cycle	1.000 pc/cycle			1.007 CNY/cycle			0.191 CNY/cycle	1.198 CNY/pc	0.374 CNY/pc	4.000 %	0.048 CNY/pc
19775	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.191 CNY/cycle				
19991	Worker, EG04	Worker			1	145.079 CNY/h	1.007 CNY/cycle							
18140	Handpaint medium parts	Work Step												
19631	Die Casting	Process	33.701 s/cycle	2.000 pc/cycle			2.716 CNY/cycle			5.838 CNY/cycle	4.277 CNY/pc	1.335 CNY/pc	4.000 %	0.171 CNY/pc
19725	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell								5.838 CNY/cycle				
362	Al 99,9	Material												
19871	Tool	Tool												
19827	Worker, EG04	Worker			1	145.079 CNY/h	2.716 CNY/cycle							
19707	Drilling	Process	156.876 s/cycle	1.000 pc/cycle			6.322 CNY/cycle			0.999 CNY/cycle	7.321 CNY/pc	2.284 CNY/pc	4.000 %	0.293 CNY/pc
6720	CNC Vertical Machining Center   Rotaion speed: < 10,000.00 1/min   parts weight: < 150.00 kg	Machine						22.925 CNY/h	22.925 CNY/h	0.999 CNY/cycle				
362	Al 99,9	Material												
19977	Worker, EG04	Worker			1	145.079 CNY/h	6.322 CNY/cycle							
19759	Polishing	Process	30.000 s/cycle	1.000 pc/cycle			1.328 CNY/cycle			0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19674	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle				
19754	Worker, EG06	Worker			1	159.400 CNY/h	1.328 CNY/cycle							
18139	Polish or clean medium parts	Work Step												
19907	Painting	Process	55.000 s/cycle	1.000 pc/cycle			2.435 CNY/cycle			0.420 CNY/cycle	2.855 CNY/pc	0.891 CNY/pc	4.000 %	0.114 CNY/pc

0.150 CNY/pc	0.027 CNY/pc	0.212 CNY/pc	
0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle	
			1.620 CNY/pc
0.150 CNY/pc	0.027 CNY/pc	0.270 CNY/pc	
0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle	
			1.620 CNY/pc
0.150 CNY/pc	0.027 CNY/pc	0.365 CNY/pc	
0.600 CNY/cycle	0.108 CNY/cycle	0.708 CNY/cycle	
			1.620 CNY/pc
3.000 CNY/pc	0.539 CNY/pc	9.321 CNY/pc	
6.000 CNY/cycle	1.077 CNY/cycle	7.077 CNY/cycle	
			9.898 CNY/pc
			2.106 CNY/pc
			3.860 CNY/pc

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19997	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.420 CNY/cycle				
19825	Color	Material											
19906	Worker, EG06	Worker				1	159.400 CNY/h	2.435 CNY/cycle					
18138	Airbrush medium parts	Work Step											
18140	Handpaint medium parts	Work Step											
19929	Die Casting	Process	21.519 s/cycle	2.000 pc/cycle				1.734 CNY/cycle	3.728 CNY/cycle	2.731 CNY/pc	0.852 CNY/pc	4.000 %	0.109 CNY/pc
19909	Cold chamber die-casting machine (Mg; Al)   clamp force: 2.600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							3.728 CNY/cycle				
362	Al 99,9	Material											
19951	Tool	Tool											
19857	Worker, EG04	Worker				1	145.079 CNY/h	1.734 CNY/cycle					
20032	Painting	Process	55.000 s/cycle	1.000 pc/cycle				2.435 CNY/cycle	0.420 CNY/cycle	2.855 CNY/pc	0.891 CNY/pc	4.000 %	0.114 CNY/pc
19642	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.420 CNY/cycle				
19797	Worker, EG06	Worker				1	159.400 CNY/h	2.435 CNY/cycle					
18138	Airbrush medium parts	Work Step											
18140	Handpaint medium parts	Work Step											
19803	Polishing	Process	30.000 s/cycle	1.000 pc/cycle				1.328 CNY/cycle	0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
20007	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle				
19781	Worker, EG06	Worker				1	159.400 CNY/h	1.328 CNY/cycle					
18139	Polish or clean medium parts	Work Step											
19855	Die Casting	Process	24.570 s/cycle	4.000 pc/cycle				1.980 CNY/cycle	4.256 CNY/cycle	1.559 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
20065	Cold chamber die-casting machine (Mg; Al)   clamp force: 2.600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							4.256 CNY/cycle				
362	Al 99,9	Material											
19760	Copy of Tool	Tool											
19617	Worker, EG04	Worker				1	145.079 CNY/h	1.980 CNY/cycle					
19675	Drilling	Process	7.540 s/cycle	1.000 pc/cycle				0.304 CNY/cycle	0.048 CNY/cycle	0.352 CNY/pc	0.110 CNY/pc	4.000 %	0.014 CNY/pc
6720	CNC Vertical Machining Center   Rotaion speed: < 10,000.00 1/min   parts weight: < 150.00 kg	Machine					22.925 CNY/h	22.925 CNY/h	0.048 CNY/cycle				
362	Al 99,9	Material											
19647	Worker, EG04	Worker				1	145.079 CNY/h	0.304 CNY/cycle					
19976	Painting	Process	12.000 s/cycle	1.000 pc/cycle				0.531 CNY/cycle	0.092 CNY/cycle	0.623 CNY/pc	0.194 CNY/pc	4.000 %	0.025 CNY/pc
20041	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle				
19793	Worker, EG06	Worker				1	159.400 CNY/h	0.531 CNY/cycle					
18142	Airbrush small parts	Work Step											
19830	Injection Molding	Process	41.464 s/cycle	2.000 pc/cycle				0.836 CNY/cycle	0.609 CNY/cycle	0.722 CNY/pc	0.225 CNY/pc	4.000 %	0.029 CNY/pc
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine					52.908 CNY/h	52.908 CNY/h	0.609 CNY/cycle				
687	ABS - Re grind	Material											
19780	Tool	Tool											
19613	Worker, EG04	Worker				0,5	145.079 CNY/h	0.836 CNY/cycle					
19676	Die Casting	Process	23.300 s/cycle	2.000 pc/cycle				1.878 CNY/cycle	4.036 CNY/cycle	2.957 CNY/pc	0.923 CNY/pc	4.000 %	0.118 CNY/pc
19915	Cold chamber die-casting machine (Mg; Al)   clamp force: 2.600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell							4.036 CNY/cycle				
362	Al 99,9	Material											
19749	Tool	Tool											
19810	Worker, EG04	Worker				1	145.079 CNY/h	1.878 CNY/cycle					
20075	Drilling	Process	3.770 s/cycle	1.000 pc/cycle				0.152 CNY/cycle	0.024 CNY/cycle	0.176 CNY/pc	0.055 CNY/pc	4.000 %	0.007 CNY/pc

	3.000 CNY/pc	0.539 CNY/pc	7.231 CNY/pc
	6.000 CNY/cycle	1.077 CNY/cycle	7.077 CNY/cycle
			3.860 CNY/pc
			2.106 CNY/pc
	0.300 CNY/pc	0.054 CNY/pc	2.462 CNY/pc
	1.200 CNY/cycle	0.215 CNY/cycle	1.415 CNY/cycle
			0.476 CNY/pc
			0.842 CNY/pc
	1.000 CNY/pc	0.180 CNY/pc	2.156 CNY/pc
	2.000 CNY/cycle	0.359 CNY/cycle	2.359 CNY/cycle
	1.500 CNY/pc	0.269 CNY/pc	5.767 CNY/pc
	3.000 CNY/cycle	0.539 CNY/cycle	3.539 CNY/cycle
			0.238 CNY/pc

# BoM-Report | Production

6720	CNC Vertical Machining Center   Rotaion speed: < 10,000.00 1/min   parts weight: < 150.00 kg	Machine					22.925 CNY/h	22.925 CNY/h	0.024 CNY/cycle					
362	Al 99,9	Material												
19820	Worker, EG04	Worker				1	145.079 CNY/h	0.152 CNY/cycle						
19889	Polishing	Process	30.000 s/cycle	1.000 pc/cycle				1.328 CNY/cycle		0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19761	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle					
19669	Worker, EG06	Worker				1	159.400 CNY/h	1.328 CNY/cycle						
18139	Polish or clean medium parts	Work Step												
19607	Painting	Process	55.000 s/cycle	1.000 pc/cycle				2.435 CNY/cycle		0.420 CNY/cycle	2.855 CNY/pc	0.891 CNY/pc	4.000 %	0.114 CNY/pc
19752	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.420 CNY/cycle					
19860	Worker, EG06	Worker				1	159.400 CNY/h	2.435 CNY/cycle						
18138	Airbrush medium parts	Work Step												
18140	Handpaint medium parts	Work Step												
19657	Die Casting	Process	22.159 s/cycle	2.000 pc/cycle				1.786 CNY/cycle		3.839 CNY/cycle	2.812 CNY/pc	0.877 CNY/pc	4.000 %	0.112 CNY/pc
19788	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell								3.839 CNY/cycle				
362	Al 99,9	Material												
19957	Copy of Tool	Tool												
20066	Worker, EG04	Worker				1	145.079 CNY/h	1.786 CNY/cycle						
19756	Painting	Process	30.000 s/cycle	1.000 pc/cycle				1.328 CNY/cycle		0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19946	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle					
19812	Worker, EG06	Worker				1	159.400 CNY/h	1.328 CNY/cycle						
18138	Airbrush medium parts	Work Step												
19859	Polishing	Process	30.000 s/cycle	1.000 pc/cycle				1.328 CNY/cycle		0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19801	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle					
19837	Worker, EG06	Worker				1	159.400 CNY/h	1.328 CNY/cycle						
18139	Polish or clean medium parts	Work Step												
19692	Die Casting	Process	22.159 s/cycle	2.000 pc/cycle				1.786 CNY/cycle		3.839 CNY/cycle	2.812 CNY/pc	0.877 CNY/pc	4.000 %	0.112 CNY/pc
19967	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell								3.839 CNY/cycle				
362	Al 99,9	Material												
19684	Copy of Tool	Tool												
19611	Worker, EG04	Worker				1	145.079 CNY/h	1.786 CNY/cycle						
20018	Painting	Process	30.000 s/cycle	1.000 pc/cycle				1.328 CNY/cycle		0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19938	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle					
19723	Worker, EG06	Worker				1	159.400 CNY/h	1.328 CNY/cycle						
18138	Airbrush medium parts	Work Step												
19804	Polishing	Process	30.000 s/cycle	1.000 pc/cycle				1.328 CNY/cycle		0.229 CNY/cycle	1.557 CNY/pc	0.486 CNY/pc	4.000 %	0.062 CNY/pc
19848	Air brush and Painting workstation	Machine					27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle					
20033	Worker, EG06	Worker				1	159.400 CNY/h	1.328 CNY/cycle						
18139	Polish or clean medium parts	Work Step												
19716	Injection Molding	Process	11.616 s/cycle	4.000 pc/cycle				0.234 CNY/cycle		0.040 CNY/cycle	0.069 CNY/pc	0.021 CNY/pc	4.000 %	0.003 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine					12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle					
687	ABS - Re grind	Material												
19813	Tool	Tool												
19626	Worker, EG04	Worker				0,5	145.079 CNY/h	0.234 CNY/cycle						

2.106 CNY/pc

3.860 CNY/pc

0.300 CNY/pc 0.054 CNY/pc 4.156 CNY/pc

0.600 CNY/cycle 0.108 CNY/cycle 0.708 CNY/cycle

2.106 CNY/pc

2.106 CNY/pc

0.300 CNY/pc 0.054 CNY/pc 4.156 CNY/pc

0.600 CNY/cycle 0.108 CNY/cycle 0.708 CNY/cycle

2.106 CNY/pc

2.106 CNY/pc

0.100 CNY/pc 0.018 CNY/pc 0.211 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle



# BoM-Report | Production

19699	Injection Molding	Process	41.464 s/cycle	4.000 pc/cycle		0.836 CNY/cycle			0.609 CNY/cycle	0.361 CNY/pc	0.113 CNY/pc	4.000 %	0.014 CNY/pc	
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine						52.908 CNY/h	52.908 CNY/h	0.609 CNY/cycle				
687	ABS - Re grind	Material												
20057	Tool	Tool												
19994	Worker, EG04	Worker			0,5	145.079 CNY/h	0.836 CNY/cycle							
19736	Injection Molding	Process	23.636 s/cycle	4.000 pc/cycle			0.476 CNY/cycle			0.082 CNY/cycle	0.139 CNY/pc	0.044 CNY/pc	4.000 %	0.006 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.082 CNY/cycle				
687	ABS - Re grind	Material												
19764	Tool	Tool												
19831	Worker, EG04	Worker			0,5	145.079 CNY/h	0.476 CNY/cycle							
19841	Die Casting	Process	22.007 s/cycle	4.000 pc/cycle			1.774 CNY/cycle			3.812 CNY/cycle	1.397 CNY/pc	0.436 CNY/pc	4.000 %	0.056 CNY/pc
19932	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell								3.812 CNY/cycle				
362	Al 99,9	Material												
19807	Copy of Tool	Tool												
19872	Worker, EG04	Worker			1	145.079 CNY/h	1.774 CNY/cycle							
20000	Painting	Process	12.000 s/cycle	1.000 pc/cycle			0.531 CNY/cycle			0.092 CNY/cycle	0.623 CNY/pc	0.194 CNY/pc	4.000 %	0.025 CNY/pc
19910	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle				
19757	Worker, EG06	Worker			1	159.400 CNY/h	0.531 CNY/cycle							
18142	Airbrush small parts	Work Step												
19662	Die Casting	Process	20.977 s/cycle	4.000 pc/cycle			1.691 CNY/cycle			3.634 CNY/cycle	1.331 CNY/pc	0.415 CNY/pc	4.000 %	0.053 CNY/pc
19942	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell								3.634 CNY/cycle				
362	Al 99,9	Material												
19811	Copy of Tool	Tool												
19787	Worker, EG04	Worker			1	145.079 CNY/h	1.691 CNY/cycle							
19981	Painting	Process	12.000 s/cycle	1.000 pc/cycle			0.531 CNY/cycle			0.092 CNY/cycle	0.623 CNY/pc	0.194 CNY/pc	4.000 %	0.025 CNY/pc
19944	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle				
19982	Worker, EG06	Worker			1	159.400 CNY/h	0.531 CNY/cycle							
18142	Airbrush small parts	Work Step												
20039	Die Casting	Process	23.411 s/cycle	4.000 pc/cycle			1.887 CNY/cycle			4.056 CNY/cycle	1.486 CNY/pc	0.464 CNY/pc	4.000 %	0.059 CNY/pc
19989	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Manufacturing Cell								4.056 CNY/cycle				
362	Al 99,9	Material												
19985	Copy of Tool	Tool												
19800	Worker, EG04	Worker			1	145.079 CNY/h	1.887 CNY/cycle							
19682	Painting	Process	12.000 s/cycle	1.000 pc/cycle			0.531 CNY/cycle			0.092 CNY/cycle	0.623 CNY/pc	0.194 CNY/pc	4.000 %	0.025 CNY/pc
19816	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.092 CNY/cycle				
19828	Worker, EG06	Worker			1	159.400 CNY/h	0.531 CNY/cycle							
18142	Airbrush small parts	Work Step												
19740	Assembly	Process	60.000 s/cycle	1.000 pc/cycle			2.418 CNY/cycle			0.133 CNY/cycle	2.551 CNY/pc	0.796 CNY/pc	4.000 %	0.102 CNY/pc
63	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Machine						7.978 CNY/h	7.978 CNY/h	0.133 CNY/cycle				
19670	Worker, EG04	Worker			1	145.079 CNY/h	2.418 CNY/cycle							
20005	Injection Molding	Process	11.616 s/cycle	2.000 pc/cycle			0.234 CNY/cycle			0.040 CNY/cycle	0.137 CNY/pc	0.043 CNY/pc	4.000 %	0.005 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle				

0.300 CNY/pc 0.054 CNY/pc 0.842 CNY/pc

1.200 CNY/cycle 0.215 CNY/cycle 1.415 CNY/cycle

0.050 CNY/pc 0.009 CNY/pc 0.248 CNY/pc

0.200 CNY/cycle 0.036 CNY/cycle 0.236 CNY/cycle

0.075 CNY/pc 0.013 CNY/pc 1.977 CNY/pc

0.300 CNY/cycle 0.054 CNY/cycle 0.354 CNY/cycle

0.842 CNY/pc

0.075 CNY/pc 0.013 CNY/pc 1.888 CNY/pc

0.300 CNY/cycle 0.054 CNY/cycle 0.354 CNY/cycle

0.842 CNY/pc

0.075 CNY/pc 0.013 CNY/pc 2.097 CNY/pc

0.300 CNY/cycle 0.054 CNY/cycle 0.354 CNY/cycle

0.842 CNY/pc

3.449 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.421 CNY/pc

# BoM-Report | Production

687	ABS - Re grind	Material												
19770	Tool	Tool												
19814	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle							
19955	Painting	Process	30.000 s/cycle	1.000 pc/cycle			1.209 CNY/cycle			0.229 CNY/cycle	1.438 CNY/pc	0.449 CNY/pc	4.000 %	0.058 CNY/pc
19912	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle				
19734	Worker, EG04	Worker			1	145.079 CNY/h	1.209 CNY/cycle							
18138	Airbrush medium parts	Work Step												
19890	Injection Molding	Process	11.616 s/cycle	2.000 pc/cycle			0.234 CNY/cycle			0.040 CNY/cycle	0.137 CNY/pc	0.043 CNY/pc	4.000 %	0.005 CNY/pc
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h	0.040 CNY/cycle				
687	ABS - Re grind	Material												
19782	Tool	Tool												
20044	Worker, EG04	Worker			0,5	145.079 CNY/h	0.234 CNY/cycle							
20035	Painting	Process	30.000 s/cycle	1.000 pc/cycle			1.209 CNY/cycle			0.229 CNY/cycle	1.438 CNY/pc	0.449 CNY/pc	4.000 %	0.058 CNY/pc
19835	Air brush and Painting workstation	Machine						27.490 CNY/h	27.490 CNY/h	0.229 CNY/cycle				
19608	Worker, EG04	Worker			1	145.079 CNY/h	1.209 CNY/cycle							
18138	Airbrush medium parts	Work Step												
19763	Rubber	Process	30.000 s/cycle	2.000 pc/cycle			1.209 CNY/cycle			0.833 CNY/cycle	1.021 CNY/pc	0.319 CNY/pc	4.000 %	0.041 CNY/pc
19864	Rubber manufacturing	Machine						100.000 CNY/h		0.833 CNY/cycle				
19903	Tool	Tool												
19999	Worker, EG04	Worker			1	145.079 CNY/h	1.209 CNY/cycle							
19840	Rubber	Process	40.000 s/cycle	2.000 pc/cycle			1.612 CNY/cycle			1.111 CNY/cycle	1.362 CNY/pc	0.425 CNY/pc	4.000 %	0.054 CNY/pc
19610	Rubber manufacturing	Machine						100.000 CNY/h		1.111 CNY/cycle				
19993	Tool	Tool												
19844	Worker, EG04	Worker			1	145.079 CNY/h	1.612 CNY/cycle							
20048	Final inspection and Packaging	Process	80.000 s/cycle	1.000 pc/cycle			3.224 CNY/cycle				3.224 CNY/pc	1.006 CNY/pc	4.000 %	0.129 CNY/pc
19937	Worker, EG04	Worker			1	145.079 CNY/h	3.224 CNY/cycle							
18137	Grap and Place a Screw	Work Step												
18139	Polish or clean medium parts	Work Step												
19971	Pack Box	Work Step												
20026	Injection Molding	Process	22.525 s/cycle	1.000 pc/cycle			0.454 CNY/cycle			0.841 CNY/cycle	1.295 CNY/pc	0.404 CNY/pc	4.000 %	0.052 CNY/pc
6531	Horizontal injection molding machine   Shot Volume: 188.00 - 188.00 cm³   clamp force: 3,000.00 kN	Machine						134.421 CNY/h	134.421 CNY/h	0.841 CNY/cycle				
687	ABS - Re grind	Material												
20076	Tool	Tool												
19628	Worker, EG04	Worker			0,5	145.079 CNY/h	0.454 CNY/cycle							
20077	Setup Injection Molding small parts	Setup Process				41.000 h/lot	500.000 pc/lot				509.518 CNY/lot	12.915 CNY/pc	3.875 CNY/pc	
6661	Horizontal injection molding machine   Shot Volume: 11.00 - 11.00 cm³   clamp force: 150.00 kN	Machine						12.427 CNY/h	12.427 CNY/h		509.518 CNY/lot			
19992	Setup Operator, EG04	Setup Operator			1	145.079 CNY/h								
20015	Setup Injection Molding medium parts	Setup Process				5.000 h/lot	500.000 pc/lot				264.539 CNY/lot	1.980 CNY/pc	0.594 CNY/pc	
6794	Horizontal injection molding machine   Shot Volume: 147.00 - 147.00 cm³   clamp force: 1,250.00 kN	Machine						52.908 CNY/h	52.908 CNY/h		264.539 CNY/lot			
19778	Setup Operator, EG04	Setup Operator			1	145.079 CNY/h								
20010	Setup Die Casting	Setup Process				5.000 h/lot	500.000 pc/lot				3,118.290 CNY/lot	7.687 CNY/pc	2.306 CNY/pc	
83	Cold chamber die-casting machine (Mg; Al)   clamp force: 2,600.00 kN   Shot mass: 1.30 - 3.80 kg	Machine						96.093 CNY/h	96.093 CNY/h		480.466 CNY/lot			

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

1.944 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 0.421 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

1.944 CNY/pc

0.200 CNY/pc 0.036 CNY/pc 1.617 CNY/pc

0.400 CNY/cycle 0.072 CNY/cycle 0.472 CNY/cycle

0.220 CNY/pc 0.039 CNY/pc 2.100 CNY/pc

0.440 CNY/cycle 0.079 CNY/cycle 0.519 CNY/cycle

4.359 CNY/pc

1.200 CNY/pc 0.215 CNY/pc 3.166 CNY/pc

1.200 CNY/cycle 0.215 CNY/cycle 1.415 CNY/cycle

16.790 CNY/pc

2.574 CNY/pc

9.994 CNY/pc

6538	Medium frequency induction heater   Melting power: < 950.00 kg/h	Machine					527.565 CNY/h	527.565 CNY/h	2,637.824 CNY/lot	
19926	Setup Operator, EG04	Setup Operator				1	145.079 CNY/h			
19744	Setup Assy line	Setup Process	1.000 h/lot	500.000 pc/lot					7.978 CNY/lot	0.306 CNY/pc
63	Reworking with auxiliary devices for high-quality work   investment: 11.00 T€	Machine					7.978 CNY/h	7.978 CNY/h	7.978 CNY/lot	
20052	Setup Operator, EG04	Setup Operator				1	145.079 CNY/h			

0.398 CNY/pc