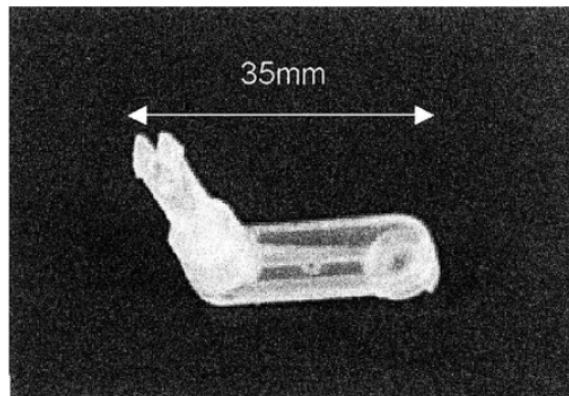


Case Study (Using Hopkinson and Dickens Cost model)

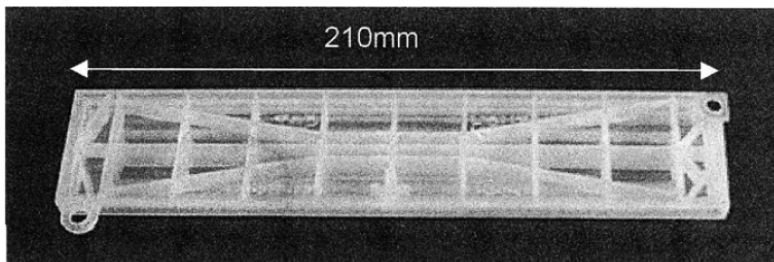
Goal of the case study: Perform cost estimation to compare a traditional manufacturing route (**injection molding**) with layer manufacturing processes (**Stereolithography SL, Fused deposition modelling FDM and Laser sintering LS**) in terms of the unit cost for parts made in various quantities.

The main purpose is to provide a direct comparison between the AM different processes/ technologies and Injection molding. For Two different parts, and quantity:

Part.1 (Lever)



Part.2 (Cover part)



Assumptions:

- The machine **depreciation for AM machines is 8 years**, same for Injection molding.
- The capacity utilization for AM machines and injection molding **is 90% that means (7884 h per year)**.
- The costs of Injection molding will be provided in this case study.
- The estimation of Overheads costs is not included in this case study.
- The costs of AM processes will include machine setup, machine output, and post processing (which are labor activity), and Machine build. Thus, the costs for AM processes are broken down into:
 - **Machine costs**
 - **Labor costs**
 - **Material costs**
- The costs of producing parts by AM are calculated by assuming that a machine produces one part consistently for 1 year.

The cost model equations:

Calculation of Machine costs, that estimate the total machine cost for one part, by each of the AM process.

	Variable	Obtained by
Number per platform	N	Maximum possible in one build
Platform build time	T	Hours
Production rate per hour	R	N/T
Hours per year in operation	HY	$365 \times 24 \times 90\% = 7884$
Production volume total per year	V	$R \times 7884$
<i>Machine costs</i>		
Machine and ancillary equipment	E	Machine purchase cost
Equipment depreciation per year	D	$E/8$
Machine maintenance per year	M	Most comprehensive package
Total machine cost per year	MC	$D + M$
Machine cost per part	MCP	MC/V

Calculation of Labor cost, to formulate the labor costs per part for each AM process used. The operator (for machine setup, and post processing) hourly rate (€/h) cost is **5.30 euros per hour**.

	Variable	Obtained by
Number per platform	N	Maximum possible in one build
Platform build time	T	Hours
Production rate per hour	R	N/T
Hours per year in operation	HY	$365 \times 24 \times 90\% = 7884$
Production volume total per year	V	$R \times HY$
<i>Labour costs</i>		
Machine operator cost per hour	Op	Minimum wage 5.30 euros
Set-up time to control machine	Set	Timed
Post-processing time per build	$Post$	Timed
Labour cost per build	L	$Op \times (Set + Post)$
Labour cost per part	LCP	L/N

Calculating material costs, however, the different nature of AM processes employed necessitated the use of different means for calculating material costs.

For SL it was sufficient to weight completed parts with supports in order to calculate the cost.

For FDM it was sufficient to weight parts and support separately and then to multiply these by the associated material costs to find the material cost.

For LS a more complex formula is required to estimate the material cost. It also assumed that no material was to be recycled to ensure the consistent part quality, only new material. The mass of material used was calculated in terms of sintered material (by weighing parts) and un-sintered material (by calculating the volume of unused material and multiplying this by its un-sintered density).

	Variable	Obtained by
Number per platform	N	Maximum possible in one build
<i>Material costs for SL</i>		
Material per part including support (kg)	SLMass	Weighing finished parts
Material cost per kg	SLcost	Quote = 275.20 euros
Material cost per SL part	SLMCP	$SLMAss \times SLcost$
<i>Material costs for FDM</i>		
Material per part (kg)	FDMPM	Weighing finished parts
Support material per part (kg)	FDMSM	Weighing finished supports
Build material cost per kg	FDMPC	Quote = 400.00 euros
Support material cost per kg	FDMSC	Quote = 216.00 euros
Material cost per FDM part		$(FDMPM \times FDMPC) + (FDMSM \times FDMSC)$
<i>Material costs for LS</i>		
Material cost per kg	LSC	Quote = 54.00 euros
Mass of each part	LSM	Weighing finished parts
Volume of each part	VP	Found with Magics software
Total build volume	TBV	$34 \times 34 \times 60 \text{ cm}^3$
Mass of sintered material per build	LSMS	$N \times LSM$
Mass of unsintered material per build	LSMU	$(TBV - N \times VP) \times 0.475^*$
Cost of material used in one build	LSMC	$(LSMU + LSMS) \times LSC$
Material cost per LS part	LSMCP	$LSMC/N$

* Published density of unsintered LS powder is $0.45\text{--}0.5 \text{ g/cm}^3$

The costs using Injecting molding

	Part name	
	Lever	Cover
Tool cost (euro)	27 360	32 100
Unit cost (euro)	0.23	0.21

Requirement for the cost estimation:

For SL:

Both parts were build using **Epoxy material** on **SLA7000 machine**.

- ☐ Number per platform: Lever: 190, Cover: 22
- ☐ Platform build time (h): Lever: 26.8, Cover: 24.73
- ☐ Machine and support equipment (€): 1040000
- ☐ Machine maintenance (€/year): 89000
- ☐ Machine setup time (min): Lever: 33, Cover: 30
- ☐ Post-processing time per build (min): Lever; 49, Cover:68
- ☐ Material per part including support (Kg): Lever; 0.0047, Cover: 0.0551
- ☐ Material cost (€/kg): 275.20

For FDM:

Both parts were build using **ABS material**, on **FDM 2000 machine**.

- ☐ Number per platform: Lever: 75, Cover: 4
- ☐ Platform build time(h): Lever: 67.27, Cover: 31.40
- ☐ Machine and support equipment (€): 101280
- ☐ Machine maintenance (€/year): 10560
- ☐ Machine setup time (min): Lever: 10, Cover: 10
- ☐ Post-processing time per build (min): Lever:60, Cover:5
- ☐ Material per part (kg): Lever: 0.0035, Cover: 0.04
- ☐ Support material per part (kg): Lever: 0.0016, Cover: 0.027
- ☐ Build material cost (€): 400
- ☐ Support material cost per part (€): 216

For LS:

Is only used to fabricate the **Lever** part only. Using **Nylon material** on **EOSP360 machine**.

- ☐ Number per platform: Lever: 1056
- ☐ Platform build time(h): Lever: 59.78
- ☐ Machine and support equipment (€): 340000
- ☐ Machine maintenance (€/year): 30450
- ☐ Machine setup time (min): Lever: 120
- ☐ Post-processing time per build (min): Lever:360
- ☐ Material cost (€/kg): 54
- ☐ Mass of each part (Kg): 0.0036
- ☐ Volume of each part (cm3): 4.3

Question:

Compare the different AM process costs with the Injection molding costs, for each part. And select the best process to adopt for each part. Write a short summary satisfying which process is more effective to adopt or use to manufacture each part (Lever, Cover).

Try to propose tables for the solutions, as it shown at the beginning of this case study (**calculation of machine costs, labor costs, and material costs**), by the finding the required parameters for the estimation for both parts costs.

Question Case 2:

Using the same cost model equations, we need to estimate the cost **using LS** for other part, using different machine, and different material. In this case we will use two different machines **EOS M290, and EOS M400-4**. And **316L Stainless Steel** material. Then compare the cost for a single part using these different machines, and write a summary which machine is more cost effective to use/ buy to manufacture the part, and why?

Also, what will happen if we exclude the **cost of un-sintered powder**? For the case that this powder will be used again for other purpose. That is mean only including the cost **of sintered powder** for the material used cost, does it affect the decision of which machine to select or use? And in your opinion, why? if this affect the decision?

Requirement for the estimation:

For LS using EOS M290 machine:

- ☐ Number per platform: 15
- ☐ Platform build time(h): 26.1
- ☐ Machine and support equipment (€): 480000
- ☐ Machine maintenance (€/year): 48000
- ☐ Machine utilization rate is the same 90%, that means (7884 h) hours per year operation
- ☐ Machine depreciation: changed to (6 years)
- ☐ Machine setup time (min): 18 min
- ☐ Post-processing time per build (min): 45 min
- ☐ Operator hourly rate (€/h): is changed to **39**, required more skilled operator
- ☐ Material Type: 316L Stainless Steel
- ☐ Material cost (€/kg): 40
- ☐ Total build volume (cm³): 25 x 25 x 35
- ☐ Mass of each part (Kg): 0.182
- ☐ Volume of each part (cm³): 23.1
- ☐ Un-sintered density (g/cm³): 4.74 (0.00474 kg/cm³)

For LS using EOS M400-4 machine:

- ☐ Number per platform: 40
- ☐ Platform build time(h): 21.7
- ☐ Machine and support equipment (€): 1420000
- ☐ Machine maintenance (€/year): 142000
- ☐ Machine utilization rate is the same 90%, that means (7884 h) hours per year operation
- ☐ Machine depreciation: changed to (6 years)
- ☐ Machine setup time (min): 48
- ☐ Post-processing time per build (min): 120
- ☐ Operator hourly rate (€/h): is changed to **39**, required more skilled operator
- ☐ Material Type: 316L Stainless Steel
- ☐ Material cost (€/kg): 40
- ☐ Total build volume (cm³): 40 x 40 x 40
- ☐ Mass of each part (Kg): 0.182
- ☐ Volume of each part (cm³): 23.1
- ☐ Unstinted density (g/cm³): 4.74 (0.00474 kg/cm³)

Solutions for Case 1:

The costs for SL:

	Part name	
	Lever	Cover
Number per platform	190	22
Platform build time (h)	26.80	24.73
Production rate per hour (h^{-1})	7.09	0.89
Hours per year in operation (h)	7884	7884
Production volume total per year	55 894	7014
<i>Machine costs</i>		
Machine and ancillary equipment (euro)	1 040 000	1 040 000
Equipment depreciation cost per year (euro)	130 000	130 000
Machine maintenance cost per year (euro)	89 000	89 000
Total machine cost per year (euro)	219 000	219 000
Machine cost per part (euro)	3.92	31.22
<i>Labour costs</i>		
Machine operator cost per hour (euro)	5.30	5.30
Set-up time to control machine (min)	33	30
Post-processing time per build (min)	49	68
Labour cost per build (euro)	7.24	8.65
Labour cost per part (euro)	0.04	0.39
<i>Material costs</i>		
Material per part including support (kg)	0.0047	0.0551
Material cost per kg (euro)	275.20	275.20
Material cost per part (euro)	1.29	15.16
Total cost per part (euro)	5.25	46.78

	Part name	
	Lever	Cover
Number per platform	190	22
Machine cost per part (euro)	3.92	31.22
Labour cost per part (euro)	0.04	0.39
Material cost per part (euro)	1.29	15.16
Total cost per part (euro)	5.25	46.78

The costs for FDM:

	Part name	
	Lever	Cover
Number per platform	75	4
Platform build time (h)	67.27	31.40
Production rate per hour (h^{-1})	1.11	0.13
Hours per year in operation (h)	7884	7884
Production volume total per year	8790	1004
<i>Machine costs</i>		
Machine and ancillary equipment (euro)	101 280	101 280
Equipment depreciation cost per year (euro)	12 660	12 660
Machine maintenance cost per year (euro)	10 560	10 560
Total machine cost per year (euro)	23 220	23 220
Machine cost per part (euro)	2.64	23.12
<i>Labour costs</i>		
Machine operator cost per hour (euro)	5.30	5.30
Set-up time to control machine (min)	10	10
Post-processing time per build (min)	60	5
Labour cost per build (euro)	6.18	1.32
Labour cost per part (euro)	0.08	0.33
<i>Material costs</i>		
Material per part (kg)	0.0035	0.04
Support material per part (kg)	0.0016	0.027
Build material cost per kg (euro)	400.00	400.00
Support material cost per kg (euro)	216.00	216.00
Material cost per part (euro)	1.75	21.83
Total cost per part (euro)	4.47	45.28

	Part name	
	Lever	Cover
Number per platform	75	4
Machine cost per part (euro)	2.64	23.12
Labour cost per part (euro)	0.08	0.33
Material cost per part (euro)	1.75	21.83
Total cost per part (euro)	4.47	45.28

For LS costs:

	Part name	
	Lever	Cover
Number per platform	1056	—
Platform build time (h)	59.78	—
Production rate per hour (h^{-1})	17.66	—
Hours per year in operation (h)	7884	—
Production volume total per year	139269	—
<i>Machine costs</i>		
Machine and ancillary equipment (euro)	340000	—
Equipment depreciation cost per year (euro)	42500	—
Machine maintenance cost per year (euro)	30450	—
Total machine cost per year (euro)	72950	—
Machine cost per part (euro)	0.52	—
<i>Labour costs</i>		
Machine operator cost per hour (euro)	5.30	—
Set-up time to control machine (min)	120	—
Post-processing time per build (min)	360	—
Labour cost per build (euro)	42.37	—
Labour cost per part (euro)	0.04	—
<i>Material costs</i>		
Material cost per kg (euro)	54	—
Mass of each part (kg)	0.0036	—
Volume of each part (cm^3)	4.3	—
Mass of sintered material per build (kg)	3.8016	—
Mass of unsintered material per build (kg)	32	—
Cost of material used in one build (euro)	1725.72	—
Material cost per part (euro)	1.63	—
Total cost per part (euro)	2.20	—

	Part name	
	Lever	Cover
Number per platform	1056	—
Machine cost per part (euro)	0.52	—
Labour cost per part (euro)	0.04	—
Material cost per part (euro)	1.63	—
Total cost per part (euro)	2.20	—

Solution for Case 2:

For LS using M290	
	Part
Number per platform	15
Platform build time (h)	26,1
Production rate per hour (1/h)	0,574712644
Hours per year in operation (h)	7884
Production volume total per year	4531,034483
Machine costs	
Equipment and ancillary equipment (€)	480000
Equipment depreciation (year)	6
Equipment depreciation cost per year (€)	80000
Machine maintenance cost per year €	48000
Total machine cost per year (€)	128000
Machine cost per part (€)	28,24961948
Labour costs	
Machine operator cost per hour (€/h)	39
Setup time to control machine (min)	18 (0,3h)
Post-processing time per build (min)	45 (0,75 h)
labour cost per build €	40,95
labor cost per part €	2,7
Material costs	
Material cost per kg (€/kg)	40
Mass of each part (kg)	0,182
Volume of each part (cm3)	23,1
Total build volume cm3	25 x 25 x 35 cm3
Mass of sintered material per build (kg)	2,73
Mass of unsinterd material per build (kg)	102
Cost of material used in one build €	4189,2
Material cost per part €	279,28
Total cost per part €	307,5296195

For LS using M400-4	
	Part
Number per platform	40
Platform build time (h)	21,7
Production rate per hour (1/h)	1,84
Hour per year in operation (h)	7884
Production volume total per year	14506,56
Machine costs	
Equipment and ancillary equipment (€)	1420000
Equipment depreciation (year)	6
Equipment depreciation cost per year (€)	236666,6667
Machine maintenance cost per year €	142000
Total machine cost per year (€)	378666,6667
Machine cost per part (€)	26,10313311
Labour costs	
Machine operator cost per hour (€/h)	39
Setup time to control machine (min)	48 (0,8)
Post-processing time per build (min)	120 (2 h)
labour cost per build €	109,2
labor cost per part €	2,73
Material costs	
Material cost per kg (€/kg)	40
Mass of each part (kg)	0,182
Volume of each part (cm3)	23,1
Total build volume cm3	40 x 40 x 40 cm3
Mass of sintered material per build (kg)	7,28
Mass of unsinterd material per build (kg)	299
Cost of material used in one build €	12250,4
Material cost per part €	306,26
Total cost per part €	332,3631331

If we exclude the un-sintered material cost:

For M290:

Un-sintered material cost for the build = 4080 €

Material cost for one part = 7.28 €

Material cost for the build = 109.2 €

Total part cost = 38.22 €

For M400-4:

Un-sintered material cost for the build = 11960 €

Material cost for one part = 7.28 €

Material cost for the build = 291.2 €

Total part cost = 36.11 €