

QUICK CHANGE PLATE COST ANALYSIS WORKSHEET (REPLACING CASTERS)

Part 1 - Old Process: Removal & Installation Cost

- | | | |
|---|-------|------------|
| 1. How many minute(s) does it take to remove one wheel and rig from the unit? | _____ | Minute(s) |
| 2. How many rigs do you have to cut off per unit? | _____ | Rig(s) |
| 3. Multiply line #1 with line #2 | _____ | Minutes(s) |
| 4. How many unit(s) do you have to rework? | _____ | Unit(s) |
| 5. Multiply line #3 with line #4 | _____ | Minute(s) |
| 6. Divide 60 into line #5 | _____ | Total Time |
| 7. Multiply worker(s) hourly rate with line #6 (Total Job Cost) | _____ | Total Cost |
- Note: Apply any other directly related costs (i.e. grinding wheels, cutting torch, paint)*

Part 2 - New Quick Change Plate (QCP) Installation Cost

- | | | |
|---|-------|------------|
| 8. How many minute(s) does it take to weld one QCP onto unit? | _____ | Minute(s) |
| 9. How many QCP's will you need to weld onto unit? | _____ | QCP(s) |
| 10. Multiply line #8 with line #9 | _____ | Minute(s) |
| 11. How many unit(s) do you have to rework? | _____ | Unit(s) |
| 12. Multiply line #10 with line #11 | _____ | Minute(s) |
| 13. Divide 60 into line #12 | _____ | Total Time |
| 14. Multiply worker(s) hourly rate with line #13 | _____ | Total Cost |
- Note: Apply any other directly related costs (i.e. grinding wheels, cutting torch, paint)*

Part 3 - Caster Change - Removal & Installation cost with QCP

- | | | |
|--|-------|-------------------|
| 15. How long to lift unit in order to remove caster from QCP? | _____ | Minute(s) |
| 16. How long to remove retainer nut and bolt or a pull pin from QCP? | _____ | Minute(s) |
| 17. How long to remove old caster & install new caster into QCP? | _____ | Minute(s) |
| 18. How long to reinstall the nut & bolt or a pull pin into QCP? | _____ | Minute(s) |
| 19. Add line #15, 16, 17, 18, 19 | _____ | Minute(s) |
| 20. How many caster(s) per unit do you have to change out? | _____ | Caster (s) |
| 21. Multiply line #19 with line #20 | _____ | Minute(s) |
| 22. How many unit(s) do you have to rework? | _____ | Unit(s) |
| 23. Multiply line #21 with line #22 | _____ | Minute(s) |
| 24. Divide 60 into line #23 | _____ | Total Time |
| 25. Multiply worker(s) hourly rate with line #24 | _____ | Total Cost |
| 26. Divide number of casters per unit into line #25 | _____ | Total Cost/Caster |

Part 4 - After initial cost to install the Quick Change Plate, subtract line #7 from line #25 to see how fast you will get a buy back on your investment

_____ Total Savings

Part 5 - Cost Analysis

Pro(s)

Con(s)

- | | | |
|-----------------|--|--|
| 27. Old Process | May be able to reuse wheel | When rig(s) are damaged repeat old process. Cost will be line #7 times 4 per rig. Rig is permanently damaged |
| 28. New Process | Major cost savings to replace rig and/or wheel after initial cost. Little down time for the unit. Rework rig and/or wheel if one or the other is good. Able to put back into inventory | Initial cost up front |