

JOB SHEET

Jenis Kerja	Unjuk Kinerja Peserta Diklat	Waktu (menit)
Persiapan Kerja	Siapkan : 1. Kertas jawaban disiapkan 2. pulpen. 3. kalkulator.	Total 5
Langkah Kerja	1. kertas soal dan jawaban ditempatkan pada meja. 2. Mengerjakan soal dengan tertib. .	5 45
Hasil Kerja	Mengerjakan soal dilengkapi dengan jawaban yang benar.	
Waktu Kerja	1. Persiapan kerja dilakukan dalam waktu 5 menit 2. Mengerjakan soal sesuai dengan jobsheet dilakukan dalam waktu 45 menit	
Total Waktu		120

SOAL

1. A 36 in. long cut is to be made on 4 in. diameter steel bars in an engine lathe. The depth of cut is 0,25 in. and the feed rate is 1,020 in. per revolution. Tool-life tests conducted for this operations yield the following equation :

$$VT^{0,25} = 200$$

The following costs were determined for this operation :

Machine labor	\$2,40 perhour
Machine burden rate	200 % of labour
Grinding labor	\$1,95 per hour
Grinding burden rate	250 % of labor
Loading time	5 min/part

Three types of carbide tools were used, namely brazed inserts, solid inserts, and throw away inserts.

For brazed inserts :

Original tool cost	\$2,64
Grinding time	6 min (1 cutting edge per grind)
Tool changing time	2 min
5 grinds available per tool before discard plus original cutting edge.	

