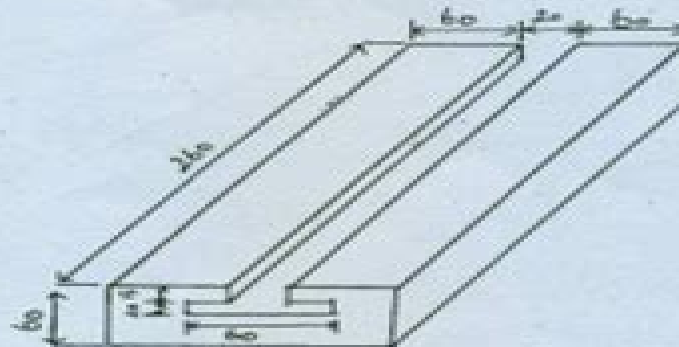
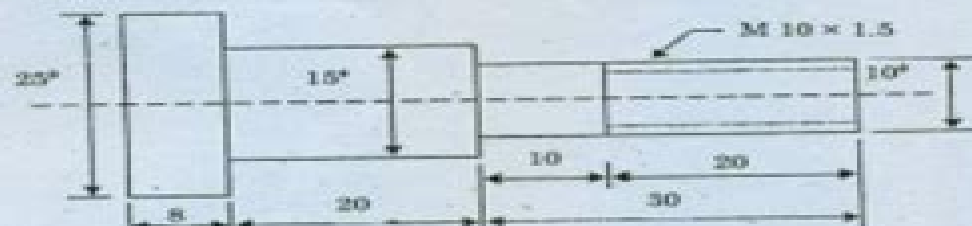


- (b) (i) In a manual operation, observed time for a cycle of operation is 0.5 minute and the rating factor as observed by the time study engineer is 125%. All allowances put together is 15% of normal time. Estimate the standard time. (8)
- (ii) In a manufacturing process the observed time for one cycle of operation is 0.75 minute. The rating factor is 110%. The following are the various allowances as the percentage of normal time.
 Personal allowance = 3%
 Relaxation allowance = 10%
 Delay allowance = 2%
 Estimate the standard time. (8)
15. (a) A T-slot is to be cut in a C.I. slab as shown in Fig. given below. Estimate the machining time. Take cutting speed 25 m/min, feed is 0.25 mm/rev. Dia of cutter for channel milling is 80 mm.



Or

- (b) Calculate the machining time required to produce one piece of the component shown in Fig. given below starting from $\phi 25$ mm bar. The following data is available.
 For turning :
 Cutting speed = 40 m/min.
 Feed = 0.4 mm/rev.
 Depth of cut = 2.5 mm/per pass
 For thread cutting :
 Cutting speed = 8 m/min.



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Table of Contents Me2027 2014 Question

1. Understanding the eBook Me2027 2014 Question
 - The Rise of Digital Reading Me2027 2014 Question
 - Advantages of eBooks Over Traditional Books
2. Identifying Me2027 2014 Question
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Me2027 2014 Question
 - User-Friendly Interface
4. Exploring eBook Recommendations from Me2027 2014 Question
 - Personalized Recommendations
 - Me2027 2014 Question User Reviews and Ratings
 - Me2027 2014 Question and Bestseller Lists
5. Accessing Me2027 2014 Question Free and Paid eBooks
 - Me2027 2014 Question Public Domain eBooks
 - Me2027 2014 Question eBook Subscription Services
 - Me2027 2014 Question Budget-Friendly Options
6. Navigating Me2027 2014 Question eBook Formats

- ePub, PDF, MOBI, and More
- Me2027 2014 Question Compatibility with Devices
- Me2027 2014 Question Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Me2027 2014 Question
 - Highlighting and Note-Taking Me2027 2014 Question
 - Interactive Elements Me2027 2014 Question
- 8. Staying Engaged with Me2027 2014 Question
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Me2027 2014 Question
- 9. Balancing eBooks and Physical Books Me2027 2014 Question
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Me2027 2014 Question
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Me2027 2014 Question
 - Setting Reading Goals Me2027 2014 Question
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Me2027 2014 Question
 - Fact-Checking eBook Content of Me2027 2014 Question
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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