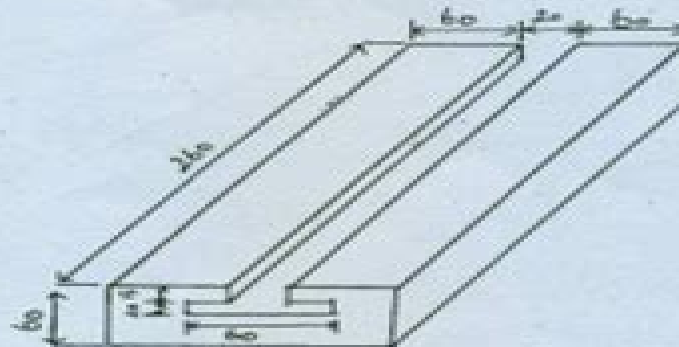
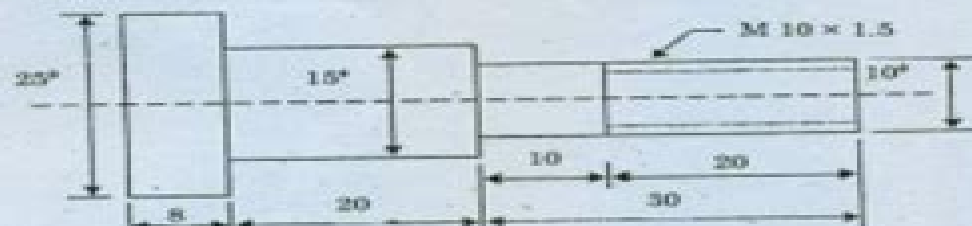


- (b) (i) In a manual operation, observed time for a cycle of operation is 0.5 minute and the rating factor as observed by the time study engineer is 125%. All allowances put together is 15% of normal time. Estimate the standard time. (8)
- (ii) In a manufacturing process the observed time for one cycle 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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Rachel Sandford



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