

Machine Rate (\$/hr)	Labor Rate (\$/hr)	% Labor	Material Cost (\$/lb)	Cycle Time (s)	Shot Weight (g)
21	15	0.25	3.23	17.3	57

Scrap %	Set-up Charge	Set-ups per Year	Annual Volume	Expected Margin (%)
3.5	\$1,500	4	750000	15

Annual Machine Hours	Annual Machine Cost	Annual Labor Cost	Annual Material Costs	Price per 1000	Expected Annual Profit