

KES

**Standard Installing Cost
Unit of Injected Product**

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1. Scope of application

This standard shall be applied to the standard installing cots unit of plastic raw material used at plastic factory injection line of the company.

2. Installing outline

Because the standard of cost unit is not existent and indefinite up to now, it is difficult to control accurate cost. So, it is on the purpose of establishing definite installing standard for cost reduction and material control.

3. Standard installing cost unit of material

Factor of cost unit	Classi-fying symbol	Installing standard		Cost unit on using new material(g)	Cost uniton using recycled material(g)
		Quantity	Calculating equation		
Product weight	A ₁	Net weight	Only g	A ₁ +A ₂ +A ₃ +A ₄ +A ₅	A ₁ +A ₅ + (A ₂ +A ₃ +A ₄) × 0. 1
Sprue, Runner weight	A ₂	Net weight	Only g		
Formed inferior product weight	A ₃	0.8%	$\frac{(A_1+A_2) \times 0.008}{1}$		
Initial shot weight (Possible recycling)	A ₄	x Shot/Lot	$\frac{(A_1+A_2) \times 10}{A_6} g$		
Purging weight (Impossible recycling)	A ₅	12 Shot/Lot	$\frac{(A_1+A_2) - \times 12 g}{A_6}$		
LOT unit	A ₆	Lot	Lot Shot		
Description of using material	New material			A ₁ +A ₂ +A ₃ +A ₄ +A ₅	A ₁ +A ₅ - (A ₂ +A ₃ +A ₄) × 0. 8
	Recycled material			0 g	(A ₂ +A ₃ +A ₄) × 0. 9

4. Factors and additional comment

- (1) A₁ indicates net weight of a product (Frt, Rr each weight)
- (2) A₂ indicates net weight of sprue, runner and gate.