

punches: 024-026 called the "parent" machine. - general items are charged to parent, & a share to each of children.
 "families" 046-047 called "children"

also have a "misc effort" category on regular machines.

Standards - benefits all machines break into { large scale } { existing }
 Reliability { regular } { new }

Special Engr. - not 4th element - unless they were called in specifically in devel.

"New products money" - first year's production part of 4th element.

Prod. devel is charged until ~50% of parts are released (but % is determined on particular case.)

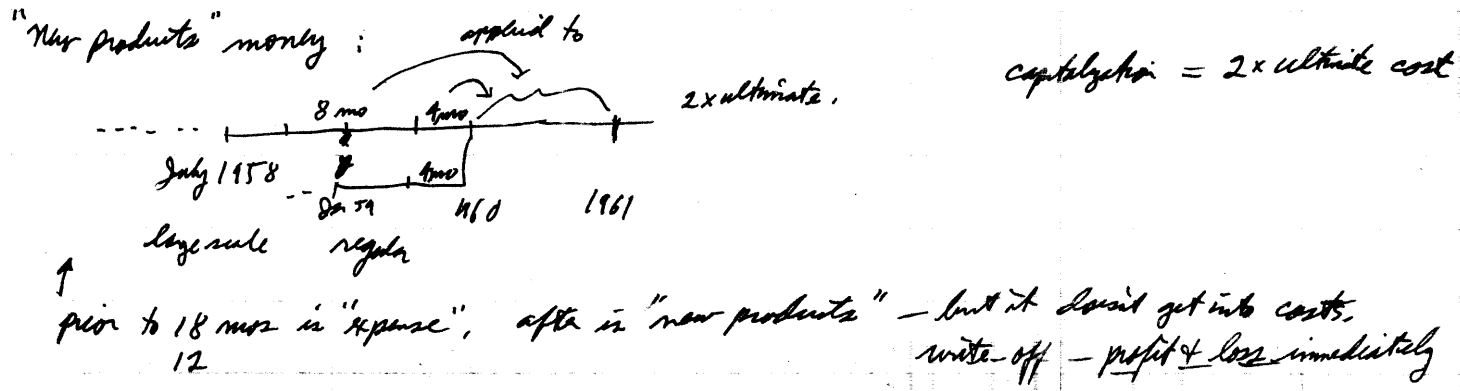
Example: 108 probably shouldn't have been in Proj. Engr.

for Each machine type:

Rate = $\frac{4 \text{ mos. Expense}}{4 \text{ mos. sched production}}$ } off-set in time
 $\frac{4 \text{ Exp}}{4 \text{ prod}}$ } changed 3 times a year.

4 mos of money on books at once ←

are trying to get on a 12 month basis.



Other types by Engineering,

1. Machine Improvement
2. Cost reduction
3. Factory service,

"Serviceability" part of machine improvement - to C.E. not part of 4th element
after 2 years in plant.

New procedure on components: cost for year ^{eg} if actual cost of tenants
is \$30, but year schedule
is \$10, product is charged
with \$10 & rest goes to prod. & loss

{ purchased parts = now is largest part of cost of medicines.
- P&L is becoming more an assembly plant & less a mfg. plant.

Movement of machines from one loc. to another - no. of expenses chargeable to P. & L.
depends on case.