

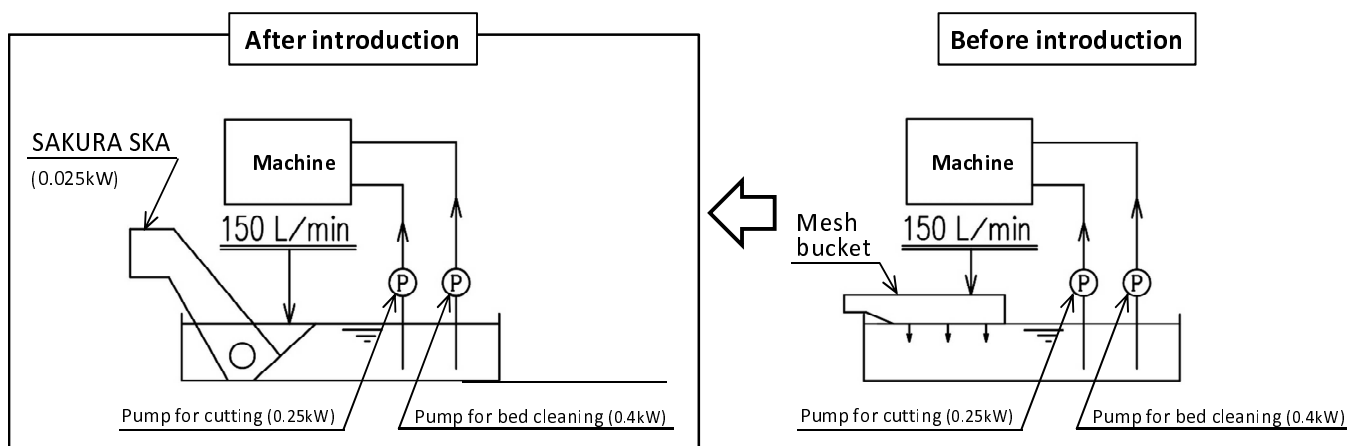
Advantageous effects of introducing "SAKURA" on environmental & energy conservation.



BUNRI Inc.
2015.9

For Machining center		Per year	Per 10 years
Comparison in running cost	Before introduction	¥2,279,200	¥22,792,000
	After introduction	¥156,400	¥1,564,000
Expected amount of money saved		¥2,122,800	¥21,228,000

Machine classification	Workpiece	Material	Coolant
Boring machine	Cylinder head	Aluminum	Water soluble: 150 L/min



Items	BUNRI's recommended model		Conventional product		
	Unit for cutting SAKURA	Expense	Mesh bucket	Expense	
Running cost	Sludge cleaning	Nil	¥ 4,000/h × 0.25 h × 8 times/day × 20 day/month × 12 months/year	1,920,000	
	Tank cleaning	¥ 4,000/h × 4 h/time × 2 times/year × 2 persons	64,000	¥ 4,000/h × 4 h/times × 4 times/year × 2 persons	128,000
	Pump cleaning	Nil	0	¥ 4,000/h × 0.5 h/times × 4 times/year	8,000
	Machining failure loss	Nil	0	¥500/piece × 8 pieces/month × 12 months	48,000
	Machine stop loss	Nil	0	¥ 2,000/h × 0.25 h × 4 times/month × 12 months	24,000
	Coolant change	¥ 200/L × 25 L/time × 2 times/year	10,000	¥ 200/L × 25 L/time × 4 times/year	20,000
	Waste coolant disposal	¥ 25/L × 1000 L/time × 2 times/year	50,000	¥ 25/L × 1000 L/time × 4 times/year	100,000
	Power consumption	0.025+0.4+0.25 = 0.675kW 0.675kW × 20 h/day × 20 day/month × 12 months/year =3,240kW : ¥ 10/kW × 3,240kW	32,400	0.4+0.25=0.65kW 0.65kW × 20 h/day × 20 day/month × 12 months =3,120kW : ¥ 10 /kW × 3,120kW	31,200
Total annual expense	156,400		2,279,200		
Expected annual amount of money saved	¥2,122,800				