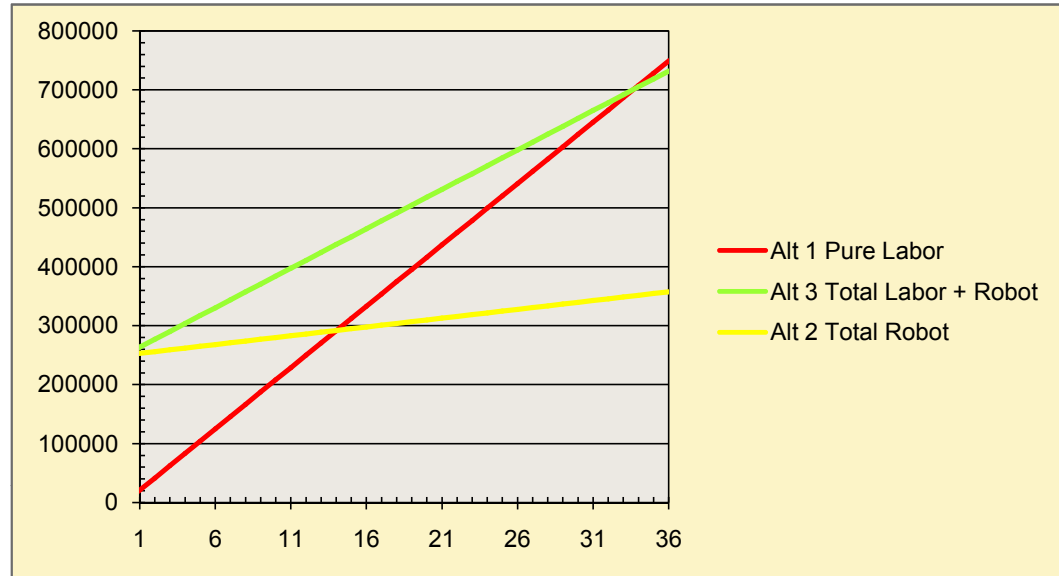


## Automation Cost and Savings Analysis

Months	Alt 1 Pure Labor	Alt 2 Total Robot	Alt 3 Total Labor + Robot
0	0	250000	250000
1	20800	252980	263380
2	41600	255960	276760
3	62400	258940	290140
4	83200	261920	303520
5	104000	264900	316900
6	124800	267880	330280
7	145600	270860	343660
8	166400	273840	357040
9	187200	276820	370420
10	208000	279800	383800
11	228800	282780	397180
12	249600	285760	410560
13	270400	288740	423940
14	291200	291720	437320
15	312000	294700	450700
16	332800	297680	464080
17	353600	300660	477460
18	374400	303640	490840
19	395200	306620	504220
20	416000	309600	517600
21	436800	312580	530980
22	457600	315560	544360
23	478400	318540	557740
24	499200	321520	571120
25	520000	324500	584500
26	540800	327480	597880
27	561600	330460	611260
28	582400	333440	624640
29	603200	336420	638020
30	624000	339400	651400
31	644800	342380	664780
32	665600	345360	678160
33	686400	348340	691540
34	707200	351320	704920
35	728000	354300	718300
36	748800	357280	731680



Hourly Rate	20	per hour	Robot Cost	100000	initial
Labor Hour (2 Emp.)	40	per hour	Robot Install. & Maint.	150000	over 5 years
Hour per Shift	8	hrs	Total Robot Cost	250000	over 5 years
Shifts per Day	3	daily	Electricity per Month	900	monthly
Labor Cost per Shift	320		Robot Efficiency	90%	Two Humans
Hours per Day	24		Robot Effic. Cost	2080	Per Month
Labor Cost per Day	960				
Work Week	5	weekly			
Hours per Week	120	weekly			
Labor Cost per Week	4800	weekly			
Weeks per Year	52	annually			
Months per Year	12	annually			
Weeks per Month	4.3333333	monthly			
Labor Cost per Month	20800	monthly			
Labor Cost per Year	249600	annually			

Alt 2 Minus Elect. & Effic.	Alt 2 Minus Effic.	Alt 3 Minus Elect. & Effic.	Alt 3 Minus Effic.
250000	250000	250000	250000
250000	250900	260400	261300
250000	251800	270800	272600
250000	252700	281200	283900
250000	253600	291600	295200
250000	254500	302000	306500
250000	255400	312400	317800
250000	256300	322800	329100
250000	257200	333200	340400
250000	258100	343600	351700
250000	259000	354000	363000
250000	259900	364400	374300
250000	260800	374800	385600
250000	261700	385200	396900
250000	262600	395600	408200
250000	263500	406000	419500
250000	264400	416400	430800
250000	265300	426800	442100
250000	266200	437200	453400
250000	267100	447600	464700
250000	268000	458000	476000
250000	268900	468400	487300
250000	269800	478800	498600
250000	270700	489200	509900
250000	271600	499600	521200
250000	272500	510000	532500
250000	273400	520400	543800
250000	274300	530800	555100
250000	275200	541200	566400
250000	276100	551600	577700
250000	277000	562000	589000
250000	277900	572400	600300
250000	278800	582800	611600
250000	279700	593200	622900
250000	280600	603600	634200
250000	281500	614000	645500
250000	282400	624400	656800