

Comparative statement of Mini-Multi Blades Vs Single Blades				
MACHINE	Diacore Mini Multi Machine		Other Single Blade Machine	
Area	Madurai		Madurai	
Customer	Madura Stones		Madura Stones	
Name of Stone	Ivory (A)		Ivory (A)	
Coolant	Water		Water	
Block No	A-1		A-2	
COSTS				
Price of Slab (Present market Value)	Rs/Sq.Ft	90	Rs/Sq.Ft	90
Power cost	Rs/Unit	5.45	Rs/Unit	5.45
Segment Cost	Rs/Set	50000	Rs/Set	12000
	Rs/Sq.Ft	4.17	Rs/Sq.Ft	2.67
OPERATING PARAMETERS				
Blade Diameter	M	2	M	2.5
Flange Thickness	mm	18	mm	Not Applicable
RPM of Blade	RPM	320	RPM	240
Tip Speed for the biggest Dia	m/sec	33.5	m/sec	31.4
Thickness of Blades	mm	5.5	mm	8
Thickness of Segments (mm)	Bottom	6	Bottom	9.5
	Top	7	Top	10.7
Slot Size (Average)	mm	7.2	mm	12
Block Size (M)	Length (L)	2.4	Length (L)	3.14
	Width (W)	1.4	Width (W)	1.4
	Depth (D1)	1	Depth (D1)	1.1
	Depth (D2)	0.6	Depth (D2)	0.914
Depth Of Cut	mm	4	mm	12
SLAB RECOVERY				
Thickness of slab	mm	18	mm	18
Area of each slab cut (LXD2)	Sq.Ft	15.49	Sq.Ft	30.88
Slabs recovered for the block	Pieces	56	Pieces	47
Area of Total slabs Cut	Sq.Ft	861	Sq.Ft	1441
Area of total slabs per metre width	Sq.Ft	615	Sq.Ft	1029
Area of total slabs per day of 20 hours	Sq.Ft	1230	Sq.Ft	626
Area of slab cut per hour	Sq.Ft	61	Sq.Ft	31
Slabs recovered per M width	Sq.Ft	40	Sq.Ft	33
TIME				
Time taken to cut entire block	hours	14	hours	46
Time per M width of block	hours	10	hours	33
Time taken per slab	minutes	15	minutes	59
POWER CONSUMPTION				
Highest Load Amperage	Amps	30	Amps	30
Voltage at site	Volts	415	Volts	415
Power consumed per hour	Kwh (Units)	17.25	Kwh (Units)	17.25
Power consumed- total block	Kwh (Units)	242	Kwh (Units)	794
Power consumed per slab	Kwh (Units)	4	Kwh (Units)	17
Power Consumed per Sq.Ft	Kwh (Units)	0.28	Kwh (Units)	0.55

PRODUCTIVITY						
					SAVINGS	% increase
Total Production per day of 20 hrs	Sq.Ft	1,230	Sq.Ft	626	603	96
Total Production month of 25 days	Sq.Ft	30,738	Sq.Ft	15,662	15,076	96
Total Production per year of 300 days	Sq.Ft	3,68,859	Sq.Ft	1,87,942	1,80,917	96