Anodizing and Plating Rack Log

How-to guide: what the workbook does, how to use it and what every number means. mfgcalcs.com

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Log every anodizing or plating order and see rack cycles, rack occupancy, first-pass yield, cost per good part and headroom to the price, by part, process and week.

For: Anodizing and plating shop managers, line supervisors, quality engineers and estimators, and buyers of finishing.

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Quick start

1. On Setup, type your shop name, currency and targets, then replace the example processes (cost per rack cycle and setup cost), parts (parts per rack and price) and defects.
2. On Rack Log, add one row per order: the part, the process, parts processed, parts accepted first time and the main defect.
3. Read the Check column: accepted parts can never outnumber the parts processed.
4. Use the Dashboard filters to look at one part, one process or one week.

What is in the workbook

Start Here	Read this first: what the workbook does and how to use it.
Setup	Your shop, currency and targets, and the process, part and defect lists.
Rack Log	One row per order: parts processed and accepted first time, with rack cycles, occupancy, cost and headroom.
Dashboard	Rack cost, first-pass yield, rack occupancy and headroom, for the parts, processes and dates you choose.
Method	How every number is calculated, with assumptions, limits and sources.
Verify	Self-check: the workbook's formulas recomputed on fixed inputs against an independent reference.
About MFG Calcs	Everything MFG Calcs offers, free: calculators, templates, tariff tools, data and the Calkee AI helper.

What each number means

Quantity	How it is calculated	Units
Parts processed and first-pass accepted	Typed per order; accepted means passed first time, without stripping or rework.	parts
Rejected	Parts processed - first-pass accepted.	parts
First-pass yield	First-pass accepted / parts processed.	%

Quantity	How it is calculated	Units
Rack cycles	ROUNDUP(parts processed / parts per rack, 0): whole rack loads.	racks
Rack slots and unused slots	Rack cycles x parts per rack, and rack slots - parts processed.	slots
Occupancy	Parts processed / rack slots.	%
Rack cycle cost	Rack cycles x the process's cost per rack cycle.	currency
Order cost	Rack cycle cost + the process's setup cost.	currency
Cost per good part	Order cost / first-pass accepted.	currency/part
Good part value	Price per part x first-pass accepted; blank when the part has no price.	currency
Headroom per good part	Price per part - cost per good part.	currency/part
Lookups	Customer, parts per rack and price per part from the Parts list; cost per rack cycle and setup cost from the Processes list (INDEX/MATCH).	-
Dashboard roll-ups	Every figure is a SUMIFS over the Rack Log restricted to rows whose View date is filled in (inside the filters), e.g. cost per good part = SUMIFS(order cost) / SUMIFS(first-pass accepted), headroom = (SUMIFS(good part value) - SUMIFS(order cost of priced orders)) / SUMIFS(first-pass accepted of priced orders).	-
Rejects Pareto	Rejected parts per defect, ranked largest first by COUNTIF ranks (ties keep list order), with each defect's share and the cumulative share. Helper columns on the Dashboard (hidden) hold the unsorted values and ranks.	parts, %

Assumptions, limitations, sources and the self-check (the Verify sheet, which recomputes the workbook's formulas on fixed test inputs) are in the workbook. The last page shows the Dashboard with the example data for Quillmere Finishing, a fictional business.

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Engineering estimates for planning and improvement work. Verify the results against your own process, data and standards before you rely on them.

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Rack cost, first-pass yield, rack occupancy and headroom, for the parts, processes and dates you choose.

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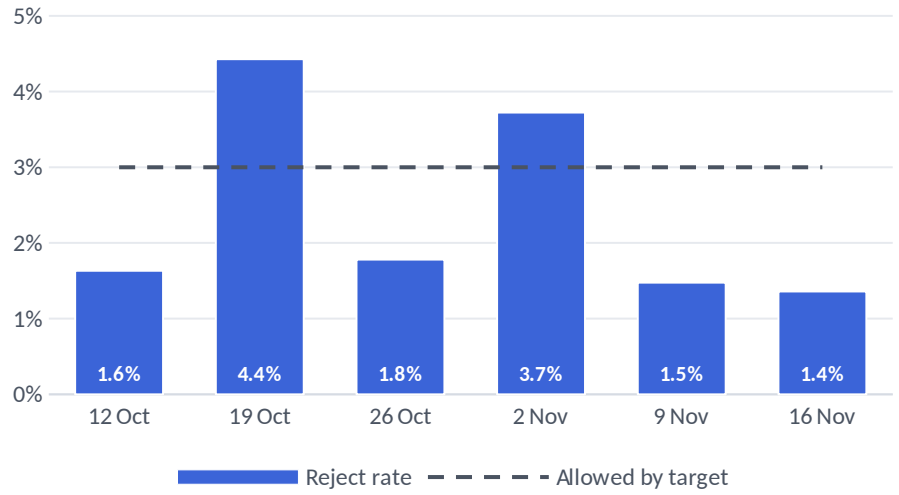
Part		From	
Process		To	

Showing 159 orders. Leave the filters blank to include everything; dates are inclusive. Money in USD.

COST PER GOOD PART (USD)	FIRST-PASS YIELD	RACK OCCUPANCY	HEADROOM PER GOOD PART (USD)
2.21	**97.8%**	**96.3%**	**+0.41**
Order cost / first-pass accepted	Target 97.0%	Target 90.0%	Price - cost per good part, priced orders
	On target	On target	

First-pass rejects by week



Cost per good part against price, by part

