I'm not a bot

Hey all We recently visited DMG in Chicago and they gave us a cycle time estimate for a part we are currently running on 1 of our lathes.Looking at it, I realized it was an excel file.It broke down the operations (ex.turn, cutoff, drill,etc.)gave a cuttime for each and added them up for a total cycle time on that machine.Does anyone have an excel file that does this?Have looked all over the web and cant seem to find one-free or not. Thanx ACE I have one that's set up for lathes. I can also send you an xla file that you can edit with visual basic, which will allow you to set up the parameters for each machine, max rpm, chip to chip time, etc...Send me an e-mail. Does it include all the factors involved in calculating the cycle start to cycle start time such as Idiot operator deciding to hit the part against the stop, moving the stop in the process Idiot operator picking his nose instead of changing parts Idiot operator playing with his mobile phone/Ipod/wanger..... no delete the last oneIdiot operator just not being there.Idiot operator getting a P45* for being such a pillock. Oh well rant over... lets hope the next operator will be an improvement on the last one it would'nt be hard Boris* P45 :- Tax form detailing your previous earnings, used when you leave or get fired from a company I'd be interested in that as well... Kindly share excel I have one that's set up for lathes. I can also send you an xla file that you can edit with visual basic, which will allow you to set up the parameters for each machine, max rpm, chip to chip time, etc...Send me an e-mail. Hello,kindly share excel sheet of cycle time calculations. my e mail id is Regards,Venkatesh R Kamat Hey all We recently visited DMG in Chicago and they gave us a cycle time estimate for a part we are currently running on 1 of our lathes.Looking at it, I realized it was an excel file.It broke down the operations (ex.turn, cutoff, drill,etc.)gave a cuttime for each and added them up for a total cycle time on that machine.Does anyone have an excel file that does this?Have looked all over the web and cant seem to find one-free or not. Thanx ACE ..i would recommend you take 2 minutes and learn how to enter a math formula into excel. it can add cells or any math you want. takes about 5 seconds to enter a math formula.i usually use a excel work log and record times as program progresses and calculate average time a program was run before. thus if average is 5.0 hours and i am over average like 5.4 hours i record why i am over average time. it identifies problems, which i work on correcting so they do not happen again. so average time goes down as improvements are made not just to program but other things like checking critical stuff before it creates a problem. basically they are warnings. watch out or check this, it caused problems before I know that this is an old thread but don't you guys use CAM? I know that Gibbs CAD/CAM and Bob CAD/CAM give you the overall cycle time and break it down into cycle time per operations. No math involved. I know that this is an old thread but don't you guys use CAM? I know that Gibbs CAD/CAM and Bob CAD/CAM give you the overall cycle time and break it down into cycle time per operations. No math involved. Why would you need CAD/CAM? It's easy to figure out how many Cubes you're moving a Minute. That is what the software does for you. What it doesn't do is add all the variables. Even the ones you know are there. IE how much time does the software calculate when it runs into an M0 for El Operator to do something? How does it work out Dogleg Rapids(rapids also not a real word Bob, but we'll go with it), as opposed to 90 Rapids, Rapid-Acceleration and Deceleration, Total IPM Rapids? Does it calculate the .02 deceleration of the Drill when it is Peck Drilling? Is Peck Drill deceleration set up in your Machine? Does that Machine even do that? When using G96, does it account for the time it takes when it gets to max spindle speed? Does it account for the time it takes for a Live Tool to engage gears? What about Turret index time? What if you are really taking a cut and getting into the torque band of the motor (but without error)? There are too many variables to really do it. And that isn't just CAD/CAM, it's any Excel spreadsheet or whatever.Robert my experience CAM time calculations are of limited use. i can set the timer on a CNC that measures actual run time. if job is 8 hours and CNC says it was running 4 hours it is of limited use. 10 operators make 100 parts over many years and nobody and i mean nobody does job in 4 hours cause it take more time that just machine time.Excel work log you can record what is taking time. repeated problems can be recorded and thats what i work on. for example broke drill bit and spent time getting it out of hole and then finish the drilling. CAM never mentions tooling problems even though it can consume considerable time CAM cycle time rarely reflects actual time to run a program. i have seen 200% to 400% more time needed for the "little stuff".then there is a scrapped part and time required to remake a part. that can easily add time to the average times Is there a way, you can share the calculator with me. Hello, tell me exactly, what you need, so I might be able to help. I work with planning software, which uses all kinds of aforementioned Excel sheets, or similar, but super simple tools for small manufacturers, so let me know, what you are looking for. Well use a simple dataset with check in and check out times to calculate the duration.The Excel formula to calculate the time duration is a simple subtraction formula. Well get the total duration. Method 1 Using Conventional FormulaSteps:Select cell E10.Use the following formula in it.This is one way to calculate the total time in Excel. Method 2 Applying the SUM FunctionSteps:Insert the following formula in cell C10. Method 3 Using the AutoSum FeatureSteps:Select the range you want to add. We used the range E5:E9.Go to the Home tab.Select AutoSum from the Editing group. You can directly click on AutoSum or you can click on the drop-down arrow and select Sum from the drop-down list.Excel will calculate the total time worked by putting in the SUM formula in the cell. Method 4 Calculate Total Time Over 24 HoursWe have a duration over 24 hours. If we used a regular sum, wed likely get the wrong result since Excel will only display the hours.Steps:Calculate the total time in cell E10 by entering the following formula in the cell.The total time here shows 17 hours and 15 minutes which is not true.Select cell E10 and press Ctrl+1 on your keyboard.The Format Cells box will appear. Go to the Number tab in it.Select Custom from the Category.You can select the Type from the options or write down the format [h]:mm:ss in the box below it.Read More: How to Sum Time in Excel Method 5 Calculate the Total Time When the Date ChangesLets consider a slightly different dataset where the check out time is before the check in time, but in the next day.Using a subtraction formula gives errors.Steps:Select cell E5.Use the following formula. =IF((D5-C5) The DAY function will return the day number of the date in cell D5. MONTH(D5) -> \The MONTH function will return the month number of the given date in cell D5. YEAR(D5) -> The YEAR function will return the year number of the given date in cell D5. DATE(YEAR(D5),MONTH(D5),DAY(D5)) -> turns intoDATE(2022,1,24) -> The DATE function will return a serial number that represents a date from a given year, month, and day. DATE(YEAR(C5),MONTH(C5),DAY(C5)) -> turns intoDATE(2014,2,15) -> The DATE function will return a serial number that represents a date from a given year, month, and day. DAYS360(DATE(YEAR(C5),MONTH(C5),DAY(C5)),DATE(YEAR(D5),MONTH(D5),DAY(D5))) -> turns intoDAYS360(41685,44585) -> The DAYS360 function will return the number of days between the two given dates. INT(DAYS360(DATE(YEAR(C5),MONTH(C5),DAY(C5)),DATE(YEAR(D5),MONTH(D5),DAY(D5)))/360) -> turns intoINT(2859/360) -> The INT function will return the integer number by rounding it down. Press Enter to get the result.Drag the Fill Handle to copy the formula to the other cells. Method 3 Using the DATEDIF Function to Calculate the Years of Service in ExcelCase 3.1 Applying the DATEDIF Function to Calculate YearsSteps:Select the cell where you want to calculate the Years of Service. We selected cell E5.Insert the following formula. =DATEDIF(C5, D5, "y")& " Years" Formula BreakdownDATEDIF(C5, D5, y) -> The DATEDIF function will return the number of years between the two given dates. DATEDIF(C5, D5, y)& Years -> turns into7& Years -> The Ampersand (&) operator will combine the text and formula. Drag the Fill Handle down to copy the formula. Case 3.2 Using the DATEDIF Function to Calculate Years and MonthsSteps:Select the cell where you want to calculate the Years of Service. We selected cell E5.Insert the following formula: =DATEDIF(C5,D5,"y")&" Years, "&DATEDIF(C5,D5,"ym")&" Months" Formula BreakdownDATEDIF(C5,D5,y) -> The DATEDIF function will return the number of years between the two given dates. DATEDIF(C5,D5,ym) -> The DATEDIF function will return the number of months between the two given dates ignoring the days and years. DATEDIF(C5,D5,y)& Years, &DATEDIF(C5,D5,ym)& Months -> turns into7& Years, &11& Months -> The Ampersand (&) operator will combine the texts and formulas.Output: 7 Years, 11 MonthsPress Enter to get the result.Drag the Fill Handle down to copy the formula. Case 3.3 Inserting the DATEDIF Function to Calculate Years, Months, and DaysSteps:Select the cell where you want to calculate the Years of Service. We selected cell E5.Insert the following formula: =DATEDIF(C5,D5,"y") & " Years, " & DATEDIF(C5,D5,"ym") & " Months, " & DATEDIF(C5,D5,"md") & " Days" Formula BreakdownDATEDIF(C5,D5,y) -> The DATEDIF function will return the number of years between the two given dates. DATEDIF(C5,D5,ym) -> The DATEDIF function will return the number of months between the two given dates ignoring the days and years. DATEDIF(C5,D5,md) -> The DATEDIF function will return the number of days between the two given dates ignoring the months and years. DATEDIF(C5,D5,y) & Years, & DATEDIF(C5,D5,ym) & Months, & DATEDIF(C5,D5,md) & Days -> turns into7 & Years, & 11 & Months, & 9 & Days -> The Ampersand (&) operator will combine the texts and formulas.Output: 7 Years, 11 Months, 9 DaysPress Enter to get the result.Drag the Fill Handle down to copy the formula. Method 4 Merging Excel IF and DATEDIF Functions to Calculate Service Years Case 4.1 Returning a Text String If the Service Duration Is Less Than One YearSteps:Select the cell where you want to calculate the Years of Service. We selected cell E5.Insert the following formula: =IF(DATEDIF(C5,D5,"y")=0,"Less than a year",DATEDIF(C5,D5,"y")&" Years, "&DATEDIF(C5,D5,"ym")&" Months") Formula BreakdownDATEDIF(C5,D5,y) -> The DATEDIF function will return the number of years between the two given dates. DATEDIF(C5,D5,ym) -> The DATEDIF function will return the number of months between the two given dates ignoring the days and years. IF(DATEDIF(C5,D5,y)=0,Less than a year,DATEDIF(C5,D5,y)& Years, &DATEDIF(C5,D5,ym)& Months) -> turns intoIF(7=0,Less than a year,7& Years, &11& Months) -> The IF function will check the logical_test. If it is True, the formula will return Less than a year. If it is False, the formula will return the Years of Service in years and months.Output: 7 Years, 11 MonthsPress Enter to get the result.Drag the Fill Handle to copy the formula. Case 4.2 Calculating the Month If the Service Duration Is Less Than One YearSteps:Select the cell where you want to calculate the Years of Service. We selected cell E5.Insert the following formula: =IF(DATEDIF(C5,D5,"y")=0,DATEDIF(C5,D5,"ym")&" Months",DATEDIF(C5,D5,"y")&" Years, "&DATEDIF(C5,D5,"ym")&" Months") Formula BreakdownDATEDIF(C5,D5,y) -> The DATEDIF function will return the number of years between the two given dates. DATEDIF(C5,D5,ym) -> This DATEDIF function will return the number of months between the two given dates ignoring the days and years. IF(DATEDIF(C5,D5,y)=0,DATEDIF(C5,D5,ym)& Months,DATEDIF(C5,D5,y)& Years, &DATEDIF(C5,D5,ym)& Months) -> turns intoIF(7=0,11& Months,7& Years, &11& Months) -> The IF function will check the logical_test. If it is True, the formula will return the Years of Service in months. If it is False, the formula will return the Years of Service in years and months.Output: 7 Years, 11 MonthsPress Enter to get the result.Drag the Fill Handle to copy the formula. Calculate the Years of Service in Excel from the Hire Date to Now in ExcelSteps:Select the cell where you want to calculate the Years of Service. We selected cell D5.Insert the following formula: =DATEDIF(C5,TODAY(),"y") & " Years, " & DATEDIF(C5,TODAY(),"ym") & " Months, " & DATEDIF(C5,TODAY(),"md") & " Days" Formula BreakdownDATEDIF(C5,TODAY(),y) -> The DATEDIF function will return the number of years between the Hire Date and the Current Date. DATEDIF(C5,TODAY(),ym) -> The DATEDIF function will return the number of months between the Hire Date and the Current Date ignoring the days and years. DATEDIF(C5,TODAY(),md) -> The DATEDIF function will return the number of days between the Hire Date and the Current Date ignoring the months and years. DATEDIF(C5,TODAY(),y) & Years, & DATEDIF(C5,TODAY(),ym) & Months, & DATEDIF(C5,TODAY(),md) & Days -> turns into8 & Years, & 6 & Months, & 22 & Days -> The Ampersand (&) operator will combine the texts and formulas.Output: 8 Years, 6 Months, 22 Days Press Enter to get the result.Drag the Fill Handle to copy the formula.Read More: How to Calculate Cycle Time in Excel Calculating the End Date from the Hire Date after Certain Years of ServiceSteps:Select the cell where you want to calculate the End Date. We selected cell E5.Insert the following formula:In the EDATE function, we selected C5 as start_date and D5*12 as months. We multiplied the years by 12 to convert them into months. The formula will return the date after these selected months.Press Enter, and you will get the End Date.Drag the Fill Handle to copy the formula. Download the Practice Workbook Calculating Years of Service.xlsx Related Articles