



Cost of scrap — what slow drifts weigh

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€86,600 a month, of which €53,700 recoverable · fictional document

Fictional document — demonstration example

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Fictional document, produced for the demonstration. **The fully loaded cost used is the one from the plant's management accounting: €1.90 a part, materials, machine and labour included.** No figure on this page comes from anywhere but the scrap tickets.

The calculation, line by line

Element	Value	Source
Parts made per month	2,400,000	MES
Scrap rate	1.9 %	Scrap tickets
Parts scrapped per month	45,600	—
Fully loaded unit cost	€1.90	Management accounting
Monthly cost	€86,600	—
Annual cost	€1.04 m	—

The share recoverable through early detection

Reason written on the scrap ticket	Share	Monthly cost
Slow drift — visible in the readings before the part	62 %	€53,700
Sharp incident — stoppage, breakage, abrupt material defect	38 %	€32,900

What early detection shifts, beyond the scrap bin

Consequence	Detection at 4 h 20	Detection at 11 minutes
Possible treatment	Batch sort	Setting change on a running press
Sorting hours per month	11 h	Returned to production
Parts involved per event	5,400	230

Proposed starting scope: the two presses running seven days a week — **they are the ones producing during the hours when nobody reads the readings.**

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