

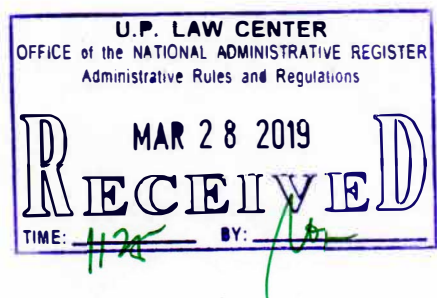
**PRESCRIBED MACHINE RATES FOR MIRDC FACILITIES**  
Effective 21 May 2019

**INVESTMENT CASTING FACILITIES**

MACHINE/EQUIPMENT		RATE PER HOUR (PhP)	
		Time Sharing	Actual Time
<b>I. WAX PATTERN</b>			
	Wax Melting Tank	90.00	280.00
	Wax Curing Tank	120.00	290.00
	Wax Injection Machine	100.00	330.00
	Hot Plate/Soldering Iron	110.00	280.00
<b>II. CERAMIC MOLD MAKING</b>			
	Slurry Mixer with parts	130.00	300.00
	Fluidized Bed	70.00	240.00
	Dust Collector	80.00	260.00
<b>III. DEWAXING</b>			
	Autoclave Machine	680.00	850.00
<b>IV. SHELL FIRING</b>			
	Shellfiring Furnace	130.00	405.00
<b>V. FETTLING</b>			
	Sand Blasting (Sinto)	200.00	370.00
	Knockoff Machine	160.00	350.00
	Cut-off Machine	210.00	380.00
	Denyu Belt Sander/Polishing	120.00	290.00
	Compressor (Sull Air)	1,240.00	1,410.00

Note:

Time Sharing = Use of machine only. Customer provides the machine operator  
 Actual Time = Use of machine with MIRDC personnel as operator



Endorsed by:

*[Signature]*  
**ROBERTO D. DIZON**  
 Executive Director  
 MIRDC

Approved by:

*[Signature]*  
**FORTUNATO T. DE LA PEÑA**  
 Secretary  
 DOST

**PRESCRIBED MACHINE RATES FOR MIRDC FACILITIES**Effective 21 May 2019**CONVENTIONAL CASTING FACILITIES**

MACHINE/EQUIPMENT		RATE PER HOUR (PhP)	
		Time Sharing	Actual Time
<b>I. MOLDING</b>			
	Furan Mixer	670.00	810.00
	Sand Reclaimer	110.00	290.00
	Forklift	280.00	430.00
<b>II. FETTLING</b>			
	Shot Blasting	1,660.00	1,800.00
	Angle grinder	100.00	275.00
	Pneumatic Chipping Hammer	210.00	630.00
	Silicon Arc Air Gouging Machine	3,550.00	3,700.00
	Oxyacetylene Kit	20.00	230.00
<b>III. PATTERN SHOP</b>			
	Drill Press	80.00	260.00
	Bandsaw	80.00	260.00
	Wood Lathe	70.00	265.00
	Rotary Machine	50.00	245.00
	Bench Table Saw	80.00	260.00
	Wood Planer	170.00	320.00
	Disc Grinder	150.00	305.00
<b>IV. MELTING</b>			
	50 Kg Induction Furnace - Non Ferrous (New)	2,050.00	2,220.00
	50 Kg Induction Furnace – Ferrous (New)	2,380.00	2,550.00
	100 Kg Induction Furnace (New)	3,530.00	3,700.00
	150 Kg Induction Furnace (New)	4,850.00	5,020.00
	150 Kg Induction Furnace(Old Inductotherm)	4,265.00	4,500.00
	250 Kg Induction Furnace(Old Inductotherm)	6,760.00	6,930.00
	500 Kg Induction Furnace(Old Inductotherm)	12,270.00	12,430.00
	Crucible Furnace	1,670.00	1,840.00

Note:

Time Sharing = Use of machine only. Customer provides the machine operator

Actual Time = Use of machine with MIRDC personnel as operator

Endorsed by:

  
**ROBERT O. DIZON**  
 Executive Director  
 MIRDC

Approved by:

  
**FORTUNATO T. DE LA PEÑA**  
 Secretary  
 DOST

**PRESCRIBED MACHINE RATES FOR MIRDC FACILITIES**  
Effective 21 May 2019

**ADVANCED MACHINING, TOOL AND DIE SHOP**

MACHINE/EQUIPMENT		RATE PER HOUR (Php)	
		Time Sharing	Actual Time
<b>I. CNC MACHINES</b>			
	CNC EDM Sinker (Sodick A50)	230.00	610.00
	CNC EDM Sinker (Mitsubishi EA12D)	540.00	860.00
	EDM Drill (Sodick K1C)	170.00	535.00
	EDM Drill (Oscarmax SD550)	230.00	590.00
	CNC EDM Wirecut (Sodick A500W)	570.00	930.00
	CNC EDM Wirecut (Robocut α-C600i)	870.00	1,180.00
	CNC Milling Machine (Mazak FJV25)	890.00	1,080.00
	CNC Milling Machine (Mazak VTC16)	840.00	1,020.00
	CNC Milling Machine (Mazak VCS 430A)	1,200.00	1,390.00
	CNC Milling Machine (Samsung Rhino LCV850)	1,380.00	1,560.00
	CNC Milling Machine - High Speed (Makino F5)	1,390.00	1,580.00
	CNC Milling Machine - CNC/Manual (Makino KE55)	750.00	940.00
	CNC Lathe w/ Milling Machine (Takisawa LA200M)	930.00	1,110.00
	CNC Lathe (Mazak QT6T)	740.00	920.00
	CNC Lathe (Mazak Quick Turn Smart 150s)	950.00	1,130.00
	CNC 5-Axis Milling (Mazak Variaxis j-600/5X)	1,800.00	2,010.00
	CNC 5-Axis Lathe (Mazak Integrex i-200)	1,930.00	2,150.00
	CNC 5-Axis Milling Machine (Okuma MU 6300V)	2,790.00	3,010.00
<b>II. DIE AND MOLD REPAIR</b>			
	Laser Welding Machine (Sisma SWA150)	440.00	740.00
	Mould Repair (TechnoCoat MicroDepo)	220.00	555.00
<b>III. MEASUREMENT AND QUALITY CONTROL</b>			
	CMM Robotic Arm (Romer Multi Gauge 6-Axis)	270.00	650.00
	CMM (Mitutoyo Beyond 504)	260.00	610.00
	CMM (Mitutoyo Crysta-Apex S 7106)	930.00	1,390.00
	Profile Projector (Sigmascope MT:500-933)	100.00	470.00
<b>IV. GRINDERS</b>			
	Surface Grinder - Big (Perfect PFG 80150AHR)	510.00	795.00
	Surface Grinder - Small (Perfect PFG 60100AHR)	440.00	740.00
	Surface Grinding Machine (Kuroda GS-62Z)	370.00	680.00
	Surface Grinding Machine (Jones and Shipman 540H)	140.00	515.00
	Cylindrical Grinding Machine (Palmerly)	630.00	890.00

Note:

Time Sharing = Use of machine only. Customer provides the machine operator

Actual Time = Use of machine with MIRDC personnel as operator

Endorsed by:

  
**ROBERT D. DIZON**  
 Executive Director  
 MIRDC

Approved by:

  
**FORTUNATO T. DE LA PEÑA**  
 Secretary  
 DOST

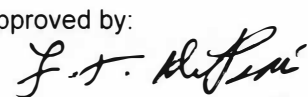
**PRESCRIBED MACHINE RATES FOR MIRDC FACILITIES**  
Effective 21 May 2019

**WELDING AND FABRICATION SHOP**

MACHINE/EQUIPMENT		RATE PER HOUR (PhP)	
		Time Sharing	Actual Time
<b>I. WELDING MACHINES</b>			
	MIG/TIG-Welding (MillerDynasty 350)	240.00	410.00
	TIG-Welding (Miller Sychrowave 200)	260.00	430.00
	TIG-Welding (Miller Diversion 165)	210.00	380.00
	TIG-Welding (OTC-Accutig 300P)	400.00	570.00
	MIG/TIG-Welding (OTC-Digital Dyna Autp XD 350S)	470.00	630.00
	MIG/TIG-Welding (Miller Thunderbolt XL)S)	530.00	700.00
	Spot Welding Machine (Tecna)	490.00	660.00
<b>II. PRESSES AND ROLLERS</b>			
	Power Press with Uncoiler (Chin Fong)	690.00	890.00
	Hydraulic Die Spotting Press (Taitian)	1,150.00	1,720.00
	Turret Punch Press (Amada)	1,520.00	2,470.00
	Universal Rolling Machine (Nanjing Shengda)	540.00	1,250.00
	Press Brake (Amada RG-60)	450.00	615.00
<b>III. CUTTING, DRILLING AND POLISHING MACHINES</b>			
	Hydraulic Shear (Amada GXII 1230)	930.00	1,100.00
	Shearing Machine	390.00	560.00
	Cutting machine (Thermal Dynamics 120S)	820.00	990.00
	Polishing Machine (Metabo)	170.00	340.00
	Drilling Machine (Magnetic Drill)	170.00	340.00
	Portable Drilling Machine	280.00	450.00
	Air Compressor (Ingersoll Rand)	280.00	450.00

Note:  
 Time Sharing = Use of machine only. Customer provides the machine operator  
 Actual Time = Use of machine with MIRDC personnel as operator

Endorsed by:  
  
**ROBERT O. DIZON**  
 Executive Director  
 MIRDC

Approved by:  
  
**FORTUNATO T. DE LA PEÑA**  
 Secretary  
 DOST

**PRESCRIBED MACHINE RATES FOR MIRDC FACILITIES**

Effective 21 May 2019

**PLASTIC INJECTION SHOP**

MACHINE/EQUIPMENT		RATE PER HOUR (Php)	
		Time Sharing	Actual Time
<b>I. PLASTIC INJECTION MACHINES</b>			
	Sumitomo 80T	370.00	540.00
	Sumitomo 150T	590.00	760.00
	Sumitomo 350T	1,060.00	1,230.00
	Mitsui Pre-heating	90.00	325.00
	Plastic Crusher	80.00	330.00

**GEARMAKING FACILITY**

MACHINE/EQUIPMENT		RATE PER HOUR (Php)	
		Time Sharing	Actual Time
<b>I. GEARMAKING MACHINES</b>			
	CNC Gear Hobber (Mitsubishi GE 25A)	2,510.00	2,720.00
	CNC Gear Shaper (Mitsubishi ST 25CNC)	2,680.00	2,900.00
	CNC Gear Shaver (Mitsubishi FE30A)	1,670.00	1,880.00
	Gear Software (KISSSoft/KISSSys)	1,020.00	1,230.00
	CMM Gear Measuring System (Zeiss Duramax RT)	860.00	1,070.00
	Dynamic Balancer (CIMAT CMTI500HZZ)	700.00	1,200.00
	Internal Broaching Machine (AXISCO CHI0510)	750.00	1,060.00

**CONVENTIONAL MACHINING SHOP**

MACHINE/EQUIPMENT		RATE PER HOUR (Php)	
		Time Sharing	Actual Time
<b>I. CONVENTIONAL MACHINES</b>			
	Turning (Lathe Machines)	500.00	650.00
	Milling (Milling Machines)	320.00	500.00
	Grinding (Grinding Machines)	210.00	370.00
	Drilling (Drilling Machines)	210.00	360.00
	Press working (Press working Machines)	200.00	350.00
	Fabrication (Fabrication Machines)	160.00	310.00
	SMAW (Welding Machines)	160.00	360.00

Note:



Time Sharing = Use of machine only. Customer provides the machine operator

Actual Time = Use of machine with MIRDC personnel as operator

Endorsed by:

  
**ROBERT O. DIZON**  
 Executive Director  
 MIRDC

Approved by:

  
**FORTUNATO T. DE LA PEÑA**  
 Secretary  
 DOST 

**PRESCRIBED HEAT TREATMENT SERVICE RATES FOR MIRDC**  
Effective 21 May 2019

**HEAT TREATMENT SERVICES**

**I. CONVENTIONAL HEAT TREATMENT**

Heat Treatment Process	RATE (PhP)*	
	Per batch from 1 to 25 kg.	Additional per kg, or fraction thereof, above 25 kg.**
1. Hardening (without tempering)	2,060.00	82.00
2. Annealing or Normalizing	1,860.00	74.00
3. Tempering	1,560.00	62.00

**II. VACUUM HEAT TREATMENT**

Heat Treatment Process	RATE (PhP)*	
	Per batch from 1 to 30 kg.	Additional per kg, or fraction thereof, above 30 kg.**
1. Hardening (without tempering)	15,100.00	500.00
2. Tempering	7,600.00	250.00

Note:

\* The rates apply to workpiece cross-sectional thickness of not more than 25 mm. For thickness above 25 mm, a new estimate shall be provided.

\*\* Maximum load shall not exceed furnace capacity

Endorsed by:

  
**ROBERTO O. DIZON**  
Executive Director  
MIRDC

Approved by:

  
**FORTUNATO T. DE LA PEÑA**  
Secretary  
DOST