

ROUTING AND RECORD SHEET

SUBJECT: (Optional)

JPRS Production

FROM: C/PP&SS/P&PD/OL 166 P&P Bldg.	EXTENSION	NO.	STAT
		DATE	STAT
		21 November 1983	

TO: (Officer designation, room number, and building)	DATE		OFFICER'S INITIALS	COMMENTS (Number each comment to show from whom to whom. Draw a line across column after each comment.)
	RECEIVED	FORWARDED		

TO: (Officer designation, room number, and building)	RECEIVED	FORWARDED	OFFICER'S INITIALS	COMMENTS (Number each comment to show from whom to whom. Draw a line across column after each comment.)
1. C/OMS		11/21	mw	
2. Prod. Mgr.			js for WD	
3. C/P&PD				
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18 November 1983

MEMORANDUM FOR: Chief, Printing and Photography Division, OL

FROM:

 Chief, Plans, Programs and Systems Staff, OL

STAT

SUBJECT: JPRS Production

1. Attached, per your request, is a cost/work hour analysis of supporting 21.1 percent (reports with a run length of under 150 copies) of the daily JPRS workload on the Xerox equipment located in the Bindery and Reproduction Center (B&RC). A three way cost/work hour comparison between the Xerox 9500, Web press, and AM duplicators was conducted. The comparison was based on an average of 3 reports per day with 295 original pages for 121 copies. The results of that comparison are as follows.

	<u>Daily</u>	<u>Xerox</u>	<u>Duplicator</u>	<u>Web</u>
a. Total Daily Work Hours		12.0	12.64	17.33
b. Total Daily Cost		\$458.54	\$281.40	\$502.14

2. There are several variables to consider when evaluating this workload to determine the most efficient production method/process. Each process has some major advantages and disadvantages. Outlined below are some points that should be given consideration:

a. XeroxAdvantages

- Three machines and three people available on a third shift to provide support.
- No masters/plates to produce.
- On line sorting (limited to 50 bins)
- Overall work hour savings

Disadvantages

- 200 original page limitation on equipment
- 50-bin sorter limitation (some jobs would have to be run 2-3 times)
- When compared to the Web press, additional bindery time would be necessary.
- Dissemination/labeling envelopes would be more of a problem in B&RC

- Quality of the end product is not as good or as consistent as Web press.
- Cut sheet paper operation - higher paper cost

B. AM Duplicator

Advantages

- Lowest cost of the three alternatives
- Equipment available at no cost from JPRS.
- Trained operators available
- Cost of paper plates is 48 cents (8 plates) compared to \$2.95 for Web press plates. Platemaking operation is 1 hour compared to 8 hours (2 workers 4 hours) for the Web operation.

Disadvantages

- Cut sheet paper operation-higher paper costs
- Off line collation (additional work hours necessary)
- Quality of the end product is not as good as the Web press.

C. Web Press

Advantages

- Faster overall throughput time (but with more labor)
- Higher quality
- Least amount of bindery/collation time

Disadvantages

- Highers overall use of work hours
- No backup equipment (laser platemaker and Web press)
- Large amount of plates (37 per day) to produce on the laser platemaker and run on the Web press
- High paper waste of short (under 150 copies) run lengths.

3. When attempting to recommend the best method for producing these reports, all the information contained in this memorandum must be considered. Additionally, it is difficult to make the determination because of the nature of the JPRS work (ad hoc number of original pages for production at sporadic times).

4. Based on the findings in this paper, the best overall production method for these reports is by using the Web press. However, this production method would utilize the laser platemaker four hours each day and would require the press operator to change 37 plates, all for the production of three books a day for 121 copies. Because of the limited

value/benefits of running these reports with this method and the lack of backup equipment for the Web press and laser platemaker, it is recommended that either the Xerox or duplicators are used for support. Final determination of the printing process however, should be done on a case-by-case basis by the Planning Services Staff.

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Attachment:
Workload Cost Analysis

Attachments

**JPRS Workload
Cost Analysis**

(All figures are based on daily averages. Only reports with a run length of under 150 copies were considered)

A. Job Profile (Daily Average)

1. Percent of total JPRS workload	21.1
2. Original reports per day	3
3. Original pages per day	295
4. Average copies per report	121
5. Total pages/impressions per day	35,695
6. Total books per day	363

B. Material/Equipment Cost

	<u>Xerox</u>	<u>Duplicator</u>	<u>Web</u>
1. Plates		<i>23.60</i> 22.96	109.15
2. Toner/Developer	32.13		
3. Ink/Solvent		5.00	5.00
4. Rental/Main	189.15	30.19	
5. Paper	<u>124.94</u>	<u>124.94</u>	<u>113.13</u>
Total	346.22	163.09	227.28

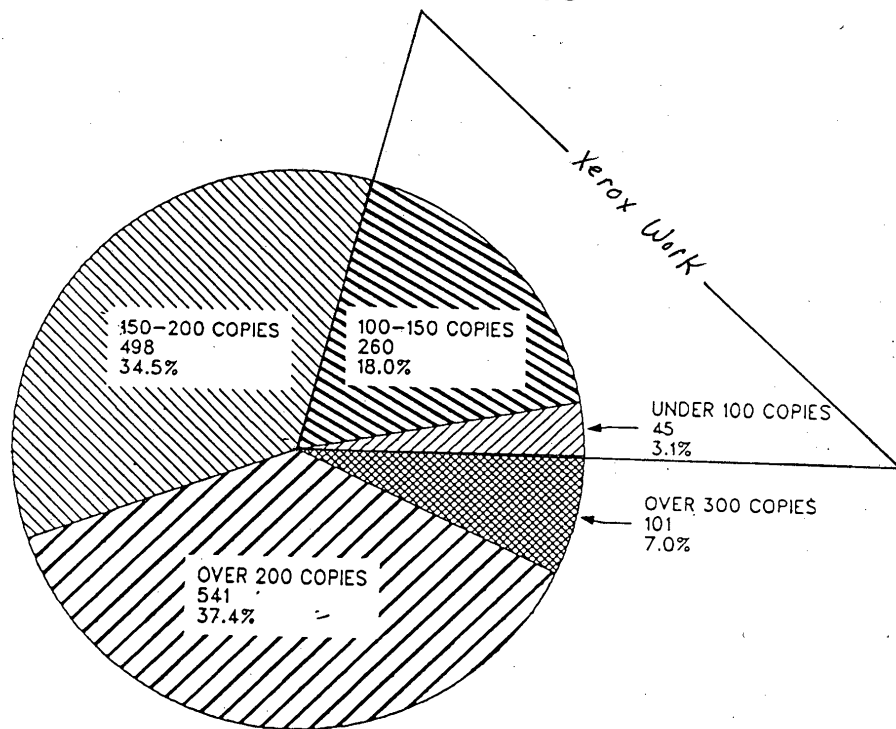
C. Labor (Daily Work Hours)

	<u>Xerox</u>	<u>Duplicator</u>	<u>Web</u>
1. Plates		.56	8.22
2. Printing	10.0	8.92	7.50
3. Bindery/Collation	2.0	3.16	1.61
Total	<u>12.00</u>	<u>12.64</u>	<u>17.33</u>
	\$9.36	\$9.36	\$15.86
	\$112.32	\$118.31	\$274.86

D. Total Daily Cost

	<u>Xerox</u>	<u>Duplicator</u>	<u>Web</u>
1. Material/Equipment	346.22	163.09	227.28
2. Labor	<u>112.32</u>	<u>118.31</u>	<u>274.86</u>
Total	458.54	281.40	502.14

JPRS PUBLICATIONS PRODUCED JANUARY 1983 - JUNE 1983



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Xerox
Work

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Technology

Copies	No. OF Orig	No. OF Times Printed PerM					
		1	2	3	4	5	6
51	60-71	2			1	2	2
82	63-76	2	3	5	3	5	7
92	60-	3	5	2	1	1	1
103	90-108	3	2	4	6	4	6
106	51-71	2	3	4	4	3	6
115	50-54	1		2	3	4	3
117		2	3				
120	37-84	2	2	2	4	4	1
122							
124	27-96	2	3	3	3	4	5
125	11-44	1	2	2	2	1	3
125	21-50	1	2	5	5	1	3
128	49-89	2	1		2	3	2
130	49-55	3	4	3	1	4	2
131					1		
132	182	4	3	2	2	6	1
133	19-39	2	2	4	3	3	3
138	89-215	1	3	2	1	1	1
139	63-84	2	3	2	3	4	4
143	35-51	3	4	3	4	8	7
146	54	1		2		1	1
148	27-75	1	1	1	1	1	1
	800						
184	23-268	16	15	19	18	19	25
174	24-61	3	3	3	4	3	2
166	44-178	10	11	15	17	14	9
175	36-148	8	7	11	7	7	8
164	62-250	7	8	4	6	4	6
157	58-166	10	8	7	8	12	11
192	103-181	2	3	2	1	2	2
193	74-165	3	2	2	1		5
162	41-125	1	2	2			2
179	30-90	3	4	2	4	2	3
187	68-181	2	3	1	1	5	3