

Cost example fff vs. welded frame:

Comparison of the time taken to fit a 1400 x 1600 mm window with a welded frame versus an fff window of the same size:

	Hourly rate	Minutes	fff Costs	Minutes	welded frame Costs
Fitting Without preparation time on board	70.00 €	20	23.33 €	90	105.00 €
After fitting					
Sanding welded joint	70.00 €	0	0.00 €	20	23.33 €
Treating with primer	70.00 €	0	0.00 €	10	11.67 €
Painting	70.00 €	0	0.00 €	10	11.67 €
Total working time / total costs per window		20	23.33 €	130	151.67 €
Total working time / total costs per set of 30 windows		600	700.00 €	3,900	4,550.00 €
Risk of broken glass / damage (assuming 3% of a set of windows)					
Glass price approx.			0.00 €		1,500.00 €
Material overheads approx. 10%			0.00 €		150.00 €
Time needed to remove the old pane of glass on board		0	0.00 €	420	490.00 €
Working time / costs incl. broken glass / damage per set of 30 windows:		600	700.00 €	4,320	6,690.00 €
Hours saved per set of windows:		62			
Cost saving in euros per set of windows					about 6,000.00 €

Preparation times, alignment of the welding gun and drying times between priming and painting not included.