



In the concept design phase the costs committed are forecasted up to 60% of the total costs. In the detailed design prototype phase the percentage of the total costs increases up to 90%, while the costs incurred in at the end of the detailed design prototype phase are only about 20% of the total cost. At the end of the distribution, service and disposal phase the costs incurred and costs committed are equal.

At the beginning of the life cycle the ease of change is very high (about 100%), but the more time has spend to developing and producing the product the lower is the possibility to change the products properties.