

# Machine Requirements Computation System

1. First, Remove the last column and last row from the data sheet. (see illustration for reference).

The screenshot shows an Excel spreadsheet with the following structure:

- Columns:** A through EL (44 columns total). The last column, EL, is highlighted in red.
- Rows:** 1 through 42. The last row, 42, is highlighted in red.
- Table Content:** The table contains various data points, including line numbers, sizes, and production details. The last column (EL) and the last row (42) are highlighted in red, indicating they are to be removed.

The screenshot shows an Excel spreadsheet with the following structure:

- Columns:** A through EL (44 columns total). The last column, EL, is highlighted in red.
- Rows:** 1 through 148. The last row, 148, is highlighted in red.
- Table Content:** The table contains various data points, including line numbers, sizes, and production details. The last column (EL) and the last row (148) are highlighted in red, indicating they are to be removed.

2. Import the file to the system.
3. After importing, Set the data on the date form then click search.

The screenshot shows the 'Plan From PC' interface in the MRCS system. The left sidebar contains a navigation menu with 'Plan From PC' selected, and sub-items: Plan Total, Plan, Total Shots, Section 1 through Section 9, and Logout. The main area has a header with 'Date From' (mm/dd/yyyy) and 'Date To' (mm/dd/yyyy) fields, a 'Search' button, and 'Import', 'Export', and 'Save' buttons. The 'Date From' and 'Date To' fields are highlighted with a red box. The 'Search' button is also highlighted with a red box. The table below is empty.

| Product | Manufacturing Location | Customer Manufacturer | Shipping Location | Vehicle Type | Vehicle Type Name | WH Type | WH Type Name | Assy Group Name | Item | Internal Item Number | Line |
|---------|------------------------|-----------------------|-------------------|--------------|-------------------|---------|--------------|-----------------|------|----------------------|------|
|---------|------------------------|-----------------------|-------------------|--------------|-------------------|---------|--------------|-----------------|------|----------------------|------|

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.

4. Once the data appears click save.

The screenshot shows the 'Plan From PC' interface with data displayed in the table. The 'Date From' field is set to 11/01/2024 and the 'Date To' field is set to 01/31/2025. The 'Save' button is highlighted with a red box. The table contains 15 columns representing dates from 1/13/2025 to 01/31/2025, and 15 rows of data.

|  | 1/13/2025 | 01/14/2025 | 01/15/2025 | 01/16/2025 | 01/17/2025 | 01/18/2025 | 01/21/2025 | 01/22/2025 | 01/23/2025 | 01/24/2025 | 01/25/2025 | 01/27/2025 | 01/28/2025 | 01/30/2025 | 01/31/2025 |
|--|-----------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
|  | 0.00      | 7.00       | 10.00      | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 11.00      | 0.00       | 0.00       | 10.00      | 0.00       |
|  | 10.00     | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 10.00      | 0.00       | 0.00       | 0.00       | 0.00       | 10.00      | 0.00       | 0.00       | 0.00       |
|  | 0.00      | 20.00      | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       |
|  | 0.00      | 0.00       | 0.00       | 0.00       | 15.00      | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       |
|  | 0.00      | 0.00       | 20.00      | 0.00       | 0.00       | 25.00      | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       |
|  | 0.00      | 0.00       | 10.00      | 0.00       | 0.00       | 0.00       | 0.00       | 0.00       | 23.00      | 20.00      | 17.00      | 20.00      | 0.00       | 20.00      | 20.00      |

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.

5. Next, Go to the "Plan total" page (seen at the left side navigation) and click extract plan.

MRCS

USER

Plan From PC

- Plan Total
- Plan

Total Shots

- Section 1
- Section 2
- Section 3
- Section 4
- Section 5
- Section 6
- Section 7
- Section 9
- Logout

Extract Plan Export

Plan

| Car Model     | 2024-11-04 | 2024-11-05 | 2024-11-06 | 2024-11-07 | 2024-11-08 | 2024-11-09 | 2024-11-11 | 2024-11-12 | 2024-11-13 | 2024-11-14 | 2024-11-15 | 2024-11-16 | 2024-11-18 | 2024-11-19 |
|---------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|------------|
| Honda TKRA    | 9709       | 9619       | 9617       | 9617       | 9447       | 9447       | 9614       | 9614       | 9612       | 9612       | 9417       | 9419       | 9685       | 9709       |
| Honda Old     | 12321      | 12130      | 12145      | 12130      | 12145      | 12185      | 12342      | 12327      | 12327      | 12307      | 12387      | 12457      | 12417      | 12307      |
| Daihatsu D01L | 10719      | 10695      | 10707      | 10697      | 10647      | 10627      | 10699      | 10677      | 10647      | 10637      | 10627      | 10647      | 10719      | 10695      |
| Honda T20     | 2085       | 1405       | 1420       | 1540       | 1515       | 1500       | 2555       | 1470       | 2012       | 2020       | 1485       | 1480       | 2070       | 1470       |
| Suzuki Old    | 88715      | 12228      | 12071      | 11942      | 11377      | 11421      | 42202      | 11604      | 11407      | 11226      | 11154      | 11002      | 11399      | 10695      |
| Subaru Others | 9870       | 10363      | 9895       | 10160      | 10135      | 10130      | 9880       | 10425      | 9848       | 10085      | 10180      | 10055      | 10160      | 10363      |
| Subaru        | 1368       | 1368       | 1440       | 1440       | 1368       | 1440       | 1440       | 1368       | 1368       | 1440       | 1368       | 1440       | 1440       | 1440       |

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.

6. And then, go to the "Plan" page and extract again.

MRCS

MARC NEILSEN OMABTANG

Plan From PC

- Plan Total
- Plan

Total Shots

- Section 1
- Section 2
- Section 3
- Section 4
- Section 5
- Section 6
- Section 7
- Section 9
- Logout

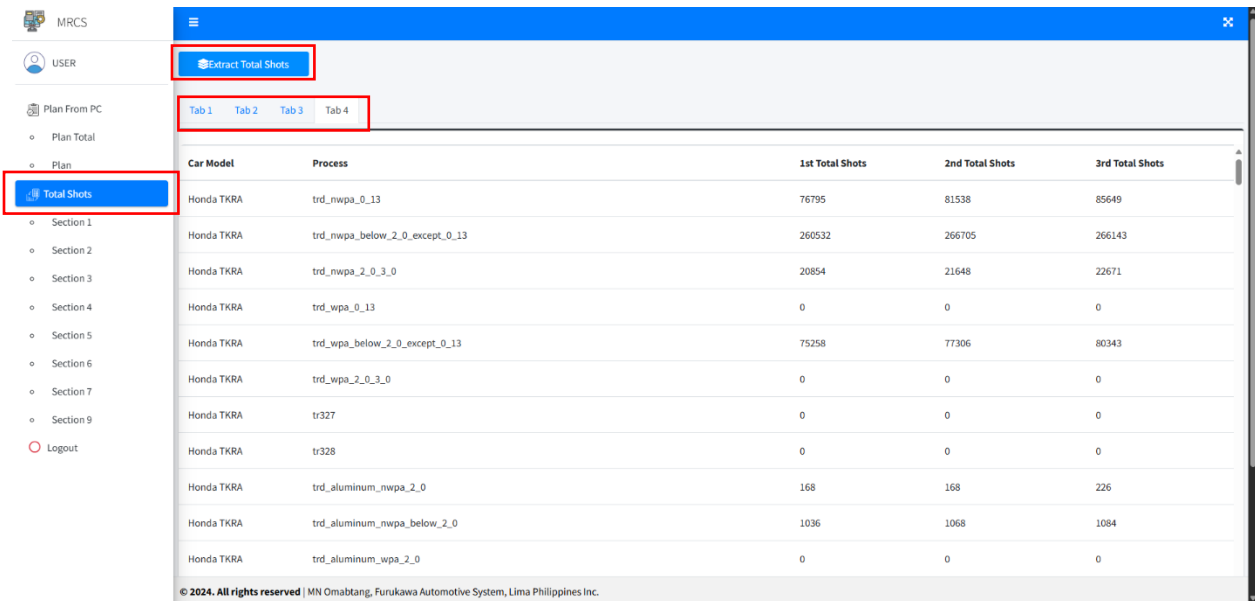
Extract Plan Export

Plan

| Car Model   | Base Product | Car Code | Code | Main Product No    | Line | 2024-11-18 | 2024-11-19 | 2024-11-20 | 2024-11-21 | 2024-11-22 | 2024-11-23 | 2024-11-24 |
|-------------|--------------|----------|------|--------------------|------|------------|------------|------------|------------|------------|------------|------------|
| Mazda Merge | GBJW-67-130  | 0        | 130  | GBJW-67-130(6)-12  | 1110 | 20.00      | 30.00      | .00        | 30.00      | 30.00      | 20.00      | 20.00      |
| Mazda Merge | GBFS-67-060  | 0        | 060  | GBFS-67-060(8)-11  | 1112 | 16.00      | 16.00      | 8.00       | 16.00      | 8.00       | 8.00       | 8.00       |
| Mazda Merge | KJM3-67-130  | 0        | 130  | KJM3-67-130(3)-10  | 1118 | 280.00     | .00        | 224.00     | 392.00     | 195.00     | 224.00     | 168.00     |
| Mazda Merge | KN4H-67-190  | 0        | 190  | KN4H-67-190(16)-15 | 1123 | .00        | .00        | .00        | .00        | 48.00      | 48.00      | 80.00      |
| Mazda Merge | KN3L-67-100  | 0        | 100  | KN3L-67-100(11)-13 | 1124 | 160.00     | 160.00     | 160.00     | 160.00     | 100.00     | 120.00     | 60.00      |
| Mazda Merge | KJN9-67-130  | 0        | 130  | KJN9-67-130(2)-9   | 1118 | .00        | .00        | .00        | .00        | 56.00      | .00        | 56.00      |
| Mazda Merge | KJL1-67-200  | 0        | 200  | KJL1-67-200A(4)-9  | 1114 | .00        | 296.00     | 312.00     | 296.00     | 200.00     | 200.00     | 160.00     |

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.

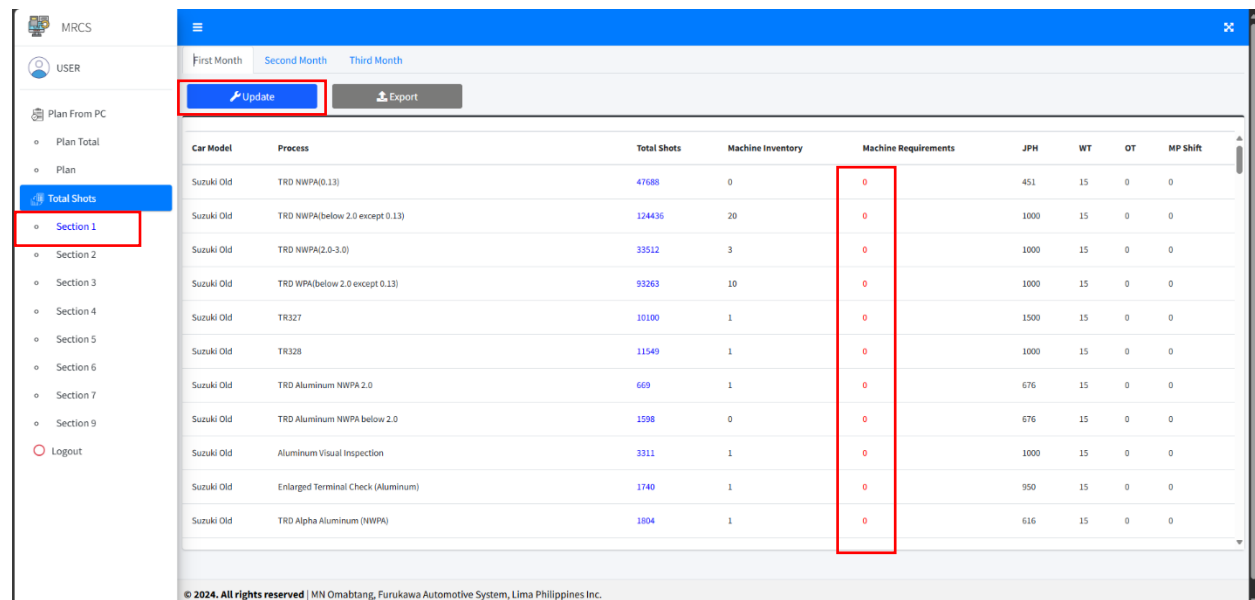
7. Go to the "Total Shots" page and load Tab1, 2, 3, and 4 and then click "Extract Total Shots"



| Car Model  | Process                        | 1st Total Shots | 2nd Total Shots | 3rd Total Shots |
|------------|--------------------------------|-----------------|-----------------|-----------------|
| Honda TKRA | trd_nwpa_0_13                  | 76795           | 81538           | 85649           |
| Honda TKRA | trd_nwpa_below_2_0_except_0_13 | 260532          | 266705          | 266143          |
| Honda TKRA | trd_nwpa_2_0_3_0               | 20854           | 21648           | 22671           |
| Honda TKRA | trd_wpa_0_13                   | 0               | 0               | 0               |
| Honda TKRA | trd_wpa_below_2_0_except_0_13  | 75258           | 77306           | 80343           |
| Honda TKRA | trd_wpa_2_0_3_0                | 0               | 0               | 0               |
| Honda TKRA | tr327                          | 0               | 0               | 0               |
| Honda TKRA | tr328                          | 0               | 0               | 0               |
| Honda TKRA | trd_aluminum_nwpa_2_0          | 168             | 168             | 226             |
| Honda TKRA | trd_aluminum_nwpa_below_2_0    | 1036            | 1068            | 1084            |
| Honda TKRA | trd_aluminum_wpa_2_0           | 0               | 0               | 0               |

© 2024. All rights reserved | MN Ombatang, Furukawa Automotive System, Lima Philippines Inc.

8. On the "Section" page, machine requirements will show 0 (shown as red, see visuals for reference). Update button should be clicked to initialize auto compute. Results will then show up. (There is no need to click update per section as each will auto compute after the first update.)



| Car Model  | Process                            | Total Shots | Machine Inventory | Machine Requirements | JPH  | WT | OT | MP Shift |
|------------|------------------------------------|-------------|-------------------|----------------------|------|----|----|----------|
| Suzuki Old | TRD NWPA(0.13)                     | 47688       | 0                 | 0                    | 451  | 15 | 0  | 0        |
| Suzuki Old | TRD NWPA(below 2.0 except 0.13)    | 124436      | 20                | 0                    | 1000 | 15 | 0  | 0        |
| Suzuki Old | TRD NWPA(2.0-3.0)                  | 33512       | 3                 | 0                    | 1000 | 15 | 0  | 0        |
| Suzuki Old | TRD WPA(below 2.0 except 0.13)     | 93263       | 10                | 0                    | 1000 | 15 | 0  | 0        |
| Suzuki Old | TR327                              | 10100       | 1                 | 0                    | 1500 | 15 | 0  | 0        |
| Suzuki Old | TR328                              | 11549       | 1                 | 0                    | 1000 | 15 | 0  | 0        |
| Suzuki Old | TRD Aluminum NWPA 2.0              | 669         | 1                 | 0                    | 676  | 15 | 0  | 0        |
| Suzuki Old | TRD Aluminum NWPA below 2.0        | 1598        | 0                 | 0                    | 676  | 15 | 0  | 0        |
| Suzuki Old | Aluminum Visual Inspection         | 3311        | 1                 | 0                    | 1000 | 15 | 0  | 0        |
| Suzuki Old | Enlarged Terminal Check (Aluminum) | 1740        | 1                 | 0                    | 950  | 15 | 0  | 0        |
| Suzuki Old | TRD Alpha Aluminum (NWPA)          | 1804        | 1                 | 0                    | 616  | 15 | 0  | 0        |

© 2024. All rights reserved | MN Ombatang, Furukawa Automotive System, Lima Philippines Inc.

9. Click the data per row to be able to modify the "JPH", "WT", and "OT".

MRCSS

USER

Plan From PC

- Plan Total
- Plan
- Total Shots
- Section 1
- Section 2
- Section 3
- Section 4
- Section 5
- Section 6
- Section 7
- Section 9
- Logout

First MonthSecond MonthThird Month

UpdateExport

| Car Model  | Process                            | Total Shots | Machine Inventory | Machine Requirements | JPH  | WT | OT | MP Shift |
|------------|------------------------------------|-------------|-------------------|----------------------|------|----|----|----------|
| Suzuki Old | TRD NWPA(0.13)                     | 47688       | 0                 | 7.05                 | 451  | 15 | 0  | 7.05     |
| Suzuki Old | TRD NWPA(below 2.0 except 0.13)    | 124436      | 20                | 8.3                  | 1000 | 15 | 0  | 8.3      |
| Suzuki Old | TRD NWPA(2.0-3.0)                  | 33512       | 3                 | 2.23                 | 1000 | 15 | 0  | 2.23     |
| Suzuki Old | TRD WPA(below 2.0 except 0.13)     | 93263       | 10                | 6.22                 | 1000 | 15 | 0  | 6.22     |
| Suzuki Old | TR327                              | 10100       | 1                 | 0.45                 | 1500 | 15 | 0  | 0.45     |
| Suzuki Old | TR328                              | 11549       | 1                 | 0.77                 | 1000 | 15 | 0  | 0.77     |
| Suzuki Old | TRD Aluminum NWPA 2.0              | 669         | 1                 | 0.07                 | 676  | 15 | 0  | 0.07     |
| Suzuki Old | TRD Aluminum NWPA below 2.0        | 1598        | 0                 | 0.16                 | 676  | 15 | 0  | 0.16     |
| Suzuki Old | Aluminum Visual Inspection         | 3311        | 1                 | 0.22                 | 1000 | 15 | 0  | 0.22     |
| Suzuki Old | Enlarged Terminal Check (Aluminum) | 1740        | 1                 | 0.12                 | 950  | 15 | 0  | 0.12     |
| Suzuki Old | TRD Alpha Aluminum (NWPA)          | 1804        | 1                 | 0.2                  | 616  | 15 | 0  | 0.2      |

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.

MRCSS

USER

Plan From PC

- Plan Total
- Plan
- Total Shots
- Section 1
- Section 2
- Section 3
- Section 4
- Section 5
- Section 6
- Section 7
- Section 9
- Logout

First MonthSecond MonthThird Month

UpdateExport

| Car Model  | Process                            | Total Shots | Machine Inventory | Machine Requirements | JPH  | WT | OT | MP Shift |
|------------|------------------------------------|-------------|-------------------|----------------------|------|----|----|----------|
| Suzuki Old | TRD NWPA(0.13)                     | 47688       | 0                 | 7.05                 | 451  | 15 | 0  | 7.05     |
| Suzuki Old | TRD NWPA(below 2.0 except 0.13)    | 124436      | 20                | 8.3                  | 1000 | 15 | 0  | 8.3      |
| Suzuki Old | TRD NWPA(2.0-3.0)                  | 33512       | 3                 | 2.23                 | 1000 | 15 | 0  | 2.23     |
| Suzuki Old | TRD WPA(below 2.0 except 0.13)     | 93263       | 10                | 6.22                 | 1000 | 15 | 0  | 6.22     |
| Suzuki Old | TR327                              | 10100       | 1                 | 0.45                 | 1500 | 15 | 0  | 0.45     |
| Suzuki Old | TR328                              | 11549       | 1                 | 0.77                 | 1000 | 15 | 0  | 0.77     |
| Suzuki Old | TRD Aluminum NWPA 2.0              | 669         | 1                 | 0.07                 | 676  | 15 | 0  | 0.07     |
| Suzuki Old | TRD Aluminum NWPA below 2.0        | 1598        | 0                 | 0.16                 | 676  | 15 | 0  | 0.16     |
| Suzuki Old | Aluminum Visual Inspection         | 3311        | 1                 | 0.22                 | 1000 | 15 | 0  | 0.22     |
| Suzuki Old | Enlarged Terminal Check (Aluminum) | 1740        | 1                 | 0.12                 | 950  | 15 | 0  | 0.12     |
| Suzuki Old | TRD Alpha Aluminum (NWPA)          | 1804        | 1                 | 0.2                  | 616  | 15 | 0  | 0.2      |

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.

First Month

Car Model

Suzuki Old

Process

trd\_nwpa\_0\_13

Machine Inventory

0

JPH

451

WT

7.5

OT

0

Close

Save changes

10. Click "update" after modifying the details in order to recompute the "Machine Requirements".

USER

Plan From PC

- Plan Total
- Plan
- Total Shots**
  - Section 1
  - Section 2
  - Section 3
  - Section 4
  - Section 5
  - Section 6
  - Section 7
  - Section 9
- Logout

First MonthSecond MonthThird Month

Update

Export

| Car Model  | Process                            | Total Shots | Machine Inventory | Machine Requirements | JPH  | WT  | OT | MP Shift |
|------------|------------------------------------|-------------|-------------------|----------------------|------|-----|----|----------|
| Suzuki Old | TRD NWPA(0.13)                     | 47688       | 0                 | 14.1                 | 451  | 7.5 | 0  | 14.1     |
| Suzuki Old | TRD NWPA(below 2.0 except 0.13)    | 124436      | 20                | 8.3                  | 1000 | 15  | 0  | 8.3      |
| Suzuki Old | TRD NWPA(2.0-3.0)                  | 33512       | 3                 | 2.23                 | 1000 | 15  | 0  | 2.23     |
| Suzuki Old | TRD WPA(below 2.0 except 0.13)     | 93263       | 10                | 6.22                 | 1000 | 15  | 0  | 6.22     |
| Suzuki Old | TR327                              | 10100       | 1                 | 0.45                 | 1500 | 15  | 0  | 0.45     |
| Suzuki Old | TR328                              | 11549       | 1                 | 0.77                 | 1000 | 15  | 0  | 0.77     |
| Suzuki Old | TRD Aluminum NWPA 2.0              | 669         | 1                 | 0.07                 | 676  | 15  | 0  | 0.07     |
| Suzuki Old | TRD Aluminum NWPA below 2.0        | 1598        | 0                 | 0.16                 | 676  | 15  | 0  | 0.16     |
| Suzuki Old | Aluminum Visual Inspection         | 3311        | 1                 | 0.22                 | 1000 | 15  | 0  | 0.22     |
| Suzuki Old | Enlarged Terminal Check (Aluminum) | 1740        | 1                 | 0.12                 | 950  | 15  | 0  | 0.12     |
| Suzuki Old | TRD Alpha Aluminum (NWPA)          | 1804        | 1                 | 0.2                  | 616  | 15  | 0  | 0.2      |

© 2024. All rights reserved | MN Omabtang, Furukawa Automotive System, Lima Philippines Inc.