

Costing Module

User Manual



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Introduction

This documentation is a guide to the web-based Costing module. It illustrates a step-by-step instruction on how to add/change/delete records, generate and print reports. The purpose of the Costing Module is to calculate the cost of each part produced at UGN. Certain team members are notified to approve the cost sheets. Once the cost sheets are approved, another set of UGN team members are notified.

General Rules for New UGN Database modules

First of all, there is no “log on” or “sign on” screen to get to any of the new UGN Database applications. Security is handled by the active directory account of the team member’s computer. Once the team member logs onto the computer, the new UGN Database will be automatically available.

Next, there is a new set of sections on the “Home” page of the UGN Database. In order to guide the user to the appropriate screen (and save users several mouse clicks), the UGN Database will check if there are any pending tasks for any of the new UGN Database Modules. (*Old modules that still require team members to click into the “Classic UGN Database Applications” will NOT see pending tasks on the home page. The team members still need to manually navigate to the appropriate pages. As each module is rebuilt, the pending tasks for the new modules will be placed in the lists below.*) A second list has been added to show the five most recent updates by the team member.

TEST: UGN Database

Home

Welcome to the TEST UGN Database

Below is the list of pending tasks for the Accounts Receivable Tracking and/or Costing Modules

| Rec ID # | Module | Description | Date Modified | Status | Preview Primary | Preview Secondary | History |
|----------|---------|---|---------------|---------|-----------------|-------------------|---------|
| 11472 | Costing | Cost Sheet and/or Die Layout to be reviewed | 05/14/2009 | Pending | | | |
| 11468 | Costing | Cost Sheet and/or Die Layout to be reviewed | 05/14/2009 | Pending | | | |

View your most recent updates

Below is the list of your last 5 most recent updates to the Accounts Receivable Tracking, and/or Costing Modules

| Rec ID # | Module | Description | Date Updated | Status | Preview Primary | Preview Secondary | History |
|----------|----------|---|--------------|---|-----------------|-------------------|---------|
| 246 | AR Event | Closed | 12/15/2008 | Closed | | | |
| 245 | AR Event | Closed | 12/15/2008 | Closed | | | |
| 15 | AR Event | Closed | 04/27/2009 | Closed | | | |
| 13 | AR Event | Waiting for Deduction Form Approval from Plant Controller | 04/27/2009 | Waiting for Deduction Form Approval from Plant Controller | | | |
| 8 | AR Event | Closed | 04/27/2009 | Closed | | | |
| 851 | Costing | Cost Sheet and/or Die Layout Reviewed | 11/15/2008 | Approved | | | |
| 4950 | Costing | Cost Sheet and/or Die Layout Reviewed | 11/15/2008 | Approved | | | |

On the left side of the UGN Database is a “tree menu” which contains the links to each page of the new modules. Depending upon the rights of the team member, different menu links will be available. For any user with “read only” or “admin” rights to the Costing Module, the “Cost Sheet” link is available to search for cost sheets.

Home

Accounts Receivable:

Acoustic:

Calendars:

Costing:

- Capital
- Catching Ab... Factor
- Cost Sheet
- Cost Sheet Activity
- Cost Sheet Approve
- Cost Sheet Notification Groups
- Formula
- Labor
- Material
- Misc Cost
- Overhead
- Process
- Template

Cycle Counter Matrix:

Data Maintenance:

Drawing Management:

The Costing Module

The rest of this document will describe the costing module specifically.

Cost Sheet List/Search

After selecting the [Cost Sheet](#) link from the tree menu, the list/search page will be shown.

Search for Cost Sheet

Review existing data or press to enter new data.

Partial Searches can be completed by placing % before or after text.

| | |
|---|---|
| Cost Sheet ID: <input type="text"/> | Cost Sheet Status: <input type="text" value="Current"/> |
| Drawing No: <input type="text"/> | BPCS Part No: <input type="text"/> <input type="checkbox"/> Check BOM |
| Customer Part No: <input type="text"/> | Design Level: <input type="text"/> |
| Part Name: <input type="text"/> | RFQ/RFC No: <input type="text"/> |
| Approval Status: <input type="text"/> | Waiting For Which Team Member To Approve: <input type="text"/> |
| Approved By Team Member: <input type="text"/> | Account Manager: <input type="text"/> |

Advanced Search
☐ Keep advanced search open
Program:
Commodity:
Year:
Formula:
UGN Facility:
Customer:
Department:

The **Cost Sheet** search parameters as follows:

| Parameter | Description |
|-------------------|--|
| Cost Sheet ID | The main identifier of each cost sheet |
| Cost Sheet Status | Current, pending, previous, proposal: the types of cost sheets available. |
| Drawing No | The Drawing Management System (DMS) number associated with the cost sheet. |
| BPCS Part No | If the cost sheet is for a semi-finished good or raw material, or if the cost sheet is carried over from the old system, the part number relating to the BPCS system can be searched. <i>Check BOM indicates that the Materials will be searched instead of the top level part number.</i> |
| Customer Part No | Particularly relating to changes requested in a “Request for Quote (RFQ)”, the part number created by the customer that identifies the part manufactured by UGN. (In the actual detailed view of the cost sheet, all BPCS Part number/Finished Good Part numbers will be listed which are associated to this Customer Part number. |
| Design Level | The design level of the new part being quoted. This is also referenced from the RFQ. |
| Part Name | The name of the part. |
| RFQ/RFC | The identifier of the RFQ or “Request for Change (RFC)” document. When the new “Request for Development (RFD)” document combines RFQ and RFC, the RFD identifier will be here. |

| | |
|--|---|
| Program | The UGN Program, which often corresponds to vehicle model |
| Commodity | The UGN Commodity is the type of part or “product line” that UGN produces. |
| Year | The year of the vehicle. |
| Formula | Each part is built with a certain formula, which contains certain measurements and bill of materials. |
| UGN Facility | Location of where the part is produced. |
| Customer (CABBV) | The CABBV is the customer abbreviation used in the billing system of UGN (Future 3 and BPCS). |
| Account Manager | The account manager at UGN that requested the cost sheet. |
| Department | The department at the UGN Facility that will be working on the part. |
| Approval Status | If the cost sheet has been approved or is pending approval by team members. |
| Waiting for which team member to approve | A dynamic list of team members who have cost sheets waiting for approval. As a team member approves all cost sheets, the name will be removed from the dropdown list. |
| Approved by team member | A dynamic list of team members of whom approved at least one cost sheet in the past. |

The **Cost Sheet results** are as follows:

For team members with “read only” rights and NO approval rights to cost sheets, a list of results will show only approved cost sheets.

For team members with “read only” rights WITH approval rights to cost sheets, a list of results will have rows containing a yellow background or white background. Rows with a yellow background indicate at least one team member still needs to approve the cost sheet. Rows with a white background indicate the cost sheet has been approved. Cost sheets that have been created BUT NOT sent to anyone for approval are not available to these team members at this point and, thus, are not included in the result list.





















For team members with “admin” rights, costing coordinators, all possible cost sheets are available. The same color scheme applies as mentioned previously. Those particular team members can also click the “add” button to create new cost sheets.

Any of the three types of team members mentioned above can click the preview links to see cost forms or die layout forms, if they exist. Team members with “read only” rights can click on the cost sheet ID to see approval details and history. Team members with “admin” rights can click on the cost sheet ID to see all details of the cost sheet.

Regarding the search result set of records, users can navigate the number of pages that are shown or directly jump to a certain page. All search parameters are saved and the page number is saved until the team member closes the browser.

Use the parameters above to filter the list below. A row with yellow background indicates approvals are pending by one or more team members. A row with red background indicates at least one team member has rejected the cost form.

Page: 1 of 188 

| Cost Sheet | Notifications | Part Name | PartNo | New Design Level | RFQ/RFC | Preview Cost Form | Preview Die Layout |
|------------|---------------|----------------------|----------------------|------------------|---------|---|---|
| 13043 | Approvers | SILENCER TUNNEL F | 90712AJ00A | EZ5-A0945 | 15742 |  |  |
| 13042 | Approvers | SILENCER TUNNEL F | RSS-90712AJ00A | EZ5-A0945 | 15742 |  |  |
| 13041 | Approvers | INS, DASHBOARD | 74260-SWA-A010X | A-09-00763 | 15743 |  | |
| 13040 | Approvers | INS, DASHBOARD | 74260-SWA-A010 | A-09-00763 | 15743 |  | |
| 13039 | Approvers | DIE-CUT BARRIER | 6147 | 04 | 15743 |  |  |
| 13038 | Approvers | Dash Inner RHD | 67900 3KE0A | Proposal 2 | 15479 |  | |
| 13037 | Approvers | Hood Insulator | 65840 3JA0A | Proposal 4 | 15485 |  | |
| 13020 | Approvers | Hood Insulator | 65840 3JA0A | Proposal 3 | 15484 |  | |
| 13015 | Approvers | Dash Outer - RHD | 67810 3KA0A | Proposal 3 | 15482 |  | |
| 13011 | Approvers | INS, DA/BD LWR OUT | 74251-TK8A-A000 | TK8A-F-2515 | 15542 |  | |
| 13010 | Approvers | INSULATOR, HOOD | 74141-TK8A-X000 | TK8A-F-1153 | 15543 |  | |
| 13009 | Approvers | Dash Outer - RHD | 67810 3KA0A | Proposal 3 | 15482 |  | |
| 13001 | Approvers | Dash Inner- LHD | 67900 3JA0A | Proposal 2 | 15478 |  | |
| 13000 | Approvers | AFR-1603-10024-1(00) | AFR-1603-10024-1(00) | | 15478 |  |  |
| 12999 | Approvers | INS, RR FLR CTR | 74689-TR0A-A000 | TR0A-F-1027 | 15754 |  |  |


Cost Sheet Detail

For team members with “admin” rights, costing coordinators, when the Cost Sheet ID is clicked on the list page, then all details for the cost sheet are shown.


There are three sections to the detail screen.


| Section | Description |
|--|---|
| Cost Sheet BPCS PartNo(s), Customer PartNo, and DrawingNo | All fields relating to the identification or description of the part being quoted. Buttons to manage the cost sheet. |
| Program Customer | Make, Program, Program Year, and Customer |
| Calculation Factors | All fields relating to the price or measurement of the part. See additional instructions below. |
| Totals | The results showing the total of each calculation factor broken down into a table. |

With every section that is a “grid”, there are special instructions for adding, editing, and deleting rows. A set of buttons are located on the right side of each grid.

To add a row, enter information in the last row and then click the “save”  button.

To ignore the change, click the “undo”  button.

To edit a row, click the “edit”  button, change the information, and then click the save button.

To delete a row, click the “delete”  button.


In some cases, if the grid is too large to fit on the web page, such as the customer information on the cost sheet details page, then a set of controls will be above the grid to handle inserting and updating information.

Cost Sheet Detail

Cost Sheet ID: **11798**

Previous Cost Sheet ID: **11557**

Cost Sheet Status: **Pending** ▼

Quote Date: **7/7/2009** 

RFQ/RFC No: **14684**

ECI No:

1. Cost Sheet BPCS PartNo(s), Customer PartNo, and DrawingNo

Designation Type: ▼

New DrawingNo: 

UGN Facility: **Somerset** ▼

Part #: 6171

Original Part #: 6068

New Customer Part Name: **LOFT FOR DASH INNER**

Purchased Good: ▼

New BPCS PartNo: 

New Revision:

Original BPCS PartNo: 

Revision:

Commodity: ▼

New Customer Part No: 

New Design Level: **02**

Original Customer Part No: 

|  Finished Good BPCS PartNo | BPCS Part Revision | BPCS Part Name | |
|---|----------------------|----------------------|---|
| <input type="text"/> | <input type="text"/> | <input type="text"/> |   |

Notes:

☒ Replicate using Formula Information

☐ Replicate using Cost Sheet Information

(Each list of items will reflect the formula exactly.) (The newest rates, crew sizes, etc. will be refreshed from the maintenance pages. Other changes to the current cost sheet will be copied.)

☒ Replicate as Pending Quote ☐ Replicate as Proposal

Save

Delete

Replicate

PRE-Approval Notify

POST-Approval Notify

2. Program / Customer

Model: Civic

Make: Honda

Year: 2009

Make: **HONDA** ▼

Program: ▼



Year: ▼

Customer: ▼

Add Program / Customer

| Make | Program | Customer | |
|-------|-----------|---|---|
| HONDA | 2HC CIVIC | 1140 HONDAN HONDA OF AMERICA MFG., INC. |  |

| Control Name | Description |
|--------------------------|--|
| Cost Sheet Status | If a cost sheet status is changed and a previous cost sheet exists, then the cost sheet status of the previous cost sheet will be changed to previous. |
| Quote Date | The current date of when the Cost Sheet was created becomes the default. |
| Part # / Original Part # | If the cost sheet was pulled from the old system and the part # has a value, it will be displayed in the label. |

| | |
|--|--|
| Designation Type | <p>This is a category for the type of part at UGN. Finished Goods are parts sold to customers. Semi-Finished Goods are parts made by UGN and used by UGN to put into Finished Goods. Raw Materials are parts purchased from Vendors.</p> <p>If Finished Good is selected, then the Customer Part No field, Original Customer Part No field, Commodity field and Finished Good BPCS Part No Grid are shown.</p> <p>If Semi-Finished or Raw Material is selected, the New BPCS Part No field, Original BPCS Part No, and Purchased Good fields are shown.</p> <p>If any other item is selected, then all fields are shown.</p> <p>The designation type will be consistent with the BPCS System. (The Phantom type is a type of formula and will be discussed later).</p> |
|  Drawing No, Customer Part No, and BPCS Part No | Each number can be searched from a popup box. Once selected in the popup box, the corresponding field will be updated. |
| BPCS Part Revision | Each BPCS Part No in the BPCS System has a revision assigned to it. |
| Finished Good BPCS Part No Grid (list) | <p>A grid appears for parts with the designation type of Finished Goods. There is a list of Finished Good BPCS Part numbers that are associated to a Customer Part number. The user can search for a BPCS Part number based on a row by row</p> <p>basis. Another option is to press the copy  button to find all Finished Good BPCS Part numbers for a particular customer part number.</p> |
| Save | Create or update the cost sheet. |
| Delete | Delete the cost sheet. |
| Replicate | <p>Copy parts of the cost sheet with various options:</p> <p>Replicate using Formula Information (Each list of items will reflect the formula exactly.)</p> <p>Replicate using Cost Sheet Information (The newest rates, crew Sizes, etc. will be refreshed. Other changes to the current cost sheet will be copied.)</p> <p>Replicate as Pending Quote (Cost Sheet Status)</p> <p>Replicate as Proposal (Cost Sheet Status)</p> |
| PRE-Approval Notify | Open the web page that creates/updates team member who need to approve the cost sheet. |
| POST-Approval Notify | Open the web page that creates/updates the team member list of those who will be notified when the cost sheet has been approved by all required team members. |

DMS Drawing No Popup:

UGN, Inc. Drawing Look Up - Windows Internet Explorer provided by UGN, Inc.

Lookup Drawing Numbers


Drawing No:
Sub-Family:
Commodity:

Name:
Program:
Purchased Good:

| Drawing No. | Release Type | Old Drawing Name | BPCS Part Name | BPCS Part No. | BPCS Part Rev. | ProgramName | SubFamilyName | CommodityName | PurchasedGoodName |
|-------------------|--------------|-----------------------------|--------------------------------|---------------|----------------|-------------|---|---------------|-------------------|
| 0502-00005-1(00) | Study | Tape Heat Resistant 3M 8978 | | | | MAZDA 6 | SF Adhesives - Tape | Carpet | |
| 0502-00015-1(00) | PAST-Release | | CHRYSLER NS MINI-VAN | 04716589 | | LEGACY | SF Adhesives - Tape | Damplex | |
| 0502-00016-9(00) | PAST-Release | | CHRYSLER NS MINI-VAN | 04716589 | | LEGACY | SF Adhesives - Tape | Damplex | |
| 0502-25003-1(00) | PRE-Release | BUTYL TAPE 2-SIDED TAPE | | | | LEGACY | SF Knitted fabrics - Circular | | Tape |
| 0502-25003-1(01) | Prototype | BUTYL TAPE 2-SIDED TAPE | | | | LEGACY | Parts Plastic - Inj.mould.parts (Aesthetic) | | Tape |
| 0520-00002-1(00) | Prototype | test | | 9999 | | 2HC CIVIC | Parts Plastic - Inj.mould.parts (>500g) | Trunk Systems | |
| 10502-00002-1(02) | PAST-Release | Tape Duct 3M 6969 N | RIE/CHRYSLER LH/FRT FLR PAN FR | 04780516AB | | LEGACY | SF Adhesives - Tape | | Tape |
| 10502-00002-1(03) | Prototype | Tape Heat Resistant 3M 8978 | CHRYSLER NS MINI-VAN | 04716589 | | LEGACY | SF Adhesives -Others | Damplex | |
| 10502-00002-1(05) | PRE-Release | | RIE/CHRYSLER LH/FRT FLR PAN FR | 04780516AD | | LEGACY | SF Adhesives - Tape | | Tape |
| 10502-00002-9(00) | PRE-Release | | | | | LEGACY | SF Adhesives - Tape | Mudguard | |

Done Local intranet 100%

The above popup occurs when a user needs to search for a DMS Drawing No.

| Control | Description |
|---|--|
| Drawing No | The DMS Drawing Identification Number |
| Name | The name of the drawing |
| Sub-Family | If the part is a raw material, the sub-family name can be used to search. This is a vendor defined description of a part. |
| Program | If the part is a finished good, it can be found based on UGN Program, which relates to vehicle model, defined by the customer. |
| Commodity | If the part is a finished good, it can be searched based on a descriptive type. |
| Purchased Good | This is a UGN defined description of a raw material purchased by UGN. |
| Search | Button to search for a field. |
| Reset | Button to clear all search parameters. |
|  | Button to select a row and populate the parent page. |

BPCS Part No Popup:

Lookup BPCS Parts

Search BPCS Part No.: Search BPCS Part Name:

Drawing Number: Active Type:

Designation Type:

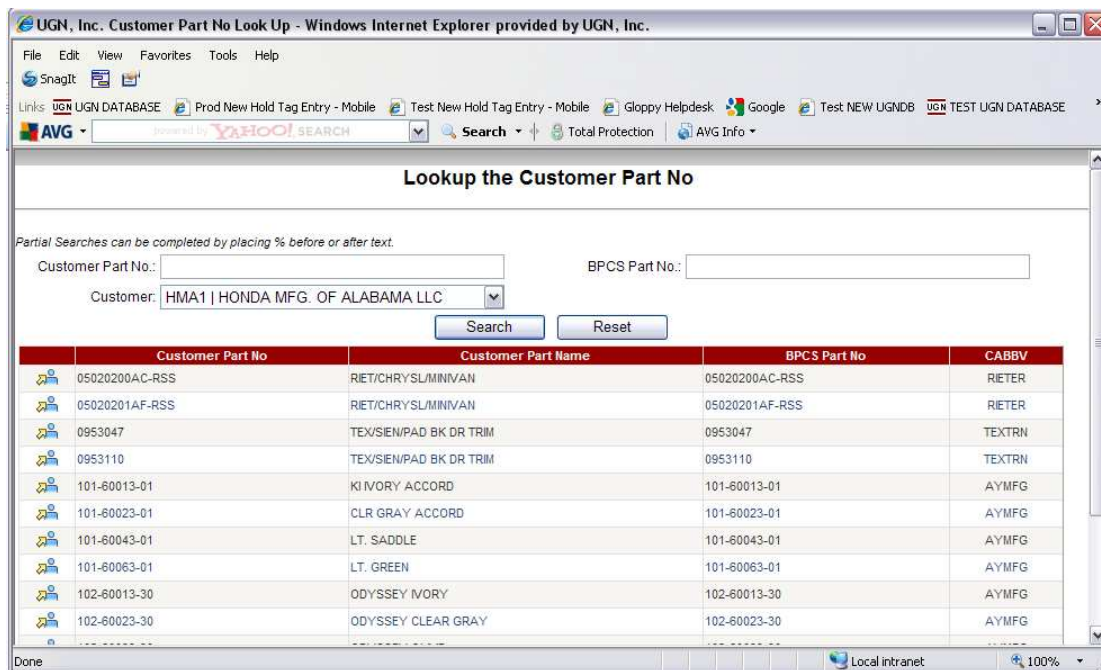
| BPCS Part No | Revision | BPCS Part Name | Designation Type | Active Type | BPCS Obsolete |
|----------------|----------|--------------------------------|------------------|-------------|---------------|
| 04716588 | 01 | CHRYSLER NS MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04716589 | 01 | CHRYSLER NS MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04716784 | 01 | CHRYSLER NS MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04716765 | 01 | CHRYSLER NS MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04716902 | 01 | CHRYSLER NS MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04716903 | 01 | CHRYSLER NS MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04780516AB | 01 | RIE/CHRYSLER LH/FRT FLR PAN FR | H-Service | IM-Active | 99-Obsolete |
| 04780516AD | 01 | RIE/CHRYSLER LH/FRT FLR PAN FR | H-Service | IM-Active | 99-Obsolete |
| 04780516AE-RSS | 01 | RIE/CHRYSLER LH/FRT FLR PAN FR | H-Service | IM-Active | 99-Obsolete |
| 04780517AC | 01 | RIE/CHRYSLER LH/FRT FLR PAN FR | H-Service | IM-Active | 99-Obsolete |
| 04783908 | 01 | CHRYSLER NEON | H-Service | IM-Active | 99-Obsolete |
| 04783976 | 01 | CHRYSLER NEON | H-Service | IM-Active | 99-Obsolete |
| 04860274 | 01 | CHRYSLER MINI-VAN | H-Service | IM-Active | 99-Obsolete |
| 04878940AA | 01 | RIE / CHRYSLER JA BODY / N/A | H-Service | IM-Active | 99-Obsolete |

Done Local intranet 100%


The above popup occurs when a user needs to search for a BPCS Part No.

| Control | Description |
|------------------|--|
| BPCS Part No | The BPCS Part Number |
| Name | The name of the part |
| Drawing No | In the BPCS System itself, a drawing number might be assigned to the BPCS part number. This will increase in the future. |
| Active Type | In the BPCS System, parts are set to active or inactive. |
| Designation Type | In the BPCS System, parts are assigned to a category. The most commonly used types for the Costing module will be: semi-finished good, finished good, raw material, phantom, and possibly service. |
| Search | Button to search for a field. |
| Reset | Button to clear all search parameters. |
| | Button to select a row and populate the parent page. |

Customer Part No Popup:



The above popup occurs when a user needs to search for a Customer Part No.

| Control | Description |
|---|---|
| Customer Part No | The Customer Part Number |
| BPCS Part No | The BPCS Part Number |
| Customer CABBV | In the BPCS System itself, a customer abbreviation is assigned to a customer part no. |
| Search | Button to search for a field. |
| Reset | Button to clear all search parameters. |
|  | Button to select a row and populate the parent page. |

Calculation Factors

3. Cost Sheet Calculation Factors

Part Specification

Additional Offline Rates

Production Rates

Quote Info

Materials

Packaging

Labor

Overhead

Misc Costs

Drawings

Composite Part Spec.

Molded Barrier

Capital

A yellow background indicates a difference from the value in the formula.

Formula: COMP. LTWT ▼

Diecut ☒

Thickness: 2.1000 mm ▼

Completed Offline ☒

Off Line Rate: 90

Number of Holes:

Part Width: m ▼

Part Length: 0.6470 m ▼

Configuration Factor: 0.9000 90.00%

Department: Melsheet 1/Off-Line (35/15) ▼

Pieces Per Cycle: 1

Pieces Caught Together: 1

Side By Side ☐

Calculated Area: 0.321800 m2 ▼

Changed Area: 0.321800 m2 ▼

Die Layout Width: 1.0800 m ▼

Die Layout Travel: 0.6870 m ▼

Specific Gravity: 1.5000 g/cm3 ▼

Process: On/Off-Line ▼

Save

Calculate

Update Totals

Preview Cost Sheet

Preview Die Layout

Part Specifications:

If a value in these fields is different than the default value of the formula, then the background color of the field will be yellow. The units are read-only at this point.

After all required information is entered, then the calculate button can be pressed to see the new totals in the bottom section of the web page.

The following fields are available to the Costing Coordinator:

| Fields/Buttons | Description |
|--------------------|---|
| Formula | The <i>formula</i> dropdown list. After the selection, the system will automatically set as default any or all values for <i>Labor</i> , <i>Overhead</i> , <i>Materials</i> , <i>Packaging</i> , and/or <i>Misc. Costs</i> entered in the formula maintenance page. Based on the formula selection, the fields/buttons on the form will enable or disable. This is a required field. |
| Die Cut | This field will be set as a default from the formula selection with an option to overwrite. If the <i>die cut</i> check box is checked then the formula is used in die-layout parts. If left unchecked, no die-layout will be available. |
| Thickness | The <i>thickness</i> for the part indicated on the cost sheet |
| Completed Off Line | If a <i>completed off line</i> is required, this field should be checked. |
| Off Line Rate | If the <i>completed off line</i> is checked, then the <i>off line rate</i> for the part indicated on the cost sheet should be entered. The <i>off line rate</i> is used to determine “per piece” and “hourly capital rate” for capital. |

| | |
|-----------------------------|--|
| Number of Holes | The <i>number of holes</i> for the part indicated on the cost sheet. The <i>number of holes</i> is used to determine the “de-plug capacity limit” for production rates. |
| Part Width in Meters | The <i>part width in meters</i> for the part indicated on the cost sheet |
| Part Length in Meters | The <i>part length in meters</i> for the part indicated on the cost sheet |
| Configuration Factor | The <i>configuration factor</i> for the part indicated on the cost sheet. By default the <i>configuration factor</i> will be set to 90%. The <i>configuration factor</i> is used to determine “quoted press cycles” and “max quoted pieces” for production rates. |
| Repack Material | The <i>repack material</i> for the part indicated on the cost sheet. The <i>repack material</i> is used with “repack” formula. |
| Approx Weight | The <i>approximate weight</i> for the part indicated on the quote. The <i>approximate weight</i> is used with the “repack” formula and will be used to display on the quote sheet. |
| Pieces/Cycle | The <i>pieces/cycle</i> for the part indicated on the cost sheet. The <i>pieces/cycle</i> is used to determine the “percent recycle”, “catching ability”, “quoted press cycles”, “max quoted pieces”, “line speed limit”, “cycle limit”, “mix capacity limit”, “press cycles”, “mix capacity kg/hr” and “coating weight” for production rates. |
| Pieces/Caught Together | The <i>pieces/caught together</i> for the part indicated on the cost sheet. The <i>pieces/caught together</i> is used to determine the “catching ability capacity” for production rates. |
| Side by Side | The <i>side-by-side</i> check box for the part indicated on the cost sheet. The <i>side by side</i> is used to determine the “catching ability” for production rates. |
| Calculated Area in sq M | The <i>calculated area in sq m</i> for the part indicated on the cost sheet. The <i>calculated area in sq m</i> is used to determine the “quoted part weight”, “percent recycle”, “mix capacity limit” and “mix capacity kg/hr” for production rates. |
| Changed Area in sq M | The <i>changed area in sq m</i> for the part indicated on the quote. The <i>changed area in sq m</i> is used to determine the “mix capacity limit” and “mix capacity kg/hr” for production rates. |
| Die Layout Width in Meters | The <i>die layout width in meters</i> for the part indicated on the cost sheet. The <i>die layout width in meters</i> is used to determine the “percent recycle”, “mix capacity limit”, “mix capacity kg/hr”, “recycle rate kg/hr” and “coating weight” for production rates. |
| Die Layout Travel in Meters | The <i>die layout travel in meters</i> for the part indicated on the cost sheet. The <i>die layout travel in meters</i> is used to determine the “percent recycle”, “line speed limit”, “mix capacity limit”, “line speed m/min”, “mix capacity kg/hr”, “recycle rate kg/hr” and “coating weight” for production rates. |
| Specific Gravity | The <i>specific gravity</i> for the part indicated on the cost sheet. The <i>specific gravity</i> is used to determine the “part weight”, “mix capacity limit”, “mix capacity kg/hr” and “recycle rate kg/hr” for production rates. |
| Weight/Area g/m2 | The <i>weight/area</i> for the part indicated on the cost sheet. The <i>weight/area</i> is used to determine the “part weight” in grams for production rates. Note: ‘Weight/Area’ and ‘Specific Gravity’ are mutually exclusive. ‘Weight/Area’ will be displayed in case of Fleece formula. ‘Specific Gravity’ will be displayed in case of Non-Fleece formula. |
| Production Rate | The <i>production rate</i> for the part indicated on the cost sheet. The <i>production rate</i> is used to determine the “per piece” and “hourly capital rate” for capital. |

| | |
|--------------------|---|
| Number of Carriers | The <i>number of carriers</i> for the part indicated on the cost sheet |
| Foam | The <i>pounds of foam</i> for the part indicated on the cost sheet |
| Department | The <i>department</i> dropdown list. The <i>department</i> is used to determine the “coating weight” for production rates. |
| Process | The <i>process</i> dropdown list. |
| Calculate | Based on the measurements and other information added on each tab, the values will be calculated. New information will be added to the “Production Rates” tab and the “Totals” section on the bottom of the web page. |
| Update Totals | If the user manually overrides a value of a standard cost per unit but does not want to do a row by row calculation from all of the tabs, then only the totals section will be updated based on the manual values. |

Additional Offline Rates:

3. Cost Sheet Calculation Factors

Part Specification | **Additional Offline Rates** | Production Rates | Quote Info | Materials | Packaging | Labor

Overhead | Misc Costs | Drawings | Composite Part Spec. | Molded Barrier | Capital

Remove All Addition Offline Rates

| Description | Pieces / Hr | Ordinal |
|--|-------------|---------|
| ▼ | | 99 |
| Off-Line Deplug/Magnetizing (15): 4.0000 32.6000 Y | | |
| Off-Line Deplug/Scrap/Pkg (15): 2.0000 32.6000 Y | | |
| 4 Off-Line Die-Cut (15): 4.0000 32.6000 Y | | |
| Off-Line Repack (15): 2.0000 32.6000 Y | | |
| Off-Line RSS Appl. & Pkg. (15): 2.0000 32.6000 Y | | |
| Off-Line tape application (15): 2.0000 32.6000 Y | | |
| Somerset Belt Press (126045): 0.0000 21.2900 Y | | |
| Somerset Damplex (126030): 0.0000 22.9800 Y | | |

Cost Sheet | Preview Die Layout

Labor rates that are checked as “offline” on the Labor Maintenance page are available in the dropdown box of the “Additional Offline Rates” tab of the Cost Sheet Detail web page.

The user must be careful to match the item to the same item on the labor tab in order for calculations to be correct.

The **Additional Offline Rates** tab contains the following fields.

| Fields | Description |
|------------------|--|
| Rate Description | The selection in the dropdown box, which corresponds to offline labor. |
| Pieces Per Hour | The pieces per hour. |
| Ordinal | Identify the order of items as they should appear in the Cost Form. |

Production Rates:

The **Production Rates** tab was designed to display the calculated rates based on the part specification entered for the cost sheet. The information displayed on this screen will later be used to export the data to a cost form and/or die-layout. If the costing coordinator sees a problem with the calculation, all fields may be overwritten.

3. Cost Sheet Calculation Factors

Part Specification

Additional Offline Rates

Production Rates

Quote Info

Materials

Packaging

Labor

Overhead

Misc Costs

Drawings

Composite Part Spec.

Molded Barrier

Capital

Formula Values

Max Mix Capacity: kg/hr ▼

Catching Ability:

Line Speed Limitation:

Catch Percent:

Coating Factor:

Weight Per Area: g/m2 ▼

Production Limits Based on 100%

| Description | Production Limit | Units |
|---------------------------|------------------|-------|
| Line Speed Limit | 3493 | m/min |
| Cycle Limit | 4320 | |
| Mix Capacity | 2960 | kg/hr |
| Catching Ability Capacity | 6261 | |

Sheets Up:

Blank Code:

Quoted Press Cycles:

Quoted Off Line Rate:

Crew Size:

Pieces/Man Hour:

Percent Recycle: 56.63%

| | Quoted | | Maximum | |
|----------------|-------------------------------------|----------------------|--|----------------------|
| Max Pieces: | <input type="text" value="2664"/> | mm ▼ | <input type="text" value="2960"/> | kg/hr ▼ |
| Press Cycles: | <input type="text" value="2664"/> | m/min ▼ | <input type="text" value="2960"/> | m/min ▼ |
| Line Speed: | <input type="text" value="31"/> | m/min ▼ | <input type="text" value="34"/> | m/min ▼ |
| Mix Capacity: | <input type="text" value="2700"/> | kg/hr ▼ | <input type="text" value="3000"/> | kg/hr ▼ |
| Recycle Rate: | <input type="text" value="3526"/> | kg/hr ▼ | <input type="text" value="3918"/> | kg/hr ▼ |
| Part Weight | <input type="text" value="2.2328"/> | lb ▼ | <input type="text" value="1013.6700"/> | g ▼ |
| Coating Weight | <input type="text" value="1291"/> | lb ▼ | | |
| Total Weight | <input type="text" value="2.3619"/> | lb ▼ | | |

Save

Calculate

Update Totals

Preview Cost Sheet

Preview Die Layout

The **Production Rates** tab is designed with the following fields.

| Fields | Description/Calculations |
|------------------|---|
| Max Mix Capacity | The <i>max mix capacity</i> found in the current cost sheet formula selection |
| Max Forming Rate | The <i>max forming rate</i> found in the current cost sheet formula selection. This field will be displayed only for a Fleece-Type formula. |
| Catching Ability | <p>Based on the <i>side by side</i> value on the current cost sheet, a query will run to get any items from the Catching Ability Factors table that match the <i>side by side</i> value. To get the right <i>catching ability</i> value, the following condition must fall true:</p> <p style="padding-left: 40px;">If (pieces per cycle < 2) then</p> <p style="padding-left: 80px;"><i>Catching Ability</i> = 1.15</p> <p style="padding-left: 40px;">Else</p> <p style="padding-left: 40px;">If (part length in meters > CAF("MinPartLength")) & (part length in meters <= CAF("MaxPartLength")) Then</p> <p style="padding-left: 80px;"><i>Catching Ability</i> = CAF("CatchingAbilityFactor")</p> |

| | |
|--|--|
| | <p>End If</p> <p>End If</p> |
| Line Speed Limitation | The <i>line speed limitation</i> found in the current cost sheet formula selection |
| Catch Percent | The <i>catch percent</i> by default is 1. |
| Coating Factor | <p>Based on the current cost sheet formula, a query will run to get any items from the Formula – Coating Factors table that match the formula value. To get the right <i>coating factor</i> value, the following condition must fall true:</p> <p>If (thickness > CF(“MinThickness”)) & (thickness <= CF(“MaxThickness”)) then</p> <p style="padding-left: 40px;"><i>Coating Factor</i> = CF(“CoatingFactor”)</p> <p>End If</p> |
| Weight Area | This field will be displayed, if it is non-zero and non-null. Based on ‘Weight/Area’ entered in Cost Sheet ‘Part Specification’ tab, it will be displayed. |
| Production Limits Based on 100% | |
| Line Speed Limit | <p>The <i>line speed limit</i> is calculated in the following format:</p> <p>If (pieces per cycles, die-layout travel & line speed limitation <> NULL) Then $Line\ Speed\ Limit = (line\ speed\ limitation * pieces\ per\ cycles * 60) / die\ layout\ travel$ End If</p> |
| Cycle Limit | <p>The <i>cycle limit</i> is calculated in the following format:</p> <p>If (pieces per cycles <> NULL) Then $Cycle\ Limit = Formula(“MaxCyclePress”) * pieces\ per\ cycle$ End If</p> |
| Mix Capacity | <p>The <i>mix capacity</i> is calculated in the following format:</p> <p>If (changed area <> calculated area) Then If (thickness, changed area, specific gravity, & max mix capacity) <> NULL or 0 Then If (diecut is unchecked) Then $Mix\ Capacity = (max\ mix\ capacity / (changed\ area * thickness * specific\ gravity)) / 2.205$ ‘convert kgs to lbs Else If (Formula(“ReturnRecycle”) is checked) Then $Mix\ Capacity = (max\ mix\ capacity / (changed\ area * thickness * specific\ gravity))$ Else $Factor = (die\ layout\ width * die\ layout\ travel * thickness * specific\ gravity) / 454 * 1000$ $Mix\ Capacity = ((max\ mix\ capacity / Factor) * piece/cycle)$ End If End IF End If Else If (thickness, calculated area, specific gravity, & max mix capacity) is</p> |

| | |
|---------------------------|---|
| | <p>not null or 0 Then</p> <p> If (diecut is unchecked) Then</p> <p> <i>Mix Capacity</i> = (max mix capacity / (calculated area * thickness * specific gravity)) / 2.205 ‘convert kgs to lbs</p> <p> Else</p> <p> If (Formula(“ReturnRecycle”) is checked) Then</p> <p> <i>Mix Capacity</i> = (max mix capacity / (calculated area * thickness * specific gravity))</p> <p> Else</p> <p> <i>Factor</i> = ((die layout width * die layout travel * thickness * specific gravity) / 454 * 1000)</p> <p> <i>Mix Capacity</i> = ((max mix capacity / <i>Factor</i>) * piece/cycle)</p> <p> End If</p> <p> End If</p> <p>End If</p> |
| Deplug Capacity | <p>Based on the current cost sheet formula, a query will run to get any items from the Formula – Hole Deplug Factors table that match the formula value. To get the right <i>deplug capacity</i> value, the following condition must fall true:</p> <p> If (thickness <> NULL) & (number of holes <> 0) Then</p> <p> If (thickness > HDF(“MinThickness”)) & (thickness <= HDF(“MaxThickness”)) Then</p> <p> <i>Deplug Capacity</i> = HDF(“DeplugFactor”) / number of holes</p> <p> End If</p> <p> End If</p> |
| Catching Ability Capacity | <p>The <i>catching ability capacity</i> is calculated in the following format:</p> <p> If (catching ability, catch percent, & pieces caught together) <> Null or 0 Then</p> <p> <i>Catching Ability Capacity</i> = (((3600 / catching ability) * 2) * catch percent) * pieces caught together)</p> <p> End If</p> |
| Forming Rate (Fleece) | <p>(Max Forming Rate / (Die Layout Width * Die Layout Travel * (Weight Area / 1000))) * Pieces Per Cycle</p> |
| Off Line Specific | |
| Sheets Up | The <i>sheets up</i> used for the part, if any. |
| Blank Code | The <i>blank code</i> used for the part, if any. |
| Quoted Press Cycles | The <i>quoted press cycles</i> for the part, if any. |
| Quoted Off Line Rate | The <i>quoted off line rate</i> for the part, if any. |
| Pieces/Man Hour | <p>The <i>pieces/man hour</i> is calculated in the following format using the first item in the Cost Sheet – Labor table:</p> <p> If (crew size & offline rate <> Null or 0) Then</p> <p> <i>Pieces/Man Hour</i> = (off line rate / crew size)</p> <p> End If</p> |
| Percent Recycle | <p>The <i>percent recycle</i> is calculated in the following format:</p> <p><i>Percent Recycle</i> = ((die layout travel * die layout width) - (pieces per cycle * calculated area)) / (die layout travel * die layout width)</p> |

| Fields | Description/Calculations |
|-------------------------------|--|
| Quoted Max Pieces | The <i>quoted max pieces</i> is calculated in the following format: <i>Quoted Max Pieces</i> = quote press cycles * pieces per cycle |
| Maximum Max Pieces | The <i>maximum max pieces</i> is the minimum value of the production limits displaying in the “Production Limits Based on 100%” text box. |
| Quoted Press Cycles | The <i>quoted press cycles</i> is calculated in the following format: <i>Quote Press Cycles</i> = maximum press cycles * configuration factor |
| Maximum Press Cycles | The <i>maximum press cycles</i> is calculated in the following format: <i>Maximum Press Cycles</i> = max pieces / pieces per cycle |
| Quoted Line Speed m/min | The <i>quoted line speed</i> is calculated in the following format: <i>Quoted Line Speed</i> = maximum line speed * configuration factor |
| Maximum Line Speed m/min | The <i>maximum line speed</i> is calculated in the following format: <i>Maximum Line Speed</i> = ((maximum press cycles * die layout travel) / 60) |
| Quoted Mix Capacity kg/hr | The <i>quoted mix capacity</i> is calculated in the following format: <i>Quoted Mix Capacity</i> = maximum mix capacity * configuration factor |
| Maximum Mix Capacity kg/hr | The <i>maximum mix capacity</i> is calculated in the following format: If (changed area <> calculated area) Then If (thickness, changed area, specific gravity, & maximum max pieces) <> NULL or 0 Then <i>Maximum Mix Capacity</i> = (changed area * thickness * specific gravity * max pieces) End If Else If (thickness, calculated area, specific gravity, & maximum max pieces) is not null or 0 Then <i>Maximum Mix Capacity</i> = (calculated area * thickness * specific gravity * max pieces) End If End If |
| Quoted Recycle Rate kg/hr | The <i>quoted recycle rate</i> is calculated in the following format: <i>Quoted Recycle Rate</i> = maximum recycle rate * configuration factor |
| Maximum Recycle Rate kg/hr | The <i>maximum recycle rate</i> is calculated in the following format: If (diecut is checked) Then <i>Maximum Recycle Rate</i> = ((die layout travel * die layout width * maximum press cycles * thickness * specific gravity) - maximum mix capacity) End If |
| Part Weight | The <i>part weight</i> is calculated in the following format: If (specific gravity <> Null or 0) Then <i>Part Weight</i> = (calculated area * specific gravity * thickness) * 1000 / 454 |

| | |
|----------------|--|
| | Else $Part\ Weight = (calculated\ area * weight\ area)$ End If |
| Gm | The <i>gm</i> is calculated in the following format: $gm = part\ weight * 454$ |
| Coating Weight | The coating <i>weight</i> is calculated in the following format: If (department <> NULL) then If (department begins with “Melsheet”) Then $Coating\ Weight = (10.76 * (die\ layout\ travel * (die\ layout\ width - 0.1) * coating\ factor) / (454 * pieces\ per\ cycle))$ Else $Coating\ Weight = (10.76 * (die\ layout\ travel * die\ layout\ width * coating\ factor) / (454 * pieces\ per\ cycle))$ End If Else $Coating\ Weight = (10.76 * (die\ layout\ travel * die\ layout\ width * coating\ factor) / (454 * pieces\ per\ cycle))$ End If |
| Total Weight | The <i>total weight</i> is calculated in the following format: $Total\ Weight = part\ weight + coating\ weight$ |

Quote Info:

The **Quote Info** tab was designed to allow the Costing Coordinator to enter general information on a cost sheet. The information entered will later be used to display on the cost form. The standard cost factor is the default factor used when calculating the materials, packaging, labor, overhead, additional offline rates, and misc cost tabs.

3. Cost Sheet Calculation Factors

Part Specification
Additional Offline Rates
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Quote Info
Materials
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Labor

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Molded Barrier
Capital

Account Manager: Meseck, Grant
Standard Cost Factor: 1.0200 (for example: 1.02 = 2%)

Pieces/Year: 102000

Comments:

1. This quote reflects a new RSS cost per RFC#: 15742, and 2010 standards.
2. The finished parts will have an SPQ of 100 pieces, and the melsheet WIP part will have an SPQ of 110 pieces.
3. Returnable packaging cost of \$5,100 covers the cost of 32 48" x 45" x 19" melsheet WIP containers. Cost is amortized over a five year volume.
4. Adhesive usage is an estimate.
5. The offline rate of 90 pcs per hour is based on deplugging both the RSS and Melsheet and gluing them together and adding three pieces of tape.
6. The cost of RSS WIP containers is included in the cost of the RSS.
7. The tie-sheets will be used in the internal WIP melsheet packaging and finished part packaging to SIA, the desiccant and bag will be used in the finished part packaging to SIA.
8. There will be three pieces of tape applied. Two pieces of tape are 270 mm long, the other is 190 mm long for a total of 730 mm. Cost of tape is \$3.15 per roll and the roll contains 60 linear yards.

Save
Calculate
Update Totals
Preview Cost Sheet
Preview Die Layout

The **Quote Info** screen is designed with the following fields.

| Fields | Description |
|----------------------|--|
| Account Manager | The <i>account manager</i> is a default value that is associated to the customer <i>cabbv</i> entered on the header info |
| Standard Cost Factor | The <i>standard cost factor</i> . The default value is 1.02. |
| Pieces Per Year | The <i>pieces per year</i> . |
| Comments | <i>Comments</i> that will be used to display on the cost sheet. |

Materials:

The **Materials** tab was designed to allow the Costing Coordinator to add, update or delete multiple material entries to a cost sheet. The information entered will later be used to display on the cost form.

Please notice that as the BPCS purchased cost and BPCS standard cost are updated from the BPCS System to the UGN DB automatically and daily, the user will be see background and foreground colors on the appropriate cell change.

If the border is aqua, then on the Material Maintenance page, the freight code plus the standard cost does not equal the purchased cost.

If the foreground color is red, then on the Material Maintenance page, the purchased cost is not equal to the quote cost.

If the background color is yellow, then on the Material Maintenance page, the cost that should be used does not match the cost on this tab.

The Costing Coordinator is notified daily via email of the changes to the BPCS System.

3. Cost Sheet Calculation Factors

Part Specification
Additional Offline Rates
Production Rates
Quote Info
Materials
Packaging
Labor

Overhead
Misc Costs
Drawings
Composite Part Spec.
Molded Barrier
Capital

When viewing the Cost per Unit below:
 If the border is aqua, then in the Material Maintenance page, the Freight Cost Plus the Standard Cost does NOT equal the Purchased Cost.
 If the foreground color is red, then on the Material Maintenance page, the Purchased Cost is not matched to the Quote Cost.
 If the background color is yellow, then on the Material Maintenance page, the Quote Cost has been updated and does not match the cost listed below.

| Material ID | BPCS PartNo (if exists) and Material Name | Quantity | Usage Factor | Cost / Unit | Freight Cost | Standard Cost Factor | Standard Cost Per Unit | Ordinal | |
|-------------|---|----------|--------------|-------------|--------------|----------------------|------------------------|---------|--|
| 49 | 1055 MIX-ASPHALT KORITE (70/30) | 0.3349 | 0.1500 | 0.269800 | 0.000000 | 0.0000 | 0.0922 | 0 | |
| 48 | 1053 MIX-ASPHALT-B25 | 0.5336 | 0.2390 | 0.216800 | 0.000000 | 0.0000 | 0.1180 | 1 | |
| 73 | 1080 MIX-WOOD FIBER | 0.0871 | 0.0390 | 0.057500 | 0.003500 | 0.0000 | 0.0054 | 2 | |
| 63 | 1069 MIX-LIMESTONE | 1.0383 | 0.4650 | 0.008400 | 0.000000 | 0.0000 | 0.0089 | 3 | |
| 65 | 1071 MIX-MICA | 0.1005 | 0.0450 | 0.127500 | 0.000000 | 0.0000 | 0.0131 | 4 | |
| 61 | 1067 MIX-LATEX 5356 | 0.0223 | 0.0100 | 0.997000 | 0.059800 | 0.0000 | 0.0240 | 5 | |
| 51 | 1057 MIX-CALCIUM OXIDE | 0.1161 | 0.0520 | 0.125000 | 0.000000 | 0.0000 | 0.0148 | 6 | |
| 3872 | 1846 B1 Coating WFD-27 | 0.1291 | 0.0000 | 0.670000 | 0.000000 | 0.0000 | 0.0883 | 7 | |
| 5209 | 1763 ADH-RT-2780 | 0.0110 | 0.0000 | 1.110000 | 0.066600 | 0.0000 | 0.0132 | 8 | |
| 3104 | RSS-90712AJ00A | 1.0000 | 0.0000 | 2.044500 | 0.000000 | 0.0000 | 2.0854 | 9 | |
| 5385 | 7043 TAPE-10502-00004-1(01) | 0.7983 | 0.0000 | 0.052500 | 0.000000 | 0.0000 | 0.0427 | 10 | |
| | | | | | | | | 99 | |

The **Materials** screen is designed with the following fields.

| Fields | Description |
|------------------------|---|
| Material | To add a new item to the list, select a <i>material</i> from the drop down list. The list is sorted by <i>BPCS #</i> and then by <i>Material Description</i> . This is a required field. |
| Quantity | The quantity |
| Cost/Unit | The <i>cost/unit</i> will be defaulted from the material maintenance page when the formula is selected on the part specifications tab. |
| Standard Cost Factor | If the Quote Info tab's value needs to be ignored, then this value can be set greater than 0. |
| Standard Cost Per Unit | This is the calculated value that will be presented on the cost form. |
| Ordinal | The <i>ordinal</i> will determine the order of display on the cost form. |

Packaging:

The **Packaging** tab was designed to allow the costing coordinator to add, update or delete multiple packaging entries to a cost sheet. The information entered will later be used to display on the cost form.

Please notice that as the BPCS purchased cost and BPCS standard cost are updated from the BPCS System to the UGN DB automatically and daily, the user will be see background and foreground colors on the appropriate cell change.

If the foreground color is red, then on the Material Maintenance page, the purchased cost is not equal to the quote cost.

If the background color is yellow, then on the Material Maintenance page, the cost that should be used does not match the cost on this tab.

The Costing Coordinator is notified daily of the changes to the BPCS System.

3. Cost Sheet Calculation Factors

Part Specification
Additional Offline Rates
Production Rates
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Packaging
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Overhead
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Molded Barrier
Capital

When viewing the Cost per Unit below:
 If the foreground color is red, then on the Material Maintenance page, the Purchased Cost is not matched to the Quote Cost.
 If the background color is yellow, then on the Material Maintenance page, the Quote Cost has been updated and does not match the cost listed below.

| Material ID | BPCS PartNo (if exists) and Material Name | Cost / Unit | Units Needed | Parts / Container | Units Needed / Parts Per Container | Standard Cost Per Unit | Used | Ordinal | |
|-------------|---|-------------------------------|-------------------------------|-------------------------------|------------------------------------|------------------------|-------------------------------------|---------|--|
| 135 | 1147 PKG-TIE SHEET | 0.3170 | 4.0000 | 210 | 0.0190 | 0.0061 | <input type="checkbox"/> | 0 | |
| 122 | 1134 PKG-DESICCANT-16UNIT | 1.1036 | 1.0000 | 100 | 0.0100 | 0.0113 | <input type="checkbox"/> | 1 | |
| 109 | 1121 PKG-BAG-POLYBAG4 - 72" X 48" | 1.8440 | 1.0000 | 100 | 0.0100 | 0.0188 | <input checked="" type="checkbox"/> | 2 | |
| | <input type="text" value=""/> | <input type="text" value=""/> | <input type="text" value=""/> | <input type="text" value=""/> | | | <input type="checkbox"/> | 99 | |

The **Packaging tab** is designed with the following fields.

| Fields | Description |
|-----------------------------------|--|
| Material ID | The unique identifiers used only in the costing module to identify parts |
| BPCS PartNo and Material Name | To add a new item to the list, select an item from the drop down list. The list is sorted by <i>BPCS # (if it exists)</i> and then by <i>Material Description</i> . This is a required field. |
| Cost/Unit | The <i>cost/unit</i> will be defaulted from the material maintenance page when the formula is selected on the part specifications tab. |
| Units Needed | The <i>units needed</i> to a line item. |
| Parts/Container | The <i>parts/container</i> to a line item. |
| Units Needed/ Parts Per Container | A calculation shown on the cost form. |
| Standard Cost Per Unit | This is the calculated value that will be presented on the cost form. |
| Use this value | A line item that will be used on the cost form. |

Labor:

The **Labor** tab was designed to allow the Costing Coordinator to add, update or delete multiple labor entries to a cost sheet. The information entered will later be used to display on the cost form.

If the background color is yellow, then the rate, crew size, and/or offline selection are different than what are on the Labor Maintenance page.






3. Cost Sheet Calculation Factors

Part Specification | Additional Offline Rates | Production Rates | Quote Info | Materials | Packaging | **Labor**

Overhead | Misc Costs | Drawings | Composite Part Spec. | Molded Barrier | Capital

When viewing the Rate, Crew Size, and Offline below:
If the background color is yellow, then on the Labor Maintenance page, the value has been updated and does not match the value listed below.

Remove All Labor

| Description | Rate | Crew Size | Offline | Standard Cost | Ordinal | |
|---------------------------------|----------------------|----------------------|-------------------------------------|---------------|---------|---|
| Melssheet Line 1 (35): | 29.0900 | 12.0000 | <input type="checkbox"/> | 0.1310 | 0 |   |
| Off-Line RSS Appl. & Pkg. (15): | 32.6000 | 2.0000 | <input checked="" type="checkbox"/> | 0.7244 | 1 |   |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | | 99 |   |

Save | Calculate | Update Totals | Preview Cost Sheet | Preview Die Layout

The **Quote – Labor** tab is designed with the following fields.

| Fields | Description |
|---------------|---|
| Description | To add a new item to the list, select a <i>description</i> from the drop down. This is a required field. |
| Rate | The <i>rate</i> will default from the labor maintenance page after the formula is selected on the part specification tab. |
| Crew Size | The <i>crew size</i> will default from the labor maintenance page after the formula is selected on the part specification tab. |
| Off Line | The line item that will be used for <i>off line</i> . It will be defaulted from the labor maintenance page after the formula is selected on the part specification tab. |
| Standard Cost | This is the calculated value that will be presented on the cost form. |
| Ordinal | The <i>ordinal</i> will determine the order of display on the cost form. |

Overhead:

The **Overhead** tab was designed to allow the Costing Coordinator to add, update or delete multiple Overhead entries to a cost sheet. The information entered will later be used to display on the cost form







3. Cost Sheet Calculation Factors

Part Specification | Additional Offline Rates | Production Rates | Quote Info | Materials | Packaging | Labor

Overhead | Misc Costs | Drawings | Composite Part Spec. | Molded Barrier | Capital

When viewing the Rate, Crew Size, and Offline below:
If the background color is yellow, then on the Overhead Maintenance page, the value has been updated and does not match the value listed below.

Remove All Overhead

| Description | Rate | Crew Size | Nbr Carriers | Offline | Proportion | Standard Cost | Ordinal | |
|---------------------------------|----------------------|----------------------|----------------------|-------------------------------------|--------------------------|---------------|---------|---|
| Melssheet Line 1 (35): | 1455.3300 | 0.0000 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | 0.5463 | 0 |   |
| Off-Line RSS Appl. & Pkg. (15): | 91.4300 | 2.0000 | 0.0000 | <input checked="" type="checkbox"/> | <input type="checkbox"/> | 2.0318 | 1 |   |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | <input type="checkbox"/> | | 99 |   |

Save | Calculate | Update Totals | Preview Cost Sheet | Preview Die Layout

If the background color is yellow, then the rate and/or crew size are different than what are on the Labor Maintenance page. Please note the labor and overhead names are IDENTICAL.

The **Overhead** tab is designed with the following fields.

| Fields | Description |
|---------------|---|
| Description | To add a new item to the list, select a <i>description</i> from the drop down. This is a required field. |
| Rate | The <i>rate</i> will default from the labor maintenance page after the formula is selected on the part specification tab. |
| Crew Size | The <i>crew size</i> will default from the labor maintenance page after the formula is selected on the part specification tab. |
| Off Line | The line item that will be used for <i>off line</i> . It will be defaulted from the labor maintenance page after the formula is selected on the part specification tab. |
| Proportion | Check if needed |
| Standard Cost | This is the calculated value that will be presented on the cost form. |
| Ordinal | The <i>ordinal</i> will determine the order of display on the cost form |

Misc Costs:

The **Misc. Costs** tab was designed to allow the costing coordinator to add, update or delete multiple miscellaneous cost entries to a cost sheet. The information entered will later be used to display on the cost form.

If the background color of the rate is yellow, then on the Misc Cost Maintenance page, the value has been updated.









3. Cost Sheet Calculation Factors

Part Specification | Additional Offline Rates | Production Rates | Quote Info | Materials | Packaging | Labor

Overhead | **Misc Costs** | Drawings | Composite Part Spec. | Molded Barrier | Capital

When viewing the Rate below:
If the background color is yellow, then on the Misc Cost Maintenance page, the value has been updated and does not match the value listed below.

Remove All Misc Costs

| Description | Rate | Cost | Amort Volume | Standard Cost | Ordinal | |
|----------------------|----------------------|----------------------|----------------------|---------------|---------|---|
| S,G,A | 0.0750 | 0.0000 | 0 | 0.4482 | 0 |   |
| Returnable Packaging | 0.0000 | 5100.0000 | 510000 | 0.0100 | 1 |   |
| Die Board | 0.0000 | 0.0000 | 0 | 0.0000 | 2 |   |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | | 99 |   |

Save | Calculate | Update Totals | Preview Cost Sheet | Preview Die Layout

The **Misc. Costs** tab is designed with the following fields.

| Fields | Description |
|---------------|---|
| Description | To add a new item to the list, select a <i>description</i> from the drop down. This is a required field. |
| Rate | The <i>rate</i> will default from the labor maintenance page after the formula is selected on the part specification tab. |
| Cost | The <i>cost</i> for each line item, if needed. |
| Amort. Volume | The <i>amortization volume</i> for each line item, if needed. |
| Standard Cost | This is the calculated value that will be presented on the cost form. |
| Ordinal | The <i>ordinal</i> will determine the order of display on the cost form |

Drawings:

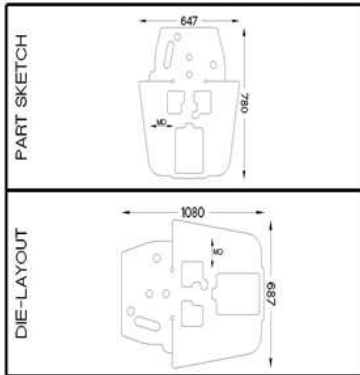
The **Drawings** screen was designed to allow the costing coordinator to upload a die-layout image to a cost sheet. The information entered will later be used to display on the die-layout.

3. Cost Sheet Calculation Factors

Part Specification | Additional Offline Rates | Production Rates | Quote Info | Materials | Packaging | Labor

Overhead | Misc Costs | **Drawings** | Composite Part Spec. | Molded Barrier | Capital

Part Sketch:



Part Sketch

Die-Layout

[Click here to view larger image](#)

Sketch Memo:

1. This die-layout has been updated due to changes to the cost form.

2. RSS AND MELSHEET WILL BE DEPLUGGED AND GLUED TOGETHER, AND THREE PIECES OF TAPE WILL BE ADDED IN OFF-LINE AT A RATE OF 90 PIECES/HOUR WITH A CREW SIZE OF THREE.

The **Drawings tab** is designed with the following fields.

| Fields | Description |
|----------------------------|---|
| Part Sketch – Browse | Click on the Browse button to help you search and select a file for the upload process. Files that end with a .jpg extension (JPEG) will be allowed in the upload process. |
| Part Sketch – Upload Image | After you have located the image, click on the Upload Image button to save the image to the database assigned to the quote. Note: <i>The image may appear a bit distorted on the html front end. The resolution on a print out is much clearer.</i> |
| Sketch Memo | Comments in the <i>sketch memo</i> area that will be used to display on the die-layout. |

Composite Part Specification:

The **Composite Part Spec** tab was designed to allow the costing coordinator to add or update composite part specs to a cost sheet. The information entered will later be used to display on the cost form

3. Cost Sheet Calculation Factors

Part Specification

Additional Offline Rates

Production Rates

Quote Info

Materials

Packaging

Labor

Overhead

Misc Costs

Drawings

Composite Part Spec.

Molded Barrier

Capital

Formula:

RSS-19-1S-Diecut

▼

Part Thickness:

2.1000

mm

▼

Part Specific Gravity:

1.8500

g/m3

▼

Part Area:

0.2867

m2

▼

RSS Weight:

2.4534

g

▼

Anti-Block Coating:

0.0573

g

▼

Hot Melt Adhesive:

0.0110

g

▼

Save

Calculate

Update Totals

Preview Cost Sheet

Preview Die Layout

The **Composite Part Spec** tab is designed with the following fields.

| Fields | Description |
|--------------------------|---|
| Formula | A <i>part formula</i> dropdown list |
| Part Thickness in mm | The <i>part thickness in mm</i> |
| Part Specific Gravity | The <i>part specific gravity</i> |
| Part Area m2 | The <i>part are m2</i> |
| RSS Weight (lbs) | The <i>RSS weight in pounds</i> |
| Anti-Block Coating (lbs) | The <i>anti-block coating in pounds</i> |
| Hot Melt Adhesive (lbs) | The <i>hot melt adhesive in pounds</i> |

Molded Barrier:

The **Molded Barrier** tab was designed to allow the costing coordinator to add, update Molded Barrier information to a cost sheet. The information entered will later be used to display on the cost form.

3. Cost Sheet Calculation Factors

Part Specification

Additional Offline Rates

Production Rates

Quote Info

Materials

Packaging

Labor

Overhead

Misc Costs

Drawings

Composite Part Spec.

Molded Barrier

Capital

Formula:

▼

Approximate Length:

mm

▼

Approximate Width:

mm

▼

Approximate Thickness:

mm

▼

Barrier Blank Area:

m2

▼

Specific Gravity:

g/m3

▼

Weight Per Area:

kg/m2

▼

Blank Weight:

lb

▼

Anti-Block Coating:

lb/blank

▼

*** TOTAL BARRIER WEIGHT:

lb

▼

Save

Calculate

Update Totals

Preview Cost Sheet

Preview Die Layout

The **Molded Barrier tab** is designed with the following fields.

| Fields | Description |
|----------------------|--|
| Formula | The <i>formula</i> dropdown list |
| Approx. Length | The <i>approximate length in mm</i> . The <i>approximate length in mm</i> is then divided by 25.4 and displayed as the <i>approximate length in inches</i> . |
| Approx. Width | The <i>approximate width in mm</i> . The <i>approximate width in mm</i> is then divided by 25.4 and displayed as the <i>approximate width in inches</i> . |
| Approx. Thickness | The <i>approximate thickness in mm</i> |
| Barrier Blank Area | The <i>barrier blank area in m2</i> |
| Specific Gravity | The <i>specific gravity in g/cm3</i> |
| Weight/Area | The <i>weight/area in kg/m2</i> |
| Blank Weight | The <i>blank weight in lbs</i> |
| Anti-Block Coating | The <i>anti-block coating in lbs/blank</i> |
| Total Barrier Weight | The <i>total barrier weight in lbs</i> |

Capital:



The **Capital** tab was designed to allow the costing coordinator to add, update or delete multiple capital entries to a cost sheet. The information entered will later be used to display on the cost form.

3. Cost Sheet Calculation Factors

Part Specification | Additional Offline Rates | Production Rates | Quote Info | Materials | Packaging | Labor

Overhead | Misc Costs | Drawings | Composite Part Spec. | Molded Barrier | **Capital**

Remove All Capitals

| Description | Total \$ Years Of Depr | Years Of Depr | Annual Amort. Vol | Rate | Standard Cost Per Unit | Offline | InLine | Ordinal | |
|----------------------|------------------------|----------------------|----------------------|----------------------|------------------------|--------------------------|--------------------------|---------|---|
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | <input type="checkbox"/> | 99 |   |

Save | Calculate | Update Totals | Preview Cost Sheet | Preview Die Layout

The **Cost Sheet – Capital** tab is designed with the following fields.

| Fields | Description |
|------------------------|---|
| Description | The <i>description</i> dropdown list. This is a required field. |
| Total \$ Years of Depr | The <i>total \$ amount</i> for each capital, if needed. |
| Years of Depr. | The <i>years of depreciation</i> for each capital, if needed. |
| Annual Amort. Volume | The <i>capital annual volume</i> for each capital, if needed. |
| Rate | If there is a <i>production rate</i> entered in the Cost Sheet – Part Specifications tab or either <i>off line</i> or <i>in line</i> is checked; the calculation for <i>per piece</i> is as follows: <i>Per Piece = ((total \$ amount / years of depr.) / annual volume)</i> |
| Standard Cost Per Unit | The calculated value that will be presented on the cost form |
| Off Line | Check <i>off line</i> to calculate the offline rate for <i>per piece</i> and <i>hourly capital rate</i> . |
| In Line | Check <i>in line</i> to calculate the quoted max pieces for <i>per piece</i> and <i>hourly capital rate</i> . |

Previewing a Cost Sheet/Form

By clicking on the “preview cost sheet” button located on any cost sheet, it opens a popup with the cost form. If a value is different between the previous cost form and the current cost form, it will be highlighted in yellow. Due to the large amount of information on each tab of the cost sheet, multiple pages may be needed. The previous copy of the quote is on the next page. If the user has “admin” rights, then the “create file” button can be pressed to save the preview as a PDF file in a shared network folder. All users have the ability to manually convert this document to another type of document (MS Excel, MS Word, Rich Text File, and PDF) and print.

File Name: 11798-6171.pdf

Create File

1 / 1+ 100%



Standard Cost Form (Current)

Print Date: 9/2/2009

CURRENT Cost Sheet ID: 11798

Changes are highlighted in yellow

PREVIOUS ID (see next page): 11557

| | | |
|---------------------------------------|-------------------|--|
| Customer: Honda | Year: 2009 | Model: Civic |
| Account Manager: Grant Meseck | | Department: Somerset Fleece Line (126055) |
| Part No: 6171 | | Process: On Line |
| Part Name: LOFT FOR DASH INNER | | Volume: 288628 |
| DMS Drawing No: | | On-Line Rate: 0 pcs/hr |
| New Design Level: 02 | | |

Part Specifications

| | |
|--|--|
| Formula: LOFT-12/37/5.5/5.5/40 | Area: 1.8149 m2 |
| Nominal Thickness: 20.0000 mm | Fleece Weight: 3.1981 lb |
| Weight/Area: 800.0000 g/m2 | Coating: lb |
| Die Layout Travel: 1090.0000 mm | ***TOTAL PART WEIGHT: 3.1981 lb |
| Die Layout Width: 2200.0000 mm | |

Comments

Quote Date: 07/07/2009

1. This quote reflects a new blend of this FR Loft pad per RFC#: 14684.
2. Blank size is 1,865 mm x 1,090 mm (+/-20 mm). This reflects the nominal size.
3. Packaging cost and SPQ are estimates.

Material Breakdown

| BPCS - Material | Vendor | Units Needed | Cost Per Unit | Freight | Standard Cost Per Unit |
|--------------------------------------|-------------------------|--------------|---------------|-----------------------------|------------------------|
| 5250 - Bi-Co PET Fiber | STEIN FIBERS LTD | 0.3838 lb | 0.7314 | 0.0000 | 0.2863 |
| 5249 - PET Staple Fiber | STEIN FIBERS LTD | 1.1833 lb | 0.5100 | 0.0000 | 0.6155 |
| 5347 - FR Shoddy | WM. T. BURNETT FOAM LLC | 0.1759 lb | 0.4240 | 0.0000 | 0.0761 |
| 5248 - Shoddy Synthetic/Cotton Blend | OMNIX, S.A. DE C.V. | 0.1759 lb | 0.2090 | 0.0000 | 0.0375 |
| 5290 - Fleece Recycle | UGN INC. | 1.2792 lb | 0.0633 | 0.0000 | 0.0826 |
| | | | | Total Material Cost: | 1.0980 |

Direct Labor

| | | | |
|---------------------------|--------------------------|----------------------|----------------------------|
| Somerset Fleece Line (55) | Crew Size: 5.0000 | Rate: 23.7700 | 0.0000 |
| | | | Total Direct Labor: |

Total Manufacturing Cost: \$1.0980

TOTAL STANDARD COST: \$1.0980

File Name: 11798-6171.pdf

Create File

2 / 2 100%



Standard Cost Form (Previous)

Print Date: 9/2/2009

PREVIOUS Cost Sheet ID: 11557

Customer: [Honda](#)
 Account Manager: [Grant Meseck](#)
 Part No: [6171](#)
 Part Name: [LOFT FOR DASH INNER](#)
 DMS Drawing No:
 New Design Level: [02](#)

Year: [2009](#)

Model: [Civic](#)
 Department: [Somerset Fleece Line \(126055\)](#)
 Process: [On Line](#)
 Volume: [288628](#)
 On-Line Rate: [828](#) pcs/hr

Part Specifications

Formula: [LOFT-12/37/5.5/5.5/40](#)
 Nominal Thickness: [20.0000](#) mm
 Weight/Area: [800.0000](#) g/m2
 Die Layout Travel: [1090.0000](#) mm
 Die Layout Width: [2200.0000](#) mm

Area: [1.8149](#) m2
 Fleece Weight: [3.1981](#) lb
 Coating: [lb](#)
 ***TOTAL PART WEIGHT: [3.1981](#) lb

Comments

1. This quote reflects a new blend of this FR Loft pad per RFC#: 14884.
2. Blank size is 1,655 mm x 1,090 mm (+/-20 mm). This reflects the nominal size.
3. Packaging cost and SPQ are estimates.

Quote Date: [06/01/2009](#)

Material Breakdown

| BPCS - Material | Vendor | Units Needed | Cost Per Unit | Freight | Standard Cost Per Unit |
|--------------------------------------|-------------------------|--------------|---------------|---------|------------------------|
| 5250 - Bi-Co PET Fiber | STEIN FIBERS LTD | 0.3838 lb | 0.6600 | 0.0000 | 0.2584 |
| 5249 - PET Staple Fiber | STEIN FIBERS LTD | 1.1833 lb | 0.5100 | 0.0000 | 0.6155 |
| 5347 - FR Shoddy | WM. T. BURNETT FOAM LLC | 0.1759 lb | 0.4240 | 0.0000 | 0.0761 |
| 5248 - Shoddy Synthetic/Cotton Blend | OMNIX, S.A. DE C.V. | 0.1759 lb | 0.2090 | 0.0000 | 0.0375 |
| 5290 - Fleece Recycle | UGN INC. | 1.2792 lb | 0.0633 | 0.0000 | 0.0826 |
| Total Material Cost: | | | | | 1.0701 |
| Packaging - UGN, Inc. | Pieces Per Container: | 30.0000 | | | |
| PKG-FLEECE-67X43.25 | | 0.0667 | 1.6832 | | 0.1145 |
| Total Packaging Cost: | | | | | 0.1145 |

Direct Labor

| | | | | | |
|----------------------------|------------|--------|-------|---------|---------------|
| Somerset Fleece Line (55) | Crew Size: | 5.0000 | Rate: | 23.7700 | 0.1435 |
| Total Direct Labor: | | | | | 0.1435 |

Previewing a Die-Layout

By clicking on the “preview die layout” button located on any cost sheet, it opens a popup with the die layout. If a value is different between the previous die layout and the current die layout, it will be highlighted in yellow. Users may click the image to see a larger view. As mentioned above, users may also print this document or convert it to another type of document. Again, the die layout of the previous cost sheet will be on the second page.

Die Layout Preview - Windows Internet Explorer provided by UGN, Inc.

1 / 1+ 75%

UGN UGN Solutions for the Automotive Industry

Die - Layout (Current) Print Date: 9/2/2009


Somerset Fleece Line (126055)

Current Die-Layout Information


CURRENT Cost Sheet ID: 11758 Changes are highlighted in yellow PREVIOUS ID (see next page): 11667

| | | | | | |
|-------------|---------------------|-------|------|------------------|--------|
| Customer: | Honda | Year: | 2009 | Model: | CMC |
| Quote Date: | 07/07/2009 | | | DM & Drawing No: | |
| Part Name: | LOFT FOR DASH INNER | | | Design Level: | 02 |
| Part No: | 6171 | | | Annual Volume: | 288628 |

PART SKETCH



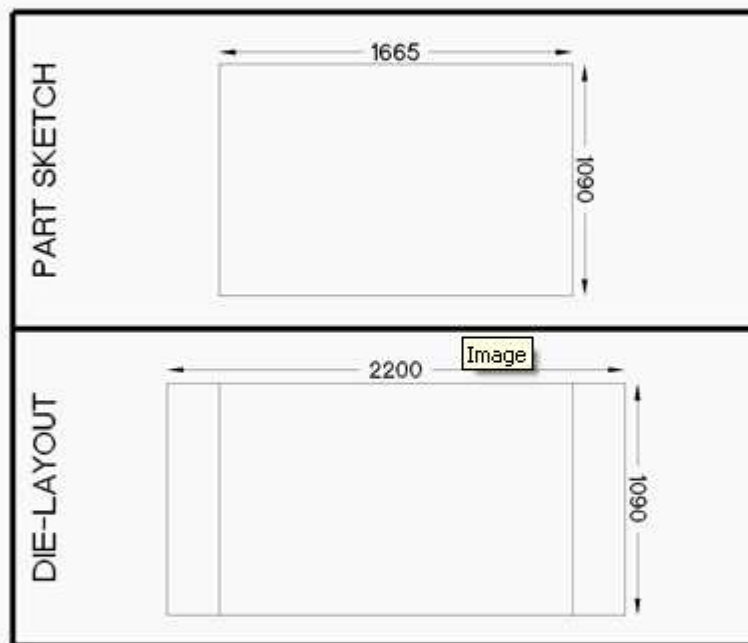
DIE-LAYOUT



| Part Specifications | | Production Rates | |
|--|-----------------------|---------------------------|--|
| Formula: | LOFT-12/37/5.5/5.5/40 | | |
| Weight/Area (g/m2): | 800.0000 | | |
| Part Area (m2): | 1.8149 | | |
| Part Thickness, nominal (mm): | 20.0000 | | |
| Part Weight (g): | 659172 | | |
| Coating (wet-lbs/part): | 0.0000 | | |
| | | Quoted - 87.60% | Max - 100% |
| | | Pieces / Man Hour: | <div style="background-color: yellow; width: 100%; height: 10px;"></div> |
| | | Press Cycles/Hour: | <div style="background-color: yellow; width: 100%; height: 10px;"></div> |
| | | Line Speed m/m: | <div style="background-color: yellow; width: 100%; height: 10px;"></div> |
| | | Net Forming Rate (kg/hr): | <div style="background-color: yellow; width: 100%; height: 10px;"></div> |
| | | Recycle Rate (kg/hr): | <div style="background-color: yellow; width: 100%; height: 10px;"></div> |
| Comments | | | |
| 1. This die-layout reflects a new blend of this FR Loft pad per RFC#: 14884. 2. Blank size is 1,665 mm x 1,090 mm (+/-20 mm). This reflects the nominal size. | | | |

PREVIOUS Cost Sheet ID: 11667

| | | | | | |
|-------------|---------------------|-------|------|------------------|--------|
| Customer: | Honda | Year: | 2009 | Model: | CMC |
| Quote Date: | 06/01/2009 | | | DM 8 Drawing No: | |
| Part Name: | LOFT FOR DASH INNER | | | Design Level: | 02 |
| Part No: | 6171 | | | Annual Volume: | 288628 |



| Part Specifications | | Production Rates | |
|-------------------------------|-----------------------|---------------------------|------------|
| Formula: | LOFT-12/37/5.5/5.5/40 | Forming Rate | |
| Weight/Area (g/m2): | 800.0000 | | |
| Part Area (m2): | 1.8148 | | |
| Part Thickness, nominal (mm): | 20.0000 | | |
| Part Weight (g): | 659172 | | |
| Coating (wet-lbs/part): | 0.0000 | | |
| | | Quoted - 87.60% | Max - 100% |
| | | Pieces / Min Hour: | 828 946 |
| | | Press Cycles/Hour: | 828 946 |
| | | Line Speed m/min: | 15 17 |
| | | Net Forming Rate (kg/hr): | 1202 1374 |
| | | Recycle Rate (kg/hr): | 398 441 |

Comments

1. This die-layout reflects a new blend of this FR Loft pad per RPCR: 14684.
2. Blank size is 1,665 mm x 1,090 mm (+/-20 mm). This reflects the nominal size.

Pre-Approval Notification

After all of the information on a cost sheet has been entered and is ready for the approval process, the Costing Coordinator will click a button to send an email notification to a list of team members requesting their approval.

To send a pre-approval notification, click on the **“Pre-Approval Notify”** button to display the **Pre-Approval List** page.

Team members can pull the list of approvers from a previously defined “Notification Group” or from a previous cost sheet. Please see a later section describing notification groups.

The user can select the group or type the previous cost sheet and click the “pull” button .

There are two levels of routing. Team members who are plant managers, in the product development department, in the corporate engineering department, or the purchasing department should be notified first. When a team member is selected, the possible role or “subscription” is available to choose.

The second level routing is for account managers or a vice president of operations.

The costing coordinator can choose to notify all team members, certain levels, and/or team members who have already been notified.

The history of the approval routing is listed at the bottom of the page.

An email will be sent to appropriate team members. There will be two or two hyperlinks in the email.

- 1) A link to the page where the team member should approve the cost sheet.
- 2) A link to preview the cost form.
- 3) A link to preview the die layout, if it exists.

Team members will be reminded daily, via email, to review pending cost sheets.


Please recall the description of the home page of the UGN Database. Any pending cost sheets will also be listed on the home page. The hyperlinks on the home page will direct the team members to the appropriate place to make the approval. So, team members now have two places to be reminded of pending cost sheets: email daily and viewing the home page.

In addition, team members can navigate to a Cost Sheet Approve page which lists all costs sheets pending approval. Finally, team members can search on the main Cost Sheet List page any cost sheets pending their approval or have already approved.




Cost Sheet Pre-Approval List

Cost Sheet ID: 11438

Choose a Notification Group: 

Choose another cost sheet to copy the list(s) from: 10573 

First Level Routing

| Team Member | Comments | Signed Status | Signed Date | Notification Date | Subscription | |
|----------------------|----------|---------------|-------------|-------------------|----------------------|---|
| Pulley, Mike | | Approved | 05/08/2009 | 05/05/2009 | Plant Manager |  |
| Rimkus, Mark | | Approved | 05/07/2009 | 05/05/2009 | Product Development |  |
| <input type="text"/> | | | | | <input type="text"/> |   |

☒ Check to only notify new people added to the list

Second Level Routing

| Team Member | Comments | Signed Status | Signed Date | Notification Date | Subscription | |
|----------------------|----------|---------------|-------------|-------------------|----------------------|---|
| Meseck, Grant | | Approved | 05/08/2009 | 05/08/2009 | Sales |  |
| <input type="text"/> | | | | | <input type="text"/> |   |

☒ Check to only notify new people added to the list

☒ Check to only notify new people added to the list

Complete Approval Routing History

| Team Member | Comments | Signed Status | Signed Date | Notification Date | Subscription | CreatedBy | CreatedOn | UpdatedBy | UpdatedOn |
|---------------|----------|---------------|-------------|-------------------|---------------------|-----------|------------|-----------|-----------|
| Pulley, Mike | | Approved | 05/08/2009 | 05/05/2009 | Plant Manager | auto | 05/14/2009 | | |
| Meseck, Grant | | Approved | 05/08/2009 | 05/08/2009 | Sales | auto | 05/14/2009 | | |
| Rinkus, Mark | | Approved | 05/07/2009 | 05/05/2009 | Product Development | auto | 05/14/2009 | | |
| Cade, Dan | | Approved | 05/05/2009 | | Costing Coordinator | | | | |

The **Pre-Approval List** page is designed with the following fields.

| Fields | Description |
|--------------------|---|
| Team Member | The <i>team member</i> dropdown list who will be receiving the cost form and/or die-layout for approval. After a selection has been made the system will verify if the team member is available for approval based on his/her workflow status. If the employee is not available, then a message will display to alert the user to select the backup person for the approval process. Also the subscription list will be filtered to make assignment faster. This is a required field. |
| Comments | The costing coordinator will have the ability to read the approvers comments. This is a read only field. |
| Signed Status | If the approval needs to be reset, the costing coordinator will delete the row and re-add the team member to the list. This way, the history table at the bottom will include the activity. |
| Date Signed | The costing coordinator will have the ability to read the date when the cost sheet was approved and if there is anyone left pending approval. This is a read only field. |
| Notification Sent | This shows the date when the approver was notified (to review the cost form). This is a read only field. |
| Notify Check boxes | The costing coordinator can check or uncheck to notify new team members in the list or all team members in the lists. |
| Notify Buttons | The costing coordinator can choose to notify all team members, certain levels, and/or team members who have already been notified. |

Notification Group Maintenance

Cost Sheet Pre-Approval Notification Group and Team Member Maintenance














Group Name: 

Team Member: 

List of Groups

| Group | Obsolete |  | Copy Group |
|----------------------|--------------------------|---|---|
| Test | <input type="checkbox"/> |  |  |
| Other | <input type="checkbox"/> |  |  |
| test 2 | <input type="checkbox"/> |  |  |
| test 3 | <input type="checkbox"/> |  |  |
| <input type="text"/> | <input type="checkbox"/> |  |  |

Team Members for selected Group

| Group | Team Member | Subscription |  |
|----------------------|----------------------|-----------------------|---|
| test 2 | Barta, Brett | Sales |  |
| test 3 | Barta, Brett | Sales |  |
| test 3 | Hall, Bryan | Corporate Engineering |  |
| Test | Hall, Bryan | Corporate Engineering |  |
| test 2 | Hall, Bryan | Corporate Engineering |  |
| Test | Meade, Jim | Sales |  |
| Test | Myotte, Ronald | Purchasing |  |
| test 2 | Myotte, Ronald | Purchasing |  |
| test 3 | Myotte, Ronald | Purchasing |  |
| test 2 | Pulley, Mike | Plant Manager |  |
| test 3 | Rinkus, Mark | Product Development |  |
| <input type="text"/> | <input type="text"/> | <input type="text"/> |  |

Groups can be created to organize approvers. For example, perhaps the group name could be the same as a commodity. Certain engineers need to be associated with a commodity. Then when the Pre-Approval List page is opened (for a specific Cost Sheet), the team members can be pulled from this list and automatically assigned to proper routing levels and subscriptions.

| Fields | Description |
|----------------------|--------------------------------------|
| Group Name | Search by existing group names |
| Team Member Name | Search by team member |
| List of groups | Created, edit, or delete groups |
| List of team members | Add or remove team members to groups |

Post-Approval Notification

Soon after the costing coordinator receives a final confirmation via an email notification from an Account Manager approving a cost sheet, then a post-approval notification will be sent with hyperlinks to the latest cost form and/or die-layout form.

The costing coordinator can send a post-approval notification by clicking on the “**Post-Approval Notify**” button to display the **Post- Approval List** page.

The costing coordinator can save the email message for later notifications if needed and to refer back to what was sent if all emails were lost.

The costing coordinator can also pull the list of team members from a previous cost sheet.

Finally, the costing coordinator can determine of all team members should be notified or just new team members added to the list.

Cost Sheet Post-Approval List

Cost Sheet ID: 11475

Notification Comments (to include in email):

Email comments go here

378 char(s) remaining.

Save

Choose another cost sheet to copy the list(s) from: 11438

| Team Member | Notification Date | |
|------------------|-------------------|--|
| Hall, Bryan | 05/13/2009 | |
| Gifford, Karla | 05/13/2009 | |
| Meseck, Grant | 05/13/2009 | |
| Bentley, Ryan | 05/13/2009 | |
| Cobden, Clifford | 05/13/2009 | |

Notify ☒ Check to only notify new people added to the list

The **Post-Approval List** page is designed with the following fields.

| Fields | Description |
|-------------------|--|
| Team Member | The <i>team member</i> dropdown list of whom will be receiving the final cost form and/or die-layout. This is a required field. |
| Notification Sent | The <i>Notification Sent</i> field will default to the current date when the email is sent. This is a read only field. |
| Notify Check box | The costing coordinator can check or uncheck to notify new team members in the list or all team members in the lists. |
| Notify | The costing coordinator can choose to notify all team members, certain levels, and/or team members who have already been notified. |

Cost Sheet Approval List

The **Cost Sheet Approval List** page was designed to allow approvers to approve or reject cost forms and/or die layout forms.

Team members who are working as a backup to someone else should change the name of the team member in the dropdown box.

Team members can search for a specific cost sheet. For deeper searching, however, the main cost sheet list page should be used. There is a link that can navigate the user to that page.

As cost sheets are approved or rejected, they are filtered out of this list.

However, the team member can change the dropdown value of the “signed status” to view approved or rejected cost sheets for a particular team member.

Cost Sheet Approval List

You are using the same rights as Team Member ID: 391

If you need to approve as a backup to another team member, select the name in the dropdown and click search.

Once you actually approve or reject the appropriate Cost Sheet in the lower section, your name will replace the original person.



Cost Sheet ID:







Signed Status:

Team Member:

[Click here to go to the full search page.](#)

[Click the edit button under the ACTION column. Enter the comment and the approval status. THEN SAVE.](#)

| Action | Cost Sheet ID | Team Member Name | Comments | Signed Status | Signed Date | See All Approvers | Preview Cost Form | Preview Die Layout |
|---|---------------|------------------|----------|---------------|-------------|---|---|--------------------|
|  | 11472 | Meseck, Grant | | Pending | |  |  | |
|  | 11460 | Meseck, Grant | | Pending | |  |  | |

| Action | Cost Sheet ID | Team Member Name | Comments | Signed Status | Signed Date | See All Approvers | Preview Cost Form | Preview Die Layout |
|---|---------------|------------------|----------------------|--------------------------------------|-------------|---|---|--------------------|
|  | 11472 | Meseck, Grant | <input type="text"/> | <input type="text" value="Pending"/> | |  |  | |
|  | 11460 | Meseck, Grant | | Approved Rejected | |  |  | |

Note: *The Cost Sheet Approval List will only display cost sheets that were assigned to the team members who is connected at the time.*

| Fields | Description |
|--------------------|---|
| Action | Click this button to determine if the cost form should be approved or rejected. |
| Cost Sheet ID | The appropriate cost sheet identifier |
| Team Member | The team member that will perform the action. <i>This will be updated to the new team member if a backup is operating here.</i> |
| Comments | The approver may enter comments. <i>Rejections require comments.</i> |
| Signed Status | Approved or Rejected |
| Signed Date | The date when the cost sheet was approved or rejected. |
| See All approvers | Opens a popup to see all approval details from all approvers. |
| Preview Cost Form | Opens a popup to show the cost form |
| Preview Die Layout | Opens a popup to show the die layout form |

Cost Sheet Pre-Approval Popup

This is the popup that show pre-approval information for a cost sheet.


Cost Sheet ID: 11460

| Team Member | Comments | Signed Status | Signed Date | Notification Date | Subscription |
|----------------|----------|---------------|-------------|-------------------|-----------------------|
| Shan, Ta-Cheng | | Approved | 05/12/2009 | 05/11/2009 | Product Development |
| Woods, Tom | | Approved | 05/11/2009 | 05/11/2009 | Plant Manager |
| Rushing, Duane | | Approved | 05/14/2009 | 05/11/2009 | Corporate Engineering |
| Myotte, Ronald | | Approved | 05/14/2009 | 05/11/2009 | Purchasing |
| Meseck, Grant | | Pending | | 05/14/2009 | Sales |
| Cade, Dan | | Approved | 05/11/2009 | | Costing Coordinator |


Maintenance


A series of “Maintenance” pages on the **Costing Menu** are used by the Costing Coordinators to set pre-defined values when creating/updating cost sheets. The information in each maintenance page must be updated as often as possible.

With every section that is a “grid”, there are special instructions for adding, editing, and deleting rows. A set of buttons are located on the right side of each grid.

To add a row, enter information in the last row and then click the “save”  button.

To ignore the change, click the “undo”  button.

To edit a row, click the “edit”  button, change the information, and then click the save button.

To delete a row, click the “delete”  button.

Capital

The **Capital** screen was designed for Costing Coordinators to add, edit, or delete capital to the Costing module. This table is used in the **Capital** tab of cost sheets

Capital Maintenance

Partial Searches can be completed by placing % before or after text.

Capital Description:

| Description | Obsolete | |
|----------------------|--------------------------|---|
| Building | <input type="checkbox"/> |  |
| Equipment | <input type="checkbox"/> |  |
| <input type="text"/> | <input type="checkbox"/> |   |

The **Capital Maintenance** page is designed with the following fields:

| Fields/Buttons | Description |
|----------------|---|
| Description | To add a new item to the list, enter the on the last row and click save. This is a required field. |
| Obsolete | A value is NEVER deleted. Instead, it is set to obsolete. This is to ensure no lost references in the cost sheets that might use the value. |

Catching Ability Factor

The **Catching Ability Factor** page was designed for the calculations in the cost sheets. This should NEVER be edited without careful consideration. It would change how ALL cost sheets are calculated.

Catching Ability Factor Maintenance

| Min Part Length | <= | Max Part Length | Side By Side | Factor | Obsolete |
|-----------------|----|-----------------|-------------------------------------|--------|--------------------------|
| 0.0000 | <= | 0.3000 | <input type="checkbox"/> | 1.3000 | <input type="checkbox"/> |
| 0.3000 | <= | 0.4000 | <input type="checkbox"/> | 1.5000 | <input type="checkbox"/> |
| 0.4000 | <= | 0.5000 | <input type="checkbox"/> | 1.8000 | <input type="checkbox"/> |
| 0.5000 | <= | 10.0000 | <input type="checkbox"/> | 1.1500 | <input type="checkbox"/> |
| 0.0000 | <= | 0.3000 | <input checked="" type="checkbox"/> | 1.1500 | <input type="checkbox"/> |
| 0.3000 | <= | 0.6000 | <input checked="" type="checkbox"/> | 1.2000 | <input type="checkbox"/> |
| 0.6000 | <= | 0.7000 | <input checked="" type="checkbox"/> | 1.3000 | <input type="checkbox"/> |
| 0.7000 | <= | 0.8000 | <input checked="" type="checkbox"/> | 1.4500 | <input type="checkbox"/> |
| 0.8000 | <= | 0.9000 | <input checked="" type="checkbox"/> | 1.6300 | <input type="checkbox"/> |
| 0.9000 | <= | 1.0000 | <input checked="" type="checkbox"/> | 1.8000 | <input type="checkbox"/> |
| 1.0000 | <= | 1.1000 | <input checked="" type="checkbox"/> | 2.0000 | <input type="checkbox"/> |
| 1.1000 | <= | 1.2000 | <input checked="" type="checkbox"/> | 2.3000 | <input type="checkbox"/> |
| 1.2000 | <= | 10.0000 | <input checked="" type="checkbox"/> | 1.1500 | <input type="checkbox"/> |

Formula List

The formula list page allows team members search for existing formulas. The formulas are the main basis for the calculation factors and items used in a cost sheet.

Costing coordinators can click the “add” button to create a new formula.

Formula List

Partial Searches can be completed by placing % before or after text.

Review existing formulas or press [Add](#) to enter a new formula.

| | | | |
|---------------------------------------|----------------------|--------------------------------------|----------------------|
| Formula Name: | <input type="text"/> | BPCS Part Name: | <input type="text"/> |
| Drawing No: | <input type="text"/> | BPCS Part No: | <input type="text"/> |
| Department: | <input type="text"/> | Process: | <input type="text"/> |
| Template: | <input type="text"/> | | |
| <input type="button" value="Search"/> | | <input type="button" value="Reset"/> | |

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| Formula | DrawingNo | BPCS PartNo | BPCS Rev. | Department | Process | Template |
|---------------------------------------|-----------|-------------|-----------|-------------------------------|-------------|---------------------------------------|
| unknown | | | | | | |
| unknown | | | | | | |
| 697-NF | | | | Melsheet 2 (25) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-18 (1.5 - 2.9999) | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-18 (3.0 - 3.9999) | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-18 (60-80%) | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-19 (1.5-2.9999) | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-19 (3.0 - 3.9999) | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-19 (4.0 - 6.0) | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| 748-M3 | | | | Melsheet 1/Off-Line (35/15) | On/Off-Line | Melsheet Standard and Quote Cost Form |
| AFR | | | | Somerset Fleece Line (126055) | On Line | Fleece |
| AFR-12/7/41/40 | | | | Somerset Fleece Line (126055) | On Line | Fleece |
| AFR-14/8/38/40 | | | | Somerset Fleece Line (126055) | On Line | Fleece |
| AFR-17/37/16/30 | | | | Somerset Fleece Line (126055) | On Line | Fleece |
| AFR-19/35/16/30 | | | | Somerset Fleece Line (126055) | On Line | Fleece |

| Fields/Buttons | Description |
|---------------------|--|
| Formula | Click on the Formula in the result list to view its details of a formula |
| Drawing No | In many cases, a DMS Drawing number was created for the formula |
| BPCS Part No / Rev. | In the BPCS System, there is a part with a designation type called “phantom,” which should correspond to a formula used to build the part. Each part has a revision. |
| Department | Certain formulas use different UGN departments for part creation. Different departments affect the calculations. |
| Process | The process used in the formula. Different processes affect the calculations |
| Template | This determines which fields should be used and how some calculations are made in the cost sheet. |

Formula Maintenance

The details of the formula can be seen on the maintenance page. There are several tabs with information that will be explained after the fields below are described. The Formula information is used in the **-Cost Sheet: Part Specification, Composite Part Specs and Molded Barrier** tabs.

Fleece-Type Formula

Formula Maintenance

Formula ID: 258

Formula Name: 748-18 (1.5 - 2.9999)

BPCS Part No: Rev.: Name:

Specific Gravity: 1.5000 g/m3

Maximum Line Speed: 40 m/min

Maximum Mix Capacity: 1580 kg/hr

Maximum Press Cycles: 4320

Coating Sides: 2

Department: Melsheet 1/Off-Line (35/15)

Process: On/Off-Line

Template: Melsheet Standard and Quote Cost Form

Obsolete: ☐

Drawing No:

Diecut: ☒

Recycle Return: ☒

FleeceType: ☐

Fleece-Type Formula

Formula Maintenance

Please remember to save your changes.

Formula ID: 258

Formula Name: 748-18 (1.5 - 2.9999)

BPCS Part No: Rev.: Name:

Maximum Line Speed: 40 m/min

Weight Per Area: g/m2

Maximum Forming Rate: kg/hr

Maximum Press Cycles: 4320

Coating Sides: 2

Department: Melsheet 1/Off-Line (35/15)

Process: On/Off-Line

Template: Melsheet Standard and Quote Cost Form

Obsolete: ☐

Drawing No:

Diecut: ☒

Recycle Return: ☒

FleeceType: ☒

| Fields/Buttons | Description |
|----------------|---|
| Formula ID | This value is automatically generated. This is a required field. |

| | |
|----------------------|---|
| Obsolete | Check if the formula should no longer be used. There is no delete in order to prevent cost sheets from losing the reference. |
| Formula Name | The descriptive name of the formula. |
| BPCS Part No / Rev. | In the BPCS System, there is a part with a designation type called “phantom,” which should correspond to a formula used to build the part. Each part has a revision. There is a popup available to search for the BPCS Part No. |
| BPCS Part Name | In the BPCS System, there is a name for the part. |
| Drawing No | In many cases, a DMS Drawing number was created for the formula. There is a popup available to search for the Drawing No. |
| Department | Certain formulas use different UGN departments for part creation. Different departments affect the calculations. |
| Specific Gravity | Numeric value used in the cost form (non-fleece type) |
| Maximum Mix Capacity | Numeric value used in the cost form (non-fleece type) |
| Maximum Line Speed | Numeric value used in the cost form |
| Maximum Press Cycles | Numeric value used in the cost form |
| Weight Per Area | Numeric value used in the cost form (fleece type) |
| Coating Sides | Numeric value used in the cost form |
| Max Forming Rate | Numeric value used in the cost form (fleece type) |
| Die Cut | Determines if Die Layout should be used on cost sheet. Also determines some calculations. |
| Recycle Return | Determines some calculations. |
| Fleece Type | Determines some calculations |
| Process | The process used in the formula. Different processes affect the calculations |
| Template | This determines which fields should be used and how some calculations are made in the cost sheet. |
| Save | Insert or update the formula |
| Copy | Copy the formula for another version or purpose. All values on all tabs will be copied. Please work with the application group as new formulas are used to see if any calculations need to be adjusted or added. |

Formula Coating Factors

| | | | | | | |
|-----------------|---------------------|----------|-----------|-------|----------|------------|
| Coating Factors | Hole Deplug Factors | Material | Packaging | Labor | Overhead | Misc. Cost |
|-----------------|---------------------|----------|-----------|-------|----------|------------|

| Minimum | Maximum | Coating Factor | Obsolete | |
|----------------------|----------------------|----------------------|--------------------------|--|
| 0.0000 | 2.2999 | 8.0931 | <input type="checkbox"/> | |
| 2.2999 | 2.6999 | 8.6846 | <input type="checkbox"/> | |
| 2.6999 | 3.0000 | 9.2762 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------------|---|
| Min | To add a new item to the list, enter the <i>minimum</i> value for a coating factor on the last line. This is a required field. |
| Max | The <i>maximum</i> value of a coating factor on the last line. This is a required field. |
| Coating Factor g/ft2 | The <i>coating factor</i> as g/ft2. This is a required field. |

Formula Deplug Factors

Coating Factors | **Hole Deplug Factors** | Material | Packaging | Labor | Overhead | Misc. Cost

| Minimum | Maximum | Deplug Factor | Obsolete | |
|----------------------|----------------------|----------------------|--------------------------|--|
| 0.0000 | 2.0000 | 13000.0000 | <input type="checkbox"/> | |
| 2.0000 | 3.9999 | 10000.0000 | <input type="checkbox"/> | |
| 3.9999 | 10.0000 | 8000.0000 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------|---|
| Min | To add a new item to the list, enter the <i>minimum</i> value for a deplug on the last line. This is a required field. |
| Max | The <i>maximum</i> value of a deplug factor. This is a required field. |
| Deplug Factor | The <i>deplug factor</i> This is a required field. |

Formula Materials

Coating Factors | Hole Deplug Factors | **Material** | Packaging | Labor | Overhead | Misc. Cost

| Material | DrawingNo | BPCS PartNo | BPCS Part Rev. | Usage Factor | Ordinal | Obsolete | |
|----------------------------|----------------------|----------------------|----------------------|----------------------|----------------------|--------------------------|--|
| MIX-ASPHALT-B25 | | 1053 | | 0.1500 | 1 | <input type="checkbox"/> | |
| MIX-ASPHALT KORITE (70/30) | | 1055 | | 0.2340 | 0 | <input type="checkbox"/> | |
| MIX-CALCIUM OXIDE | | 1057 | | 0.0460 | 3 | <input type="checkbox"/> | |
| MIX-LATEX 5356 | | 1067 | | 0.0140 | 6 | <input type="checkbox"/> | |
| MIX-LIMESTONE | | 1069 | | 0.4710 | 2 | <input type="checkbox"/> | |
| MIX-MICA | | 1071 | | 0.0240 | 5 | <input type="checkbox"/> | |
| MIX-WOOD FIBER | | 1080 | | 0.0480 | 4 | <input type="checkbox"/> | |
| MIX-CELOGEN OT | | 1824 | | 0.0130 | 7 | <input type="checkbox"/> | |
| B1 Coating WFD-27 | | 1846 | | 0.0000 | 8 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------|--|
| Material | To add a new item to the list, select the <i>material</i> from the drop down list on the last line. This is a required field. |
| Usage Factor | The <i>percent of part used</i> . |
| Ordinal | The order in which the list should display in the Cost Sheet – Materials page as a default. |

Formula Packaging

Coating Factors | Hole Deplug Factors | Material | **Packaging** | Labor | Overhead | Misc. Cost

| Material | DrawingNo | BPCS PartNo | BPCS Part Rev. | Ordinal | Obsolete | |
|----------------------|----------------------|----------------------|----------------------|----------------------|--------------------------|--|
| PKG-TIE SHEET | | 1147 | | 0 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------|---|
| Packaging | To add a new item to the list, select the <i>packaging</i> from the drop down list on the last line. This is a required field. |
| Ordinal | The order in which the list should display in the Cost Sheet – Packaging page as a default. |

Formula Labor

Coating Factors | Hole Deplug Factors | Material | Packaging | Labor | Overhead | Misc. Cost

| Description | Ordinal | Obsolete | |
|---------------------------------|----------------------|--------------------------|--|
| Melsheet Line 1 (35): | 0 | <input type="checkbox"/> | |
| Off-Line Deplug/Scrap/Pkg (15): | 1 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------|---|
| Labor Items | To add a new item to the list, select the <i>labor items</i> from the drop down list on the last line. This is a required field. |
| Ordinal | The order in which the list should display in the Cost Sheet – Labor page as a default. |

Formula Overhead

Coating Factors | Hole Deplug Factors | Material | Packaging | Labor | Overhead | Misc. Cost

| Description | Ordinal | Obsolete | |
|---------------------------------|----------------------|--------------------------|--|
| Melsheet Line 1 (35): | 0 | <input type="checkbox"/> | |
| Off-Line Deplug/Scrap/Pkg (15): | 1 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------|--|
| Overhead Items | To add a new item to the list, select the <i>overhead items</i> from the drop down list on the last line. This is a required field. |
| Ordinal | The order in which the list should display in the Cost Sheet – Overhead page as a default. |

Formula Misc. Cost

Coating Factors | Hole Deplug Factors | Material | Packaging | Labor | Overhead | Misc. Cost

| Description | Ordinal | Obsolete | |
|----------------------|----------------------|--------------------------|--|
| Die Board | 2 | <input type="checkbox"/> | |
| Returnable Packaging | 1 | <input type="checkbox"/> | |
| S,G,A | 0 | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|----------------|--|
| Cost Item | To add a new item to the list, select the <i>cost items</i> from the drop down list on the last line. This is a required field. |
| Ordinal | The order in which the list should display in the Cost Sheet – Misc. Costs tab as a defaulted. |

Labor

The **Labor** page was designed for costing coordinators to add, edit, or delete labor information to the Costing module with the option to search by *Description*. This table is used in both **Formula – Labor** and **Cost Sheet- Labor** pages.

Labor Maintenance

Partial Searches can be completed by placing % before or after text.

Labor Description:

| Description | Rate | Crew Size | Offline | Obsolete | |
|------------------------------|----------------------|----------------------|--------------------------|--------------------------|--|
| Barrier/RSS Line (30): | 32.8900 | 11.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Carpet/Waterjet-Somerset | 22.4700 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Freight | 0.0000 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Heights Molding#1 (40): | 32.1400 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Heights Molding#2 (Damplex) | 31.1800 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Heights Molding#2 (Sunshade) | 28.5500 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX - Repack | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX General - Fiberglass | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX General - RUL | 27.5400 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX General Hot Mold | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#1 (15) | 27.5400 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#10 (70) | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#11 (75) | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#12 (80) | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#13 (90) | 27.0200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | <input type="checkbox"/> | |
| 1 2 3 4 5 | | | | | |

The **Labor** page is designed with the following fields:

| Fields/Buttons | Description |
|----------------|---|
| Description | To add a new item to the list, enter the <i>on the last line</i> . This is a required field. |
| Rate | The <i>rate</i> for the labor. |
| Crew Size | The number of <i>crew size</i> . |
| Off Line | Check the item if required for <i>offline</i> . |
| Obsolete | This will indicate to the team member to no longer use this value. |

Material/Packaging List

The **Material/Packaging List** page was designed for costing coordinators to display a list of materials that were added to the costing module with the ability to search by *Material ID, Part, BPCS PartNo. Purchased Good, Vendor, Coating Usage, Packaging usage, or obsolete*. The Materials information is used in the **Formula – Material** tab and **Cost Sheet– Materials** tab. Costing coordinators can add new materials by clicking on the “add” button. Team members can view the details of a material by clicking on the Material ID or Name.

The **Packaging List** was designed for Costing Coordinators to display a list of materials that were added to the costing module. The Materials table is used in **Formula – Packaging** tab and **Cost Sheet – Packaging** tab.

Note: *Only materials that have the packaging value set to true will display in the **Packaging Material List**.*

Material/Packaging List

Partial Searches can be completed by placing % before or after text.

Review existing materials or press to enter a new material.

| | | | |
|--|----------------------|---------------------|----------------------|
| MaterialID: | <input type="text"/> | DMS Drawing No: | <input type="text"/> |
| Part (Material/BPCS Name/Desc): | <input type="text"/> | Vendor: | <input type="text"/> |
| BPCS Part No: | <input type="text"/> | Old Material Group: | <input type="text"/> |
| Purchased Good: | <input type="text"/> | Obsolete: | <input type="text"/> |
| Coating: | <input type="text"/> | | |
| Packaging: | <input type="text"/> | | |
| <input type="button" value="Search"/> <input type="button" value="Reset"/> | | | |

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| Material ID | Material Name | DrawingNo | BPCS PartNo | BPCS Rev. | UGNDB Vendor | BPCS Standard Cost | Quote Cost | Freight Cost |
|-------------|--------------------------|-----------|-------------|-----------|-------------------------|--------------------|------------|--------------|
| 1003 | undefined | | 3197 | | UGN, Inc. | 5.588540 | 5.826500 | 0.000000 |
| 1382 | undefined | | 1524 | | Freudenberg | 0.386630 | 0.387600 | 0.000000 |
| 4424 | | | | | TS Tech. | 0.000000 | 0.000000 | 0.000000 |
| 1083 | #63-120-59 Composite | | | | Harodite | 0.000000 | 1.492000 | 0.000000 |
| 3210 | #63-90 Composite | | 3838 | | H.R. Technologies, Inc. | 1.436370 | 1.418100 | 0.000000 |
| 3293 | #63-90 Composite | | 3869 | | H.R. Technologies, Inc. | 1.768930 | 1.743800 | 0.000000 |
| 3323 | #63-90 Composite | | 3872 | | H.R. Technologies, Inc. | 1.564690 | 1.542900 | 0.000000 |
| 1482 | #63120 Composite | | 3591 | | Harodite | 1.582460 | 1.543500 | 0.000000 |
| 1481 | #64088 Composite | | 3590 | | Harodite | 1.526480 | 1.488900 | 0.000000 |
| 1084 | #64088-59 Composite | | | | Harodite | 0.000000 | 1.364000 | 0.000000 |
| 928 | (TPE-101) | | 4226 | | Global Docugraphix | 0.023850 | 0.023600 | 0.000000 |
| 3180 | 1"x2" FLEXPack 440 LABEL | | 3804 | | Weber Marking Systems | 0.020350 | 0.018400 | 0.000000 |
| 3181 | 1"x2" FLEXPack 440 LABEL | | 3805 | | Weber Marking Systems | 0.018060 | 0.018400 | 0.000000 |
| 3457 | 1"x2" FLEXPack 440 LABEL | | 3891 | | Weber Marking Systems | 0.020350 | 0.018400 | 0.000000 |
| 3619 | 1"x2" FLEXPack 440 LABEL | | 3924 | | Weber Marking Systems | 0.015070 | 0.014000 | 0.000000 |

Material/Packaging Maintenance

The BPCS standard cost and purchased cost are downloaded daily from the BPCS System into the UGN Database. An email is sent to the costing coordinators with a list of the changes. The costing coordinator should check each of those materials to see if any changes are needed for the quote cost, which is the cost that should be used in cost sheets. If the BPCS purchased cost is not equal to the quote cost, then the background color of the quote cost will be yellow. If the purchased cost plus the freight cost does not equal the BPCS standard cost, the background color of the freight cost will be yellow.

Note: *Only materials that have the packaging value set to true will display in the **Packaging List**.*


Material/Packaging Maintenance


WARNING: The purchased cost does NOT EQUAL the quote cost.

Material ID: 3210 Obsolete: ☐

Material Name: #63-90 Composite


Material Desc: 60" wide roll

BPCS Part No.: 3838  BPCS Part Revision:

Drawing No.: 

Coating: ☐

Packaging: ☐

Vendor: 11833 | H R TECHNOLOGIES INC  View Vendor
List

Purchased Good: Old Material Group: fabric/glass/film

Unit of Measure: Ln/Mtr

Quote Cost: 1.418100 Last Changed: 01/08/2009

Freight Cost:

BPCS Standard Cost:

BPCS Purchased Cost:

The **Material Detail** page is designed with the following fields:

| Fields/Buttons | Description |
|----------------------|--|
| Material ID | This is the unique identifier of a material. Once the record is saved, the system will get the next sequential <i>material id</i> . This is a read only field. |
| Material Name | The name of the <i>material</i> . This is a required field. |
| Material Description | The <i>description</i> of the material. |
| BPCS PartNo | The <i>BPCS part number</i> . The system will verify if the BPCS number entered is used in another material. If so, the system will display a warning message. The BPCS PartNo popup is available for searching. |
| DrawingNo | Enter the DMS Drawing No associated with the part. The DMS DrawingNo popup is available for searching. |
| Purchased Good | Select the type of raw material |
| Material Group | If an old material group was used in the old system, it will be carried over to a label. |
| Vendor | Select a <i>vendor</i> from the drop down list. This list is derived from the BPCS System. If a value does not exist, the costing coordinator may add a new value in the Vendor Maintenance page of the Data Maintenance Module. |
| Quote Cost | The <i>quote cost per unit</i> , which will be used in the <i>cost sheets</i> . A label will be shown the last time this page changed. |
| Unit of Measure | Select the <i>unit of measure</i> . If the value is missing, the costing coordinator can add a value in the Unit Maintenance page of the Data Maintenance Module. |
| Freight Cost | The <i>freight cost</i> . A label will show the last time this value changed. |
| BPCS Standard Cost | The standard cost of the part in the BPCS System. This is a label. A second label will indicate the last time it changed. |
| BPCS Purchased Cost | The purchased cost of the part in the BPCS System. This is a label. A second label will indicate the last time it changed. |
| Coating | If the material requires <i>coating</i> , this box is checked |
| Packaging | If the material is used for <i>packaging</i> , this box is checked |

| | |
|-------------|--|
| Obsolete | If the material will no longer be in use, this box is checked |
| Save Record | The Save Record button should be clicked completed the entry or update. |
| Copy | The Copy button will recreate a new material record with the same information of a current material. The <i>BPCS Number</i> and <i>Make Obsolete</i> values will not be included in the copy process. |

Misc. Costs

The **Misc Costs** page was designed for costing coordinators to add, edit, or delete costs to the Costing module with the ability to search for a particular description. This table is used in both **Formula – Misc Costs** tab and **Cost Sheet- Misc. Costs** tab.

Misc Cost Maintenance

Partial Searches can be completed by placing % before or after text.

Misc Cost Type Description:

| Description | Rate | Show as Rate Percent On Cost Form | Obsolete | |
|-------------------------|----------------------|-------------------------------------|--------------------------|--|
| Adv. Eng. Ting (S/R) | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Adv. Eng. Tooling (A/C) | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Design Cost | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Die Board | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Interplant Freight | 0.0600 | <input checked="" type="checkbox"/> | <input type="checkbox"/> | |
| Packaging | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Profit | 0.0500 | <input checked="" type="checkbox"/> | <input type="checkbox"/> | |
| Returnable Packaging | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| RUL Design Cost | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| S,G,A | 0.0750 | <input checked="" type="checkbox"/> | <input type="checkbox"/> | |
| Tooling | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Tooling (Toyota) | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| UGN, Inc. Tooling | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | <input type="checkbox"/> | |

| Fields/Buttons | Description |
|---------------------------------------|---|
| Description | To add a new item to the list, enter the <i>on the last line</i> . This is a required field. |
| Rate | The <i>rate</i> for the labor. |
| Show as Rate Percent on the Cost Form | If this is checked, then the cost form should show the rate or the percentage. |
| Obsolete | This will indicate to the team member to no longer use this value. |

Overhead

The **Overhead** page was designed for costing coordinators to add, edit, or delete overhead information to the Costing module with the option to search by *Description*. This table is used in both **Formula – Overhead** tab and **Cost Sheet-Overhead** tab.

Overhead Maintenance

Partial Searches can be completed by placing % before or after text:

Description:

| Description | Rate | Crew Size | Offline | Obsolete | |
|------------------------------|----------------------|----------------------|--------------------------|--------------------------|--|
| Barrier/RSS Line (30): | 762.7100 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Barrier/RSS Line (30): | 762.7100 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Carpet/Waterjet-Somerseset | 405.0400 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Freight | 0.0000 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Heights Molding#1 (40): | 237.6200 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Heights Molding#2 (Dimplex) | 110.3300 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| Heights Molding#2 (Sunshade) | 361.0800 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX - Repack | 51.4400 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX General - Fiberglass | 246.8300 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX General - RUL | 291.0900 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX General Hot Mold | 246.8300 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#1 (15) | 291.0900 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#10 (70) | 246.8300 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#11 (75) | 246.8300 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| JX-Ce#12 (80) | 246.8300 | 0.0000 | <input type="checkbox"/> | <input type="checkbox"/> | |
| <input type="text"/> | <input type="text"/> | <input type="text"/> | <input type="checkbox"/> | <input type="checkbox"/> | |
| 1 2 3 4 5 | | | | | |

The **Overhead** screen is designed with the following fields:

| Fields/Buttons | Description |
|----------------|--|
| Description | To add a new item to the list, enter the <i>description</i> on the last line. This is a required field. |
| Rate | The <i>rate</i> for the labor. |
| Crew Size | The number of <i>crew size</i> . |
| Off Line | This is checked if the item is required for <i>offline</i> . |
| Obsolete | This will indicate to the team member to no longer use this value. |

Processes

The **Process** page is designed for costing coordinators to display a list of processes that were added to the Costing module with the ability to search by *Process* name. The Process table is used in **Formula – top level properties** and **Cost Sheet – Part Specification** tab.

Process Maintenance

Partial Searches can be completed by placing % before or after text.

Process Name:

| Name | Obsolete | |
|------------------------|-------------------------------------|--|
| Carpet/Waterjet | <input type="checkbox"/> | |
| Fleece Line | <input type="checkbox"/> | |
| Headliner/Waterjet | <input type="checkbox"/> | |
| Hot/Cold Mold | <input type="checkbox"/> | |
| Injection Mold | <input type="checkbox"/> | |
| Jackson Headliner Ass. | <input type="checkbox"/> | |
| Laminate & Tape Appt. | <input type="checkbox"/> | |
| NT Dimplex | <input type="checkbox"/> | |
| Off-Line | <input type="checkbox"/> | |
| Off-Line Die-Cut | <input type="checkbox"/> | |
| On Line | <input type="checkbox"/> | |
| On/Off-Line | <input type="checkbox"/> | |
| Packaging | <input type="checkbox"/> | |
| Pad/PVC | <input type="checkbox"/> | |
| RSS Application | <input type="checkbox"/> | |
| Ultralight Molding | <input type="checkbox"/> | |
| ** undefined | <input checked="" type="checkbox"/> | |
| <input type="text"/> | <input type="checkbox"/> | |

The **Process** page is designed with the following fields:

| Fields/Buttons | Description |
|----------------|---|
| Name | To add a new item to the list, enter the <i>on the last line</i> . This is a required field. |
| Obsolete | This will indicate to the team member to no longer use this value. |

Template

The **Template** page is designed for costing coordinators to display a list of templates that were added to the costing module with the ability to search by *Template* name. The Template table is used in **Formula – top level properties** and used in the calculations of cost sheets, as well as a deciding factor in which fields are used when presenting the cost form and die layout form.

Template Maintenance

Partial Searches can be completed by placing % before or after text.

Template Description:

| Name | Obsolete | |
|--|-------------------------------------|--|
| Barrier Standard and Quote Cost Form | <input type="checkbox"/> | |
| Composite | <input type="checkbox"/> | |
| Fleece | <input type="checkbox"/> | |
| Injection Molding (Valpo) | <input type="checkbox"/> | |
| Inline die-cut | <input type="checkbox"/> | |
| Melshheet Standard and Quote Cost Form | <input type="checkbox"/> | |
| Molding | <input type="checkbox"/> | |
| Off-line Die-cut template | <input type="checkbox"/> | |
| OLD RSS Die-cut | <input type="checkbox"/> | |
| Re-Packaging | <input type="checkbox"/> | |
| RSS Standard and Quote Cost Form | <input type="checkbox"/> | |
| RSS-Diecut | <input type="checkbox"/> | |
| Used for Chicago, Heights and Jackson | <input type="checkbox"/> | |
| Used for Valpo | <input type="checkbox"/> | |
| ** undefined | <input checked="" type="checkbox"/> | |
| <input type="text"/> | <input type="checkbox"/> | |



The **Template** page is designed with the following fields:

| Fields/Buttons | Description |
|----------------|--|
| Name | To add a new item to the list, enter the <i>on the last</i> line. This is a required field. |
| Obsolete | This will indicate to the team member to no longer use this value. |

Cost Sheet Activity Report

The cost sheet activity report on the **Costing Menu** screen is used to show the response time in summary or detail of a particular team memory or facility, based on an optional date range.

Cost Sheet Activity

Quote Date FROM:  Quote Date TO: 

UGN Facility: Team Member:

Team Member Turn Around Time Activity Report - Windows Internet Explorer provided by UGN, Inc.

File Edit View Favorites Tools Help

SnagIt

Links UGN DATABASE Prod New Hold Tag Entry - Mobile Test New Hold Tag Entry - Mobile Gloppe Helpdesk Google

AVG Yahoo! SEARCH Search 100% Total Protection AVG Info

1 / 1 100%

UGN
Board Solutions for the Auto motive industry

Average Turnaround Time for Cost Sheet Approval (Summary)

Quote Date From:

Quote Date To:

| UGN Facility | Team Member | Total Cost Sheets | Hours | Days |
|----------------|-------------|-------------------|-----------|-----------|
| Chicago | Ron | 1527 | Total: | 27,170.65 |
| | | | Average: | 17.79 |
| Chicago | Chris | 1353 | Total: | 19,539.00 |
| | | | Average: | 14.44 |
| Chicago | John | 235 | Total: | 4,274.15 |
| | | | Average: | 18.19 |
| Chicago | Michael | 115 | Total: | 1,611.63 |
| | | | Average: | 14.01 |
| Overall Total: | | 3,230 | 52,595.43 | 6,604.00 |

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