

Ver : 3.2

**FORM** Dokumen: PWI-IE-LEAN-F-001

KERJA No Dokumen

Judul: LINE BALANCING

Halaman : 1/5

Tanggal Efe 6 July 2022

Revisi

R.Tanggal

Nama Dokumen

PS-GS 327 Kids Model (CBW.CGP.CGW.CNW Date 11-Dec-23

					Update		
Part	Description	Unit	Dev Stage	01	02	03	Remarks
	Man Power	#		3			x2 shift
	Product by Hr.	Pairs		48			
7 h	РРН	#		16.0			
ING	Line balance	%		52.85%			
CUTTING	No of Cell	#		1			
り	Takt Time	Sec		75.0			
	TCT	Sec		118.9			
	Pitch time	Sec		48.6			
	Man Power	#		25			x2 shift
<b>→</b>	Product by Hr.	Pairs		48			
ION	РРН	#		1.9			
PREPARATION	Line balance	%		57.67%			
PAI	No of Cell	#		1			
PRE	Takt Time	Sec		75.0			
	TCT	Sec		1081.4			
	Pitch time	Sec		72.7			
	Man Power	#		43			
	Product by Hr.	Pairs		96			
ZG	РРН	#		2.2			
STITCHING	Line balance	%		75.11%			
IIT	No of Cell	#		1			
S	Takt Time	Sec		37.5			
	TCT	Sec		1211.1			
	Pitch time	Sec		35.3			
	Man Power	#		40			
	Product by Hr.	Pairs		96			
LY	PPH	#		2.4			
MB	Line balance	%		72.5%			
ASSEMBI	No of Cell	#		1			
A	Takt Time	Sec		37.5			
	TCT	Sec		1086.9			
	Pitch time	Sec		37.1			
	Man Power	#		139			
	Product by Hr.	Pairs		96			
AL	PPH	#		0.69			
TOTAL	Line balance	%		67.11%			
	Takt Time	Sec		37.5			
	TCT	Sec		3498.3			
	Pitch time	Sec		36.3			



## FORM KERJA

Dokumen: PWI-IE-LEAN-F-001 No Dokumen

PS-GS 327 Kids

PPH

Halaman 2/5 Tanggal Efektif 6 July 2022 Revisi

Judul: LINE BALANCING

Nama Dokumen

16.0 T.T 75 Detik

R.Tanggal

			PS-GS 327 Kids (CBW,CGP,CG W,CNW,CWB, Prod./H				T.T Date	75 Detik 11-Dec-23				
NT-	D	Material	Pcs/dies	Pcs/pai	Machine		С	.T	BF %	Man	Power	
No.	Process	Material	Pcs/dies	r	Layer	Name(Model)	Q'ty	Process	Work	BF %	Cal	Standard
A	CUTTING TRAVELING	<del>,</del>					3.00	118.92	48.6		1.6	3
1	Tip	VIDAN SUEDE,1.1MM,110CM + MER	1	2	4	TRAVELLING	1	6.96	38.9	80%	0.5	1.0
	Collar Overlay Lat/Med.	VIDAN SUEDE,1.1MM,110CM + MER	1	4	4			9.53				
	Under Eyestay Lat/Med.	VIDAN SUEDE,1.1MM,110CM + MER	1	4	4			9.53				
	Foxing	VIDAN SUEDE,1.1MM,110CM + MER	1	2	4			5.96				
	Boot Vamp & Saddle	LJ-B2572B-EPM5, 44IN + LJ-B1150B-	1	2	4			6.96				
2	Tongue	LJ-B2572B-EPM5, 44IN + K329, 4MM	1	2	4	TRAVELLING	1	6.96	35.0	72%	0.5	1.0
	Collar Lining	TSCC-155-EPM5, 44IN + K329, 4MM,	1	2	4			6.96				
	Boxtoe	TEXON UNO, 0.4MM	1	2	8			3.81				
	Eyestay Reinf	SUPER LIGHT SL380, 0.6MM, 54IN	1	2	8			4.31				
	Eyestay Lining	TCPP-2600-12/POLYPAG IL EPM 5, 4	1	2	8			5.96				
	Collar Foam	K50, 4MM, 44IN	1	2	4			6.96				
3	Med. Collar Reinf	EVA 25+/-3C 2MM, 44IN	1	2	4	TRAVELLING	1	5.96	48.6	100%	0.6	1.0
	Lat. Collar Reinf	EVA 25+/-3C 2MM, 44IN	1	2	4			5.96				
	Heel Counter	TENOFLEX C36, 1.15MM	1	2	2			10.25				
	Hel Counter Reinf.	0.6MM TAIBRELLE, 44IN	1	2	8			3.63				
	N'Logo (Lat. Side)	NB-GREEN, 1.4MM, 54IN + TCCP-552	2	2	2		_	6.96			_	
	Stroble	DOUBLE TEX 25 ECO,0.9MM, 44IN	1	2	2		_	12.25			_	
	Foxing Med. Reinf	DPP16/160 DT66 BLK, 44IN	1	2	8			3.63				
		TOTAL					3	118.92	48.6		1.59	3





## FORM KERJA

Dokumen : PWI-IE-LEAN-F-001 No Dokumen

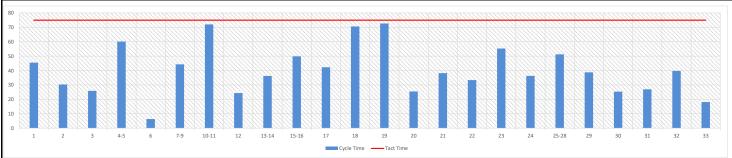
Halaman Tanggal Efek : 6 July 2022

Revisi

Judul : LINE BALANCING Nama Dokumen

kumen			R.Tanggal	
-GS 327 Kids	PPH	1.9	T.T	75 Detik

	PREPARATION	(CBW,CGP,CGW,CNW,CW	Prod./Hr	48 Pasa	ng/jam	Date		ec-23
		1		C	.т		Man	Power
No.	Process	Name(Model)	Q'ty	Process	Work	BF %	Cal	Standard
В	PREPARATION COMPONENT		8	384.35	72.0		5	9
1	Water Spider Cut-Prep-Tongue		1	91.00	45.5	63%	1.2	2
2	Press HRP: Tempel Boxtoe ke Tip, Foxing Med Reinf & Press HRP,	HRP	1	30.31	30.3	42%	0.4	1
3	Skiving Component : Counter	SKIVING COUNTER	1	25.93	25.9	36%	0.3	1
4.5	Skiving Component : Lat/Med Collar Reinf			31.51	60.2	020/	0.0	
4-5	: N'Logo Lat.	SKIVING COMPONENT	1	28.64	60.2	83%	0.8	1
6	Potong Webbing			6.31		CEN	ΓRAL	
	Gauge : Tip			15.60				
7-9	: N-Logo Lat. Ka/Ki	Machine   Name(Model)   Q'ty   8     1	1	16.35	44.3	61%	0.6	1
	: Foxing Med			12.36			5 1.2 0.4 0.3 0.8	
10-11	: Boot Vamp Saddle	CODEEN DRING	1	51.36	72.0	99%	1.0	1
10-11	: Insole	SCREENPRINI	1	20.68	72.0	9970	1.0	1
12	Tempel Heel Counter Reinf Ke Counter	TABLE	1	24.36	24.4	34%	0.3	1
13-14	Jahit Kunci Pinggir Collar Linning*	EDCN	1	21.98	36.3	50%	0.5	1
13-14	Jahit Balik Collar Linning Bagian Bawah	FBSN	1	14.27	30.3			1
C	Prep. Before Computer Stitching		1	49.87	49.9		1	1
15-16	Tempel Eyestay Reinf Ke Boot Vamp Saddle	TABLE	1	18.29	49.9	69%	0.7	1
13-10	Tempel L/M Collar Reinf Ke Boot Vamp Saddle			31.58	47.7	07/0	0.7	1
E	BINDING PROCESS		4	258.3	72.7		3.4	4.0
17	Jahit Saddle Binding*	PBSN	1	42.31	42.3	58%	0.6	1
18	Lem & Lipat Binding (Manual)	TABLE	1	70.64	70.6	97%	0.9	1
19	Jahit TIP Ke Upper	PBDN	2	145.36	72.7	100%	1.9	2
D	COMPUTER STITCHING		5	188.69	55.3		2.5	5.0
20	Jahit Deco Upper Lateral	COM 6040	1	25.50	25.5	35%	0.3	1
21	Tempel Eyestay Linning*	TABLE	1	38.21	38.2	53%	0.5	1
22	Jahit Tepi Bagian Eyerow	PBSN	1	33.36	33.4	46%	0.4	1
23	Jahit N logo	COM 6040	1	55.31	55.3	76%	0.7	1
24	Jahit Under Eyerow Ke Upper	COM 1510	1	36.31	36.3	50%	0.5	1
F	TONGUE		7	200.14	51.3		2.7	6.0
	Gauge: Tongue			14.36				
25-28	: Tongue (size label)	TABLE	1	7.36	51.3	71%	0.7	1
	: Tongue Webbing			19.58				
	Tempel Webbing	BALL MELT	1	9.95				
29	Jahit Tongue Webbing Ke Tongue	COM 1510	1	38.74	38.7	53%	0.5	1
30	Jahit Pinggir Tongue	FBSN	1	25.36	25.4	35%	0.3	1
31	Jahit Tongue Binding Ke Tongue	FBSN (CORONG)	1	26.95	27.0	37%	0.4	1
32	Jahit Tongue Label Ke Tongue	FBSN	1	39.74	39.7	55%	0.5	1
33	Press Size Label	SIZE LABEL	1	18.10	18.1	25%	0.2	1
	TOTAL		25.00	1081.35	72.68		14.42	25.00





FORM KERJA

Dokumen : PWI-IE-LEAN-F-

001 No Dokumen Halaman : 4/5
Tanggal Efektif : 6 July 2022

Revisi

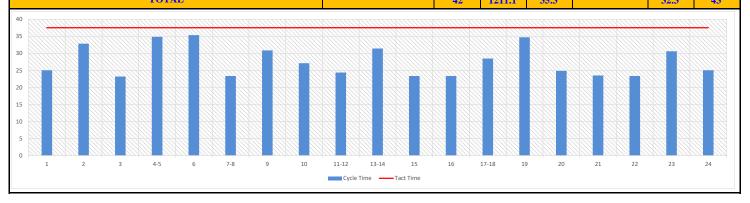
R.Tanggal

Judul: LINE BALANCING

Nama Dokumen

STITCHING		PS-GS 327 Kids (CBW,CGP,CGW,CNW	PPH	2.2		T.T	37.50	
	SIIICIIIII	,CWB,CTB)	Prod./Hr	96 Pasa	ng/jam	Date	11-D	ec-23
No	Process	Machine	C.T		BF %	Man Power		
No.		Name(Model)	Qty	Process	Work	DF 70	Cal	Standard
H	STITCHING SG							
1	INDUT SETTING DC	TROLLEY	2	50.00	25.00	710/	1.2	2

No.	Process	Machine		C	.T	BF %	Man	Power
NO.	Process	Name(Model)	Qty	Process	Work	DF 70	Cal	Standard
Н	STITCHING SG							
1	INPUT, SETTING DC	TROLLEY	2	50.00	25.00	71%	1.3	2
2	Jahit Z-Z Boot Vamp, Tip, Upper Heel	FLAT ZIG-ZAG	2	65.64	32.82	93%	1.8	2
3	Spray Upper TIP & Tempel Collar Foam	COLD SPRAY	2	46.36	23.18	66%	1.2	2
4-5	Jahit Balik Collar Linning Bagian Pinggir Upper	PBSN	2	69.64	34.82	00%	1.9	2
4-5	Trimming Area Collar Linning	FBSN	2	09.04	34.62	9970	1.9	2
6	Jahit Collar Binding Ke Upper	CANGKLONG	2	70.64	35.32	100%	1.9	2
7-8	Lem & Tempel Foxing	BALL MELT	2	46.69	23.35	66%	1.2	2
7-0	Leni & Temper Foxing	TABLE	2	40.09	23.33	00%	1.2	2
9	Jahit Foxing Ke Upper	PBDN	4	123.36	30.84	87%	3.3	4
10	Jahit Balik Collar Linning Ke Foxing	PBSN	2	54.19	27.10	77%	1.4	2
11-12	Jahit Zig-zag Bagian Foxing & Heel	FLAT ZIG-ZAG	2	32.36	24.36	60%	1.3	2
11-12	Jahit Zig-zag Counter Foxing	FLAT ZIG-ZAG	2	16.36	24.30	66% 99% 100% 66% 87% 77% 69% 89% 66% 66% 66% 66% 66%	1.3	2
13-14	Spray Counter Ke Upper dan Upper Linning	COLD SPRAY	2	58.94	31.40	99% 32 99% 32 100% 35 66% 34 87% 30 77% 36 69% 40 89% 33 66% 33 66% 45 81% 70 98% 34 70% 49 67%	3.3	4
13-14	Balik Collar Linning	COLD SPRAY	2	66.64	31.40	89%	3.3	4
15	Jahit Pading 2 (Lateral)*	PBSN	2	46.65	23.33	66%	1.2	2
16	Jahit Pading 2 (Medial)*	PBSN	2	46.65	23.33	66%	1.2	2
17-18	Tempel & lipat Collar Overlay L/M Ke Upper	BALL MELT	1	36.54	28.45	910/	1.5	2
17-10	Hammering Eyerow	HAMMER	1	20.36	26.43	81%	1.3	2
19	Jahit Collar Overlay L/M (eyesty top) Ke Upper*	PBSN	2	69.40	34.70	98%	1.9	2
20	Process Pounching Hole	POUNCHING	2	49.68	24.84	70%	1.3	2
21	Jahit Tongue Ke Upper	COM 1510	2	46.98	23.49	67%	1.3	2
22	Jahit Tepi Bagian Bawah Upper	PBSN	2	46.69	23.35	66%	1.2	2
23	Insert Lace	TABLE LACE	2	122.36	30.59	87%	3.3	4
24	OUTPUT			25.00	25.00	71%	0.7	1
25	TQC	TABLE QC	2	25.00				
	TOTAL		42	1211.1	35.3		32.3	43





## FORM KERJA

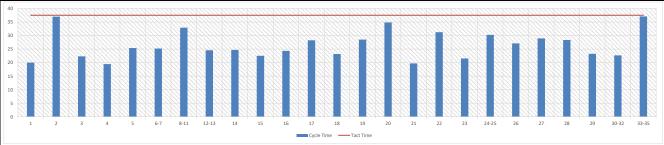
Dokumen : PWI-IE-LEAN-F-001 No Dokumen Halaman : 5 / 5
Tanggal Efek : 06 July 2022
Revisi :

R.Tanggal

Judul : LINE BALANCING

Nama Dokumen

	ASSEMBLY	7 Kids (CBW,CGP,CGW,CNW,C	PPH	2.	4	T.T	37	7.50	
	ASSENIBLI	/ Kius (CBW,CGI,CGW,CIW,C	Prod./Hr	96 Pasa	ng/jam	Date	11-D	ec-23	
		Machine		С	т.		Man	Power	
No.	Process	Name(Model) Q'ty		Process Work		BF %	Cal	Standard	
I	ASSEMBLY	` '							
1	INPUT	RACK UPPER	1	20.00	20.0	54%	0.5	1	
_	COUNTER ACTIVATOR (TIMER : 30 Sec) (M/W) *	COUNTER ACTIVATOR	1					_	
2	BACK PART MOULDING COOL (TIMER : 25 Sec) (M/W) *	BPM	1	74.00	37.0	100%	2.0	2	
3	JAHIT GATHERING *	GATHERING MACHINE	1	22.31	22.3	60%	0.6	1	
4	JAHIT BACK LAST MARGIN	PBSN	1	19.44	19.4	52%	0.5	1	
5	JAHIT STROBLE *	STROBEL M/C	2	50.76	25.4	68%	1.4	2	
	METAL DETECTOR	METAL DETECTOR	1						
6-7	STEAM UPPER (TIMER = 15" - 20") + SETTING LASTE	STEAM BOX	1	14.75	25.2	68%	1.2	2	
0-7	INSERT LASTE * CHECK LAST STROBLE	KABUKI INSERT	1	35.64	25.2	08%	1.5	2	
	HEEL LASTING (TIMER = 3")	HEEL LAST (BIG)	1	10.64			11-De Man F Cal  0.5  2.0  0.6  0.5		
8-11	HEEL HIGH	HEEL HEIGH	1	16.20	32.9	89%	1.8	2	
0-11	KENCANG LACE * CHECK LASER	KENCANG TALI	1	20.31	32.9	0970	11-De  Man F  Cal  0.5  2.0  0.6  0.5  1.4  1.3  1.8  1.3  1.2  1.3  1.5  1.5  0.8  0.6  0.8  0.7  0.8  0.8  0.6  1.2  1.0	2	
	PRESS TOE & HEEL	TOE HEEL PRESS	1	18.64					
	HEATING CHAMBER (TEMP : 70-80°C, TIME : 4'00")	HEATING SETTING A-NAM	1						
12-13	SETTING OUT SOLE KE UPPER *	TROLLEY BOTTTOM	1	18.49	24.5	66%	1.3	2	
12-13	GAUGE TOE UPPER *	TABLE	1	30.60	24.5	0070	1.3 1.3 1.3 1.3 1.3 1.3 1.3 1.3 1.5 1.5 1.6 1.7 0.5 0.8 0.6 0.8 0.7 0.8	2	
14	GAUGE MARKING UPPER * (PRESSURE : 2.5-3.0 Kg)	GAUGE MARKING	2	49.34	24.7	67%	1.3	2	
15	SLIGHT BUFFING *	HAND BUFFING	2	45.02	22.5	61%	1.2	2	
	DRY CHAMBER I (TEMP : 50-60°C, TIME : 1'15 ~ 1'20")								
16	PRIMER OUTSOLE *			48.69	24.3	66%	1.3	2	
17	PRIMER UPPER *			56.51	28.3	76%	1.5	2	
	DRY CHAMBER II (TEMP : 55-60°C, TIME : 1'25 ~ 1'30")								
18	CEMENT OUTSOLE *			46.36	23.2	63%	1.2	2	
19	CEMENT UPPER *			57.01	28.5	77%	1.5	2	
	DRY CHAMBER III (TEMP : 60-65°C, TIME : 1'25 ~ 1'30")								
20	TEMPEL OUTSOLE KE UPPER *			139.36	34.8	94%	3.7	4	
21	PRESS UNIVERSAL (TIMER PRESS : MIN 10 Sec)	PRESS UNIVERSAL - DP (KD-S9	1	19.72	19.7	53%	0.5	1	
22	PRESS TOE & HEEL	HAND HAMMER	1	31.25	31.3	84%	0.8	1	
	CHILLER (TEMP : 25-31°C, TIME : 4'00")	CHILLER	1						
23	BUKA LASTE & TALI *	OPEN LASTE	1		21.5	58%	0.6	1	
24-25	CHECKING BOUNDING	TABLE INSOLE	1		30.2	82%	0.8	1	
	PASANG INSOLE *						11-Do  Man I  Cal  0.5  2.0  0.6  0.5  1.4  1.3  1.8  1.3  1.2  1.3  1.5  0.8  0.6  0.8  0.7  0.8  0.8  0.6  1.2  1.0		
	RAPIH TALI		1						
	CLEANER SHOES (OUTSOLE + UPPER)	-	1	28.96	29.0	78%		1	
28	REPAIR SHOES			28.36	28.4	76%	0.8	1	
	QIP CONTROL	_	1						
	METAL DETECTOR				22 -	2011	0.7		
29	CLOSE HANGTAG & INSERT PAPER	TABLE	1		23.2	63%	0.6	1	
20.22	INNERBOX FOLDING	TARKE			22.7	(10)	1.2		
30-32	PLACE HANGTAG	IABLE	1		22.7	61%	1.2	2	
	ATTACH UPC LABEL TO INNERBOX								
22.25	WRAPPING (QC)				27.1	1000/	1.0		
33-35	SCAN & OUTPUT (QC)	TABLE	1		5/.1	100%	1.0	1	
	PACKING SHOE KE KARTON BOX (QC)		24		25.4		20.0	40	
40		A6.36   23.2   63%   1.2   2							



## NEW BALANCE PS-GS 327 (CBW, CGP, CGW, CNW, CWB, CTB) 2 SHIFT CUT-PREP (96prs)

