




Date Modify : 08 September 2023			Picture (Upper)		Picture (Bottom)	
Model : ULTRABOUNCE 5		Season : FW24				
Status : Presell		Model ID : NKE18				
Article : IE8792		LC C2B 151,30				
EOLR 120		Total MP C2B 98				
PPH (C2B)+WS 1,22		Total WS 7				
Efficiency C2B 79,5%		TCT C2B + WS 2.191,62				

1). IE DATA SUMMARY

C2B Process	Daily Target	WH	MC	EOLR	Target CT	LC Costing	MP	MP Conversion (120prs)	Last Modify Date
Cutting	960	8		120	114,64	8,64	6	6	
Sewing	960	8		120	896,21	66,87	41	41	
Assy	960	8		120	750,25	58,1	33	33	
Stockfit	2.560	8		320	430,52	17,69	48	18	
Sub Total					2.191,62	151,30	128	98	
Treatment Process									
Screen Print Tongue Patch Logo	1.000	8		125	10,63	21,00	1	1	
No Sew Vamp	1.000	8		125	142,00		6	6	
No Sew Eyestay	1.000	8		125	219,00		6	6	
Sub Total					371,63	21,00	13	13	
Total					2.563,25		141	111	
Treatment Process EQ23 RUN									


ULTRABOUNCE 5.0 Cutting analysis						Daily Target :		960	Worker/960prs/8hr		MC/960prs/8hr					
						Working Hour :		8	6		6					
						Takt Time :		28,125								
No	Component name	Picture	Subcont process	Material type	Machine	Piece/Prs	Layer	Piece/ Cutting Die	Time/ Cutting die	CT/Prs	Capa 8hr/1shift	MC /Target 4,08	Actual MC/ Target 6	Available rate 62%		
1	Vamp/Quarter		√	Engineered Mesh	hydraulic	2	1	1	27,00	54,00	500	1,9	2,0	96%		
2	Toe Box		√	Syn	hydraulic	2	4	1	6,96	3,48	1266	0,76	1,00	76%		
3	Quarter Reinf Medial		√	Syn	hydraulic	2	4	1	6,96	3,48						
4	Eyestay		√	Syn	hydraulic	2	4	1	6,96	3,48						
5	Eyestay Lining		√	Syn	hydraulic	2	4	1	6,96	3,48						
6	Collar Reinf		√	Syn	hydraulic	2	4	1	6,96	3,48						
7	Tongue		√	Syn	hydraulic	2	4	1	6,96	3,48						
8	Heel Tab (Cutting Before)		√	Syn	hydraulic	2	4	8	6,96	0,435						
9	Tongue Lining			Syn	hydraulic	2	4	1	6,96	3,48	2586	0,37	1,00	37%		
10	Collar Lining			Syn	hydraulic	2	4	1	6,96	3,48						
11	Tongue Top			Syn	hydraulic	2	4	1	6,96	3,48						
12	Tongue Top Padding			Syn	hydraulic	2	4	1	6,96	3,48	1293	0,74	1,00	74%		
13	Collar Padding			Syn	hydraulic	2	4	1	6,96	3,48						
14	Heel Foam			Syn	hydraulic	2	4	1	6,96	3,48						
15	Heel Tab			Syn	hydraulic	2	4	1	6,96	3,48						
16	Heel Tab Reinf			Syn	hydraulic	2	4	1	6,96	3,48						
17	Insole/Stroble			Syn	hydraulic	2	4	1	6,96	3,48						
18	Heel Tab (re-Cutting)			Syn	Thomson	2	1	1		8	3375	0,28	1,00	28%		
						114,635										
						Leather :		9,67	Synthetic/Textile :		6,96	Engineered Mesh/Knit :		27,00		
* Cutting time per die according to material type																

Stitching										
Stitching analysis ULTRABOUNCE 5.0			Daily Target :	960	Worker/960prs/8hr		Worker/960prs/8hr		MC/960prs/8hr	
			Wokring Hour:	8	24		41			
			Takt Time	28,1						
				56,3						
No.	Process Name	Machine	Q'ty/Prs	CT/Prs	Worker	CT/Prs	Worker	Adjusted	Available rate(%)	Remark
	Printing Tongue , Heel Tab	Table								
	No-Sew Vamp, Tongue	Printing								
1	Prepare Component	Handwork	2			26,5	1	26,5	100,0%	
2	Gauge Vamp/Quarter	Gauge	2			18,10	2	20,9	78,7%	
3	Gauge Tongue Top	Gauge	2			12,30				
	Gauge Tongue Bottom	Gauge	2			11,30				
4	Cutting Tongue Laceloop	Auto Webbing	2			18,00	1	18,0	67,9%	
5	Stitch Deco Eyestay	Posh 1 N	2			73,80	3	24,6	92,8%	Suggest CS
6	Stitch Quarter Cage	CS-5030	2			64,00	3	21,3	80,5%	
7	Stamping Size Label to Tongue Lining	Label Mc	2			12,10	1	12,1	45,7%	
8	Stitch Tongue Top to Tongue Bottom	Posh 1 N	2			24,10	1	24,1	90,9%	
9	Stitch and Turn Tongue to Tongue Lining	Posh 1 N	2			26,50	1	26,5	100,0%	
10	Attach Tongue Padding to Tongue	Table	2			17,34	2	19,2	72,3%	
11	Reverse Tongue and then Hammering	Hammering MC	2			21,00				
12	Stitch Tongue Edge	Post 1 N	2			22,30	1	22,3	84,2%	
13	Stitch Tongue Laceloop	Posh 1 N	2			12,40	1	12,4	46,8%	
14	Stitch Collar Lining Edge	Flat 1 N	2			16,00	1	16,0	60,4%	
Preparation sub_ Total				376	9	376	18	26,5		
15	Stitch and Turn Vamp Quarter Heel Area	CS - 1507	2	40,25	1	40,25	2	40,3	76,1%	
16	Folded Upper	Double Folded MC	2	20,80	1	20,80	2	36,2	68,4%	
17	Hammer Upper	Hammering MC	2	15,40		15,40				
18	Stitch Heel Tab	Posh 1 N	2	52,70	1	52,70	2	52,7	99,6%	
19	Attaching Heel Tab Reinf to Heel Tab	Table	2	11,20	1	11,20	2	28,0	52,9%	
20	Hammering Heel Tab	Hammering MC	2	16,80		16,80				
21	Attach Heel Foam to Upper	Table	2	36,00	1	36,00	2	36,0	68,1%	
22	Stitching Collar Lining to upper	Post 1 N	2	47,22	1	47,22	2	47,2	89,3%	
23	Spray Upper and Attach Collar Padding to Upper	Spray Hot Melt Mc	2	45,50	1	45,50	2	45,5	86,0%	
24	Reverse Collar Lining	Table	2	32,40	1	32,40	2	52,9	100,0%	
	Hammering Upper	Hammering Mc	2	20,50		20,50				
Stitching sub_ Total				339	8	339	16	52,9		
25	Pounching Upper	Pouch MC	8	26,00	1	26,00	1	26,0	95,1%	Recutting + Pounching after No Sew
26	Stitching tongue to upper	CS-1507	2	24,70	1	24,70	1	24,7	90,4%	
27	Stitching lasting margin	Post 1 N	2	25,10	1	25,10	1	25,1	91,8%	
28	Insert Shoelace	Table	2	82,00	3	82,00	3	27,3	100,0%	
29	Finishing Sewing	Table	2	23,90	1	23,90	1	23,9	87,4%	
Sharing sub_ Total				182	7	182	7	27,3		
Total				896,2	24	896,2	41	52,9		



Line balancing	Line balancing	Preparation	Stitching
		78,8%	95,0%


Assembly

Assembly analysis ULTRABOUNCE 5.0		Daily Target :		960	Worker/960prs/8hr		MC/960prs/8hr		
		Wokring Hour:		8	33				
		Takt Time		28,1					
No.	Process Name	Machine	Process condition	Chemical	CT/Prs	Worker	Adjusted	Available rate[%]	Remark
1	Prepare upper ,	Trolly			13,49	1	13,5	51,2%	
2	Back part molding,	BackpartMold Mc			24,70	1	24,7	93,7%	
3	Vamp press,	Toe Vamp Molding Mc			25,30	1	25,3	96,0%	
4	Stitching Gathering Tape	Gathering Mc			20,00	1	20,0	75,9%	
5	Stitch strobel,	Strobel Mc			38,00	2	19,0	72,1%	
6	Steam Upper and Setting last,	Trolly Laste			22,26	1	22,3	84,5%	
7	Insert last and heel last	heel last Mc			26,35	1	26,4	100,0%	
8	Strengthen lace,	Table			25,20	1	25,2	95,6%	
9	Setting outsole	Trolly			22,42	1	22,4	85,1%	
10	Gauge marking,	Gauge Marking Mc	2.8 - 3 kg/cm2		24,90	1	24,9	94,5%	
11	Toe gauge,	Table			20,33	1	20,3	77,2%	
12	Transfer to Conveyor	Conveyor			14,50	1	14,5	55,0%	
13	Chamber 1	Chamber m/c							
14	Primer upper,	Conveyor			49,70	2	24,9	94,3%	
15	Cement Outsole (TPU and Toe Tip)	Conveyor			20,80	1	20,8	113,3%	
16	Chamber 2	Chamber m/c							
17	Cement upper,	Conveyor			49,50	2	24,8	93,9%	
18	Chamber 3	Chamber m/c							
19	Attach outsole,	Conveyor	55 + 3 °C Min		75,20	3	25,1	95,1%	
20	Universal press,	Vacum Pressing Machine	Pressure : 14-18 Kg/cm		24,59	1	24,6	93,3%	
21	Blower outsole,	Blower MC			25,63	1	25,6	97,3%	
22	Chiller	Chiller MC	10-15 °C Max						
23	Open lace and open last,	Open last			22,52	1	22,5	85,5%	
24	Cement & insert sockliner,	Rollhotmelt Sockliner			25,36	1	25,4	96,2%	
25	Rapikan tali,	Table			25,22	1	25,2	95,7%	
26	Cleaning shoes,	Table			21,26	1	21,3	80,7%	
27	Repaire shoes,	Table			22,62	1	22,6	85,8%	
28	Finishing inspection,	Table							
29	Metal detector	Metal Detector							
30	Insert paper,	Table			23,66	1	23,7	89,8%	
31	Inner box folding,	Table			22,26	1	22,3	84,5%	
32	Attach UPC,	Table			9,89	1	22,9	86,9%	
	Attach hang tag,	Table			13,00				
33	Wrapping,	Table			23,23	1	23,2	88,2%	
34	Packing,	Table			18,36	1	18,4	69,7%	
Assembly_ Total					750,3	33	26,4		

Line balancing

Assembly

86,3%

Ultra Bounce Stockfit + Precoating analysis		Stockfit		Worker/1320prs/16hr		MC/1320prs/16hr		
		Daily Target :	2560					
		Wokring Hour:	8					
		Takt Time	10,55	48		19		
No.	Process Name	Process condition	Chemical	CT/Prs	Worker	Adjusted	Available rate(%)	Remark
1	Buffing Rubber			19,29	2	9,6	95,0%	
2	Degreaser Imeva		WS-990	10,00	1	10,0	98,5%	
3	UV		UV P5-2NF	32,99	4	8,2	81,3%	
5	Input Imeva, Rubber, TPU			18,50	2	9,3	91,1%	
6	Cleaner TPU Stablizer		HC 800	11,00	3	9,5	93,3%	
	Cleaner Rubber		Cleaner M3	17,40				
7	Mini Chamber	Rubber : 50°C ~ 55°C / 35" - 45"						
		Stabilizer : 55°C ~ 60°C / 35" - 45"						
8	Primer Imeva Up and Bottom and Imeva for Stabilizer			19,32	2	9,7	95,2%	
	Primer Rubber			19,20	2	9,6	94,6%	
10	Chamber 1	Imeva : 50°C ~ 55°C / 1'.25" - 1'.35"						Chamber : 1.50 Cm
		Stabilizer : 50°C ~ 55°C / 1'.25" - 1'.35"						
		Rubber : 60°C ~ 65°C / 1'.25" - 1'.35"						
11	Cement TPU Stabilizer			18,50	2	9,25	91,1%	
12	Cement Imeva (Precoating)		HA SMA 1	19,24	2	9,62	94,8%	
	Cement Imeva For Stabilizer			19,20	2	9,60	94,6%	
14	Chamber 2	Imeva : 50°C ~ 55°C / 1'.25" - 1'.35"						Chamber : 1.50 Cm
		Stabilizer : 60°C ~ 65°C / 1'.25" - 1'.35"						
		Rubber : 60°C ~ 65°C / 1'.25" - 1'.35"						
15	Attaching stabilizer to Imeva			26,00	4	6,5	64,0%	
16	Primer Inside Stabilizer		TU 106 TF	19,60	2	9,8	96,6%	
17	Cement Imeva Bottom		HA -SMA 1 NEW	38,00	4	9,5	93,6%	
18	Cemment Rubber		WA 1 C	19,90	2	10,0	98,0%	WB roller Machine 2 Unit
19	Chamber 3	Imeva : 50°C ~ 55°C / 1'.25" - 1'.35"						Chamber : 1.50 Cm
		Rubber : 60°C ~ 65°C / 1'.25" - 1'.35"						
20	Attaching Imeva to Rubber			64,50	8	8,1	79,4%	
21		14 - 18 kg/cm2 / 10"-12"		18,00	2	9,0	88,7%	Universal Press [press : 2unit]
22	Clean Outsole			20,30	2	10,2	100,0%	
23	Qc Checking							
24	Metal Detector							
25	Packing			19,6	2	9,8	96,5%	
Stock fit_Total				430,5	48	10,2		

Line : 7

Line : 41

Line : 7

Line : 41

Line balancing	Stock fit
	88,4%
TARGET	320
PPH	6,67