



Date Modify				Picture (Upper)		Picture (Bottom)		
Model : Runfalcon 4.0		Season : FW24						
Status : CR2		Model ID : NKE45 Art: IG6247						
Upper ID		LC C2B	144.01					
EOLR	120	Total MP C2B						91
PPH (C2B)	1.32	Total WS						7
Efficiency C2B	81.8%	TCT C2B						2,065.96


1). IE DATA SUMMARY

C2B Process	Daily Target	WH	MC	EOLR	Total CT	LC COST	CT COST	GAP CT	MP	MP Conversion (120prs)	MP Conversion (60prs)	Last Modify Date
Cutting	960	8	-	120	41.76	18.78	290.15	248.39	2	2	1	
Sewing	960	8	-	120	845.98	61.47	949.71	103.73	37	37	18	
Assy	960	8	-	120	866.15	46.90	724.61	-141.55	39	39	20	
Stockfit	2,400	8	-	300	312.07	16.86	260.49	-51.58	33	13	7	
Sub Total			0		2,065.96	144.01	2,224.95	158.99	111	91	46	


Cutting

Cutting analysis RUNFALCON 4.0						Daily Target :		960	Worker/960prs/8hr		MC/960prs/8hr			
						Working Hour :		8	2		2			
						Takt Time :		28.1						
No	Component name	Picture	Subcont process	Material type	Machine	Pcs/Prs	Layer	Piece/ Cutting Die	Time/ Cutting die	CT/Prs	Capa 8hr/1shift	MC /Target	Actual MC/ Target	Available rate
1	Quarter Overlay		v	syn	hydraulic	2	2	1	6.96	7.0	969	0.99	2	99%
2	Quarter Reinf Medial		v	syn	hydraulic	2	4	1	6.96	3.5				
3	3 Stripes L/M		v	syn	hydraulic	12	4	6	6.96	3.5				
4	Heel Cap Lateral		v	syn	hydraulic	2	2	1	6.96	7.0				
5	Heel Cap Medial		v	syn	hydraulic	2	2	1	6.96	7.0				
6	Tongue Padding Top			syn	hydraulic	2	4	1	6.96	3.5	1939	0.50	1.0	50%
7	Collar Padding			syn	hydraulic	2	4	1	6.96	3.5				
8	Heel Counter			syn	hydraulic	2	4	1	6.96	3.5				
9	Heel Reinf			syn	hydraulic	2	4	1	6.96	3.5				
10	Recutting Heel Cap L/M			syn	Thompson									
						Leather :		9.67	Synthetic/Textile :		6.96	Engineered Mesh/Knit :		27.0


* Cutting time per die according to material type


Cutting																	
Cutting analysis RUNFALCON 4.0						Daily Target :		960		Worker/960prs/8hr		MC/960prs/8hr					
						Working Hour :		8		3		3					
						Takt Time :		28.1									
No	Component name	Picture	Subcont process	Material type	Machine	Pcs/Prs	Layer	Piece/ Cutting Die	Time/ Cutting die	CT/Prs	Capa 8hr/1shift	MC /Target	Actual MC/ Target	Available rate			
												1.11	3	56%			
1	Toe Box		v	syn	AutoCutting	2	4	1	6.96	3.5	862	1.11	2.0	56%			
2	Toe Box 2		v	syn	AutoCutting	2	4	1	6.96	3.5							
3	Vamp Accent		v	syn	AutoCutting	2	4	1	6.96	3.5							
4	Vamp		v	syn	AutoCutting	2	4	1	6.96	3.5							
5	Eyestay Lining Medial		v	syn	AutoCutting	2	4	1	6.96	3.5							
6	Eyestay Lining Lateral		v	syn	AutoCutting	2	4	1	6.96	3.5							
7	Collar Reinf Lateral		v	syn	AutoCutting	2	4	1	6.96	3.5							
8	Collar Reinf Medial		v	syn	AutoCutting	2	4	1	6.96	3.5							
9	Tongue Top		v	syn	AutoCutting	2	4	1	6.96	3.5							
10	Tongue Bottom			syn	AutoCutting	2	4	1	6.96	3.5	1939	0.50	1.0	50%			
11	Collar Lining			syn	AutoCutting	2	2	1	6.96	7.0							
12	Heel Tab			syn	AutoCutting	2	4	1	6.96	3.5							
13	Insole			syn	AutoCutting	2	4	1	6.96	3.5							
						Leather :		9.67		Synthetic/Textile :		6.96		Engineered Mesh/Knit :		27.0	

* Cutting time per die according to material type

Stitching											
Stitching analysis RUNFALCON 4.0			Daily Target :	960	Worker/480prs/8hr		Worker/960prs/8hr		MC/960prs/8hr		
			Wokring Hour:	8	13		7				
			Takt Time	28.1							
				56.3							
No.	Process Name	Machine	Q'ty/Prs			CT/Prs	Worker	Adjusted	Available rate(%)	Remark	
1	Printing Tongue	Printing								Subcont	
2	No Sew Vamp/Quarter	No Sew									
3	Gauge Vamp	Gauge Marking	2			26.65	2	27.3	99.4%		
4	Gauge Tongue Top	Gauge Marking	2			13					
5	Gauge Tongue Bottom	Gauge Marking	2			15.0					
6	Skiving Heel Counter	Skiving Mc	2			16.4	1	16.4	59.6%		
7	Stamping Size Label	Auto Size Label	2			13.4	0.5	26.8	97.6%	Central 2 Line 1 MP [1 Line 0.5]	
8	Cutting Laceloop	Auto Webbing	2			18.00	1	18.0	65.5%		
9	Stitch Laceloop to tongue bottom	Post 1N	2			20	1	20.0	72.7%		
10	Stitch tongue top with tonge bottom	Post 1N	2			23.5	1	23.5	85.5%		
11	Reverse tongue top and bottom than hammering	Hammering Mc	2			18	1	18.0	65.5%		
12	Stitch and turn tongue to tongue lining	Post 1N	2			26.50	1	26.5	96.4%		
13	Attach Tongue Padding to tongue and reverse	Table	2			55.00	2	27.5	100.0%		
14	Hammering Tongue	Hammering Mc	2			19.80	1	19.8	72.0%		
15	Stitch Tongue Edge	Post 1N	2			14.48	1	14.5	52.7%		
16	Stitch Tongue Laceloop	Post 1N	2			20.40	1	20.4	74.2%		
17	Stitch Collar Edge	Post 1N	2			21.00	1	21.0	76.4%		
Preparation sub_ Total						300.2	13.5	27.5			
17	Stitch and Turn Upper Lat with Upper Med	CS 1510	2	32.00	1	32.00	2	16.0	57.7%		
18	Cement and Hammering Quarter Lat/Med	Double Folded & Hammering	2	40.65	1	40.65	2	20.3	73.3%		
19	Attach heel reinf to heel patch	Table	2	8.80	2	8.80	4	27.5	99.2%		
20	Stitch Heel Patch to Upper	Post 1N	2	68.90		68.90		27.5	99.2%		
21	Hammering Heel Patch	Hammering Mc	2	16.20		16.20		20.5	73.9%		
22	Stitching collar lining to upper	Post 1N	2	45.70	1	45.70	2	22.9	82.4%		
23	Spray Upper and Attach TR Counter	Spray hot melt Mc	2	44.60	2	44.60	4	22.6	81.5%		
24	Spray Upper And Attach Collar Padding	Spray hot melt Mc	2	45.2		45.20		22.6	81.5%		
25	Reverse Collar Lining	Table	2	35.35	2	55.47	2	27.7	100.0%		
26	Hammering upper	Hammer Mc	2	20.12							
Stitching sub_ Total				357.52	8	357.5	16.0	27.7			
27	Pouching eyestay	Pouching mc	2	26	1	26.00	1	26.0	95.1%	Suggest Group Pouching	
28	Stitching tongue to upper	CS-1507	2	26.11	1	26.11	1	26.1	95.1%		
29	Stitching lasting margin	Posh 1N	2	27.1	1	27.10	1	27.1	95.5%		
30	Insert Shoe lace	Upper Clamp	2	82	2	82	3	27.3	99.1%		
31	Finishing Sewing	Table	2	27.1	1	27.1	1	27.1	100.0%	Ws	
Stitching sub_ Total				188.31	13	188.3	7	27.3			
Total				546	21	846	37	27.7			

Line balancing	Preparation	Stitching
	80.8%	100.0%

Assembly Runfalcon 4.0			Daily Target :		960	Worker/960prs/16hr		MC/480prs/16hr		
			Working Hour:		8	39		20		
			Takt Time		28.1					
No.	No Process	Process Name	Machine	Process condition	Chemical	CT/Prs	Worker	Adjusted	Available rate(%)	
1		Prepare Upper	Table			14.5	1	14.5	51.8%	
2		Back part molding,	BackpartMold Mc			25.0	1	25.0	89.3%	
3		Vamp Press	Vamp Press Mc			25.0	1	25.0	89.3%	
4		Stitch Ghatring	Gathering Mc			24.0	1	24.0	85.7%	
5		Stitch Strobel,	Strobel Mc			36.8	2	18.4	65.7%	
6		Prepare Laste	Hand Work			12.0	1	24.0	85.7%	Combine
7		Seting Laste to Upper	Hand Work			12.0				
8		Steam Upper	Steam Mc			8.0	1	8.0	28.6%	
9		Insert last,	Kabuki			28.0	1	8.2	29.3%	
10		Heel last,								
11		Strengthen lace,	Table			26.0	1	26.0	92.9%	
12		Setting Outsole	Table			26.0	1	26.0	92.9%	
13		Insert Soes Cover				14.2	1	14.2	50.7%	
14		Gauge marking,	Gauge Marking Mc			28.0	1	28.0	100.0%	
15		Hand Buffing	Buffing Mc			47.2	2	23.6	84.3%	
16		Cleaning Upper buffing area	Table			21.0	1	28.0	100.0%	
17		Transfer to conveyor,	Conveyor			7.0				
18		Chamber 1	Chamber m/c							
19		Primer upper,	Conveyor			67.4	3	22.5	80.2%	
20		Primer Oustole	Conveyor			38.6	2	19.3	68.9%	0
21		Chamber 2	Chamber m/c							
22		Cement upper,	Conveyor			52.8	2	26.4	94.3%	
23		Cement outsole	Conveyor			30.0	2	15.0	53.6%	
24		Chamber 3	Chamber m/c							
25		Attach outsole to upper	Conveyor			100.6	4	25.2	89.8%	High CT
26		Universal press,	Universal Press			24.6	1	24.6	87.8%	
27		Chiller	Chiller MC							
28		Open lace and open last,	Open last m/c			22.5	1	22.5	80.4%	
29		Cerment & insert sockliner,	Rollhotmelt Sockliner			25.4	1	25.4	90.6%	
30		Rapikan tali,	Table			25.2	1	25.2	90.1%	
31		Cleaning shoes,	Table			21.0	1	21.0	75.0%	
32		Finishing inspection,	Table							
33		Metal detector	Metal Detector							
34		Insert paper,	Table			23.0	1	23.0	82.1%	
35		Inner box folding,	Table			22.3	1	22.3	79.5%	
36		Attach UPC,	Table			9.9	1	22.9	81.8%	
37		Attach hang tag,	Table			13.0				
38		Wrapping,	Table			23.2	1	23.2	83.0%	
39		Packing,	Table			12.0	1	12.0	42.8%	
Assembly_Total						866.2	39	28.0		

Stockfit								
Stockfit Runfalcon 4.0		Daily Target :	2400	Worker/2400prs/16hr		MC/2400prs/16hr		
		Wokring Hour:	8	33		19		
		Takt Time	11.3					
No.	Process Name	Process condition	Chemical	CT/Prs	Worker	Adjusted	Available rate(%)	Remark
1	Buffing Rubber			19.80	2	9.9	89.6%	
2	Degresing			10.00	1	10.0	90.5%	
3	UV Imeva		P-5-2NF	32.99	4	8.2	74.6%	
4	Setting Base Imeva, Rubber			18.60	2	9.3	84.2%	
5	Cleaner Rubber		TNR-05	18.20	2	9.1	82.4%	
6	Chamber 1	Rubber : 55°C ~ 60°C / 50" ~ 60"						
7		Imeva : 50°C ~ 55°C / 50" ~ 60"						
8	Primer Rubber		PR-505A + 1.6% POWDER	19.40	2	9.7	87.8%	
9	Chamber 2	Rubber : 60°C ~ 65°C / 1'20" ~ 1'40"						
10		Imeva : 50°C ~ 55°C / 1'20" ~ 1'40"						
11	Cement Imeva		LB 5100 AU-2+5% UNIDURE 1001 RN	43.64	4	10.9	98.7%	
12	Cement Rubber		ROLLER COATER SW-07	24.96	4	6.2	56.5%	
13	Chamber 3	Rubber : 60°C ~ 65°C / 2'30" ~ 3'00"						
14		Imeva : 50°C ~ 55°C / 2'30" ~ 3'00"						
15	Attaching Rubber to Imeva			61.68	6	10.3	93.0%	High CT
16	Pressing	(Temp. During Pressing : Temp : 50± 2 0C Min) Up I : 20-25kg/cm², Up II : 30-35 kg/cm² Side/Toe Heel :35-40 kg/cm² Time : 10"-12"		22.10	2	11.1	100.0%	
17	Chiller	Temp : 10-15°C Max, Temp Surface : Max 30°C Time : 2'30"-3'00"						
18	Cleaning & Repair			20.10	2	10.1	91.0%	
19	QC Checking							
20	Metal Detector							
21	Packing			20.60	2	10.3	93.2%	
Stock fit_Total				312.1	33	11.1		



Line balancing	Stock fit
TARGET	300
	85.6%