Date Modify					Picture (Upper)	Pictur
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	ст 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	C	utting analysis RUNF	ALCON 4.0	)		Daily Target : Working Hour : Takt Time :		960 8 28.1	8 2		MC/960prs/8hr		(III)	
No	Component name	Picture	Subcont process	Material type	Machine	Pcs/Prs	Layer	Piece/ Cutting Die	Time/ Cutting die	CT/Prs	Capa 8hr/1shif t	MC /Target	Actual MC/ Target	Available rate
1	Quarter Overlay		v	syn	hydraulic	2	2	1	6.96	7.0				
2	Quarter Reinf Medial		v	syn	hydraulic	2	4	1	6.96	3.5				
3	3 Stripes L/M		٧	syn	hydraulic	12	4	6	6.96	3.5	969	0.99	1.0	99%
4	Heel Cap Lateral		٧	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				
7	Collar Padding			syn	hydraulic	2	4	1	6.96	3.5				
8	Heel Counter			syn	hydraulic	2	4	1	6.96	3.5	1939	0.50	1.0	50%
9	Heel Reinf			syn	hydraulic	2	4	1	6.96	3.5				
10	Recutting Heel Cap L/M			syn	Thompson									
							Leather :	9.67	Syntheti	c/Textile :	6.96	ngineered	Mesh/Knit :	27.0

<sup>\*</sup> Cutting time per die according to material type

Cutting						D-:	l T	0/0	W/== -==/0	/ O /Oh	MC/0/0	/0b-		
	·	utting analysis RUNFA	1 CON 4 C	<b>,</b>			ly Target : king Hour :	960 8		60prs/8hr	MC/960			
		uttilig allatysis KONI F	LCON 4.0	•			akt Time :	28.1	;	3	;	3		
No	Component name	Picture	Subcont process	Material type	Machine	Pcs/Prs	Layer	Piece/ Cutting Die	Time/ Cutting die	CT/Prs	Capa 8hr/1shif t	MC /Target	Actual MC/ Target	Available rate 56%
1	Toe Box		V	syn	AutoCutting	2	4	1	6.96	3.5				
2	Toe Box 2		٧	syn	AutoCutting	2	4	1	6.96	3.5				
3	Vamp Accent		٧	syn	AutoCutting	2	4	1	6.96	3.5				
4	Vamp		٧	syn	AutoCutting	2	4	1	6.96	3.5				
5	Eyestay Lining Medial		٧	syn	AutoCutting	2	4	1	6.96	3.5	862	1.11	2.0	56%
6	Eyestay Lining Lateral		٧	syn	AutoCutting	2	4	1	6.96	3.5				
7	Collar Reinf Lateral		>	syn	AutoCutting	2	4	1	6.96	3.5				
8	Collar Reinf Medial		>	syn	AutoCutting	2	4	1	6.96	3.5				
9	Tongue Top		٧	syn	AutoCutting	2	4	1	6.96	3.5				
10	Tongue Bottom			syn	AutoCutting	2	4	1	6.96	3.5				
11	Collar Lining			syn	AutoCutting	2	2	1	6.96	7.0	1939	0.50	1.0	50%
12	Heel Tab			syn	AutoCutting	2	4	1	6.96	3.5	1737	0.30	1.0	3070
13	Insole			syn	AutoCutting	2	4	1	6.96	3.5				
							Leather :	9.67	Syntheti	c/Textile :	6.96	ngineered	Mesh/Knit :	27.0

<sup>\*</sup> Cutting time per die according to material type

Stitch	hing									
		Daily Target :	960	Worker/	480prs/8hr	Worker/9	50prs/8hr	MC/960	ors/8hr	
		Wokring Hour:	8							
	Stitching analysis RUNFALCON 4.0		28.1		13	7				
		Takt Time	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								Subcont
3	Gauge Vamp	Gauge Marking	2			26.65				
4	Gauge Tongue Top	Gauge Marking	2			13	2	27.3	99.4%	
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		8.80		27.5	99.2%	
20	Stitch Heel Patch to Upper	Post 1N	2	68.90	2	68.90	4	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	2	45.20	4	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		33.47	2	21.1	100.0%	
	Stitching sub_T	otal	•	357.52	8	357.5	16.0	27.7		
27	Pounching eyestay	Pounching mc	2	26	1	26.00	1	26.0	95.1%	Suggest Group Pounching
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_1	otal		188.31	13	188.3	7	27.3		
	Total			546	21	846	37	27.7		

	040	3/	21.1	
	Line hal	ncina	Preparation	Stitching
Line balancing			80.8%	100.0%

March   Mar	Assembly	/									
Process Name		As	sembly Runfalcon 4.0	Working	Hour:	960 8					
Process   Proc			<b>,</b>	Takt Ti	me	28.1	3	9	2		
Bick part molding	No.		Process Name	Machine	Process condition	Chemical	CT/Prs	Worker	Adjusted		Remark
Vamp Press   Vamp Press Me   25.0   1.1   25.0   89.3%	1		Prepare Upper	Table			14.5	1	14.5	51.8%	
Section Chartering   Grantmering Me   24.0   24.0   25.0   15.0   55.7%	2		Back part molding,	BackpartMold Mc			25.0	1	25.0	89.3%	
Sitich Stroebel,   Stroebelk   Hand Work	3		Vamp Press	Vamp Press Mc			25.0	1	25.0	89.3%	
Proper Laste   Hand Work	4		Stitch Ghatring	Ghathering Mc			24.0	1	24.0	85.7%	
Sating Laste to Upper	5		Stitch Strobel,	Strobel Mc			36.8	2	18.4	65.7%	
Setting Laste to Upper	6		Prepare Laste	Hand Work			12.0	1	26.0	85.7%	Combine
Primer upper	7		Seting Laste to Upper	Hand Work			12.0		24.0	03.770	Combine
Heel Last,	8		Steam Upper	Steam Mc			8.0	1	8.0	28.6%	
10	9		Insert last,	Kabuki			20.0	1	0.2	20.20/	
Table   Setting Outsole   Table   Cause Marking Mc   Sauge Marking Mc   Sauge marking,   Gauge Marking Mc   Sauge marking,   Gauge Marking Mc   Sauge marking,   Sauge Marking Mc   Sauge marking,   Sauge Marking Mc   Sauge marking,   Sauge Marking Mc   Sauge Marking Markin	10		Heel last,	Nabuki			20.0	'	0.2	27.370	
Table   Tabl	11		Strengthen lace,	Table			26.0	1	26.0	92.9%	
13	12		Setting Outsole	Toble			26.0	1	26.0	92.9%	
Hand Buffing   Buffing Mc   A7.2   2   23.6   84.3%	13		Insert Soes Cover	- Table			14.2	1	14.2	50.7%	
Cleaning Upper buffing area   Table   21.0   1   28.0   100.0%	14		Gauge marking,	Gauge Marking Mc			28.0	1	28.0	100.0%	
Transfer to conveyor, Conveyor 7.0 1 28.0 100.0%  Transfer to conveyor, Conveyor 7.0 1 28.0 100.0%  Primer upper, Conveyor 8.67.4 3 22.5 80.2%  Primer Dustole Conveyor 8.67.4 3 22.5 80.2%  Chamber 2 Chamber m/c 8.7 2 19.3 68.9%  Cement outsole Conveyor 8.52.8 2 26.4 94.3%  Cement outsole Conveyor 9.52.8 2 26.4 94.3%  Cement outsole Conveyor 9.52.8 2 26.4 94.3%  Chamber 3 Chamber m/c 9.7 100.6 4 25.2 89.8% High CT 9.7 100.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor 1.00.6 89.8% Primer sould be a second of the conveyor sould be a	15		Hand Buffing	Buffing Mc			47.2	2	23.6	84.3%	
Transfer to conveyor,   Conveyor   7.0	16		Cleaning Upper buffing area	Table			21.0			400.00/	
Primer upper,   Conveyor   38.6   2   19.3   68.9%   0	17		Transfer to conveyor,	Conveyor			7.0	'	28.0	100.0%	
Primer Oustole	18		Chamber 1	Chamber m/c							
Chamber 2   Chamber m/c	19		Primer upper,	Conveyor			67.4	3	22.5	80.2%	
Cement upper,   Conveyor	20		Primer Oustole	Conveyor			38.6	2	19.3	68.9%	0
Cement outsole	21		Chamber 2	Chamber m/c							
24         Chamber 3         Chamber m/c         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         22.5         1         22.5         80.4%           29         Cement & 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         21.0         1         21.0         75.0%           33         Metal detector         Metal Detector         3         1         23.0         82.1%           34         Insert paper,         Table         22.3         1         22.3         79.5%           35         Inner box folding,         Table         9.9         1         22.3         79.5%           36         Attach UPC,         Table         9.9         1         22.9         81.8% <td>22</td> <td></td> <td>Cement upper,</td> <td>Conveyor</td> <td></td> <td></td> <td>52.8</td> <td>2</td> <td>26.4</td> <td>94.3%</td> <td></td>	22		Cement upper,	Conveyor			52.8	2	26.4	94.3%	
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       Chiller MC       Coment & Section of the Company of the Com	23		Cement outsole	Conveyor			30.0	2	15.0	53.6%	
26   Universal press,   Universal Press   24.6   1   24.6   87.8%	24		Chamber 3	Chamber m/c							
27         Chiller         Chiller MC         22.5         1         22.5         80.4%           28         Open lace and open last,         Open last m/c         22.5         1         22.5         80.4%           29         Cement & 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         21.0         1         21.0         75.0%           33         Metal detector         Metal Detector         Image: Company of the compan	25		Attach outsole to upper	Conveyor			100.6	4	25.2	89.8%	High CT
28         Open lace and open last,         Open last m/c         22.5         1         22.5         80.4%           29         Cement & 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         2         2         1         22.0         75.0%           33         Metal detector         Metal Detector         2         2         2         1         23.0         82.1%           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         1         23.2         83.0%           38         Wrapping,         Table         23.2         1 <t< td=""><td>26</td><td></td><td>Universal press,</td><td>Universal Press</td><td></td><td></td><td>24.6</td><td>1</td><td>24.6</td><td>87.8%</td><td></td></t<>	26		Universal press,	Universal Press			24.6	1	24.6	87.8%	
29         Cement & 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         20.0         1         21.0         75.0%           33         Metal detector         Metal Detector         23.0         1         23.0         82.1%           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         1         23.2         83.0%           38         Wrapping,         Table         23.2         1         23.2         83.0%           39         Packing,         Table         12.0         1         12.0         42.8%	27		Chiller	Chiller MC							
Rapikan tali,   Table   25.2   1   25.2   90.1%	28		Open lace and open last,	Open last m/c			22.5	1	22.5	80.4%	
Cleaning shoes,   Table   21.0   1   21.0   75.0%	29		Cement & insert sockliner,	Rollhotmelt Sockliner			25.4	1	25.4	90.6%	
Finishing inspection,   Table	30		Rapikan tali,	Table			25.2	1	25.2	90.1%	
Metal detector   Metal Detector   23.0   1   23.0   82.1%	31		Cleaning shoes,	Table			21.0	1	21.0	75.0%	
Insert paper,   Table   23.0   1   23.0   82.1%	32		Finishing inspection,	Table							
Inner box folding,   Table   22.3   1   22.3   79.5%	33		Metal detector	Metal Detector							
36     Attach UPC,     Table     9.9     1     22.9     81.8%       37     Attach hang tag,     Table     13.0     1     23.2     1     23.2     83.0%       38     Wrapping,     Table     23.2     1     23.2     83.0%       39     Packing,     Table     12.0     1     12.0     42.8%	34		Insert paper,	Table			23.0	1	23.0	82.1%	
37     Attach hang tag,     Table     13.0     1 22.9     81.8%       38     Wrapping,     Table     23.2     1 23.2     83.0%       39     Packing,     Table     12.0     1 12.0     42.8%	35		Inner box folding,	Table			22.3	1	22.3	79.5%	
37     Attach hang tag,     Table     13.0	36		Attach UPC,	Table			9.9		05.7	04.77	
39 Packing, Table 12.0 1 12.0 42.8%	37		Attach hang tag,	Table		İ	13.0	1	22.9	81.8%	
39 Packing, Table 12.0 1 12.0 42.8%	38		Wrapping,	Table			23.2	1	23.2	83.0%	
Assembly_Total 866.2 39 28.0	39			Table		İ	12.0	1	12.0	42.8%	
			As	sembly_Total		1	866.2	39	28.0		

			Stockfit					
		Daily Target :	2400	Worker/24	00prs/16hr	MC/240	Oprs/16hr	
	Stockfit Runfalcon 4.0	Wokring Hour:	8					
		Takt Time	11.3	3	33	Í	19	
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   : 20-25kg/cm², Up     : 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 belonding	Stock fit 85.6%					
Line balancing						
TARGET	300					