120 OSA

FTY Name	**PWJ**
Model Name	**Duramo 10 MW**
Season	**FW21**
Model ID	**LWO08**
Upper ID	**GW8347**
Forecast (Pairs)	
Latest Update	**August 6Th, 2021**
Inline EOLR	**120**
LC CTB	**130.26**
LB Efficiency	**82.0%**
Theoritical CT Efficiency	**97.5%**
LLER	**82%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Leather Central	30.6	240	3	2	80	68%
Pre-coating Insole Central	5.2	2260	4	0.2	565	82%
STOCKFITTING - Buffing	15.4	300	2	0.8	150	64%
STOCKFITTING - Degreaser	15.5	1200	6	0.6	200	86%
STOCKFITTING - UV Light	48.4	800	14	2.1	57	77%
STOCKFITTING - Attaching Rubber to	302.7	300	31	12.4	10	81%
Cutting Inline	57.3	120	3	3	40	64%
Preparation	341.6	120	13	13	9	88%
Sewing	281.1	120	11	11	11	85%
Assembly	687.4	120	28	28	4	82%
SUBTOTAL	**1785.2**	**120**		**73**	**1.65**	**82%**
Water Spider		120		9		
TOTAL Incl WS		**120**		**82**	**1.47**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydrolic	1	Cutting Vamp Accent,	4.4	0.1	3	189	64%
			2	Cutting Eyestay Top L/M	4.2	0.1			
			3	Cutting 3 Stripe,	6.0	0.2			
			4	Cutting Heelcap Backer	4.3	0.1			
			5	Cutting eyestay reinf,	4.8	0.2			
			6	Cutting eyestay lower	4.2	0.1			
			7	Cutting Heelcap Foam Bottom	4.5	0.2			
			8	Cutting Heelcap foam Top	4.6	0.2			
			9	Cutting Collar Padding,	5.0	0.2			
			10	Cutting Heel Counter,	5.1	0.2			
			11	Cutting Toebox,	4.6	0.2			
			12	Cutting Heelcap Reinf	4.2	0.1			
			13	Cutting Heelcap	5.5	0.2			
TOTAL					**57.3**	**2**	**3**	**189**	**64%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Skiving Counter	1	Skiving Heel Counter,	13.4	0.4	0.5	135	89%
		Auto size label	2	Stamping Size Label	14.3	0.5	0.5	126	95%
		CS 6040	3	Stitch Tongue Overlay to Tongue,	28.3	0.9	1	127	94%
		CS 6040	4	Stitch Tongue to Tongue Lining,	19.1	0.6	1	130	92%
		Tongue Forming	5	Tongue Reverse,	8.5	0.3			
		Flat 1N	6	Stitch Tongue Overlay (Laceloop Side),	8.4	0.3	1	164	73%
		Flat 1N	7	Attach and Stitch Eyestay Laceloop to Tongue,	13.5	0.5			
		Flat 1N	8	Stitch Tongue Edge,	26.5	0.9	1	136	88%
		Flat 1N	9	Stitching Lasting Margin,	25.0	0.8	1	144	83%
		Table	10	Gauge Heelcap Area	28.5	1.0	1	126	95%
		Post 1N	11	Stitch & Turn Heel and Quarter (Medial Area)	55.1	1.8	2	131	92%
		Manual	12	Cementing & Folded after Stitch	28.5	1.0	1	126	95%
		Hammering MC	13	Hammering Heel (Medial Area)	29.0	1.0	1	124	97%
		Post 1N	14	Stitch Heel Counter to Upper,	18.5	0.6	1	195	62%
		Flat 1N	15	Stich Collar Lining Edge,	24.9	0.8	1	130	92%
TOTAL					**341.6**	**11.4**	**13**	**124**	**88%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitching Collar Lining to Upper,	49.1	1.6	2	147	82%
		Spray & Hammering Mc	2	Spray on Collar Padding Area (Use Jig Spray),	10.4	0.3	2	148	81%
			3	Spray on Collar Padding Area (Use Jig Spray),	12.8	0.4			
			4	Reserve Collar lining,	19.1	0.6			
			5	Hammering,	6.5	0.2			
		Post 1N	6	Stitch Lock Collar Linning,	27.4	0.9	1	132	91%
		Pounching Mc	7	Upper Pounching,	53.0	1.8	2	136	88%
		CS 1510	8	Stitching Tongue to Upper,	26.4	0.9	1	136	88%
		Upper Clamp	10	Insert Shoe Lace,	76.4	2.5	3	141	85%
TOTAL					**281.1**	**9**	**11**	**132**	**85%**

EOLR	WS	Deffinition	TT
120	2		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM Mc	1	Back Part Molding,	28.1	0.9	1	128	94%
		Vamp Press Mc	2	Vamp Molding,	28.2	0.9	1	127	94%
		Strobel Mc	3	Stitch Strobel,	48.3	1.6	2	149	80%
		Table	4	Setting Last,	18.5	0.6	1	195	62%
		Kabuki	5	Insert Last,	16.3	0.5	1	126	95%
		Heel last Mc	6	Heel Lasting,	12.3	0.4			
		Table	7	Tightening Lace,	28.6	1.0	1	126	95%
		Rak outsole	8	Prepare Outsole,	20.4	0.7	1	176	68%
		Gauge Marking Mc	9	Sole Gauge Marking,	28.4	0.9	1	127	95%
		Table	10	Toe Gauge,	28.5	1.0	1	126	95%
		Conveyor Mc	11	Transfer to Conveyor,	9.1	0.3	1	122	99%
		Conveyor Mc	12	Cleaner Upper,	20.4	0.7			
		Chamber Mc	13	Chamber 1	29.2				
		Conveyor Mc	14	Primer Upper,	49.1	1.6	2	147	82%
		Conveyor Mc	15	Primer Outsole,	24.9	0.8	1	145	83%
		Chamber Mc	16	Chamber 2	29.2				
		Conveyor Mc	17	Cement Outsole,	24.0	0.8	1	150	80%
		Chamber Mc	18	Chamber 3	29.2				
		Conveyor Mc	19	Attaching Outsole,	64.2	2.1	3	168	71%
		Universal Press Mc	20	Universal Press,	21.6	0.7	1	167	72%
		Blowing Mc	21	Blowing Outsole	22.0	0.7	1	164	73%
		Chiller Mc	22	Chiller	25.1				
		Open laste Mc	23	Open Lace & Open Laste,	26.5	0.9	1	136	88%
		Table	24	Hotmelt Sockliner,Insert Sockliner,	26.6	0.9	1	135	89%
		Table	25	Finishing	53.5	1.8	2	135	89%
		Table	26	Inspection,	27.2				
		Metal Detector Mc	27	Metal detector	5.0				
		Table	28	Innerbox Folding,	8.5	0.3	1	142	85%
		Table	29	Insert Paper,	16.9	0.6			
		Table	30	Attach UPC,	6.2	0.2	1	193	62%
		Table	31	Attach Hantag,	12.4	0.4			
		Table	32	Wrapping Shoe,	23.3	0.8	1	155	78%
		Table	33	Final Packing,	20.5	0.7	1	176	68%
TOTAL					**687.4**	**23**	**28**	**122**	**82%**

EOLR	WS	Deffinition	TT
120	2.5		30.0

120 NON OSA

FTY Name	**PWJ**
Model Name	**Duramo 10 MW**
Season	**FW21**
Model ID	**LWO08**
Upper ID	**GW8347**
Forecast (Pairs)	
Latest Update	**August 6Th, 2021**
Inline EOLR	**120**
LC CTB	**130.26**
LB Efficiency	**82.9%**
Theoritical CT Efficiency	**99.8%**
LLER	**81%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Leather Central	30.6	240	3	2	80	68%
Pre-coating Insole Central	5.2	2260	4	0.2	565	82%
STOCKFITTING - Buffing	15.4	300	2	0.8	150	64%
STOCKFITTING - Degreaser	15.5	1200	6	0.6	200	86%
STOCKFITTING - UV Light	48.4	800	14	2.1	57	77%
STOCKFITTING - Attaching Rubber to	302.7	300	31	12.4	10	81%
Cutting Inline	57.3	120	3	3	40	64%
Preparation	322.4	120	13	13	9	83%
Sewing	252.3	120	10	10	12	84%
Assembly	687.4	120	28	28	4	82%
SUBTOTAL	**1737.1**	**120**		**72**	**1.68**	**81%**
Water Spider		120		9		
TOTAL Incl WS		**120**		**81**	**1.48**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydrolic	1	Cutting Vamp Accent,	4.4	0.1	3	189	64%
			2	Cutting Eyestay Top L/M	4.2	0.1			
			3	Cutting 3 Stripe,	6.0	0.2			
			4	Cutting Heelcap Backer	4.3	0.1			
			5	Cutting eyestay reinf,	4.8	0.2			
			6	Cutting eyestay lower	4.2	0.1			
			7	Cutting Heelcap Foam Bottom	4.5	0.2			
			8	Cutting Heelcap foam Top	4.6	0.2			
			9	Cutting Collar Padding,	5.0	0.2			
			10	Cutting Heel Counter,	5.1	0.2			
			11	Cutting Toebox,	4.6	0.2			
			12	Cutting Heelcap Reinf	4.2	0.1			
			13	Cutting Heelcap	5.5	0.2			
TOTAL					**57.3**	**2**	**3**	**189**	**64%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Skiving Counter	1	Skiving Heel Counter,	13.4	0.4	0.5	135	89%
		Auto size label	2	Stamping Size Label	14.3	0.5	0.5	126	95%
		CS 6040	3	Stitch Tongue Overlay to Tongue,	28.3	0.9	1	127	94%
		CS 6040	4	Stitch Tongue to Tongue Lining,	19.1	0.6	1	130	92%
		Tongue Forming	5	Tongue Reverse,	8.5	0.3			
		Flat 1N	6	Stitch Tongue Overlay (Laceloop Side),	8.4	0.3	1	164	73%
			7	Attach and Stitch Eyestay Laceloop to Tongue,	13.5	0.5			
		Flat 1N	8	Stitch Tongue Edge,	26.5	0.9	1	136	88%
		Flat 1N	9	Stich Collar Lining Edge,	8.4	0.3	1	427	28%
		Pounching Mc	10	Upper Pounching #1	24.3	0.8	1	148	81%
		Flat 1N	11	Stitch Lasting Margin, Edge Vamp & Heelcap	26.4	0.9	1	136	88%
		Post 1N	12	Stitch & Turn Heel and Quarter (Medial Area)	55.1	1.8	2	131	92%
		Manual	13	Cementing & Folded after Stitch	28.5	1.0	1	126	95%
		Hammering MC	14	Hammering Heel (Medial Area)	29.0	1.0	1	124	97%
		Post 1N	15	Stitch Heel Counter to Upper,	18.5	0.6	1	195	62%
TOTAL					**322.4**	**10.7**	**13**	**124**	**83%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitching Collar Lining to Upper,	49.1	1.6	2	147	82%
		Spray & Hammering Mc	2	Spray on Collar Padding Area (Use Jig Spray),	10.4	0.3	2	148	81%
			3	Spray on Collar Padding Area (Use Jig Spray),	12.8	0.4			
			4	Reserve Collar lining,	19.1	0.6			
			5	Hammering,	6.5	0.2			
		Post 1N	6	Upper Pounching #2	26.5	0.9	1	136	88%
		Pounching Mc	7	Stitching Tongue to Upper,	26.4	0.9	1	136	88%
		CS 1510	8	Stitching Lasting Margin,	25.0	0.8	1	144	83%
		Upper Clamp	12	Insert Shoe Lace,	76.4	2.5	3	141	85%
TOTAL					**252.3**	**8**	**10**	**136**	**84%**

EOLR	WS	Deffinition	TT
120	2		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM Mc	1	Back Part Molding,	28.1	0.9	1	128	94%
		Vamp Press Mc	2	Vamp Molding,	28.2	0.9	1	127	94%
		Strobel Mc	3	Stitch Strobel,	48.3	1.6	2	149	80%
		Table	4	Setting Last,	18.5	0.6	1	195	62%
		Kabuki	5	Insert Last,	16.3	0.5	1	126	95%
		Heel last Mc	6	Heel Lasting,	12.3	0.4			
		Table	7	Tightening Lace,	28.6	1.0	1	126	95%
		Rak outsole	8	Prepare Outsole,	20.4	0.7	1	176	68%
		Gauge Marking Mc	9	Sole Gauge Marking,	28.4	0.9	1	127	95%
		Table	10	Toe Gauge,	28.5	1.0	1	126	95%
		Conveyor Mc	11	Transfer to Conveyor,	9.1	0.3	1	122	99%
		Conveyor Mc	12	Cleaner Upper,	20.4	0.7			
		Chamber Mc	13	Chamber 1	29.2				
		Conveyor Mc	14	Primer Upper,	49.1	1.6	2	147	82%
		Conveyor Mc	15	Primer Outsole,	24.9	0.8	1	145	83%
		Chamber Mc	16	Chamber 2	29.2				
		Conveyor Mc	17	Cement Outsole,	24.0	0.8	1	150	80%
		Chamber Mc	18	Chamber 3	29.2				
		Conveyor Mc	19	Attaching Outsole,	64.2	2.1	3	168	71%
		Universal Press Mc	20	Universal Press,	21.6	0.7	1	167	72%
		Blowing Mc	21	Blowing Outsole	22.0	0.7	1	164	73%
		Chiller Mc	22	Chiller	25.1				
		Open laste Mc	23	Open Lace & Open Laste,	26.5	0.9	1	136	88%
		Table	24	Hotmelt Sockliner,Insert Sockliner,	26.6	0.9	1	135	89%
		Table	25	Finishing	53.5	1.8	2	135	89%
		Table	26	Inspection,	27.2				
		Metal Detector Mc	27	Metal detector	5.0				
		Table	28	Innerbox Folding,	8.5	0.3	1	142	85%
		Table	29	Insert Paper,	16.9	0.6			
		Table	30	Attach UPC,	6.2	0.2	1	193	62%
		Table	31	Attach Hantag,	12.4	0.4			
		Table	32	Wrapping Shoe,	23.3	0.8	1	155	78%
		Table	33	Final Packing,	20.5	0.7	1	176	68%
TOTAL					**687.4**	**23**	**28**	**122**	**82%**

EOLR	WS	Deffinition	TT
120	2.5		30.0

60 NON OSA

FTY Name	**PWJ**
Model Name	**Duramo 10 MW**
Season	**FW21**
Model ID	**LWO08**
Upper ID	**GW8347**
Forecast (Pairs)	
Latest Update	**August 6Th, 2021**
Inline EOLR	**60**
LC CTB	**130.26**
LB Efficiency	**77.8%**
Theoritical CT Efficiency	**104.4%**
LLER	**77%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Leather Central	30.6	240	3	1	80	68%
Pre-coating Insole Central	5.2	2260	4	0.1	565	82%
STOCKFITTING - Buffing	15.4	300	2	0.4	150	64%
STOCKFITTING - Degreaser	15.5	1200	6	0.3	200	86%
STOCKFITTING - UV Light	48.4	800	14	1.1	57	77%
STOCKFITTING - Attaching Rubber to	302.7	300	31	6.2	10	81%
Cutting Inline	57.3	240	5	1	48	76%
Preparation	341.6	240	26	6	9	89%
Sewing	254.6	60	6	6	10	71%
Assembly	716.1	60	16	16	4	75%
SUBTOTAL	**1787.4**	**60**		**38**	**1.56**	**77%**
Water Spider		60		5		
TOTAL Incl WS		**60**		**43**	**1.39**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydrolic	1	Cutting Vamp Accent,	4.4	0.3	5	314	76%
			2	Cutting Eyestay Top L/M	4.2	0.3			
			3	Cutting 3 Stripe,	6.0	0.4			
			4	Cutting Heelcap Backer	4.3	0.3			
			5	Cutting eyestay reinf,	4.8	0.3			
			6	Cutting eyestay lower	4.2	0.3			
			7	Cutting Heelcap Foam Bottom	4.5	0.3			
			8	Cutting Heelcap foam Top	4.6	0.3			
			9	Cutting Collar Padding,	5.0	0.3			
			10	Cutting Heel Counter,	5.1	0.3			
			11	Cutting Toebox,	4.6	0.3			
			12	Cutting Heelcap Reinf	4.2	0.3			
			13	Cutting Heelcap	5.5	0.4			
TOTAL					**57.3**	**4**	**5**	**314**	**76%**

EOLR	WS	Deffinition	TT
240	0.5		15.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Skiving Counter	1	Skiving Heel Counter,	13.4	0.9	0.9	242	99%
		Auto size label	2	Stamping Size Label	14.3	1.0	1	252	95%
		CS 6040	3	Stitch Tongue Overlay to Tongue,	28.3	1.9	2	254	94%
		CS 6040	4	Stitch Tongue to Tongue Lining,	19.1	1.3	2	261	92%
		Tongue Forming	5	Tongue Reverse,	8.5	0.6			
		Flat 1N	6	Stitch Tongue Overlay (Laceloop Side),	8.4	0.6	2	328	73%
		Flat 1N	7	Attach and Stitch Eyestay Laceloop to Tongue,	13.5	0.9			
		Flat 1N	8	Stitch Tongue Edge,	26.5	1.8	2	272	88%
		Flat 1N	9	Stitching Lasting Margin,	25.0	1.7	2	288	83%
		Table	10	Gauge Heelcap Area	28.5	1.9	2	253	95%
		Post 1N	11	Stitch & Turn Heel and Quarter (Medial Area)	55.1	3.7	4	261	92%
		Manual	12	Cementing & Folded after Stitch	28.5	1.9	2	253	95%
		Hammering MC	13	Hammering Heel (Medial Area)	29.0	1.9	2	248	97%
		Post 1N	14	Stitch Heel Counter to Upper,	18.5	1.2	2	389	62%
		Flat 1N	15	Stich Collar Lining Edge,	24.9	1.7	2	246	98%
TOTAL					**341.6**	**22.8**	**26**	**242**	**89%**

EOLR	WS	Deffinition	TT
240	0.5		15.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitching Collar Lining to Upper,	49.1	0.8	1	73	82%
		Spray & Hammering Mc	2	Spray on Collar Padding Area (Use Jig Spray),	10.4	0.2	1	74	81%
			3	Spray on Collar Padding Area (Use Jig Spray),	12.8	0.2			
			4	Reserve Collar lining,	19.1	0.3			
			5	Hammering,	6.5	0.1			
		Pounching Mc	6	Upper Pounching #2	26.5	0.4	1	136	44%
		Post 1N	7	Stitch Lock Collar Linning,	27.4	0.5	1	67	90%
		CS 1510	8	Stitching Tongue to Upper,	26.4	0.4			
		Upper Clamp	9	Insert Shoe Lace,	76.4	1.3	2	94	64%
TOTAL					**254.6**	**4**	**6**	**67**	**71%**

EOLR	WS	Deffinition	TT
60	1		60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM Mc	1	Back Part Molding,	28.1	0.5	1	64	94%
		Vamp Press Mc	2	Vamp Molding,	28.2	0.5			
		Strobel Mc	3	Stitch Strobel,	48.3	0.8	1	75	80%
		Table	4	Setting Last,	18.5	0.3	1	76	78%
		Kabuki	5	Insert Last,	16.3	0.3			
		Heel last Mc	6	Heel Lasting,	12.3	0.2			
		Table	7	Tightening Lace,	28.6	0.5	1	73	82%
		Rak outsole	8	Prepare Outsole,	20.4	0.3			
		Gauge Marking Mc	9	Sole Gauge Marking,	28.4	0.5	1	63	95%
		Table	10	Toe Gauge,	28.5	0.5			
		Table	11	Primer Upper,	49.1	0.8	1	73	82%
		Table	12	Primer Outsole,	24.9	0.4	1	145	41%
		Rotary Chamber	13	Chamber 1	29.2				
		Table	14	Cement Upper,	58.3	1.0	1	62	97%
			15	Cement Outsole,	24.0	0.4	1	150	40%
		Rotary Chamber	16	Chamber 2	29.2				
		Table	17	Attaching Outsole,	64.2	1.1	2	112	54%
		Universal Press Mc	18	Universal Press,	21.6	0.4	1	83	73%
		Blowing Mc	19	Blowing Outsole	22.0	0.4			
		Chiller Mc	20	Chiller	25.1				
		Open laste Mc	21	Open Lace & Open Laste,	26.5	0.4	1	68	89%
		Table	22	Hotmelt Sockliner,Insert Sockliner,	26.6	0.4			
		Table	23	Finishing	53.5	0.9	1	67	89%
		Table	24	Inspection,	27.2				
		Metal Detector Mc	25	Metal detector	5.0				
		Table	26	Innerbox Folding,	8.5	0.1	1	82	73%
		Table	27	Insert Paper,	16.9	0.3			
		Table	28	Attach UPC,	6.2	0.1			
		Table	29	Attach Hantag,	12.4	0.2			
		Table	30	Wrapping Shoe,	23.3	0.4	1	82	73%
		Table	31	Final Packing,	20.5	0.3			
TOTAL					**716.1**	**12**	**16**	**62**	**75%**

EOLR	WS	Deffinition	TT
60	1.25		60.0