120 OSA

FTY Name	PWJ
Model Name	Duramo SL
Season	FW21
Model ID	LEC86
Upper ID	53395
Forecast (Pairs)	30026
Latest Update	JUNE 18th, 2021
Inline EOLR	120
LC CTB	141.50
LB Efficiency	87.1%
Theoritical CT Efficiency	116.4%
LLER	84%

Module	TCT Module	EOLR Module	MP Module	MP Module conversio	PPH	LLER
Cutting Auto	28.4	240	2	1	120	95%
Pre-coating Insole Central	2.7	2400	2	0	1200	90%
Stockfitting - Buffing	18.4	300	2	1	150	77%
Stockfitting - Degreaser	15.5	1200	6	1	200	86%
Stockfitting - UV Light	51.2	800	14	2	57	81%
Stockfitting - Attaching	315.0	300	30	12	10	87%
Cutting Inline	78.0	120	3	3	40	87%
Preparation	252.8	120	11	11	11	77%
Sewing	417.3	120	16	16	8	87%
Assembly	698.8	120	28	28	4	83%
SUBTOTAL	1878.0	120		75	1.61	84%
Water Spider		120		9		
TOTAL Incl WS		120		84	1.43	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		1	Cutting Vamp/Quarter Top,	5.22	0.17				
			2	Cutting Vamp/Quarter Bottom,	18.15	0.61			
			3	Cutting Collar Padding,	4.82	0.16			
			4	Cutting Eyestay Reinf Lat,	3.51	0.12			87%
	CUTTING INLINE 0.15		5	Cutting Eyestay Reinf Med,	3.51	0.12			
CULTING INLINE		Hydrolic Mc	6	Cutting Heel Counter	2.74	0.09	3.00	138	
COTTING INLINE	0.15		7	Cutting Toe Cap,	5.84	0.19			
			8	Cutting Mudguard Overlay Lat,	8.27	0.28			
			9	Cutting Mudguard Overlay Med,	8.27	0.28			
			10	Cutting Eyestay Lower,	7.83	0.26			
			11	Cutting 3 Stripes Lat,	4.94	0.16			
			12	Cutting 3 Stripes Med,	4.94	0.16			
	TOTAL							138	87%
	EOLR WS Deffinition						•		•

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AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Skiving Counter Mc	1	Skiving Heel Counter,	13.88	0.46	0.50	130	93%
		Size Label Mc	2	Stamping Size label Tonge Linning,	14.24	0.47	0.50	126	95%
		CS-6040	3	Stitch Tongue Overlay to Tongue,	21.57	0.72	1.00	167	72%
		CS-3020	4	Stitch Tongue Linning to tongue,	17.29	0.58	1.00	208	58%
		Reverse Tongue Mc	5	Tongue reverse,	10.66	0.36	1.00	138	87%
PREPARATION UPPER	15%	Flat 1N	6	Stitch Tongue EDGE,	15.44	0.51	1.00	130	0/70
PREPARATION OPPER	15%	Flat 1N	7	Stitch Lace loop to tongue,	13.96	0.47	1.00	258	47%
		Flat 1N	8	Collar linning edge,	18.46	0.62	1.00	195	62%
		Punching Mc	9	Pounching Eyestay #1,	17.46	0.58	1.00	206	58%
		Post 1N	10	Stitch heel cap to Vamp quarter,	55.84	1.86	2.00	129	93%
		Zig-Zag Mc	11	Stitch zig zag heel cap to vamp/ quarter #1	24.68	0.82	1.00	146	82%
		Post 4N	12	Stitch heel cap with vamp/ quarter #2 ,	29.30	0.98	1.00	123	98%
TOTAL					252.78	8.43	11.00	123	77%

EOLR ws Deffinition TT 120 30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Post 1N	1	Stitch eyestay top To vamp/ quarter,	97.34	3.24	4.00	148	81%
		Post 1N	2	stitch heel counter to upper	28.52	0.95	2.00	147	82%
		POSLIN	3	Stitch Collar Linning to Upper,	20.50	0.68	2.00	147	0270
		Spray Mc	4	Spray Upper,	14.56	0.49			96%
			5	Attaching Collar Padding to Upper,	19.28	0.64	2.00	126	
STITCHING	15%		6	Reverse Collar Linning,	10.94	0.36	2.00	120	
SITICHING		Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.54	0.42			
		Punching Mc	8	Pounching Eyestay #2,	29.24	0.97	1.00	123	97%
		Post 1N	9	Stitch Tongue/Eyestay Laceloop to Tongue	29.38	0.98	1.00	123	98%
		CS-1510	10	Stitch Conection Vamp tongue to Upper,	29.16	0.97	1.00	123	97%
		Post 1N	11	Stitch Lasting Margin	28.44	0.95	1.00	127	95%
		Upper Clamp	12	Insert Shoe Lace,	97.36	3.25	4.00	148	81%
TOTAL					417.26	13.91	16.00	123	87%
		EOLR	ws	Deffinition	TT				

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120

2

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		ВРМ	1	Back Part Molding,	29.24	0.97	1.00	123	97%
		Vamp Mold Mc	2	Toecap Molding,	18.36	0.61	1.00	196	61%
		Strobel Mc	3	Stitch Strobel,	48.26	1.61	2.00	149	80%
		Table	4	Setting Last,	18.36	0.61	1.00	196	61%
		Kabuki	5	Insert Last,	14.40	0.48	1.00	146	82%
		Heel Last Mc	6	Heel Last,	10.24	0.34	1.00	140	02 /0
		Table	7	Tightening Lace,	27.28	0.91	1.00	132	91%
		Gauge Marking Mc	8	Gauge Marking,	25.28	0.84	1.00	142	84%
		Table	9	Gauge Toe,	19.34	0.64	1.00	186	64%
		Rack Outsole	10	Prepare Outsole,	17.26	0.58	1.00	209	58%
		Conveyor	11	Cleaner Upper,	22.96	0.77	1.00	157	77%
		Chamber 1	12	Chamber 1	23.52				
		Conveyor	13	Primer Upper,	48.30	1.61	2.00	149	81%
		Conveyor	14	Primer Outsole,	29.14	0.97	1.00	124	97%
		Chamber 2	15	Chamber 2	25.36				
		Conveyor	16	Cement Outsole,	23.08	0.77	1.00	156	77%
ASSEMBLY	0.15	Chamber 3	17	Chamber 3	78.36				
		Conveyor	18	Attach Outsole,	69.44	2.31	3.00	156	77%
		Universal Press Mc	19	Universal Pressing,	26.34	0.88	1.00	137	88%
		Blower Mc	20	Blowing Outsole,	18.88	0.63	1.00	191	63%
		Chiller Mc	21	Chiller	21.36				
		Table	22	Open Lace,Open Last,	28.70	0.96	1.00	125	96%
		Sockliner Mc	23	Hotmelt Aplication on Inlaysole,	19.12	0.64	1.00	188	64%
		Table	24	Lacing,	29.28	0.98	1.00	123	98%
		Table	25	Finishing,	28.88	0.96	1.00	125	96%
		Table	26	Finishing Inspection,	28.62				
		Metal Detector Mc	27	Metal detector	4.21				
		Table	28	Insert Paper,	14.68	0.49	1.00	123	97%
		Table	29	Innerbox Folding,	14.49	0.48		.20	,,,,,
		Table	30	Attach UPC,	13.45	0.45	1.00	129	93%
		Table	31	Attach Hantag,	14.35	0.48		/	, 5 %
		Table	32	Wrapping,	19.55	0.65	1.00	184	65%
		Table	33	Packing,	19.23	0.64	1.00	187	64%
TOTAL					698.8	22	28	123	80%

 EOLR
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120 NON OSA

FTY Name	PWJ
Model Name	Duramo SL
Season	FW21
Model ID	LEC86
Upper ID	53395
Forecast (Pairs)	30026
Latest Update	JUNE 18th, 2021
Inline EOLR	120
LC CTB	140.04
LB Efficiency	84.2%
Theoritical CT Efficiency	115.9%
LLER	81%

Module	TCT Module	EOLR Module	MP Module	MP Module conversio	PPH	LLER
Cutting Auto	28.4	240	2	1	120	95%
Pre-coating Insole Central	2.7	2400	2	0.1	1200	90%
Stockfitting - Buffing	18.4	300	2	0.8	150	77%
Stockfitting - Degreaser	15.5	1200	6	0.6	200	86%
Stockfitting - UV Light	51.2	800	14	2.1	57	81%
Stockfitting - Attaching	315.0	300	30	12.0	10	87%
Cutting Inline	78.0	120	3	3	40	87%
Preparation	252.8	120	11	11	11	77%
Sewing	417.3	120	16	16	8	87%
Assembly	687.6	120	30	30	4	76%
SUBTOTAL	1866.8	120	116	77	1.57	81%
Water Spider		120		9		
TOTAL Incl WS		120		86	1.40	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
			1	Cutting Vamp/Quarter Top,	5.22	0.17			
			2	Cutting Vamp/Quarter Bottom,	18.15	0.61			
			3	Cutting Collar Padding,	4.82	0.16			
			4	Cutting Eyestay Reinf Lat,	3.51	0.12			
			5	Cutting Eyestay Reinf Med,	3.51	0.12			
CUTTING INLINE	0.15	Hydrolic Mc	6	Cutting Heel Counter	2.74	0.09	3.00	138	87%
COTTING INCINE	0.10	Tryarote Me	7	Cutting Toe Cap,	5.84	0.19	3.00	130	<i>67 %</i>
			8	Cutting Mudguard Overlay Lat,	8.27	0.28			
			9	Cutting Mudguard Overlay Med,	8.27	0.28			
			10	Cutting Eyestay Lower,	7.83	0.26			
			11	Cutting 3 Stripes Lat,	4.94	0.16			
			12	Cutting 3 Stripes Med,	4.94	0.16			
	TOTAL							138	87%
		EOLR	ws	Deffinition	TT				

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AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Skiving Counter Mc	1	Skiving Heel Counter,	13.9	0.5	0.5	130	93%
		Size Label Mc	2	Stamping Size label Tonge Linning,	14.2	0.5	0.5	126	95%
		CS-6040	3	Stitch Tongue Overlay to Tongue,	21.6	0.7	1	167	72%
		CS-3020	4	Stitch Tongue Linning to tongue,	17.3	0.6	1	208	58%
PREPARATION UPPER 15%	Reverse Tongue Mc	5	Tongue reverse,	10.7	0.4	1	138	87%	
THE ARATION OF LER	1570	Flat 1N	6	Stitch Tongue EDGE,	15.4	0.5		130	0776
		Flat 1N	7	Stitch Lace loop to tongue,	14.0	0.5	1	258	47%
		Flat 1N	8	Collar linning edge,	18.5	0.6	1	195	62%
		Punching Mc	9	Pounching Eyestay #1,	17.5	0.6	1	206	58%
		Post 1N	10	Stitch heel cap to Vamp quarter,	55.8	1.9	2	129	93%
		Zig-Zag Mc	11	Stitch zig zag heel cap to vamp/ quarter #1	24.7	0.8	1	146	82%
		Post 4N	12	Stitch heel cap with vamp/ quarter #2 ,	29.3	1.0	1	123	98%
TOTAL					252.8	8	11	123	77%

EOLR	ws	Deffinition	TT
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AREA	ALLOWANCE	MACHINERY	N0	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Post 1N	1	Stitch eyestay top To vamp/ quarter,	97.3	3.2	4.00	148	81%
		Post 1N	2	stitch heel counter to upper	28.5	1.0	2.00	147	82%
			3	Stitch Collar Linning to Upper,	20.5	0.7	2.00	147	0270
		Spray Mc	4	Spray Upper,	14.6	0.5			96%
			5	Attaching Collar Padding to Upper,	19.3	0.6	2.00	126	
STITCHING	15%		6	Reverse Collar Linning,	10.9	0.4	2.00		7070
SITICIINO	1370	Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.5	0.4			
		Punching Mc	8	Pounching Eyestay #2,	29.2	1.0	1.00	123	97%
		Post 1N	9	Stitch Tongue/Eyestay Laceloop to Tongue	29.4	1.0	1.00	123	98%
		CS-1510	10	Stitch Conection Vamp tongue to Upper,	29.2	1.0	1.00	123	97%
		Post 1N	11	Stitch Lasting Margin	28.4	0.9	1.00	127	95%
		Upper Clamp	12	Insert Shoe Lace,	97.4	3.2	4.00	148	81%
TOTAL					417.3	14	16	123	87%
		EOLR	ws	Deffinition	TT		<u> </u>	•	•

30.0

BPM	AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
Strobel Mc 3 Strich Strobel 48 76 1.41 2.00 147 80% Table 4 Setting Last 118.36 0.41 1.00 196 61% Kabuki 5 Insert Last 10.24 0.24 1.00 166 82% Heat Last Mc 6 Heis Last 10.24 0.24 1.00 120 17% Table 7 Tightening Lece, 27.78 0.91 1.00 132 91% Gauge Marking Mc 8 Gauge Marking 27.64 0.97 1.00 121 97% Table 9 Sauge Toe, 19.34 0.44 1.00 186 64% Table 9 Sauge Toe, 19.34 0.44 1.00 186 64% Table 10 Prepare Outsole, 17.26 0.88 1.00 2.99 58% Conveyor 11 Cleaner Upper, 22.96 0.77 1.00 157 77% Chamber 1 27 Chamber 1 27.57 1.00 157 77% Conveyor 13 Primer Upper, 48.30 1.61 2.00 149 81% Conveyor 14 Primer Disable, 29.14 0.97 1.00 124 97% Chamber 2 15 Chamber 2 27.34 0.45 1.00 186 65% Conveyor 16 Cament Outsole, 19.54 0.45 1.00 186 65% Chamber 3 18 Chamber 3 78.35 1.00 186 65% Chamber 4 20 Chimer Disable, 19.54 0.45 1.00 186 65% Chamber 5 18 Chamber 7 2.34 0.88 1.00 137 88% Chamber 6 21 Eliwing Outsole, 19.88 0.43 1.00 191 43% Childer Mc 22 Chiller 21.36 0.86 1.00 123 98% Sockiner Mc 24 Holmett Aplication on Integration 19.54 0.56 1.00 123 98% Table 25 Lacing, 29.28 0.98 1.00 123 98% Table 26 Lacing, 19.54 0.45 1.00 120 95% Table 27 Finishing Inspection, 28.52 Meal Claescer Mc 28 Meal Selector 4.21 1.00 184 65% Table 29 Insert Paper, 14.68 0.49 1.00 123 99% Table 31 Attach Urch, 14.56 0.48 1.00 179 97% Table 32 Attach Harrag, 14.56 0.48 1.00 179 97% Table 32 Attach Harrag, 14.56 0.48 1.00 179 97% Table 33 Attach Harrag, 14.56 0.46 1.00 184 65% Table 34 Attach Harrag, 14.56 0.46 1.00 184 65% Tab			ВРМ	1	Back Part Molding,	29.24	0.97	1.00	123	97%
ASSEMBLY Table 4 Setting Last, 18.36 0.61 1.00 196 61% Kabuki 5 Incort Last, 11.40 0.68 Hotel Last Mc 6 Heat Last, 10.24 0.62 Table 7 Tiphrening Leco, 27.28 0.91 0.00 122 91% Gauge Marking Mc 8 Gauge Marking, 29.64 0.99 1.00 121 99% Table 9 Gauge Toc, 11.34 0.64 1.00 186 64% Rich Dutsolde 10 Prepare dutsole, 17.26 0.68 1.00 229 58% Conveyor 11 Cleaner Upper, 27.96 0.77 1.00 137 77% Chamber 1 12 Chamber 1 2.352 Conveyor 14 Primer Upper, 46.30 0.61 1.00 186 64% Conveyor 15 Chamber 2 25.36 Conveyor 16 Cament Upper, 57.20 1.91 2.00 126 99% Chamber 2 15 Chamber 2 25.36 Conveyor 16 Cament Upper, 57.20 1.91 2.00 126 99% Conveyor 19 Attach Outsole, 17.54 0.65 1.00 184 65% Elowar Mc 21 Blowing Outsole, 18.38 0.63 1.00 137 88% Elowar Mc 21 Blowing Outsole, 18.38 0.63 1.00 191 6.3% Chiller Mc 22 Chiller 21.36 Table 23 Open Laco, Open Last, 28.70 0.96 1.00 123 99% Table 24 Finishing Inspection, 18.46 0.47 1.00 123 99% Table 25 Indign. 1.04 0.65 1.00 188 64% Table 26 Finishing, 1.04 0.65 1.00 123 99% Table 27 Finishing Inspection, 16.48 0.49 1.00 123 99% Table 28 Metal detector 4.21 1.00 1.00 1.00 1.00 1.00 1.00 1.00 1			Vamp Mold Mc	2	Toecap Molding,	18.36	0.61	1.00	196	61%
Rabular S			Strobel Mc	3	Stitch Strobel,	48.26	1.61	2.00	149	80%
Heat Last Mc			Table	4	Setting Last,	18.36	0.61	1.00	196	61%
Heel Last Mc			Kabuki	5	Insert Last,	14.40	0.48	1.00	1//	020/
Gauge Marking Mc			Heel Last Mc	6	Heel Last,	10.24	0.34	1.00	140	02 /0
ASSEMBLY Table 9 Gauge Toe, 19 34 0.64 1.00 188 6.4% Rak Outsole 10 Prepare Outsole, 17.26 0.58 1.00 209 58% Conveyor 11 Cleaner Upper, 22.96 0.77 1.00 157 77% Chamber 1 22 Chamber 1 22.52 Conveyor 13 Primer Upper, 48.30 1.61 2.00 149 81% Conveyor 14 Primer Outsole, 29 14 0.97 1.00 124 97% Chamber 2 Conveyor 15 Chamber 2 Conveyor 16 Cement Upper, 57.20 1.91 2.00 126 95% Conveyor 17 Cement Outsole, 19 54 0.65 1.00 184 65% Chamber 3 18 Chamber 3 78.36 Conveyor 19 Attach Outsole, 69 44 2.31 3.00 156 77% Universal Press Mc 20 Universal Pressing, 8 Sockliner Mc 21 Blowing Outsole, 18 88 0.03 1.00 191 6.3% Chiller Mc 22 Chiller Table 25 Qena Lace Open Last, Sockliner Mc 24 Hotmetl Aplication on Inlaysole, 19 12 0.64 1.00 188 64% Table 25 Incing, 7 Phishing Inspection, Metal Detector Mc 28 Metal detector Table 29 Insert Paper, 10 184 65% Table 31 Insert Paper, 10 184 65% Table 32 Attach Harbag, Table 33 Wrapping, 19 25 0.66 1.00 123 97% Table 34 Attach Harbag, Table 35 0.48 1.00 184 65% Table 33 Wrapping, 19 25 0.66 1.00 187 64%			Table	7	Tightening Lace,	27.28	0.91	1.00	132	91%
Rak Outsole 10 Prepare Outsole, 17.26 0.58 1.00 209 58%			Gauge Marking Mc	8	Gauge Marking,	29.64	0.99	1.00	121	99%
ASSEMBLY Conveyor 11 Cleaner Upper, 22.96 0.77 1.00 157 77% 77% 78 78 78 78 78			Table	9	Gauge Toe,	19.34	0.64	1.00	186	64%
ASSEMBLY Chamber 1 12 Chamber 1 23.52			Rak Outsole	10	Prepare Outsole,	17.26	0.58	1.00	209	58%
ASSEMBLY Conveyor 13			Conveyor	11	Cleaner Upper,	22.96	0.77	1.00	157	77%
ASSEMBLY 15% Conveyor 14 Primer Outsole, 29.14 0.97 1.00 124 97%			Chamber 1	12	Chamber 1	23.52				
ASSEMBLY 15% Conveyor 16 Cement Upper, 57,20 1,91 2,00 126 95%			Conveyor	13	Primer Upper,	48.30	1.61	2.00	149	81%
ASSEMBLY 15% Conveyor 16 Cement Upper, 197. 191 2.00 126 95%			Conveyor	14	Primer Outsole,	29.14	0.97	1.00	124	97%
ASSEMBLY Conveyor 17 Cement Outsole, 19,54 0.65 1.00 184 65%			Chamber 2	15	Chamber 2	25.36				
ASSEMBLY 15% Chamber 3 18 Chamber 3 78.36			Conveyor	16	Cement Upper,	57.20	1.91	2.00	126	95%
Chamber 3 18 Chamber 3 78.36 Conveyor 19 Attach Outsole, 69.44 2.31 3.00 156 77% Universal Press Mc 20 Universal Pressing, 26.34 0.88 1.00 137 88% Blower Mc 21 Blowing Outsole, 18.88 0.63 1.00 191 63% Chitler Mc 22 Chitler 21.36 21.36 21.36 21.36 22.36 28.70 0.96 1.00 125 96% <td>ASSEMBLY</td> <td>15%</td> <td>Conveyor</td> <td>17</td> <td>Cement Outsole,</td> <td>19.54</td> <td>0.65</td> <td>1.00</td> <td>184</td> <td>65%</td>	ASSEMBLY	15%	Conveyor	17	Cement Outsole,	19.54	0.65	1.00	184	65%
Universal Press Mc 20 Universal Pressing, 26.34 0.88 1.00 137 88%	ASSEMBET		Chamber 3	18	Chamber 3	78.36				
Blower Mc 21 Blowing Outsole, 18.88 0.63 1.00 191 63%			Conveyor	19	Attach Outsole,	69.44	2.31	3.00	156	77%
Chiller Mc 22 Chiller 21.36 21.36 Table 23 Open Lace, Open Last, 28.70 0.96 1.00 125 96% Sockliner Mc 24 Hotmelt Aplication on Inlaysole, 19.12 0.64 1.00 188 64% Table 25 Lacing, 29.28 0.98 1.00 123 98% Table 26 Finishing, 16.94 0.56 1.00 213 56% Table 27 Finishing Inspection, 28.62 28.62 28.62 28.62 28.62 28.62 29.6			Universal Press Mc	20	Universal Pressing,	26.34	0.88	1.00	137	88%
Table 23 Open Lace, Open Last, 28.70 0.96 1.00 125 96% Sockliner Mc 24 Hotmelt Aplication on Inlaysole, 19.12 0.64 1.00 188 64% Table 25 Lacing, 29.28 0.98 1.00 123 98% Table 26 Finishing, 16.94 0.56 1.00 213 56% Table 27 Finishing Inspection, 28.62 2 28.62 2 Metal Detector Mc 28 Metal detector 4.21			Blower Mc	21	Blowing Outsole,	18.88	0.63	1.00	191	63%
Sockliner Mc 24 Hotmelt Aplication on Inlaysole, 19.12 0.64 1.00 188 64% Table 25 Lacing, 29.28 0.98 1.00 123 98% Table 26 Finishing, 16.94 0.56 1.00 213 56% Table 27 Finishing Inspection, 28.62 Metal Detector Mc 28 Metal detector 4.21 Table 29 Insert Paper, 14.68 0.49 1.00 123 97% Table 30 Innerbox Folding, 14.49 0.48 1.00 123 97% Table 31 Attach UPC, 13.45 0.45 1.00 129 93% Table 32 Attach Hantag, 14.35 0.48 1.00 129 93% Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Chiller Mc	22	Chiller	21.36				
Table 25 Lacing, 29.28 0.98 1.00 123 98% Table 26 Finishing, 16.94 0.56 1.00 213 56% Table 27 Finishing Inspection, 28.62 Metal Detector Mc 28 Metal detector 4.21 Table 29 Insert Paper, 14.68 0.49 Table 30 Innerbox Folding, 14.49 0.48 Table 31 Attach UPC, 13.45 0.45 Table 32 Attach Hantag, 14.35 0.48 Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	23	Open Lace,Open Last,	28.70	0.96	1.00	125	96%
Table 26 Finishing, 16.94 0.56 1.00 213 56% Table 27 Finishing Inspection, 28.62 Metal Detector Mc 28 Metal detector 4.21 Table 29 Insert Paper, 14.68 0.49 Table 30 Innerbox Folding, 14.49 0.48 Table 31 Attach UPC, 13.45 0.45 Table 32 Attach Hantag, 14.35 0.48 Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Sockliner Mc	24	Hotmelt Aplication on Inlaysole,	19.12	0.64	1.00	188	64%
Table 27 Finishing Inspection, 28.62 Metal Detector Mc 28 Metal detector 4.21 Table 29 Insert Paper, 14.68 0.49 Table 30 Innerbox Folding, 14.49 0.48 Table 31 Attach UPC, 13.45 0.45 Table 32 Attach Hantag, 14.35 0.48 Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	25	Lacing,	29.28	0.98	1.00	123	98%
Metal Detector Mc 28 Metal detector 4.21 30 4.21 30 14.68 0.49 1.00 123 97% Table 30 Innerbox Folding, 14.49 0.48 1.00 123 97% Table 31 Attach UPC, 13.45 0.45 1.00 129 93% Table 32 Attach Hantag, 14.35 0.48 1.00 129 93% Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	26	Finishing,	16.94	0.56	1.00	213	56%
Table 29 Insert Paper, 14.68 0.49 1.00 123 97% Table 30 Innerbox Folding, 14.49 0.48 1.00 123 97% Table 31 Attach UPC, 13.45 0.45 1.00 129 93% Table 32 Attach Hantag, 14.35 0.48 1.00 129 93% Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	27	Finishing Inspection,	28.62				
Table 30 Innerbox Folding, 14.49 0.48 1.00 123 97% Table 31 Attach UPC, 13.45 0.45 1.00 129 93% Table 32 Attach Hantag, 14.35 0.48 1.00 129 93% Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Metal Detector Mc	28	Metal detector	4.21				
Table 30 Innerbox Folding, 14.49 0.48 Table 31 Attach UPC, 13.45 0.45 Table 32 Attach Hantag, 14.35 0.48 Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	29	Insert Paper,	14.68	0.49	1 00	122	97%
Table 32 Attach Hantag, 14.35 0.48 1.00 129 93% Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	30	Innerbox Folding,	14.49	0.48	1.00	123	7770
Table 32 Attach Hantag, 14.35 0.48 Table 33 Wrapping, 19.55 0.65 1.00 184 65% Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	31	Attach UPC,	13.45	0.45	1 00	120	930/
Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	32	Attach Hantag,	14.35	0.48	1.00	127	93%
			Table	33	Wrapping,	19.55	0.65	1.00	184	65%
TOTAL 687.6 24 30 121 79%			Table	34	Packing,	19.23	0.64	1.00	187	64%
	TOTAL					687.6	24	30	121	79%

 EOLR
 WS
 Deffinition
 TT

 120
 2.5
 30.0

60 NON OSA

FTY Name	PWJ
Model Name	Duramo SL
Season	FW21
Model ID	LEC86
Upper ID	53395
Forecast (Pairs)	30026
Latest Update	JUNE 18th, 2021
Inline EOLR	60
LC CTB	140.04
LB Efficiency	78.8%
Theoritical CT Efficiency	117.4%
LLER	75%

Module	TCT Module	EOLR Module	MP Module	MP Module conversio	РРН	LLER
Cutting Auto	28.4	240	2	1	120	95%
Pre-coating Insole Central	2.7	2400	2	0.1	1333	99%
Stockfitting - Buffing	18.4	300	2	0	150	77%
Stockfitting - Degreaser	15.5	1200	6	0	200	86%
Stockfitting - UV Light	51.2	800	14	1	57	81%
Stockfitting - Attaching	315.0	300	30	6	10	87%
Cutting Inline	78.0	60	2	2	40	87%
Preparation	252.8	60	5	5	13	90%
Sewing	417.3	60	10	10	6	70%
Assembly	664.0	60	17	17	4	67%
SUBTOTAL	1843.2	60	89	41	1.46	75%
Water Spider		60		5		
TOTAL Incl WS		60		46	1.31	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
			1	Cutting Vamp/Quarter Top,	5.22	0.09			
			2	Cutting Vamp/Quarter Bottom,	18.15	0.30		69	
			3	Cutting Collar Padding,	4.82	0.08			
			4	Cutting Eyestay Reinf Lat,	3.51	0.06			87%
		Hydrolic Mc	5	Cutting Eyestay Reinf Med,	3.51	0.06			
CUTTING INLINE	0.15		6	Cutting Heel Counter	2.74	0.05	2		
COTTING INCINE	0.13		7	Cutting Toe Cap,	5.84	0.10			07/0
			8	Cutting Mudguard Overlay Lat,	8.27	0.14			
			9	Cutting Mudguard Overlay Med,	8.27	0.14			
			10	Cutting Eyestay Lower,	7.83	0.13			
			11	Cutting 3 Stripes Lat,	4.94	0.08			
			12	Cutting 3 Stripes Med,	4.94	0.08			
TOTAL					78.0	1.30	2	69	87%
		EOLR	ws	Deffinition	TT				

EOLR	ws	Deffinition	TT	
60	0.5		60.0	

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Skiving Counter Mc	1	Skiving Heel Counter,	13.9	0.2	0.3	78	77%
		Size Label Mc	2	Stamping Size label Tonge Linning,	14.2	0.2	0.3	76	79%
		CS-6040	3	Stitch Tongue Overlay to Tongue,	21.6	0.4	0.4	60	100%
		CS-6040	4	Stitch Tongue Linning to tongue,	17.3	0.3	0.3	62	96%
		Reverse Tongue Mc	5	Tongue reverse,	10.7	0.2	1	73	82%
PREPARATION UPPER	15%	Flat 1N	6	Stitch Lace loop to tongue,	14.0	0.2	'		02 /0
THE ARATION OF LER	1570	Flat 1N	7	Stitch Tongue EDGE,	15.4	0.3	1	64	94%
		Flat 1N	8	Collar linning edge,	18.5	0.3	ļ	04	74/0
		Punching Mc	9	Pounching Eyestay #1,	17.5	0.3	0.3	62	97%
		Post 1N	10	Stitch heel cap to Vamp quarter,	55.8	0.9	1	64	93%
		Zig-Zag Mc	11	Stitch zig zag heel cap to vamp/ quarter #1	24.7	0.4	0.5	73	82%
		Post 4N	12	Stitch heel cap with vamp/ quarter #2 ,	29.3	0.5	0.5	61	98%
		·				4	5	60	90%
		EOLR	ws	Deffinition	TT				

60

60

TOTAL

TOTAL

0.5

0.5

		MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Post 1N	13	Stitch eyestay top To vamp/ quarter,	97.3	1.6	2.00	74	81%
AREA	ALLOWANCE	Post 1N	14	stitch heel counter to upper	28.5	0.5	1.00	73	82%
		FUSLIN	15	Stitch Collar Linning to Upper,	20.5	0.3	1.00	73	02 /0
			16	Spray Upper,	14.6	0.2			96%
		Spray Mc	17	Attaching Collar Padding to Upper,	19.3	0.3	1.00	63	
			18	Reverse Collar Linning,	10.9	0.2	1.00		
		Hammering MC	19	Hammering and Attach Upper to Jig Eva,	12.5	0.2			
STITCHING	15%	Punching Mc	20	Pounching Eyestay #2,	29.2	0.5	1.00	123	49%
SITICHING	1376	Post 1N	21	Stitch Tongue/Eyestay Laceloop to Tongue	29.4	0.5	1.00	123	49%
		CS-1510	22	Stitch Conection Vamp tongue to Upper,	29.2	0.5	1.00	123	49%
		Post 1N	23	Stitch Lasting Margin	28.4	0.5	1.00	127	47%
		Upper Clamp	24	Insert Shoe Lace,	97.4	1.6	2.00	74	81%
					417.3	7	10	63	70%
		EOLR	ws	Deffinition	TT				

60.0

60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		ВРМ	1	Back Part Molding,	29.24	0.49	1.00	7/	700/
		Vamp Mold Mc	2	Toecap Molding,	18.36	0.31	1.00	76	79%
		Strobel Mc	3	Stitch Strobel,	48.26	0.80	1.00	75	80%
		Table	4	Setting Last,	18.36	0.31			
		Kabuki	5	Insert Last,	14.40	0.24	1.00	84	72%
		Heel Last Mc	6	Heel Last,	10.24	0.17			
		Table	7	Tightening Lace,	27.28	0.45	1.00	132	45%
		Gauge Marking Mc	8	Gauge Marking,	29.64	0.49	1.00	121	49%
		Table	9	Gauge Toe,	19.34	0.32	1.00	85	71%
		Conveyor	10	Cleaner Upper,	22.96	0.38	1.00	00	/ 170
		Conveyor	11	Primer Upper,	48.30	0.81	1.00	75	81%
		Conveyor	12	Primer Outsole,	29.14	0.49	0.50	62	97%
		Chamber 2	13	Chamber 1	25.36				
		Conveyor	14	Cement Upper,	57.20	0.95	1.00	63	95%
		Conveyor	15	Cement Outsole,	19.54	0.33	1.00	184	33%
		Chamber 3	16	Chamber 2	78.36				
		Conveyor	17	Attach Outsole,	69.44	1.16	2.00	75	80%
ASSEMBLY	15%	Universal Press Mc	18	Universal Pressing,	26.34	0.44	2.00	/5	80%
		Blower Mc	19	Blowing Outsole,	18.88	0.31	1.00	100	60%
		Table	20	Cleaning Shoes,	17.10	0.29	1.00	100	60%
		Chiller Mc	21	Chiller	21.36				
		Table	22	Open Lace,Open Last,	28.70	0.48	1.00	75	80%
		Sockliner Mc	23	Hotmelt Aplication on Inlaysole,	19.12	0.32	1.00	75	0070
		Table	24	Lacing,	29.28	0.49	1.00	78	77%
		Table	25	Finishing,	16.94	0.28	1.00	70	7770
		Table	26	Finishing Inspection,	28.62				
		Metal Detector Mc	27	Metal detector	4.21				
		Table	28	Insert Paper,	14.68	0.24			
		Table	29	Innerbox Folding,	14.49	0.24	1.00	63	95%
		Table	30	Attach UPC,	13.45	0.22	1.00	03	7570
		Table	31	Attach Hantag,	14.35	0.24			
		Table	32	Wrapping,	19.55	0.33	1.00	93	45%
		Table	33	Packing,	19.23	0.32	1.00	73	65%
					664.0	12	17	62	72%
		EOLR	ws	Deffinition	TT				

60.0

TOTAL

60

2