

120 OSA

FTY Name	PWJ
Model Name	Duramo SL K
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%
Theoretical 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	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp/Quarter Top,	5.22	0.17	3.00	138	87%
			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			
			6	Cutting Heel Counter	2.74	0.09			
			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					78.02	2.60	3.00	138	87%
		EOLR	WS	Deffinition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	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%
		Flat 1N	6	Stitch Tongue EDGE,	15.44	0.51			
		Flat 1N	7	Stitch Lace loop to tongue,	13.96	0.47	1.00	258	47%
		Flat 1N	8	Collar lining 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	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPU T	LLER
STITCHING	15%	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%
			3	Stitch Collar Linning to Upper,	20.50	0.68			
		Spray Mc	4	Spray Upper,	14.56	0.49	2.00	126	96%
			5	Attaching Collar Padding to Upper,	19.28	0.64			
			6	Reverse Collar Linning,	10.94	0.36			
		Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.54	0.42	1.00	123	97%
		Punching Mc	8	Pounching Eyestay #2,	29.24	0.97			
		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				
		120	2		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	0.15	BPM	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			
		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%
		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			
		Table	30	Attach UPC,	13.45	0.45	1.00	129	93%
		Table	31	Attach Hantag,	14.35	0.48			
		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	WS	Deffinition	TT				
		120	2.5		30.0				

120 NON OSA

FTY Name	PWJ
Model Name	Duramo SL K
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%
Theoretical 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	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp/Quarter Top,	5.22	0.17	3.00	138	87%
			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			
			6	Cutting Heel Counter	2.74	0.09			
			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					78.0	2.60	3	138	87%

EOLR	WS	Definition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	N0	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	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%
		Reverse Tongue Mc	5	Tongue reverse,	10.7	0.4	1	138	87%
		Flat 1N	6	Stitch Tongue EDGE,	15.4	0.5			
		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				
		120	1		30.0				

EOLR	WS	Definition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPU T	LLER
STITCHING	15%	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			
		Spray Mc	4	Spray Upper,	14.6	0.5	2.00	126	96%
			5	Attaching Collar Padding to Upper,	19.3	0.6			
			6	Reverse Collar Linning,	10.9	0.4			
		Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.5	0.4	1.00	123	97%
		Punching Mc	8	Pounching Eyestay #2,	29.2	1.0			
		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				
		120	2		30.0				

EOLR	WS	Definition	TT
120	2		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	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			
		Table	7	Tightening Lace,	27.28	0.91	1.00	132	91%
		Gauge Marking Mc	8	Gauge Marking,	29.64	0.99	1.00	121	99%
		Table	9	Gauge Toe,	19.34	0.64	1.00	186	64%
		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	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 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,	26.34	0.88	1.00	137	88%
		Blower Mc	21	Blowing Outsole,	18.88	0.63	1.00	191	63%
		Chiller Mc	22	Chiller	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				
		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			
		Table	31	Attach UPC,	13.45	0.45	1.00	129	93%
		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%
TOTAL					687.6	24	30	121	79%
		EOLR	WS	Deffinition	TT				
		120	2.5		30.0				

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FTY Name	PWJ
Model Name	Duramo SL K
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%
Theoretical CT Efficiency	117.4%
LLER	75%

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	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	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp/Quarter Top,	5.22	0.09	2	69	87%
			2	Cutting Vamp/Quarter Bottom,	18.15	0.30			
			3	Cutting Collar Padding,	4.82	0.08			
			4	Cutting Eyestay Reinf Lat,	3.51	0.06			
			5	Cutting Eyestay Reinf Med,	3.51	0.06			
			6	Cutting Heel Counter	2.74	0.05			
			7	Cutting Toe Cap,	5.84	0.10			
			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	Definition	TT
60	0.5		60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER		
PREPARATION UPPER	15%	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%		
		Flat 1N	6	Stitch Lace loop to tongue,	14.0	0.2					
		Flat 1N	7	Stitch Tongue EDGE,	15.4	0.3	1	64	94%		
		Flat 1N	8	Collar linning edge,	18.5	0.3					
		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%		
						252.8	4	5	60	90%	
		EOLR		WS	Deffinition		TT				
		TOTAL		60	0.5	60.0					

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	13	Stitch eyestay top To vamp/ quarter,	97.3	1.6	2.00	74	81%
		Post 1N	14	stitch heel counter to upper	28.5	0.5	1.00	73	82%
			15	Stitch Collar Linning to Upper,	20.5	0.3			
		Spray Mc	16	Spray Upper,	14.6	0.2	1.00	63	96%
			17	Attaching Collar Padding to Upper,	19.3	0.3			
			18	Reverse Collar Linning,	10.9	0.2			
		Hammering MC	19	Hammering and Attach Upper to Jig Eva,	12.5	0.2	1.00	123	49%
		Punching Mc	20	Pounching Eyestay #2,	29.2	0.5			
		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	Definition	TT				
TOTAL		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding,	29.24	0.49	1.00	76	79%
		Vamp Mold Mc	2	Toecap Molding,	18.36	0.31			
		Strobel Mc	3	Stitch Strobel,	48.26	0.80	1.00	75	80%
		Table	4	Setting Last,	18.36	0.31	1.00	84	72%
		Kabuki	5	Insert Last,	14.40	0.24			
		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			
		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%
		Universal Press Mc	18	Universal Pressing,	26.34	0.44			
		Blower Mc	19	Blowing Outsole,	18.88	0.31	1.00	100	60%
		Table	20	Cleaning Shoes,	17.10	0.29			
		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			
		Table	24	Lacing,	29.28	0.49	1.00	78	77%
		Table	25	Finishing,	16.94	0.28			
		Table	26	Finishing Inspection,	28.62				
		Metal Detector Mc	27	Metal detector	4.21				
		Table	28	Insert Paper,	14.68	0.24	1.00	63	95%
		Table	29	Innerbox Folding,	14.49	0.24			
		Table	30	Attach UPC,	13.45	0.22			
		Table	31	Attach Hantag,	14.35	0.24			
		Table	32	Wrapping,	19.55	0.33	1.00	93	65%
		Table	33	Packing,	19.23	0.32			
					664.0	12	17	62	72%
		EOLR	WS	Deffinition	TT				
TOTAL		60	2		60.0				