

60 OSA PRE SEAL

FTY Name	PWJ
Model Name	GRAND COURT BASE BEYOND
Season	FW21
Model ID	LWP50, LWP53
Upper ID	
Forecast (Pairs)	
Latest Update	Tuesday, June 29, 2021
Inline EOLR	60
LC CTB	126.28
LB Efficiency	94.1%
Theoretical CT Efficiency	133.6%
LLER	79%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Central	14.0	120	1	0	240	94%
Pre-coating Insole Central	5.4	2640	4	0	660	99%
Stockfitting - Degreaser	22.1	1200	8	0.4	150	92%
Stockfitting - Precoating	102.1	600	18	1.8	33	95%
Cutting Inline	54.2	240	4	1	60	90%
Preparation	350.5	240	29	7	8	81%
Sewing	330.9	60	7	7	9	79%
Assembly	581.1	60	13	13	5	75%
SUBTOTAL	1460.3	60		31	1.95	79%
Water Spider	123.6	60		4		
TOTAL Incl WS		60		35	1.74	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICA L	# MP	THROUGHPU T	LLER
CUTTING IN LINE	15%	Manual (Hydrolic)	1	Cutting Quarter Lat,	6.35	0.42	4.00	266	90%
			2	Cutting Quarter Med,	6.95	0.46			
			3	Cutting Heel Tab,	5.36	0.36			
			4	Cutting tongue,	5.40	0.36			
			5	Cutting tongue vamp lining,	5.39	0.36			
			6	Cutting collar lining,	5.39	0.36			
			7	Cutting collar foam,	4.56	0.30			
			8	Cutting toe box,	3.01	0.20			
			9	Cutting heel counter,	5.43	0.36			
			10	Cutting 3 Stripes Lat/Med,	6.35	0.42			
TOTAL					54.2	3.6	4	266	90%
		EOLR	WS	Deffinition	TT				
		240	0.5		15.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
PREPARATION	15%	Booster Punching Mc	1	Re-Cutting 3 Stripes Lat/Med,	21.63	1.4	2	333	72%
		Skiving Mc	2	Skiving vamp,	11.56	0.8	4	317	76%
			3	Skiving qtr med & heel tab	17.32	1.2			
			4	Skiving qtr lateral,	16.60	1.1			
		Skiving Counter Mc	5	Skiving heel counter,	11.12	0.7	1	324	74%
		Roll Hotmelt Mc	6	Attach toe box & Roll hotmelt vamp,	14.70	1.0	2	260	92%
			7	Hotmelt Quarter Lining & Quarter,	13.00	0.9			
		Stamping Size Label	8	Stamping size label,	14.64	1.0	1	246	98%
		Post 1N	9	Stitch tongue to tongue lining,	12.36	0.8	2	313	77%
			10	Stitch Vamp to Tongue and Vamp Edge,	10.63	0.7			
		CS-1510	11	Stitch Tongue Label to Tongue,	10.62	0.7	2	302	80%
			12	Stitch Zig-Zag Tongue Label to Tongue,	13.26	0.9			
		Table	13	Attach 3 Stripes t Pallet,	38.21	2.5	3	283	85%
		CS-6040	14	Stitching 3 Stripe to Quarter,	49.92	3.3	4	288	83%
		Table	15	Attach Eyestay to Pallet,	21.36	1.4	2	337	71%
		CS-6040	16	Stitching Eyestay to Quarter,	12.90	0.9	3	332	72%
			17	Stitch Rear Quarter Lat/Med Deco,	19.63	1.3			
		Post 1N	18	Stitch and Turn Quarter Lat/Med,	28.63	1.9	2	251	95%
		Double Folding Mc	19	Folding and Hammering,	21.36	1.4	2	337	71%
		Flat 1N	20	Stitch edge collar lining,	12.70	0.8	0.9	255	94%
TOTAL					350.52	23	29	246	81%
		EOLR	WS	Definition	TT				
		240	1		15.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heel Tab to Upper,	28.7	0.5	1	81	74.1%
			2	Stitch heel counter to upper,	15.8	0.3			
		Post 1N	3	Stitch collar lining to upper,	53.6	0.9	1	67	89.3%
		Spray Mc	4	Spray upper,	13.6	0.2	1	81	74.3%
			5	Attach collar foam,	9.5	0.2			
			6	Reverse collar lining,	9.3	0.2			
		Hammering Mc	7	Hammer upper,	12.2	0.2			
		Punching Mc	8	Punching upper,	38.5	0.6	1	94	64.1%
		Post 1N	9	Stitch Lasting Margin,	40.4	0.7	1	89	67.3%
		CS-1510	10	Stitch Vamp/Tongue to upper,	50.5	0.8	1	71	84.2%
		Upper Claim	11	Insert Shoe Lace,	58.9	1.0	1	61	98.1%
TOTAL					330.9	6	7	61	78.8%
		EOLR	WS	Deffinition	TT				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITIC AL	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding [Cold, Max 40c/20"]	27.84	0.46	1	66	91%
		Vamp press Mc	2	Toe vamp molding,	26.90	0.45			
		Strobel Mc	3	Stitch Strobel,	48.64	0.81	1	74	81%
		Table	4	Setting Laste	20.72	0.35	1	66	91%
		Kabuki	5	Insert Laste,	18.50	0.31			
		Heel last	6	Heel Last,	15.12	0.25			
		Table	7	Strengthen lace,	29.12	0.49	1	65	92%
			8	Cleaner Upper	26.08	0.43			
		Laser Gauge	9	Gauge Marking,	28.50	0.48	1	126	48%
		Rotary Chamber MC	10	Chamber 1					
		Conveyor MC	11	Primer Upper,	43.04	0.72	1	84	72%
		Rotary Chamber MC	12	Chamber 2					
		Table	13	Attach Outsole,	51.34	0.86	2	90	67%
		Pressing Mc	14	Universal Press,	28.60	0.48			
		Chiller MC	15	Chiller,					
		Table	16	Open Lace,	16.68	0.28	1	63	96%
			17	Open Laste,	12.84	0.21			
		Sockliner Mc	18	Cement & Insert Sockliner,	27.96	0.47			
		Table	19	Fix Lace,	28.06	0.47	2	95	63%
		Table	20	Cleaning,	25.04	0.42			
		Table	21	Finishing Shoes,	22.72	0.38			
		Table	22	Finishing Inspection					
		MD Mc	23	Metal Detector					
		Table	24	Inner Box Folding	15.04	0.25	1	86	70%
		Table	25	Attach Hang tag,	14.20	0.24			
		Table	26	Attach Upc,	12.70	0.21			
		Table	27	Wrapping	20.35	0.34	1	87	69%
		Table	28	Packing Shoes	21.15	0.35			
TOTAL					581.14	10	13	63	75%
		EOLR	WS	Definition	TT				
		60	1.25		60.0				