

## 120 OSA

FTY Name	PWJ
Model Name	Duramo 10 K
Season	FW21
Model ID	LW008
Upper ID	GZ0609
Forecast (Pairs)	
Latest Update	August 26Th, 2021
Inline EOLR	120
LC CTB	128.96
LB Efficiency	83.6%
Theoretical CT Efficiency	99.4%
LLER	82%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Leather Central	26.9	240	2	1	133	100%
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	66.6	120	3	3	40	74%
Preparation	311.1	120	13	13	9	80%
Sewing	271.2	120	10	10	12	90%
Assembly	690.0	120	28	28	4	82%
<b>SUBTOTAL</b>	<b>1753.0</b>	<b>120</b>		<b>71</b>	<b>1.69</b>	<b>82%</b>
Water Spider		120		8		
<b>TOTAL Incl WS</b>		<b>120</b>		<b>79</b>	<b>1.51</b>	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydraulic	1	Cutting Toebox,	3.8	0.1	3	172	74%
			2	Cutting Vamp Accent,	3.8	0.1			
			3	Cutting 3 Stripe,	5.6	0.2			
			4	Cutting eyestay reinf,	5.6	0.2			
			5	Cutting Heelcap	5.6	0.2			
			6	Cutting Heel Counter,	3.4	0.1			
			7	Cutting Collar Padding,	3.1	0.1			
			8	Cutting Quarter Reinf Lat,	4.3	0.1			
			9	Cutting eyestay lower	4.9	0.2			
			10	Cutting Eyestay Top L/M	4.9	0.2			
			11	Cutting Heelcap Reinf	4.9	0.2			
			12	Cutting Heelcap Foam Bottom	3.7	0.1			
			13	Cutting Heelcap foam Top	3.7	0.1			
			14	Cutting Heelcap Backer	5.0	0.2			
			15	Cutting Tongue Overlay,	4.4	0.1			
TOTAL					66.6	2	3	172	74%
		EOLR	WS	Definition	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,	24.2	0.8	1	149	81%
		Tongue Forming	5	Tongue Reverse,	8.3	0.3	1	143	84%
		Flat 1N	6	Stitch Tongue Edge,	16.9	0.6			
		Flat 1N	7	Stitch tongue Overlay Through Lining,	12.4	0.4	1	290	41%
		Flat 1N	8	Stich Collar Lining Edge,	14.9	0.5	1	242	50%
		Pouching Mc	9	Upper Pouching #1	24.3	0.8	1	148	81%
		Flat 1N	10	Stitch Lasting Margin, Edge Vamp & Heelcap	26.4	0.9	1	136	88%
		Post 1N	11	Stitch & Turn Heel and Quarter (Medial Area)	58.6	2.0	2	123	98%
		Manual	12	Cementing & Folded after Stitch	28.5	1.0	1	126	95%
		Hammering MC	13	Hammering Heel (Medial Area)	17.6	0.6	1	205	59%
		Post 1N	14	Stitch Heel Counter to Upper,	23.0	0.8	1	156	77%
TOTAL					311.1	10.4	13	123	80%
		EOLR	WS	Defffinition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
Sewing	15%	Post 1N	1	Stitch Collar Lining to Upper,	58.8	2.0	2	123	98%
		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			
		Pouching Mc	6	Upper Pouching #2	26.5	0.9	1	136	88%
		CS 1510	7	Stitch Tongue to Upper,	29.1	1.0	1	124	97%
		Post 1N	8	Stitch Lasting Margin,	25.0	0.8	1	144	83%
		Upper Clamp	9	Insert Shoe Lace,	83.0	2.8	3	130	92%
TOTAL					271.2	9	10	123	90%
		EOLR	WS	Definition		TT			
		120	2			30.0			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
		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,	4.6	0.2	1	128	94%
		Conveyor Mc	12	Cleaner Outsole & Cleaner Upper,	23.5	0.8			
		Chamber Mc	13	Chamber 1	29.2				
		Conveyor Mc	14	Primer Upper,	58.6	2.0	2	123	98%
		Conveyor Mc	15	Primer Outsole,	28.5	1.0	1	126	95%
		Chamber Mc	16	Chamber 2	29.2				
		Conveyor Mc	17	Cement Outsole,	21.8	0.7	1	165	73%
		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,	16.4	0.5	1	219	55%
		Table	33	Final Packing,	20.5	0.7	1	176	68%
TOTAL					690.0	23	28	123	82%
		EOLR	WS	Definiton	TT				
		120	2.5		30.0				