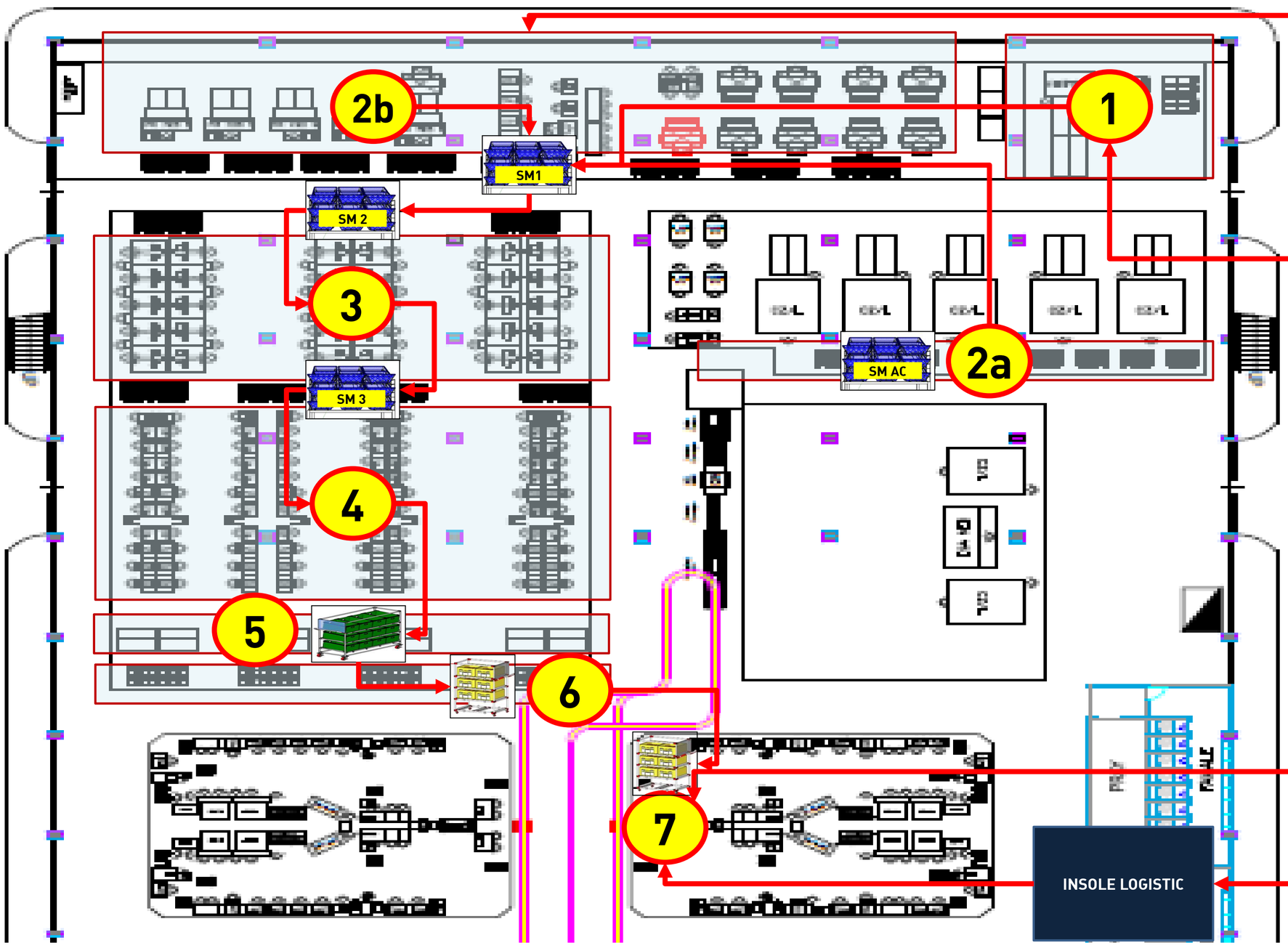
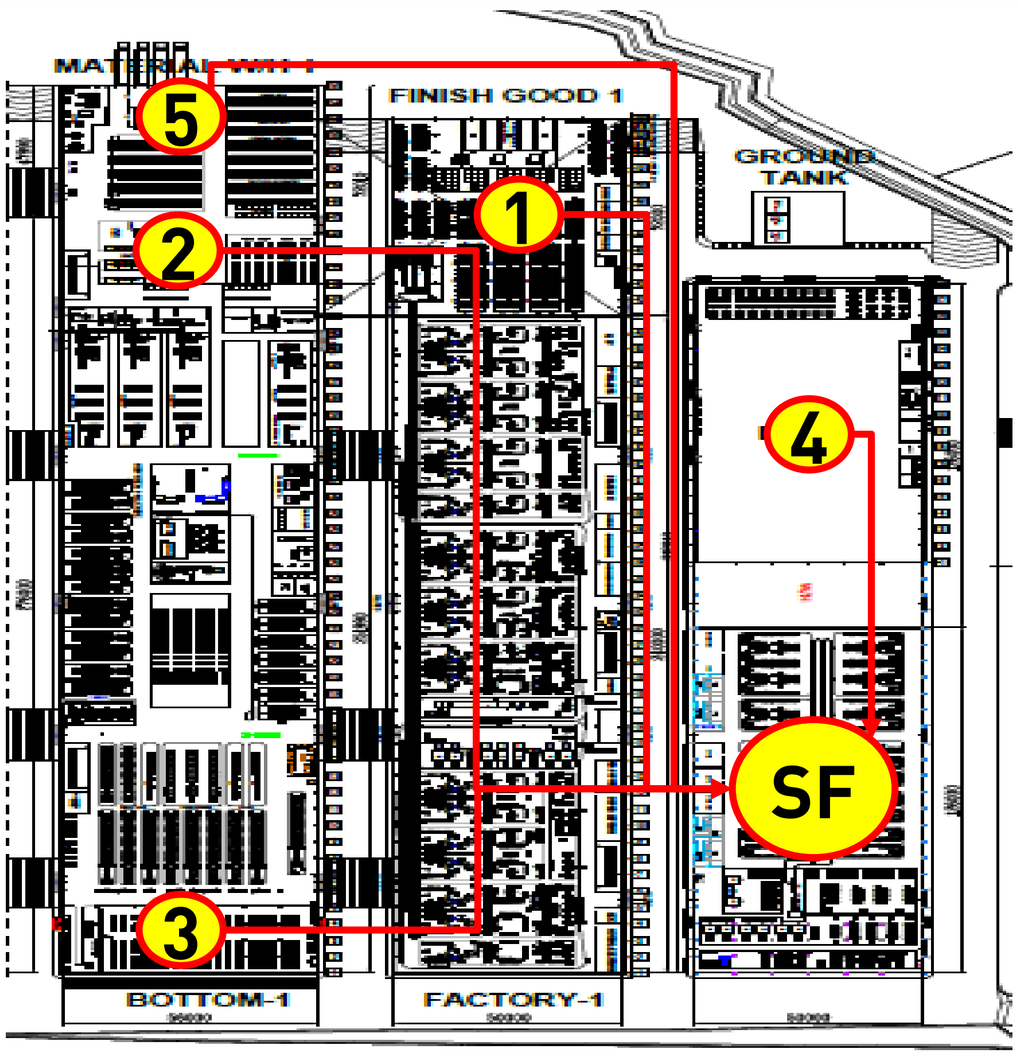
MATERIAL FLOW – SPECIAL FACTORY



Proses Sebelumnya		Proses Setelahnya		Nama Material
-	Laminating material	2b	Manual Cutting area	• Raw Material cutting
-	Inhouse Treatment Process	1	Subcont Incoming FTY	• Subcont component setting
-	Bottom Warehouse Stockfit	8	Assembly Cell	• Outsole component
1	Subcont Incoming FTY	SM1	Supermarket Output central cutting	• Subcont component setting (upper)
2a	Supermarket Output Autocutting	SM1	Supermarket Output central cutting	• Autocutting output component setting (upper)
2b	Manual cutting Area	SM1	Supermarket Output central cutting	• Manual cutting and skiving output component setting (upper)
SM1	Supermarket Output central cutting	SM2	Supermarket Input COS	• Setting Input component upper (COS & tongue)
SM2	Supermarket Input COS	3	COS Central Process	• Semi upper
3	COS Central Process	SM3	Supermarket Output COS	• Semi upper
SM3	Supermarket Output COS	4	Tongue Central process	• Semi upper , tongue, collar component and other
4	Tongue Central process	5	Trolley Output central preparation	• Semi upper , tongue, collar component and other
5	Trolley Output central preparation	6	Distribution Center	• Semi upper , tongue, collar component and other
6	Distribution Center	7	Cell	• Semi upper , tongue, collar component and other

FTY OVERALL FLOW – SPECIAL FACTOTY

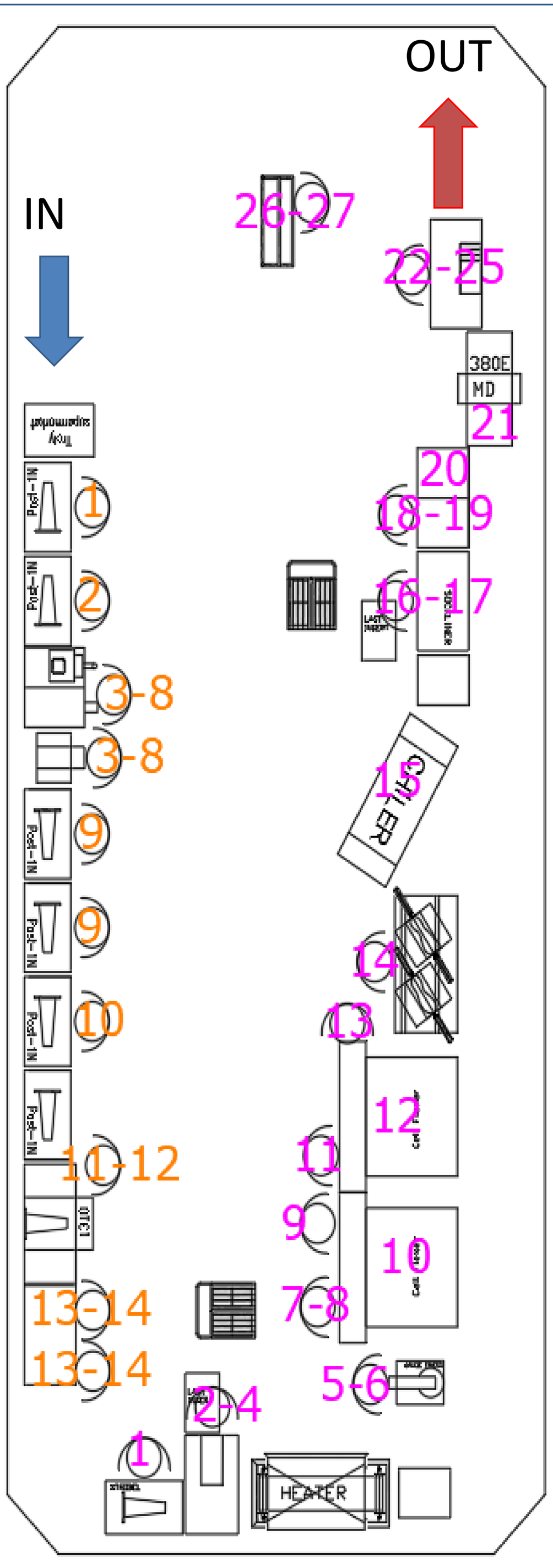


CODE	AREA	MATERIAL
1	WH RAW Material	• RAW material before laminating process • Accesories component (Webbing, Handtag, loop, etc) • Thread • Karton • Inner Box • Wrapping paper
2	Laminating Process	• RAW material after laminating process
3	Bottom Warehouse Stockfit	• Insole • Outsole
4	Inhouse Treatment	• Subcont Component
5	Chemical Warehouse	• Chemical material (cementing, primer, etc)

MATERIAL FLOW S2A – SPECIAL FACTORY

Tracking IE Data Actual

Model : Racer TR 21 K



NO	Process	CT STD	MP Std	MP Act	Remark
1	Stitch Heel Cap To upper,	58.10	1		
2	Stitch Collar Linning to Upper,	54.10	1		
3	Spray Area Padding 2 Lat/Mad to Upper,	17.80	2		
4	Attaching Collar Padding 2 Lat/Mad to Upper,	14.40			
5	Spray Upper,	12.00			
6	Attaching Collar Padding to Upper,	19.00			
7	Reverse Collar Lining,	43.50			
8	Hammer Upper,	12.70			
9	Stitch Eyestay to Upper,	88.60	2		
10	Stitch Quarter Deco (Padding 2),	52.00	1		
11	Stitching Lasting Margin,	28.30	1		
12	Stitch Connection Tounge to Upper,	29.00			
13	Insert Shoe Lace,	79.60	2		
14	Finishing,	15.40			
Total Sewing		**524.50**	**10**		
NO	Process	CT STD	MP Std	MP Act	Remark
1	Stitch Strobel,	49.54	1		
2	Insert Last,	16.93	1		
3	Heel Last,	10.03			
4	Tightening Lace,	27.74			
5	Gauge Marking,	28.52	1		
6	Gauge Toe,	23.59			
7	Cleaner Upper,	19.60	1		
8	Primer Outsole,	23.83			
9	Primer Upper,	54.07	1		
10	Rotary Chamber 1				
11	Cement Outsole,	26.75	1		
12	Rotary Chamber 2				
13	Attach Outsole,	77.30	2		
14	Universal Pressing,	25.13			
15	Chiller				
16	Open Lace,Open Last,	28.96	1		
17	Hotmelt Aplication on Inaysole	26.59			
18	Lacing,	28.18	1		
19	Finishing,	25.36			
20	Inspection,				
21	Metal detector				
22	Innerbox Folding,	17.30	1		
23	Insert Paper,	11.98			
24	Attach UPC,	14.61			
25	Attach Hantag,	12.28			
26	Wrapping,	27.20	1		
27	Packing,	28.24			
Total Assembly		**603.710**	**12**		

LINE BALANCING

FTY Name	**PWJ**
Model Name	**Racer TR21**
Season	**FW21**
Model ID	**LLB64**
Upper ID	**41088**
Forecast (Pairs)	
Latest Update	**29-Jul-22**
Inline EOLR	**60**
LC CTB	**150.32**
LB Efficiency	**87.4%**
Theoritical CT Efficiency	**104.5%**
LLER	**86%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Central	8.2	240	1	0.15	400	91%
Cutting Laceloop Central	2.7	2640	2	0.05	1320	99%
Pre-coating Insole Central	5.5	2400	4	0.10	600	92%
Stockfitting - Buffing	40.4	300	4	0.80	75	84%
Stockfitting - Degreaser	22.9	1200	8	0.40	150	95%
Stockfitting - UV Light	46.1	1000	15	0.90	67	85%
Stockfitting - Attaching Rubber to Phylon	261.1	300	25	5.00	12	87%
STOCKFITTING - Painting Outsole	207.9	400	25	3.75	16	92%
Cutting Inline	82.1	360	9	2	40	91%
Preparation	283.0	360	30	5	12	96%
Sewing	484.2	60	10	10	6	85%
Assembly	579.9	60	12	12	5	81%
SUBTOTAL	**2024.1**	**60**	**144**	**39**	**1.54**	**86%**
Water Spider	198.3	60		5.21		
TOTAL Incl WS	**2222.4**	**60**		**44.29**	**1.35**	

Racer TR21 K

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Manual	1	Cutting 3 Stripes Lat/Mad,	12.91	9.00	395	91%
			2	Cutting Heel Linning Lat/Mad,	6.74			
			3	Cutting Laceloops,	10.07			
			4	Cutting Heelcap,	12.34			
			5	Cutting Collar Padding,	9.33			
			6	Cutting Padding 2,	7.03			
			7	Cutting Eyestay Lat/Mad Reinf,	5.30			
			8	Cutting Eyestay,	9.14			
			9	Cutting Laceloops,	9.26			
TOTAL					**82.1**	**9**	**395**	**91%**

EOLR	WS	Deffinition	TT
360	0.5		10.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	# MP	THROUGHPUT	LLER
PREPARATION	15%	Table	1	Attach Eyestay Linning to Vamp/Quarter,	9.9	2	406	89%
			2	Attach Eyestay Lat/Mad Reinf to Eyestay	7.8			
		CS 6040	10	Stitch Eyestay Laceloops Decoration,	56.2	6	384	94%
		Table	11	Attach Eyestay Laceloops to Pallet	47.2	5	382	94%
		Stampling Size label Mc	3	Stampling collar linning,	14.6	2	370	97%
		Flat 1	4	Stitch Collar Linning Edge,	21.2	2	374	96%
		Flat 1	5	Stitch Tongue Linning to Tongue,	16.6	2	368	98%
		Table	6	Reverse Tounge	17.5	2	371	97%
		Flat 1	7	Stitch Tongue Edge,	12.2	1	382	94%
		Cs 1510	8	Stitch Tounge Logo to Tounge	32.2	3	368	98%
		Flat 1	9	Stitch Laceloops to tounge	28.8	3	362	99%
		Zig-zag MC	12	Stitch Connection Zig-Zag Heel Area,	18.7	2	366	98%
		CS 1510	13	Stitch Wabbing 1 to Upper,	16.6	2	369	98%
		CS 1510	14	Stitch Wabbing 2 to Upper,	19.1	2	376	96%
TOTAL					**283.0**	**30**	**362**	**96%**

EOLR	WS	Deffinition	TT
360	1		10.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heel Cap To upper,	58.1	1	62	97%
		Post 1N	2	Stitch Collar Linning to Upper,	54.1	1	67	90%
		Spray MC	3	Spray Area Padding 2 Lat/Mad to Upper,	12.2	2	61	98%
			4	Attaching Collar Padding 2 Lat/Mad to Upper,	12.1			
			5	Spray Upper,	14.6			
			6	Attaching Collar Padding to Upper,	14.4			
			7	Reverse Collar Lining,	24.5			
			8	Hammer Upper,	10.4			
		Posh 1N	9	Stitch Eyestay to Upper,	79.4	2	91	66%
		Posh 1N	10	Stitch Quarter Deco (Padding 2),	52.0	1	69	87%
		Posh 1N	11	Stitching Lasting Margin,	28.3	1	63	96%
		CS1510	12	Stitch Connection Tounge to Upper,	29.0			
		Upper Clamp	13	Insert Shoe Lace,	79.6	2	76	79%
		Table	14	Finishing,	15.4			
TOTAL					**484.2**	**10**	**61**	**85%**

EOLR	WS	Deffinition	TT
60	1		60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	# MP	THROUGHPUT	LLER
ASSEMBLY	1.15	Strobel Mc	1	Stitch Strobel,	49.54	1.00	73	83%
		Kabuki	2	Insert Last,	16.93	1.00	66	91%
		Heel last Mc	3	Heel Last,	10.03			
		Table	4	Tightening Lace,	27.74			
		Gauge Marking Mc	5	Gauge Marking,	28.52	1.00	69	87%
		Table	6	Gauge Toe,	23.59			
		Table	7	Cleaner Upper,	19.60	1.00	83	72%
		Table	8	Primer Outsole,	23.83			
		Table	9	Primer Upper,	54.07	1.00	67	90%
		Rotary Chamber	10	Rotary Chamber 1				
		Table	11	Cement Outsole,	26.75	1.00	135	45%
		Rotary Chamber	12	Rotary Chamber 2				
		Conveyor Mc	13	Attach Outsole,	77.30	2.00	70	85%
		Universal Press Mc	14	Universal Pressing,	25.13			
		Chiller Mc	15	Chiller				
		Table	16	Open Lace,Open Last,	28.96	1.00	65	93%
		Sockliner Mc	17	Hotmelt Aplication on Inaysole	26.59			
		Table	18	Lacing,	28.18	1.00	67	89%
		Table	19	Finishing,	25.36			
		Table	20	Inspection,				
		Metal Detector Mc	21	Metal detector				
		Table	22	Innerbox Folding,	17.30	1.00	64	94%
		Table	23	Insert Paper,	11.98			
		Table	24	Attach UPC,	14.61			
		Table	25	Attach Hantag,	12.28			
		Table	26	Wrapping,	27.20	1.00	65	92%
		Table	27	Packing,	28.24			
TOTAL					**579.9**	**12**	**64**	84%

EOLR	WS	Deffinition	TT
60	1		60.0