

120 OSA

FTY Name	PWJ
Model Name	GRAND COURT BASE
Season	FW21
Model ID	EOS85, EOU26, KYJ12
Upper ID	5692
Forecast (Pairs)	1612309
Latest Update	28-Mar-21
Inline EOLR	120
LC CTB	127.58
LB Efficiency	89.53%
Theoretical CT Efficiency	105.4%
LLER	83%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Central	11.5	120	1	1	109	35%
Pre-coating Insole Central	5.4	2640	4	0	660	99%
Stockfitting - Degreaser	22.1	1200	8	0.8	150	92%
Cutting Inline	36.7	120	2	2	60	61%
Preparation	514.8	120	21	21	6	82%
Sewing	365.6	120	13	13	9	94%
Assembly	694.0	120	28	28	4	83%
SUBTOTAL	1650.1	120		66	1.82	83%
Water Spider		120		7		
TOTAL Incl WS		120		73	1.64	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING IN LINE	15%	Manual (Hydraulic)	1	Cutting heel counter,	6.91	0.23	2.00	196	61%
			2	Cutting collar lining,	5.75	0.19			
			3	Cutting collar foam,	5.18	0.17			
			4	Cutting tongue,	5.64	0.19			
			5	Cutting tongue lining,	5.98	0.20			
			6	Cutting 3 Stripes,	4.83	0.16			
			7	Cutting toe box,	2.42	0.08			
TOTAL					36.7	1.2	2	196	61%
		EOLR	WS	Deffinition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
		Skiving Counter	1	Skiving heel counter,	14.08	0.5	0.5	128	94%
		Skiving Mc	2	Skiving vamp,	10.47	0.3			
		Skiving Mc	3	Skiving qtr lat/med,	23.06	0.8			
		Skiving Mc	4	Skiving Eyestay,	16.91	0.6			
		Skiving Mc	5	Skiving heel tab	9.89	0.3			
		CS-1510	6	Stitching tongue label,	18.80	0.6	1	191	63%
		Auto label	7	Stamping size label,	14.19	0.5	0.5	127	95%
		Flat 1N	8	Stitching tongue to tongue lining,	16.42	0.5			
		Tongue forming Mc	9	Reverse tongue,	10.81	0.4	1	132	91%
		Flat 1N	10	Stitching lace loop,	22.56	0.8	1	160	75%
		Post 1N	11	Stitch Tongue Edge,	14.97	0.5	1	240	50%
		Post 2N	12	Stitching vamp to tongue,	9.35	0.3	1	171	70%
			13	Stitching vamp margin,	11.70	0.4			
		Flat 1N	14	Stitch edge collar lining,	28.24	0.9	1	127	94%
		Roll hotmelt Mc	15	Roll hotmelt qtr lat/med,	28.79	1.0	2	161	75%
			16	Attach toe box & Roll hotmelt vamp,	15.95	0.5			
		CS-6040	17	Stitch 3 stripes Deco quarter IN,	27.99	0.9	1	129	93%
		Table	18	placing 3 stripes to pallet,	49.78	1.7	2	145	83%
		CS-6040	19	Stitch 3 stripes quarter Out,	26.84	0.9	1	134	89%
		Table	20	Placing Eyestay to pallet,	27.84	0.9	1	129	93%
		CS-6040	21	Stitch eyestay L/M to quarter L/M,	58.98	2.0	2	122	98%
		Flat 1N	22	Stitch Join Quarter L/M,	29.18	1.0	1	123	97%
		double folding	23	Turn quarter and Hammering heel area upper,	27.99	0.9	1	129	93%
TOTAL					514.8	17	21	122	82%
		EOLR	WS	Definition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heel tab to Upper,	42.0	1.4	2	132	91%
		Post 1N	2	Stitch heel counter to upper,	12.6	0.4			
		Post 1N	3	Stitch collar lining to upper,	59.3	2.0	2	121	99%
		Spray Mc	4	Spray upper,	14.4	0.5	2	135	88.9%
			5	Attach collar foam,	12.9	0.4			
			6	Reverse collar lining,	10.8	0.4			
		Hammering Mc	7	Hammer upper,	15.2	0.5	1	124	97%
		Punching Mc	8	Punching upper,	29.0	1.0			
		Post 1N	9	Stitching lasting margin,	54.8	1.8	2	131	91%
		CS-1510	10	Stitch Vamp/Tongue to upper,	56.6	1.9	2	127	94%
		Table	11	Insert shoe lace,	57.9	1.9	2	124	97%
TOTAL					365.6	6	13	1	46%
		EOLR	WS	Definition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding [Cold, Max 40c/20"]	29.12	0.97	1.00	124	97%
		Vamp Press Mc	2	Toe vamp molding,	28.87	0.96	1.00	125	96%
		Strobel Mc	3	Stitch Strobel,	58.39	1.95	2.00	123	97%
		Kabuki	4	Insert Laste,	21.28	0.71	1.00	125	96%
		Heel last	5	Heel Last,	7.48	0.25			
		Table	6	Strengthen lace,	28.38	0.95	1.00	127	95%
		Gauge Marking MC	7	Hell High Inspection	7.16	0.24	2.00	180	67%
			8	Gauge Marking,	32.89	1.10			
		Table	9	Prepare Outsole,	21.28	0.71	1.00	169	71%
		Table	10	Cleaner Outsole	21.28	0.71	1.00	169	71%
		Chamber MC	11	Chamber 1					
		Conveyor	12	Cleaner upper	54.66	1.82	2.00	132	91%
		Conveyor	13	Primer Outsole	26.68	0.89	1.00	135	89%
		Chamber MC	14	Chamber 2					
		Conveyor	15	Primer Upper	43.95	1.47	2.00	164	73%
		Conveyor	16	Cement Outsole	28.00	0.93	1.00	129	93%
		Chamber MC	17	Chamber 3					
		Table	18	Attach Outsole	35.42	1.18	3.00	175	69%
		Universal Pressing	19	Universal press,	26.27	0.88			
		Chiller MC	20	Chiller					
		Table	21	Open Lace,	15.30	0.51	1.00	120	100%
		Table	22	Open Laste,	14.61	0.49			
		Table	23	Cement & Insert Sockliner,	25.75	0.86	1.00	140	86%
		Table	24	Fix Lace,	23.62	0.79	1.00	152	79%
		Table	25	Finishing	44.05	1.47	2.00	163	73%
		Table	26	Inspection					
		MD Mc	27	Metal Detector					
		Table	28	Inner Box Folding	18.53	0.62	2.00	151	80%
			29	Attach Hang Tag	22.01	0.73			
			30	Attach UPC	7.18	0.24			
		Table	31	Wrapping	29.19	0.97	1.00	123	97%
			32	Packing Shoes	22.68	0.76	1.00	159	76%
TOTAL					694.0	23	28	120	83%
		EOLR	WS	Deffinition	TT				
		120	2.5		30.0				

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Model Name	GRAND COURT BASE
Season	FW21
Model ID	EOS85, EOU26, KYJ12
Upper ID	5692
Forecast (Pairs)	1612309
Latest Update	28-Mar-21
Inline EOLR	60
LC CTB	127.58
LB Efficiency	91.65%
Theoretical CT Efficiency	106.5%
LLER	84%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Central	11.5	120	1	1	109	35%
Pre-coating Insole Central	5.4	2640	4	0	660	99%
Stockfitting - Degreaser	22.1	1200	8	0	150	92%
Stockfitting - Pre-coating Outsole	102.1	600	18	2	33	95%
Cutting Inline	36.7	120	2	1	60	61%
Preparation	514.8	120	19	9	6	92%
Sewing	365.6	60	7	7	9	87%
Assembly	573.1	60	12	12	5	80%
SUBTOTAL	1631.3	60	71	32	1.86	84%
Water Spider		60		4		
TOTAL Incl WS		60		36	1.67	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING IN LINE	15%	Manual (Hydrolic)	1	Cutting heel counter,	6.91	0.23	2.00	196	61%
			2	Cutting collar lining,	5.75	0.19			
			3	Cutting tongue,	5.64	0.19			
			4	Cutting tongue lining,	5.98	0.20			
			5	Cutting 3 Stripes,	4.83	0.16			
			6	Cutting toe box,	2.42	0.08			
			7	Cutting collar foam,	5.18	0.17			
TOTAL					36.7	1.2	2	196	61%
		EOLR	WS	Deffinition	TT				
		120	0.5		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICA L	# MP	THROUGHPU T	LLER
PREPARATION	15%	Skiving Counter	1	Skiving heel counter,	14.08	0.5	0.5	128	94%
		Skiving Mc	2	Skiving vamp,	10.47	0.3	2.1	125	96%
		Skiving Mc	3	Skiving qtr lat/med,	23.06	0.8			
		Skiving Mc	4	Skiving Eyestay,	16.91	0.6			
		Skiving Mc	5	Skiving heel tab	9.89	0.3			
		CS-1510	6	Stitching tongue label,	18.80	0.6	0.7	134	90%
		Auto label	7	Stamping size label,	14.19	0.5	0.5	127	95%
		Flat 1N	8	Stitching tongue to tongue lining,	16.42	0.5	1	132	91%
		Tongue forming Mc	9	Reverse tongue,	10.81	0.4			
		Flat 1N	10	Stitching lace loop,	22.56	0.8	0.8	128	94%
		Post 1N	11	Stitch Tongue Edge,	14.97	0.5	0.5	120	100%
		Post 2N	12	Stitching vamp to tongue,	9.35	0.3	1	171	70%
			13	Stitching vamp margin,	11.70	0.4			
		Flat 1N	14	Stitch edge collar lining,	28.24	0.9	1	127	94%
		Roll hotmelt Mc	15	Roll hotmelt qtr lat/med,	28.79	1.0	2	161	75%
			16	Attach toe box & Roll hotmelt vamp,	15.95	0.5			
		CS-6040	17	Stitch 3 stripes Deco quarter IN,	27.99	0.9	1	129	93%
		Table	18	placing 3 stripes to pallet,	49.78	1.7	1.7	123	98%
		CS-6040	19	Stitch 3 stripes quarter Out,	26.84	0.9	0.9	121	99%
		Table	20	Placing Eyestay to pallet,	27.84	0.9	1	129	93%
		CS-6040	21	Stitch eyestay L/M to quarter L/M,	58.98	2.0	2	122	98%
		Flat 1N	22	Stitch Join Quarter L/M,	29.18	1.0	1	123	97%
		double folding	23	Turn quarter and Hammering heel area upper,	27.99	0.9	1	129	93%
TOTAL					514.8	17	19	120	92%
		EOLR	WS	Deffinition	TT				
		120	0.5		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heel tab to Upper,	42.0	0.7	1	66	91%
		Post 1N	2	Stitch heel counter to upper,	12.6	0.2			
		Post 1N	3	Stitch collar lining to upper,	59.3	1.0	1	61	99%
		Spray Mc	4	Spray upper,	14.4	0.2	1	67	89%
			5	Attach collar foam,	12.9	0.2			
			6	Reverse collar lining,	10.8	0.2			
		Hammering Mc	7	Hammer upper,	15.2	0.3	1	124	48%
		Punching Mc	8	Punching upper,	29.0	0.5			
		Post 1N	9	Stitching lasting margin,	54.8	0.9	1	66	91%
		CS-1510	10	Stitch Vamp/Tongue to upper,	56.6	0.9	1	64	94%
		Table	11	Insert shoe lace,	57.9	1.0	1	62	97%
TOTAL					365.6	6	7	61	87%
		EOLR	WS	Deffinition		TT			
		60	0.5			60.0			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding [Cold, Max 40c/20"]	29.12	0.49	1.00	62	97%
		Vamp Press Mc	2	Toe vamp molding,	28.87	0.48			
		Strobel Mc	3	Stitch Strobel,	58.39	0.97			
		Kabuki	4	Insert Laste,	21.28	0.35			
		Heel last	5	Heel Last,	7.48	0.12			
		Sthrengthen lace Hanger	6	Strengthen lace,	28.38	0.47	1.00	90	67%
		Gauge Marking MC	7	Hell High Inspection	7.16	0.12			
			8	Gauge Marking,	32.89	0.55			
		Table	9	Cleaner upper	54.66	0.91	1.00	66	91%
		Rotary Chamber MC	10	Rotary Chamber					
		Table	11	Primer Upper	43.95	0.73	1.00	82	73%
		Rotary Chamber MC	12	Rotary Chamber					
		Open last Mc	13	Attach Outsole	35.42	0.59	2.00	117	51%
		Table	14	Universal press,	26.27	0.44			
		Chiller MC	15	Chiller					
		Table	16	Open Lace,	15.30	0.25	1.00	65	93%
		MD Mc	17	Open Laste,	14.61	0.24			
		Table	18	Cement & Insert Sockliner,	25.75	0.43			
		Table	19	Finishing	44.05	0.73	1.00	82	73%
		Table	20	Inspection					
		MD Mc	21	Metal Detector					
		Table	22	Inner Box Folding	18.53	0.31	1.00	75	80%
			23	Attach Hang Tag	22.01	0.37			
			24	Attach UPC	7.18	0.12			
		Table	25	Wrapping	29.19	0.49	1.00	69	86%
			26	Packing Shoes	22.68	0.38			
TOTAL					573.12	10	12	65	80%
		EOLR	WS	Deffinition	TT				
		60	1.25		60.0				