120

FTY Name	**PWJ**
Model Name	**Retropy F2**
Season	**SS22**
Model ID	**LWA658**
Upper ID	**GW0505 GW0506 GW0507 GW0508 GW0509 GW0510 GW0511 GW1**
Forecast (Pairs)	**682660**
Latest Update	**Friday, October 1, 2021**
Inline EOLR	**120**
LC CTB	**163.51**
LB Efficiency	**73.7%**
Theoritical CT Efficiency	**91.2%**
LLER	**82%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversio	**PPH**	**LLER**
Cutting Auto	20.3	240	2	1	120	68%
Pre-coating Insole Central	2.7	2400	2	0.1	1200	90%
Stockfitting - Buffing	53.4	300	5	2.0	60	89%
Stockfitting - Degreaser	15.5	1200	6	0.6	200	86%
Stockfitting - UV Light	51.2	800	14	2.1	57	81%
Stockfitting - Attaching	363.4	300	35	14.0	9	87%
Cutting Inline	131.6	120	5	5	24	88%
Preparation	642.0	120	28	28	4	76%
Sewing	626.9	120	23	23	5	91%
Assembly	669.3	120	29	29	4	77%
SUBTOTAL	**2576.3**	**120**	**149**	**105**	**1.15**	**82%**
Water Spider		120		10		
TOTAL Incl WS		**120**		**114**	**1.05**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp / Quarter,	6.87	0.23	5.00	137	88%
			2	Cutting Toecap Accent,	3.74	0.12			
			3	Cutting Heelpatch Underlay,	9.49	0.32			
			4	Cutting 3 Stripe,	7.19	0.24			
			5	Cutting Heelpatch,	15.63	0.52			
			6	Cutting Toecap,	19.19	0.64			
			7	Cutting Heelcap,	17.63	0.59			
			8	Cutting Heel Counter	3.37	0.11			
			9	Cutting Collar padding	3.36	0.11			
			10	Cutting Tongue Logo Reinf,	6.25	0.21			
			11	Cutting Eyestay,	19.63	0.65			
			12	Cutting Tongue,	10.56	0.35			
			13	Cutting Tongue Laceloops,	4.50	0.15			
			14	Cutting Tongue Padding Reinf,	0.99	0.03			
			15	Cutting Tongue Padding,	3.25	0.11			
TOTAL					**131.6**	**4.39**	**5**	**137**	**88%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Manual/ Table	1	Attach Tongue Loop to Tongue	27.0	0.9	1	133	90%
		Press MC	2	Press Nosew Tongue Lace Loop,	25.1	0.8	1	143	84%
		CS 1510	3	Stitch Tongue Laceloop,	23.0	0.8	1	156	77%
		Pounching MC	4	Pounching Slit Tongue Laceloop,	17.3	0.6	1	208	58%
		Manual	5	Attach Tongue Padding,	13.0	0.4	1	276	43%
		Manual	6	Attach Tongue Reinf to Tongue Padding,	15.3	0.5	1	235	51%
		Flat 1N	7	Stitch Tongue to Linning,	40.5	1.3	2	178	67%
		Obaroco	8	Lock Stitch Tongue Binding,	56.5	1.9	2	127	94%
		Post 1N	9	Folded Tongue Lining Logo and Then Stitching Tongue Logo to Tor	15.0	0.5	1	240	50%
		Auto Stamping	10	Stamping Size Label to Tongue linning,	14.2	0.5	1	253	47%
		Flat 1N	11	Stitch Edge Collar linning,	25.1	0.8	1	143	84%
		Hand Work	12	Attach Vamp Qrt Reinf,	26.0	0.9	2	131	92%
			13	Attach Heelpatch Reinf,	11.0	0.4			
			14	Attach Eyestay Reinf to Eyestay	18.0	0.6			
		Hotmelt Roll Press	15	Attach Heel Counter & Hotmelt	16.9	0.6	1	121	99%
			16	Attach Toecap reinf and Roll hotmelt,	12.9	0.4			
		CS 6040	16	Stitch Deco Heelcap,	28.5	1.0	1	126	95%
		Manual	16	Attach 3 Stripe,	45.2	1.5	2	159	75%
		CS 6040	16	Stitch 3 Stripe to Upper,	53.0	1.8	2	136	88%
		Manual	17	Attach Heepatch underlay, toecap underlay to pallet	57.0	1.9	2	126	95%
		CS 6040	18	Stitch Toecap Accent to Vamp,Stitch Heelpatch Underlay to Vamp	49.1	1.6	2	147	82%
		Flat Z/Z	19	Stitch Z/Z Vapm Qrt (Toe Area)	29.0	1.0	1	124	97%
		Flat Z/Z	20	Stitch Z/Z Vamp Qrt (Heel Area)	23.1	0.8	1	156	77%
TOTAL					**642.0**	**21.4**	**28.0**	**121**	**76%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heelpatch to Upper,	57.4	1.9	2.00	125	96%
		Post 2N	2	Stitch Toecap to Upper,	87.2	2.9	3.00	124	97%
		Post 2N	3	Stitch Heelcap to Upper,	51.3	1.7	2.00	140	86%
		Post 1N	4	Stitch Collar linning to Upper,	55.2	1.8	2.00	131	92%
		Multy Spray	5	Spray Vamp/Quarter (Toe Area)	7.2	0.2	2.00	122	98%
			6	Spray Collar linning	14.6	0.5			
			7	Attach Collar padding,	9.0	0.3			
			8	Reverse Collar linning	15.2	0.5			
		Hammering Mc	9	Hammering	13.0	0.4			
		Post 1 N/CS 1510	10	Stitch Collar Linning 2ND (Padding 2)	58.0	1.9	2.00	124	97%
		Post 1N	11	Spray Eyestay & Stitch Eyestay to Upper,	96.5	3.2	4.00	149	80%
		Pounching Mc	12	Eyestay Hole Pounch,	27.0	0.9	1.00	133	90%
		CS 1510	13	Stitch Joint Tongue to Upper,	25.0	0.8	1.00	144	83%
		Post 1N	14	Stitch Margin Upper	23.2	0.8	1.00	155	77%
		Upper Clamp	15	Insert Shoe Lace,	87.1	2.9	3.00	124	97%
TOTAL					**626.9**	**21**	**23**	**122**	**91%**

EOLR	WS	Deffinition	TT
120	2		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding,	29.24	0.97	1.00	123	97%
		Strobel Mc	2	Stitch Strobel,	48.26	1.61	2.00	149	80%
		Table	3	Setting Last,	18.36	0.61	1.00	196	61%
		Kabuki	4	Insert Last,	14.40	0.48	1.00	146	82%
		Heel Last Mc	5	Heel Last,	10.24	0.34			
		Table	6	Tightening Lace,	27.28	0.91	1.00	132	91%
		Gauge Marking Mc	7	Gauge Marking,	29.64	0.99	1.00	121	99%
		Table	8	Gauge Toe,	19.34	0.64	1.00	186	64%
		Rak Outsole	9	Prepare Outsole,	17.26	0.58	1.00	209	58%
		Conveyor	10	Cleaner Upper,Cleaner Outsole,	22.96	0.77	1.00	157	77%
		Chamber 1	11	Chamber 1	23.52				
		Conveyor	12	Primer Upper,	48.30	1.61	2.00	149	81%
		Conveyor	13	Primer Outsole,	29.14	0.97	1.00	124	97%
		Chamber 2	14	Chamber 2	25.36				
		Conveyor	15	Cement Upper,	57.20	1.91	2.00	126	95%
		Conveyor	16	Cement Outsole,	19.54	0.65	1.00	184	65%
		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,	16.94	0.56	1.00	213	56%
		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					**669.3**	**23**	**29**	**121**	**80%**

EOLR	WS	Deffinition	TT
120	2.5		30.0