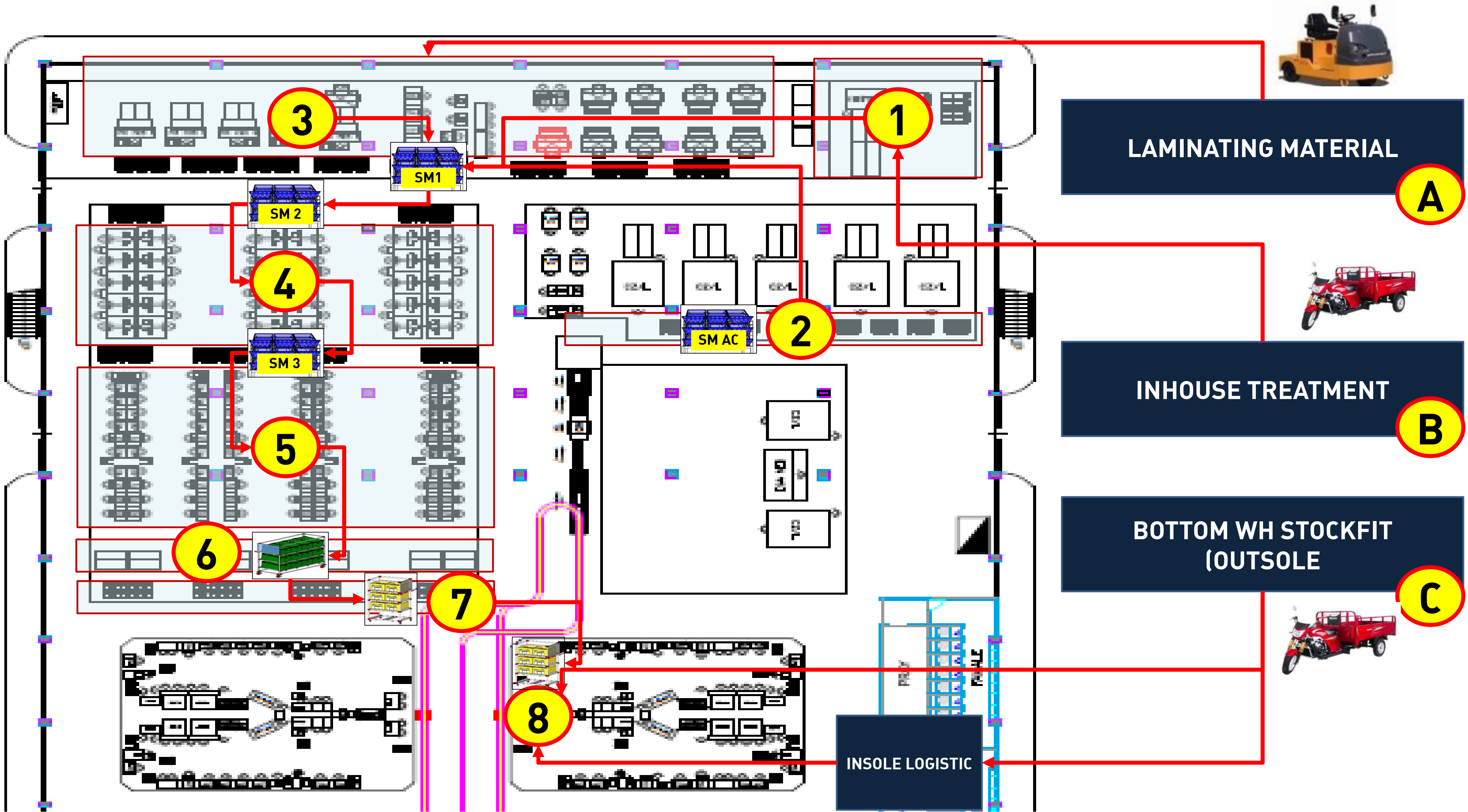
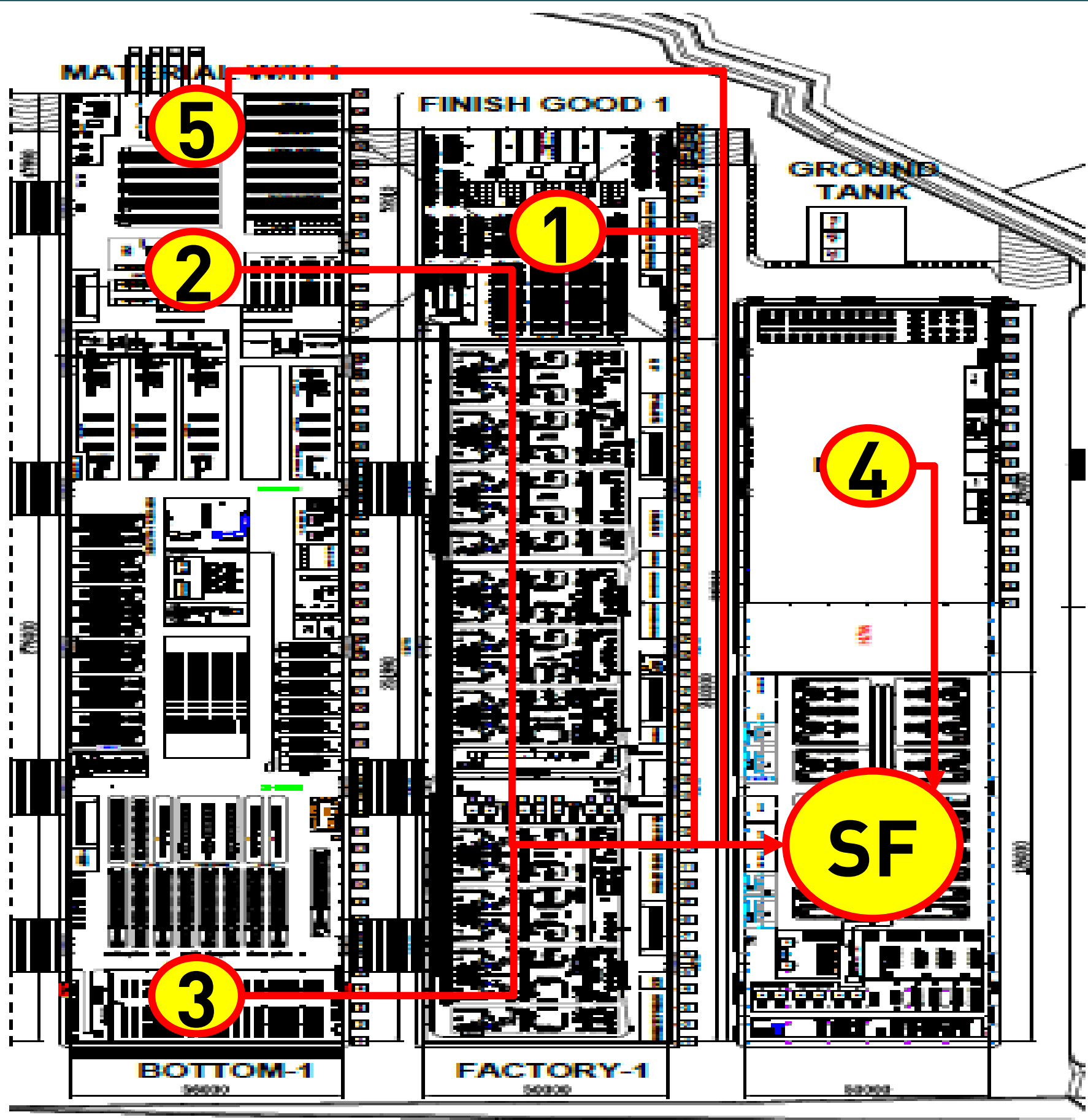


# MATERIAL FLOW – SPECIAL FACTORY



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

## FTY OVERALL FLOW – SPECIAL FACTOTY



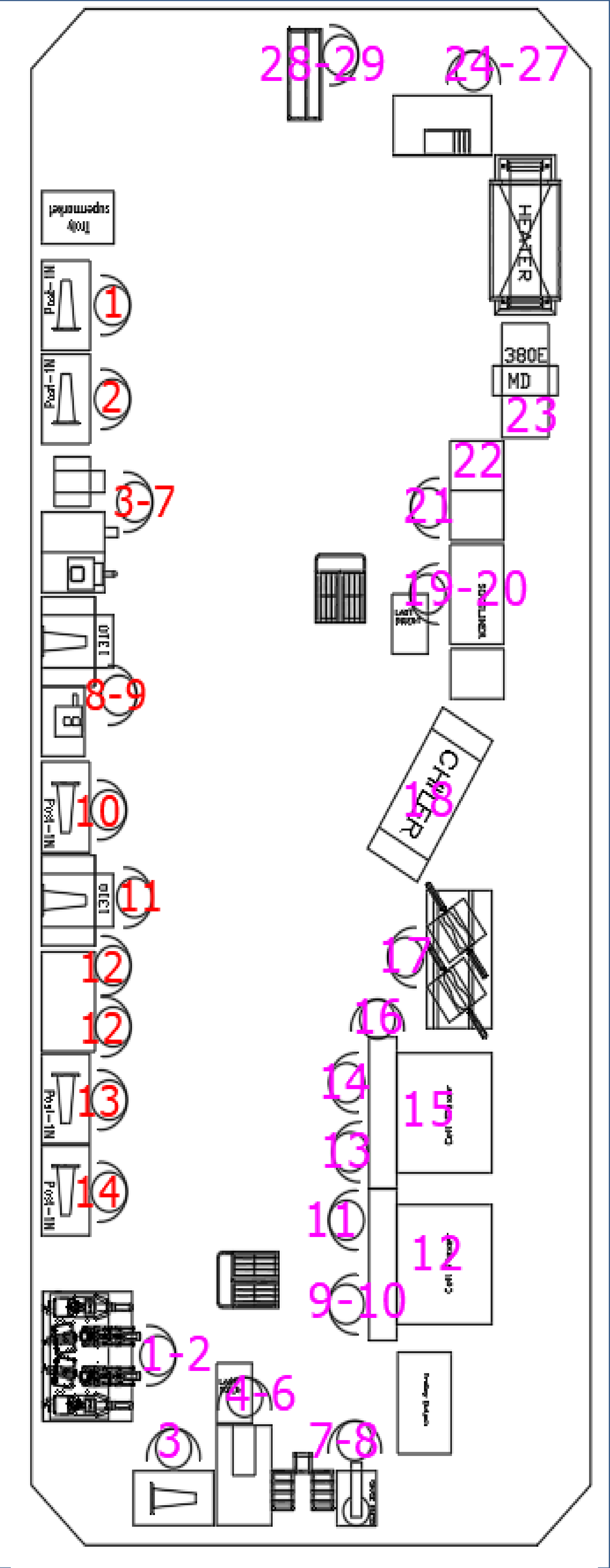
| CODE | AREA                      | MATERIAL  | TRANSPORTATION |
|------|---------------------------|---|----------------|
| 1    | WH RAW Material           | • RAW material before laminating process<br>• Accesories component (Webbing, Handtag, loop, etc)<br>• Thread<br>• Karton<br>• Inner Box<br>•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

Tracking IE Data Actual

Model : Racer TR 21 C

Layout

IE Data



| NO             | Process                                      | CT STD | MP Std | MP Act | Remark |
|----------------|--|--------|--------|--------|--------|
| 1              | Stitch Heel Cap To upper,                    | 58.1   | 1      |        |        |
| 2              | Stitch Collar Lining to Upper,               | 54.1   | 1      |        |        |
| 3              | Attaching Collar Padding 2 Lat/Mad to Upper, | 12.1   | 1      |        |        |
| 4              | Spray Upper,                                 | 12     |        |        |        |
| 5              | Attaching Collar Padding to Upper,           | 14.4   |        |        |        |
| 6              | Reverse Collar Lining,                       | 13     |        |        |        |
| 7              | Hammer Upper,                                | 8.1    | 1      |        |        |
| 8              | Stitch hole deco to upper                    | 26.1   |        |        |        |
| 9              | pouncing Hole Deco to upper                  | 28.3   | 1      |        |        |
| 10             | Stitching Lasting Margin,                    | 16.9   |        |        |        |
| 11             | Stitch Connection Tounge to Upper,           | 29     | 2      |        |        |
| 12             | Insert Shoe Lace,                            | 79.6   |        |        |        |
| 13             | Stitch Padding 2 And Stitch Lock lace,       | 95.7   | 2      |        |        |
| 14             | Stitch Straps Loops to Upper,                | 56.6   | 1      |        |        |
| Total Sewing   |  | 504.00 | 10     |        |        |
| 1              | Toe Vamp Molding,                            |        |        |        |        |
| 2              | Stitch Strobel,                              | 49.54  | 1      |        |        |
| 3              | Setting Laste,                               | 21.9   | 1      |        |        |
| 4              | Insert Last,                                 | 16.93  |        |        |        |
| 5              | Heel Last,                                   | 10.03  |        |        |        |
| 6              | Tightening Velcro,                           | 27.74  | 1      |        |        |
| 7              | Prepare Outsole,                             | 12.03  |        |        |        |
| 8              | Cleaner Upper,                               | 19.6   | 1      |        |        |
| 9              | Gauge Marking,                               | 28.52  |        |        |        |
| 10             | Gauge Toe,                                   | 23.59  | 1      |        |        |
| 11             | Primer Upper,                                | 54.07  |        |        |        |
| 12             | Primer Outsole,                              | 23.83  | 1      |        |        |
| 13             | Chamber 1                                    |        |        |        |        |
| 14             | Cement Upper,                                | 57.98  | 1      |        |        |
| 15             | Cement Outsole,                              | 26.75  | 1      |        |        |
| 16             | Chamber 2                                    |        |        |        |        |
| 17             | Attach Outsole,                              | 58.9   | 1      |        |        |
| 18             | Universal Pressing,                          | 25.13  | 1      |        |        |
| 19             | Cleaning Shoes,                              | 28.84  |        |        |        |
| 20             | Chiller                                      |        |        |        |        |
| 21             | Open Velcro,Open Last,                       | 21.53  | 1      |        |        |
| 22             | Cement & Insert Sockliner,                   | 22.17  |        |        |        |
| 23             | Lacing,                                      | 28.18  | 1      |        |        |
| 24             | Repairing                                    | 21.44  |        |        |        |
| 25             | Inspection,                                  |        |        |        |        |
| 26             | Metal detector                               |        |        |        |        |
| 27             | Innerbox Folding,                            | 17.3   | 1      |        |        |
| 28             | Insert Paper,                                | 11.98  |        |        |        |
| 29             | Attach UPC,                                  | 14.61  |        |        |        |
| 30             | Attach Hantag,                               | 12.28  | 1      |        |        |
| 31             | Wrapping,                                    | 27.2   |        |        |        |
| 32             | Packing,                                     | 28.24  |        |        |        |
| Total Assembly |  | 690.31 | 14     |        |        |



## LINE BALANCING

|                           |              |  |
|---------------------------|--------------|--|
| FTY Name                  | PWJ          |  |
| Model Name                | Racer TR21 C |  |
| Season                    | FW21         |  |
| Model ID                  | LV192        |  |
| Upper ID                  | 41088        |  |
| Forecast (Pairs)          |              |  |
| Latest Update             | 9-Mar-21     |  |
| Inline EOLR               | 60           |  |
| LC CTB                    | 155,19       |  |
| LB Efficiency             | 87,0%        |  |
| Theoritical CT Efficiency | 107,5%       |  |
| LLER                      | 84%          |  |

| Module                                    | TCT<br>Module | EOLR<br>Module | MP<br>Module | MP<br>Module<br>conversion | PPH         | LLER       |
|---|---------------|----------------|--------------|----------------------------|-------------|------------|
| Cutting Central                           | 6,6           | 240            | 1            | 0,13                       | 480         | 88%        |
| Pre-coating Insole Central                | 5,5           | 2400           | 4            | 0,10                       | 600         | 92%        |
| Stockfitting - Buffing                    | 40,4          | 400            | 5            | 0,75                       | 80          | 90%        |
| 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 | 224,1         | 400            | 29           | 4,35                       | 14          | 86%        |
| STOCKFITTING - Painting Outsole           | 217,9         | 400            | 26           | 3,90                       | 15          | 93%        |
| Cutting Inline                            | 95,6          | 360            | 12           | 2                          | 30          | 80%        |
| Preparation                               | 338,6         | 360            | 38           | 6                          | 10          | 90%        |
| Sewing                                    | 508,9         | 60             | 10           | 10                         | 6           | 84%        |
| Assembly                                  | 603,5         | 60             | 13           | 13                         | 5           | 77%        |
| <b>SUBTOTAL</b>                           | <b>2110,0</b> | <b>60</b>      | <b>160</b>   | <b>42</b>                  | <b>1,43</b> | <b>84%</b> |
| Water Spider                              |               | 60             |              | 4                          |             |            |
| <b>TOTAL Incl WS</b>                      |               | <b>60</b>      |              | <b>46</b>                  | <b>1,31</b> |            |

# Racer TR21 C

| AREA           | Allowance | MACHINERY | NO | PROCESS DESCRIPTION            | CYCLE TIME | THEORITICAL | # MP  | THROUGHPUT | LLER |
|----------------|-----------|-----------|----|--------------------------------|------------|-------------|-------|------------|------|
| CUTTING INLINE | 15%       | Manual    | 1  | Cutting 3 Stripes Lat/Mad,     | 14,06      | 1,4         | 12,00 | 373        | 97%  |
|                |           |           | 2  | Cutting Eyestay Linning,       | 8,53       | 0,9         |       |            |      |
|                |           |           | 3  | Cutting Heel Linning Lat/Mad,  | 9,04       | 0,9         |       |            |      |
|                |           |           | 4  | Cutting Laceloops,             | 15,25      | 1,5         |       |            |      |
|                |           |           | 5  | Cutting Heelcap,               | 12,91      | 1,3         |       |            |      |
|                |           |           | 6  | Cutting Collar Padding,        | 9,33       | 0,9         |       |            |      |
|                |           |           | 7  | Cutting Eyestay Lat/Mad Reinf, | 8,03       | 0,8         |       |            |      |
|                |           |           | 8  | Cutting Laceloops,             | 9,14       | 0,9         |       |            |      |
|                |           |           | 9  | Cutting Eyestay,               | 9,26       | 0,9         |       |            |      |
|                |           |           | 10 | Cutting Velcro Hooks,          | 9,64       | 1,0         |       |            |      |
|                |           |           | 11 | Cutting Straps Loops,          | 10,65      | 1,1         |       |            |      |
| TOTAL          |           |           |    |                                | 95,6       | 9,6         | 12    | 373        | 80%  |
|                |           | EOLR      | WS | Deffinition                    | TT         |             |       |            |      |
|                |           | 360       | 1  |                                | 10,0       |             |       |            |      |

| AREA        | ALLOWANCE | MACHINERY              | NO | PROCESS DESCRIPTION  | CYCLE TIME | THEORITICAL | # MP | THROUGHPUT | LLER |
|-------------|-----------|------------------------|----|--|------------|-------------|------|------------|------|
| PREPARATION | 15%       | Table                  | 1  | Attach Eyestay Linning to Vamp/Quarter,                      | 8,6        | 0,9         | 2    | 374        | 96%  |
|             |           |                        | 2  | Attach Eyestay Laceloops to Eyestay Lat/Mad Reinf            | 10,7       | 1,1         |      |            |      |
|             |           | CS 3020                | 3  | Attach Strap Velcro Loop And Tounge Strap To Pallet computer | 16,6       | 1,7         | 2    | 434        | 83%  |
|             |           |                        | 4  | stitch Strap variation                                       | 14,6       | 1,5         | 2    | 495        | 73%  |
|             |           | Zig-zag MC             | 5  | Stitch velcro Hook & Loops                                   | 6,3        | 0,6         | 1    | 570        | 63%  |
|             |           | Booster Mc             | 6  | Re-Cutting strap   | 10,5       | 1,1         | 2    | 684        | 53%  |
|             |           | Stamping Size label Mc | 7  | Stamplng collar linning,                                     | 14,6       | 1,5         | 2    | 370        | 97%  |
|             |           | Flat 1                 | 8  | Stitch Collar Linning Edge,                                  | 14,7       | 1,5         | 2    | 366        | 98%  |
|             |           | Flat 1                 | 9  | Stitch Tongue Linning to Tongue,                             | 19,8       | 2,0         | 2    | 363        | 99%  |
|             |           | Table                  | 10 | Reverse Tounge   | 15,2       | 1,5         | 2    | 379        | 95%  |
|             |           | Flat 1                 | 11 | Stitch Tongue Edge,  | 12,2       | 1,2         | 2    | 588        | 61%  |
|             |           | Cs 1510                | 12 | Stitch Tounge Logo to Tounge                                 | 7,2        | 0,7         | 2    | 371        | 97%  |
|             |           | Cs 1510                | 13 | Stitch Zigzag Tongue Logo to Tongue,                         | 8,3        | 0,8         |      |            |      |
|             |           | Flat 1                 | 14 | Stitch Tongue Laceloop to Tongue,                            | 18,2       | 1,8         | 2    | 375        | 96%  |
|             |           | CS 6040                | 15 | Stitch Eyestay to Upper,                                     | 38,2       | 3,8         | 4    | 377        | 96%  |
|             |           | Cs 6040                | 16 | Stitch Eyestay Laceloops Decoration,                         | 39,8       | 4,0         | 4    | 362        | 99%  |
|             |           | Table                  | 17 | Attach Eyestay Laceloops to pallet                           | 28,3       | 2,8         | 3    | 381        | 94%  |
|             |           | Zig-zag MC             | 17 | Stitch Connection Zig-Zag Heel Area,                         | 18,2       | 1,8         | 2    | 375        | 96%  |
|             |           | CS1510                 | 18 | Stitch Wabbing 1 to Upper,                                   | 16,3       | 1,6         | 2    | 375        | 96%  |
|             |           | CS1510                 | 19 | Stitch Wabbing 2 to Upper,                                   | 20,1       | 2,0         | 2    | 376        | 96%  |
| TOTAL       |           |                        |    |  | 338,6      | 33,9        | 38   | 362        | 90%  |
|             |           | EOLR                   | WS | Deffinition  | TT         |             |      |            |      |
|             |           | 360                    | 1  |  | 10,0       |             |      |            |      |

| AREA      | ALLOWANCE | MACHINERY   | NO   | PROCESS DESCRIPTION                          | CYCLE TIME  | Theoretical | # MP | THROUGHPUT | LLER |  |
|-----------|-----------|-------------|------|--|-------------|-------------|------|------------|------|--|
| STITCHING | 15%       | Post 1N     | 1    | Stitch Heel Cap To upper,                    | 58,1        | 1,0         | 1    | 62         | 97%  |  |
|           |           |             | 2    | Stitch Collar Linning to Upper,              | 54,1        | 0,9         | 1    | 67         | 90%  |  |
|           |           | Spray MC    | 3    | Attaching Collar Padding 2 Lat/Mad to Upper, | 12,1        | 0,2         | 1    | 62         | 98%  |  |
|           |           |             | 4    | Spray Upper,                                 | 7,4         | 0,1         |      |            |      |  |
|           |           |             | 5    | Attaching Collar Padding to Upper,           | 14,4        | 0,2         |      |            |      |  |
|           |           |             | 6    | Reverse Collar Lining,                       | 24,5        | 0,4         |      |            |      |  |
|           |           |             | 7    | Hammer Upper,                                | 5,8         | 0,1         |      |            |      |  |
|           |           | CS1510      | 8    | Stitch hole deco to upper                    | 26,1        | 0,4         | 1    | 84         | 91%  |  |
|           |           | Pouncing Mc | 9    | pouncing Hole Deco to upper                  | 16,9        | 0,5         |      |            |      |  |
|           |           | Post 1N     | 10   | Stitching Lasting Margin,                    | 28,3        | 0,5         | 1    | 63         | 96%  |  |
|           |           | CS1510      | 11   | Stitch Connection Tounge to Upper,           | 29,0        | 0,5         |      |            |      |  |
|           |           | Upper Clamp | 12   | Insert Shoe Lace,                            | 79,6        | 1,3         | 2    | 90         | 66%  |  |
|           |           | Post 1N     | 13   | Stitch Padding 2 And Stitch Lock lace,       | 95,7        | 1,6         | 2    | 75         | 80%  |  |
|           |           | Posh 1N     | 14   | Stitch Straps Loops to Upper,                | 56,6        | 0,9         | 1    | 64         | 94%  |  |
|           |           |             |      |  | 508,9       | 8,7         | 10,1 | 62         | 86%  |  |
|           |           |             | EOLR | WS   | Deffinition | TT          |      |            |      |  |
|           |           | TOTAL       |      | 60   | 1           |             | 60,0 |            |      |  |

| AREA     | ALLOWANCE | MACHINERY          | NO | PROCESS DESCRIPTION        | CYCLE TIME | Theoritical | # MP | THROUGHPUT | LLER |
|----------|-----------|--------------------|----|----------------------------|------------|-------------|------|------------|------|
| ASSEMBLY | 15%       | Toe Vamp Molding   | 1  | Toe Vamp Molding,          | 25,99      | 0,43        | 1    | 139        | 43%  |
|          |           | Strobel Mc         | 2  | Stitch Strobel,            | 49,54      | 0,83        | 1    | 73         | 83%  |
|          |           | Rack laste         | 3  | Setting Laste,             | 21,90      | 0,36        | 1    | 74         | 81%  |
|          |           | Kabuki             | 4  | Insert Last,               | 16,93      | 0,28        |      |            |      |
|          |           | Heel last Mc       | 5  | Heel Last,                 | 10,03      | 0,17        |      |            |      |
|          |           | Table              | 6  | Tightening Velcro,         | 27,74      | 0,46        | 1    | 61         | 99%  |
|          |           | Rack Outsole       | 7  | Prepare Outsole,           | 12,03      | 0,20        |      |            |      |
|          |           | Table              | 8  | Cleaner Upper,             | 19,60      | 0,33        |      |            |      |
|          |           | Gauge Marking Mc   | 9  | Gauge Marking,             | 28,52      | 0,48        | 1    | 69         | 87%  |
|          |           | Table              | 10 | Gauge Toe,                 | 23,59      | 0,39        |      |            |      |
|          |           | Table              | 11 | Primer Upper,              | 54,07      | 0,90        | 1,00 | 67         | 90%  |
|          |           | Table              | 12 | Primer Outsole,            | 23,83      | 0,40        | 1,00 | 151        | 40%  |
|          |           | Rotary Chamber     | 13 | Chamber 1                  |            |             |      |            |      |
|          |           | Conveyor Mc        | 14 | Cement Outsole,            | 26,75      | 0,45        | 1,00 | 135        | 45%  |
|          |           | Rotary Chamber     | 15 | Chamber 2                  |            |             |      |            |      |
|          |           | Conveyor Mc        | 16 | Attach Outsole,            | 58,90      | 0,98        | 1    | 61         | 98%  |
|          |           | Universal Press Mc | 17 | Universal Pressing,        | 25,13      | 0,42        | 1    | 67         | 90%  |
|          |           | Table              | 18 | Cleaning Shoes,            | 28,84      | 0,48        |      |            |      |
|          |           | Chiller Mc         | 19 | Chiller                    |            |             |      |            |      |
|          |           | Table              | 20 | Open Velcro,Open Last,     | 21,53      | 0,36        | 1    | 82         | 73%  |
|          |           | Sockliner Mc       | 21 | Cement & Insert Sockliner, | 22,17      | 0,37        |      |            |      |
|          |           | Table              | 22 | Lacing,                    | 28,18      | 0,47        | 1    | 73         | 83%  |
|          |           | Table              | 23 | Repairing                  | 21,44      | 0,36        |      |            |      |
|          |           | Table              | 24 | Inspection,                |            |             |      |            |      |
|          |           | Metal Detector Mc  | 25 | Metal detector             |            |             |      |            |      |
|          |           | Table              | 26 | Innerbox Folding,          | 17,30      | 0,29        | 1    | 64         | 94%  |
|          |           | Table              | 27 | Insert Paper,              | 11,98      | 0,20        |      |            |      |
|          |           | Table              | 28 | Attach UPC,                | 14,61      | 0,24        |      |            |      |
|          |           | Table              | 29 | Attach Hantag,             | 12,28      | 0,20        |      |            |      |
|          |           | Table              | 30 | Wrapping,                  | 27,20      | 0,45        | 1    | 65         | 92%  |
|          |           | Table              | 31 | Packing,                   | 28,24      | 0,47        |      |            |      |
| TOTAL    |           |                    |    |                            | 603,5      | 11          | 13   | 61         | 81%  |
|          |           | EOLR               | WS | Deffinition                | TT         |             |      |            |      |
|          |           | 60                 | 1  |                            | 60,0       |             |      |            |      |