

120 OSA

FTY Name	PWJ
Model Name	Duramo 10 WIDE
Season	FW21
Model ID	LWO08GW8347
Upper ID	
Forecast (Pairs)	
Latest Update	August 6Th, 2021
Inline EOLR	120
LC CTB	130.26
LB Efficiency	82.0%
Theoretical CT Efficiency	97.5%
LLER	82%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Leather Central	30.6	240	3	2	80	68%
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	57.3	120	3	3	40	64%
Preparation	341.6	120	13	13	9	88%
Sewing	281.1	120	11	11	11	85%
Assembly	687.4	120	28	28	4	82%
SUBTOTAL	1785.2	120		73	1.65	82%
Water Spider		120		9		
TOTAL Incl WS		120		82	1.47	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydraulic	1	Cutting Vamp Accent,	4.4	0.1	3	189	64%
			2	Cutting Eyestay Top L/M	4.2	0.1			
			3	Cutting 3 Stripe,	6.0	0.2			
			4	Cutting Heelcap Backer	4.3	0.1			
			5	Cutting eyestay reinf,	4.8	0.2			
			6	Cutting eyestay lower	4.2	0.1			
			7	Cutting Heelcap Foam Bottom	4.5	0.2			
			8	Cutting Heelcap foam Top	4.6	0.2			
			9	Cutting Collar Padding,	5.0	0.2			
			10	Cutting Heel Counter,	5.1	0.2			
			11	Cutting Toebox,	4.6	0.2			
			12	Cutting Heelcap Reinf	4.2	0.1			
			13	Cutting Heelcap	5.5	0.2			
TOTAL					57.3	2	3	189	64%
		EOLR	WS	Definition		TT			
		120	1			30.0			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# 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,	19.1	0.6	1	130	92%
		Tongue Forming	5	Tongue Reverse,	8.5	0.3			
		Flat 1N	6	Stitch Tongue Overlay (Laceloop Side),	8.4	0.3	1	164	73%
		Flat 1N	7	Attach and Stitch Eyestay Laceloop to Tongue,	13.5	0.5			
		Flat 1N	8	Stitch Tongue Edge,	26.5	0.9	1	136	88%
		Flat 1N	9	Stitching Lasting Margin,	25.0	0.8	1	144	83%
		Table	10	Gauge Heelcap Area	28.5	1.0	1	126	95%
		Post 1N	11	Stitch & Turn Heel and Quarter (Medial Area)	55.1	1.8	2	131	92%
		Manual	12	Cementing & Folded after Stitch	28.5	1.0	1	126	95%
		Hammering MC	13	Hammering Heel (Medial Area)	29.0	1.0	1	124	97%
		Post 1N	14	Stitch Heel Counter to Upper,	18.5	0.6	1	195	62%
		Flat 1N	15	Stich Collar Lining Edge,	24.9	0.8	1	130	92%
TOTAL					341.6	11.4	13	124	88%
		EOLR	WS	Definition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitching Collar Lining to Upper,	49.1	1.6	2	147	82%
		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			
		Post 1N	6	Stitch Lock Collar Linning,	27.4	0.9	1	132	91%
		Punching Mc	7	Upper Punching,	53.0	1.8	2	136	88%
		CS 1510	8	Stitching Tongue to Upper,	26.4	0.9	1	136	88%
		Upper Clamp	10	Insert Shoe Lace,	76.4	2.5	3	141	85%
TOTAL					281.1	9	11	132	85%
		EOLR	WS	Definition		TT			
		120	2			30.0			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	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,	9.1	0.3	1	122	99%
		Conveyor Mc	12	Cleaner Upper,	20.4	0.7			
		Chamber Mc	13	Chamber 1	29.2				
		Conveyor Mc	14	Primer Upper,	49.1	1.6	2	147	82%
		Conveyor Mc	15	Primer Outsole,	24.9	0.8	1	145	83%
		Chamber Mc	16	Chamber 2	29.2				
		Conveyor Mc	17	Cement Outsole,	24.0	0.8	1	150	80%
		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,	23.3	0.8	1	155	78%
		Table	33	Final Packing,	20.5	0.7	1	176	68%
TOTAL					687.4	23	28	122	82%
		EOLR	WS	Definition	TT				
		120	2.5		30.0				

120 NON OSA

FTY Name	PWJ
Model Name	Duramo 10 WIDE
Season	FW21
Model ID	LW008
Upper ID	GW8347
Forecast (Pairs)	
Latest Update	August 6Th, 2021
Inline EOLR	120
LC CTB	130.26
LB Efficiency	82.9%
Theoretical CT Efficiency	99.8%
LLER	81%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Leather Central	30.6	240	3	2	80	68%
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	57.3	120	3	3	40	64%
Preparation	322.4	120	13	13	9	83%
Sewing	252.3	120	10	10	12	84%
Assembly	687.4	120	28	28	4	82%
SUBTOTAL	1737.1	120		72	1.68	81%
Water Spider		120		9		
TOTAL Incl WS		120		81	1.48	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydraulic	1	Cutting Vamp Accent,	4.4	0.1	3	189	64%
			2	Cutting Eyestay Top L/M	4.2	0.1			
			3	Cutting 3 Stripe,	6.0	0.2			
			4	Cutting Heelcap Backer	4.3	0.1			
			5	Cutting eyestay reinf,	4.8	0.2			
			6	Cutting eyestay lower	4.2	0.1			
			7	Cutting Heelcap Foam Bottom	4.5	0.2			
			8	Cutting Heelcap foam Top	4.6	0.2			
			9	Cutting Collar Padding,	5.0	0.2			
			10	Cutting Heel Counter,	5.1	0.2			
			11	Cutting Toebox,	4.6	0.2			
			12	Cutting Heelcap Reinf	4.2	0.1			
			13	Cutting Heelcap	5.5	0.2			
TOTAL					57.3	2	3	189	64%
		EOLR	WS	Definition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# 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,	19.1	0.6	1	130	92%
		Tongue Forming	5	Tongue Reverse,	8.5	0.3			
		Flat 1N	6	Stitch Tongue Overlay (Laceloop Side),	8.4	0.3	1	164	73%
			7	Attach and Stitch Eyestay Laceloop to Tongue,	13.5	0.5			
		Flat 1N	8	Stitch Tongue Edge,	26.5	0.9	1	136	88%
		Flat 1N	9	Stich Collar Lining Edge,	8.4	0.3	1	427	28%
		Pouncing Mc	10	Upper Pouncing #1	24.3	0.8	1	148	81%
		Flat 1N	11	Stitch Lasting Margin, Edge Vamp & Heelcap	26.4	0.9	1	136	88%
		Post 1N	12	Stitch & Turn Heel and Quarter (Medial Area)	55.1	1.8	2	131	92%
		Manual	13	Cementing & Folded after Stitch	28.5	1.0	1	126	95%
		Hammering MC	14	Hammering Heel (Medial Area)	29.0	1.0	1	124	97%
		Post 1N	15	Stitch Heel Counter to Upper,	18.5	0.6	1	195	62%
TOTAL					322.4	10.7	13	124	83%
		EOLR	WS	Definiton	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitching Collar Lining to Upper,	49.1	1.6	2	147	82%
		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			
		Post 1N	6	Upper Pouncing #2	26.5	0.9	1	136	88%
		Pouncing Mc	7	Stitching Tongue to Upper,	26.4	0.9	1	136	88%
		CS 1510	8	Stitching Lasting Margin,	25.0	0.8	1	144	83%
		Upper Clamp	12	Insert Shoe Lace,	76.4	2.5	3	141	85%
TOTAL					252.3	8	10	136	84%
		EOLR	WS	Definition	TT				
		120	2		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	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,	9.1	0.3	1	122	99%
		Conveyor Mc	12	Cleaner Upper,	20.4	0.7			
		Chamber Mc	13	Chamber 1	29.2				
		Conveyor Mc	14	Primer Upper,	49.1	1.6	2	147	82%
		Conveyor Mc	15	Primer Outsole,	24.9	0.8	1	145	83%
		Chamber Mc	16	Chamber 2	29.2				
		Conveyor Mc	17	Cement Outsole,	24.0	0.8	1	150	80%
		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,	23.3	0.8	1	155	78%
		Table	33	Final Packing,	20.5	0.7	1	176	68%
TOTAL					687.4	23	28	122	82%
		EOLR	WS	Definition	TT				
		120	2.5		30.0				

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FTY Name	PWJ
Model Name	Duramo 10 WIDE
Season	FW21
Model ID	LW008
Upper ID	GW8347
Forecast (Pairs)	
Latest Update	August 6Th, 2021
Inline EOLR	60
LC CTB	130.26
LB Efficiency	77.8%
Theoretical CT Efficiency	104.4%
LLER	77%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Leather Central	30.6	240	3	1	80	68%
Pre-coating Insole Central	5.2	2260	4	0.1	565	82%
STOCKFITTING - Buffing	15.4	300	2	0.4	150	64%
STOCKFITTING - Degreaser	15.5	1200	6	0.3	200	86%
STOCKFITTING - UV Light	48.4	800	14	1.1	57	77%
STOCKFITTING - Attaching Rubber to	302.7	300	31	6.2	10	81%
Cutting Inline	57.3	240	5	1	48	76%
Preparation	341.6	240	26	6	9	89%
Sewing	254.6	60	6	6	10	71%
Assembly	716.1	60	16	16	4	75%
SUBTOTAL	1787.4	60		38	1.56	77%
Water Spider		60		5		
TOTAL Incl WS		60		43	1.39	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydraulic	1	Cutting Vamp Accent,	4.4	0.3	5	314	76%
			2	Cutting Eyestay Top L/M	4.2	0.3			
			3	Cutting 3 Stripe,	6.0	0.4			
			4	Cutting Heelcap Backer	4.3	0.3			
			5	Cutting eyestay reinf,	4.8	0.3			
			6	Cutting eyestay lower	4.2	0.3			
			7	Cutting Heelcap Foam Bottom	4.5	0.3			
			8	Cutting Heelcap foam Top	4.6	0.3			
			9	Cutting Collar Padding,	5.0	0.3			
			10	Cutting Heel Counter,	5.1	0.3			
			11	Cutting Toebox,	4.6	0.3			
			12	Cutting Heelcap Reinf	4.2	0.3			
			13	Cutting Heelcap	5.5	0.4			
TOTAL					57.3	4	5	314	76%
		EOLR	WS	Definition	TT				
		240	0.5		15.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Skiving Counter	1	Skiving Heel Counter,	13.4	0.9	0.9	242	99%
		Auto size label	2	Stamping Size Label	14.3	1.0	1	252	95%
		CS 6040	3	Stitch Tongue Overlay to Tongue,	28.3	1.9	2	254	94%
		CS 6040	4	Stitch Tongue to Tongue Lining,	19.1	1.3	2	261	92%
		Tongue Forming	5	Tongue Reverse,	8.5	0.6			
		Flat 1N	6	Stitch Tongue Overlay (Laceloop Side),	8.4	0.6	2	328	73%
		Flat 1N	7	Attach and Stitch Eyestay Laceloop to Tongue,	13.5	0.9			
		Flat 1N	8	Stitch Tongue Edge,	26.5	1.8	2	272	88%
		Flat 1N	9	Stitching Lasting Margin,	25.0	1.7	2	288	83%
		Table	10	Gauge Heelcap Area	28.5	1.9	2	253	95%
		Post 1N	11	Stitch & Turn Heel and Quarter (Medial Area)	55.1	3.7	4	261	92%
		Manual	12	Cementing & Folded after Stitch	28.5	1.9	2	253	95%
		Hammering MC	13	Hammering Heel (Medial Area)	29.0	1.9	2	248	97%
		Post 1N	14	Stitch Heel Counter to Upper,	18.5	1.2	2	389	62%
		Flat 1N	15	Stich Collar Lining Edge,	24.9	1.7	2	246	98%
TOTAL					341.6	22.8	26	242	89%
		EOLR	WS	Definition	TT				
		240	0.5		15.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitching Collar Lining to Upper,	49.1	0.8	1	73	82%
		Spray & Hammering Mc	2	Spray on Collar Padding Area (Use Jig Spray),	10.4	0.2	1	74	81%
			3	Spray on Collar Padding Area (Use Jig Spray),	12.8	0.2			
			4	Reserve Collar lining,	19.1	0.3			
			5	Hammering,	6.5	0.1			
		Pouncing Mc	6	Upper Pouncing #2	26.5	0.4	1	136	44%
		Post 1N	7	Stitch Lock Collar Lining,	27.4	0.5	1	67	90%
		CS 1510	8	Stitching Tongue to Upper,	26.4	0.4			
		Upper Clamp	9	Insert Shoe Lace,	76.4	1.3	2	94	64%
TOTAL					254.6	4	6	67	71%
		EOLR	WS	Definition	TT				
		60	1		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM Mc	1	Back Part Molding,	28.1	0.5	1	64	94%
		Vamp Press Mc	2	Vamp Molding,	28.2	0.5			
		Strobel Mc	3	Stitch Strobel,	48.3	0.8	1	75	80%
		Table	4	Setting Last,	18.5	0.3			
		Kabuki	5	Insert Last,	16.3	0.3			
		Heel last Mc	6	Heel Lasting,	12.3	0.2	1	76	78%
		Table	7	Tightening Lace,	28.6	0.5			
		Rak outsole	8	Prepare Outsole,	20.4	0.3			
		Gauge Marking Mc	9	Sole Gauge Marking,	28.4	0.5	1	73	82%
		Table	10	Toe Gauge,	28.5	0.5			
		Table	11	Primer Upper,	49.1	0.8			
		Table	12	Primer Outsole,	24.9	0.4	1	145	41%
		Rotary Chamber	13	Chamber 1	29.2				
		Table	14	Cement Upper,	58.3	1.0	1	62	97%
			15	Cement Outsole,	24.0	0.4	1	150	40%
		Rotary Chamber	16	Chamber 2	29.2				
		Table	17	Attaching Outsole,	64.2	1.1	2	112	54%
		Universal Press Mc	18	Universal Press,	21.6	0.4	1	83	73%
		Blowing Mc	19	Blowing Outsole	22.0	0.4			
		Chiller Mc	20	Chiller	25.1				
		Open laste Mc	21	Open Lace & Open Laste,	26.5	0.4	1	68	89%
		Table	22	Hotmelt Sockliner,Insert Sockliner,	26.6	0.4			
		Table	23	Finishing	53.5	0.9	1	67	89%
		Table	24	Inspection,	27.2				
		Metal Detector Mc	25	Metal detector	5.0				
		Table	26	Innerbox Folding,	8.5	0.1	1	82	73%
		Table	27	Insert Paper,	16.9	0.3			
		Table	28	Attach UPC,	6.2	0.1			
		Table	29	Attach Hantag,	12.4	0.2			
		Table	30	Wrapping Shoe,	23.3	0.4	1	82	73%
		Table	31	Final Packing,	20.5	0.3			
TOTAL					716.1	12	16	62	75%
		EOLR	WS	Deffinition	TT				
		60	1.25		60.0				