120 NON OSA

FTY Name	**PWJ**
Model Name	**Showtheway 2.0**
Season	**SS22**
Model ID	**LIP38**
Upper ID	**GY6348**
Forecast (Pairs)	**445135**
Latest Update	**August 24Th, 2021**
Inline EOLR	**120**
LC CTB	**126.51**
LB Efficiency	**80.0%**
Theoritical CT Efficiency	**94.3%**
LLER	**83%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Central Cutting	27.5	240	2	1	126	97%
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 t	302.7	300	31	12.4	10	81%
Cutting Inline	70.0	120	3	3	40	78%
Preparation	213.2	120	9	9	14	84%
Sewing	400.0	120	15	15	8	89%
Assembly	707.9	120	29	29	4	81%
SUBTOTAL	**1805.8**	**120**		**73**	**1.65**	**83%**
Water Spider		120		9		
TOTAL Incl WS		**120**		**81**	**1.47**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydrolic	1	Cutting Qrt Overlay,	10.2	0.3	3	154	66%
			2	Cutting Eyestay Linning,	5.0	0.2			
			3	Cutting Heelcap Overlay l/m,	5.6	0.2			
			4	Cutting Toebox,	3.2	0.1			
			5	Cutting Heel Counter,	4.6	0.2			
			6	Cutting Collar Padding,	4.6	0.2			
			7	Cutting Vamp Overlay l/m,	9.7	0.3			
			8	Cutting Heelcap Backer Lat,	3.6	0.1			
			9	Cutting Heelcap Backer Med,	3.6	0.1			
			10	Cutting 3 Stripe,	10.5	0.3			
			11	Cutting Tongue Tab,	9.4	0.3			
TOTAL					**70.0**	**2**	**3**	**154**	**78%**
		EOLR	**WS**	**Deffinition**	**TT**				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# 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%
		Table	3	Gauge Vamp/Qrt	28.5	1.0	1	126	95%
		Pounching Mc	4	Recutting Tongue	14.5	0.5	1	249	48%
		Flat 1N	5	Stitch Tongue to Tongue Lining,	24.2	0.8	1	149	81%
		Tongue Forming	6	Tongue Reverse,	8.3	0.3	1	143	84%
		Flat 1N	7	Stitch Tongue Edge,	16.9	0.6			
		Post 1N	8	Stitch & Turn Rear Part,	25.3	0.8	1	142	84%
		Double Folding Mc	9	Cement & Hamering (Back Area)	10.3	0.3	1	129	93%
		Hammering mC	10	Hammering after folded Vamp Quarter,	17.6	0.6			
			11	Stitch Heel Counter to Upper,	25.1	0.8	1	143	84%
		Flat 1N	12	Stich Collar Lining Edge,	14.9	0.5	0.5	121	99%
TOTAL					**213.2**	**7.1**	**9**	**121**	**84%**
		EOLR	**WS**	**Deffinition**	**TT**				
		120	2		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
		Post 1N	1	Stitching Collar Lining to Upper,	44.5	1.5	2	162	74%
		Spray & Hammering Mc	2	Spray Collar linning,	17.8	0.6	3	142	85%
			3	Spray on Collar Padding Area (Use Jig Spray),	12.8	0.4			
			4	Reserve Collar lining,	31.0	1.0			
			5	Hammering,	14.6	0.5			
		CS 1510	6	Stitch Quarter Deco (Padding2)	58.0	1.9	2	124	97%
		Pounching Mc	7	Upper Pounching,	57.5	1.9	2	125	96%
		CS 1510	8	Stitching Tongue to Upper,	29.1	1.0	1	124	97%
		Post 1N	9	Stitching Lasting Margin,	26.4	0.9	1	136	88%
		Upper Clamp	10	Insert Shoe Lace,	108.2	3.6	4	133	90%
TOTAL					**400.0**	**13**	**15**	**124**	**89%**
		EOLR	**WS**	**Deffinition**	**TT**				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
		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,	17.0	0.6	1	138	87%
		Conveyor Mc	11	Transfer to Conveyor,	9.1	0.3			
		Heating Chamber	12	Chamber 1					
		Conveyor Mc	13	Primer Upper,	49.1	1.6	2	147	82%
		Conveyor Mc	14	Primer Outsole,	24.9	0.8	1	145	83%
		Heating Chamber	15	Chamber 2					
		Conveyor Mc	16	Cement Upper,	58.3	1.9	2	124	97%
			17	Cement Outsole,	24.0	0.8	1	150	80%
		Heating Chamber	18	Chamber 3					
		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 Shoe	54.5	1.8	2	132	91%
		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,	16.4	0.5	1	219	55%
		Table	33	Final Packing,	20.5	0.7	1	176	68%
TOTAL					**707.9**	**24**	**29**	**124**	**81%**
		EOLR	**WS**	**Deffinition**	**TT**				
		120	2.5		30.0				

60 NON OSA

FTY Name	**PWJ**
Model Name	**Showtheway 2.0**
Season	**SS22**
Model ID	**LIP38**
Upper ID	**GY6348**
Forecast (Pairs)	**445135**
Latest Update	**August 24Th, 2021**
Inline EOLR	**60**
LC CTB	**126.51**
LB Efficiency	**73.6%**
Theoritical CT Efficiency	**101.0%**
LLER	**76%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Central Cutting	27.5	240	2	0.5	126	97%
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 t	302.7	300	31	6.2	10	81%
Cutting Inline	70.0	240	5	1.3	48	93%
Preparation	213.2	240	16	4.0	15	89%
Sewing	400.0	60	9	9.0	7	74%
Assembly	673.9	60	16	16.0	4	70%
SUBTOTAL	**1771.8**	**60**		**39**	**1.55**	**76%**
Water Spider		60		5		
TOTAL Incl WS		**60**		**44**	**1.36**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Hydrolic	1	Cutting Qrt Overlay,	10.2	0.7	5	257	80%
			2	Cutting Eyestay Linning,	5.0	0.3			
			3	Cutting Heelcap Overlay l/m,	5.6	0.4			
			4	Cutting Toebox,	3.2	0.2			
			5	Cutting Heel Counter,	4.6	0.3			
			6	Cutting Collar Padding,	4.6	0.3			
			7	Cutting Vamp Overlay l/m,	9.7	0.6			
			8	Cutting Heelcap Backer Lat,	3.6	0.2			
			9	Cutting Heelcap Backer Med,	3.6	0.2			
			10	Cutting 3 Stripe,	10.5	0.7			
			11	Cutting Tongue Tab,	9.4	0.6			
TOTAL					**70.0**	**5**	**5**	**257**	**93%**
		EOLR	**WS**	**Deffinition**	**TT**				
		240	1		15.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Skiving Counter	1	Skiving Heel Counter,	13.4	0.9	1	269	89%
		Auto size label	2	Stamping Size Label	14.3	1.0	1	252	95%
		Table	3	Gauge Vamp/Qrt	28.5	1.9	2	253	95%
		Pounching Mc	4	Recutting Tongue	14.5	1.0	1	249	97%
		Flat 1N	5	Stitch Tongue to Tongue Lining,	24.2	1.6	2	297	81%
		Tongue Forming	6	Tongue Reverse,	8.3	0.6	2	286	84%
		Flat 1N	7	Stitch Tongue Edge,	16.9	1.1			
		Post 1N	8	Stitch & Turn Rear Part,	25.3	1.7	2	285	84%
		Double Folding Mc	9	Cement & Hamering (Back Area)	10.3	0.7	2	259	93%
		Hammering mC	10	Hammering after folded Vamp Quarter,	17.6	1.2			
		Post 1N	11	Stitch Heel Counter to Upper,	25.1	1.7	2	287	84%
		Flat 1N	12	Stich Collar Lining Edge,	14.9	1.0	1	242	99%
TOTAL					**213.2**	**14.2**	**16**	**242**	**89%**
		EOLR	**WS**	**Deffinition**	**TT**				
		240	1		15.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
SEWING	15%	Post 1N	1	Stitching Collar Lining to Upper,	44.5	0.7	1	81	74%
		Spray & Hammering Mc	2	Spray Collar linning,	17.8	0.3	2	95	63%
			3	Spray on Collar Padding Area (Use Jig Spray),	12.8	0.2			
			4	Reserve Collar lining,	31.0	0.5			
			5	Hammering,	14.6	0.2			
		Post 1N	6	Stitch Quarter Deco (Padding2)	58.0	1.0	1	62	97%
		Pounching Mc	7	Upper Pounching,	57.5	1.0	1	63	96%
		Post 1N	8	Stitching Lasting Margin,	26.4	0.4	1	136	44%
		CS 1510	9	Stitching Tongue to Upper,	29.1	0.5	1	124	48%
		Upper Clamp	10	Insert Shoe Lace,	108.2	1.8	2	67	90%
TOTAL					**400.0**	**7**	**9**	**62**	**74%**
		EOLR	**WS**	**Deffinition**	**TT**				
		60	1		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# 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	1	76	78%
		Kabuki	5	Insert Last,	16.3	0.3			
		Heel last Mc	6	Heel Lasting,	12.3	0.2			
		Table	7	Tightening Lace,	28.6	0.5	1	73	82%
		Rak outsole	8	Prepare Outsole,	20.4	0.3			
		Gauge Marking Mc	9	Sole Gauge Marking,	28.4	0.5	1	79	76%
		Table	10	Toe Gauge,	17.0	0.3			
		Conveyor Mc	11	Primer Outsole,	24.9	0.4	1	145	41%
		Conveyor Mc	12	Primer Upper,	49.1	0.8	1	73	82%
		Rotary Chamber Mc	13	Chamber 1	29.2				
		Conveyor Mc	14	Cement Upper,	58.3	1.0	1	62	97%
			15	Cement Outsole,	24.0	0.4	1	150	40%
		Rotary Chamber Mc	16	Chamber 2	29.2				
		Conveyor Mc	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 Shoe	54.5	0.9	1	66	91%
		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,	16.4	0.3	1	98	61%
		Table	31	Final Packing,	20.5	0.3			
TOTAL					**673.9**	**12**	**16**	**62**	**73%**

EOLR	WS	Deffinition	TT
60	1.25		60.0