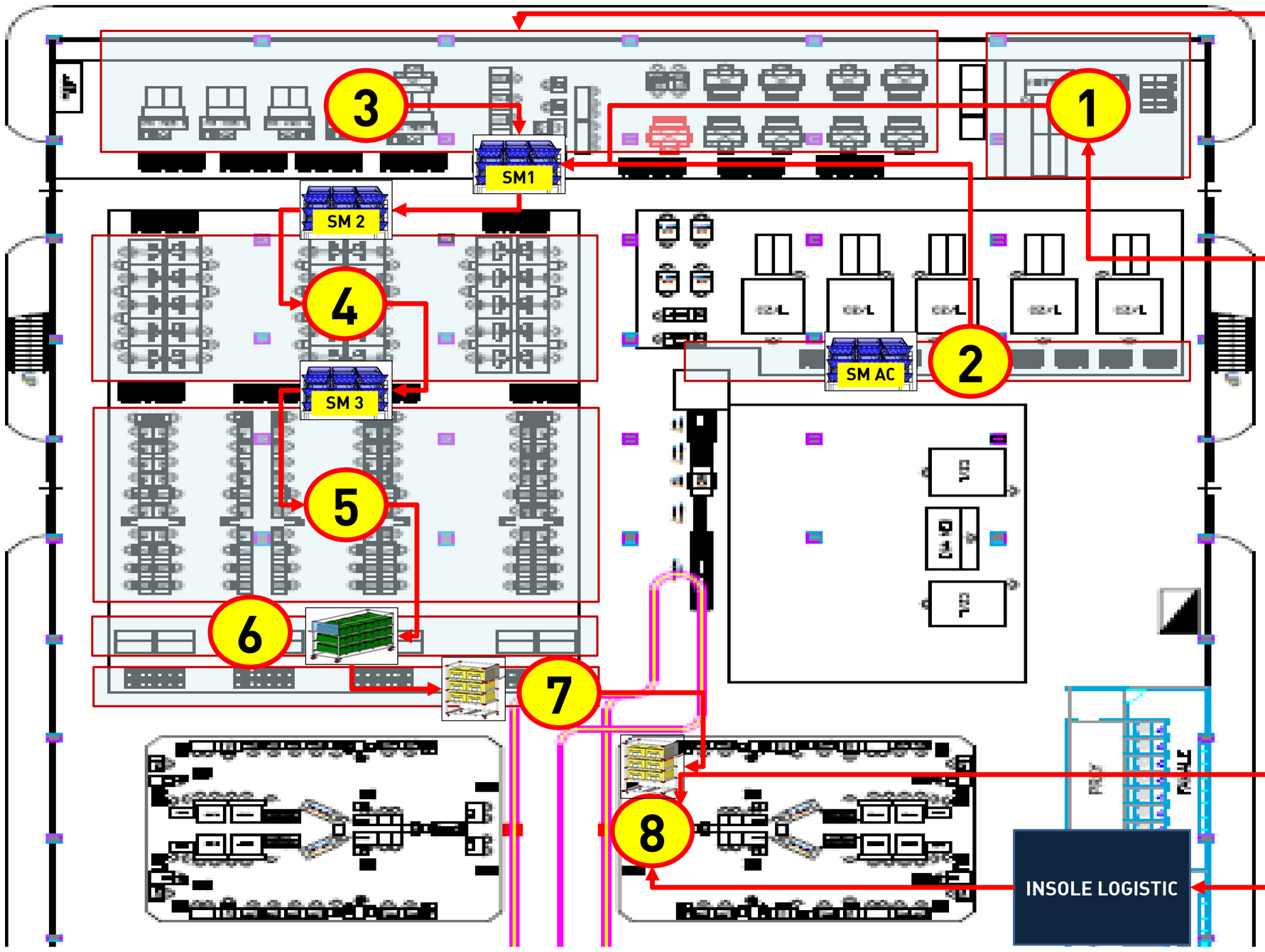
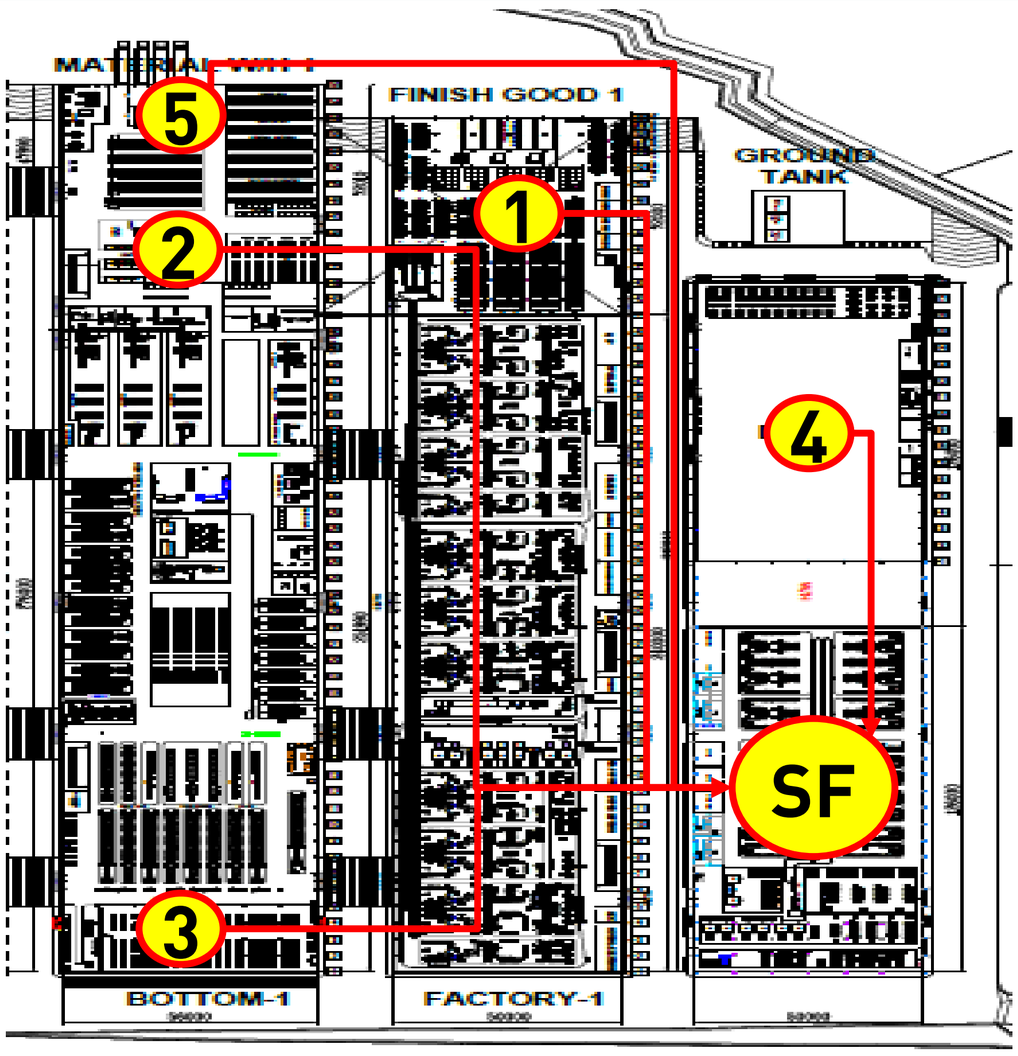
MATERIAL FLOW – SPECIAL FACTORY



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

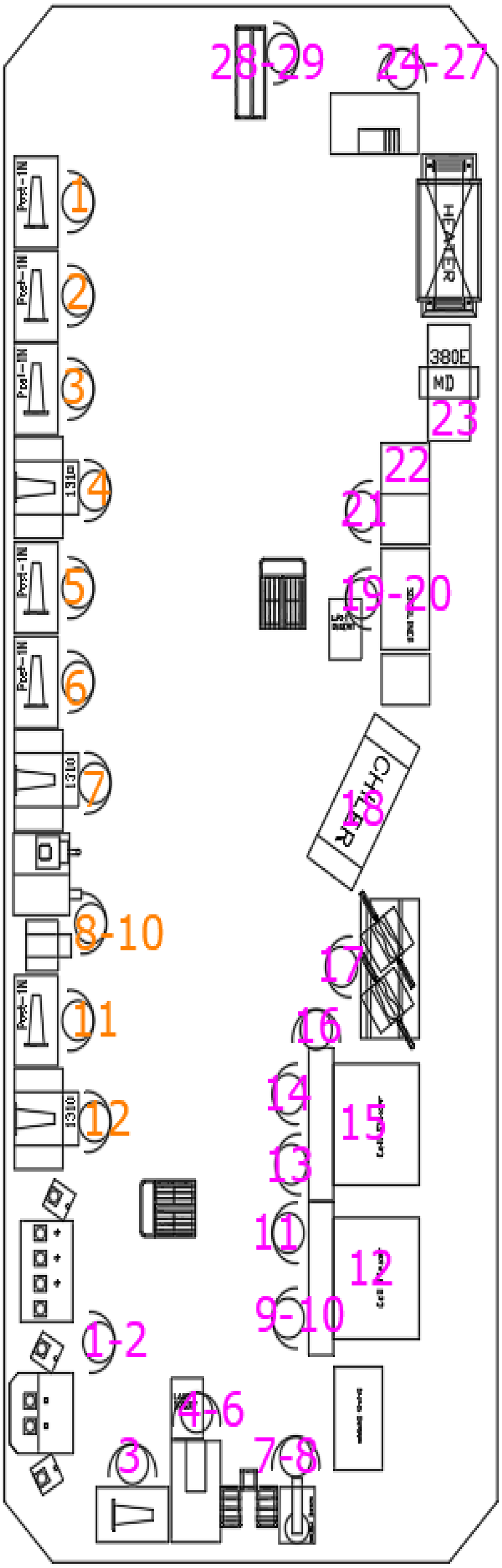


CODE	AREA	MATERIAL	TRANSPORTATION
1	WH RAW Material	• RAW material before laminating process • Accesories component (Webbing, Handtag, loop, etc) • Thread • Karton • Inner Box • Wrapping paper	Taw tractor
2	Laminating Process	• RAW material after laminating process	
3	Bottom Warehouse Stockfit	• Insole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

Tracking IE Data Actual

Model : SURU 365

Layout



IE Data

NO	Process	CT STD	MP Std	MP Act	Remark
1	Stitch Collar Strap to Upper & Reverse	42.51	1		
2	Stitch Collar Strap Deco to Upper 1-2	42	1		
3	Stitch Collar Strap Deco to Upper 3-4	47.2	1		
4	Stitch Z/Z Heel Weebing to Upper	14.5	1		
5	Stitch Heel Weebing to Upper	9.9	1		
6	Stitch Heel Cap to Upper	39.7			
7	Stitch collar lining to upper	51.5	1		
8	Attach Collar padding to upper	19.1	1		
9	Spray collar lining	19.9			
10	Reverse Collar Lining &Hammering	20.2			
11	Stitch Strap Velcro hooks to Upper	57.5	1		
12	Stitch Lasting Margin (Full)	58	1		
Total Sewing		**422.01**	**9**		
1	Back Part Molding [Cold, Max 40c/20"]	28.58	1		
2	Toe vamp molding,	23.64			
3	Stitch Strobel,	46.83	1		
4	Setting Laste,	14.52	1		
5	Insert Laste,	14.26			
6	Heel Last,	14.12			
7	Setting Outsole,	6.3	1		
8	Gauge Marking,	47.24			
9	Cleaner Upper,	29.18	1		
10	Primer Outsole	29.03			
11	Primer Upper,	56.86	1		
12	Chamber 1				
13	Cement Upper	56.7	2		
14	Cement Outsole (Tip Only)	22.26			
15	Chamber 2				
16	Attach Outsole	79.7	2		
17	Universal press,	24.36			
18	Chiller				
19	Open Laste,	16.68	1		
20	Cement & Insert Sockliner,	22.2			
21	Finishing	55.55	1		
22	Inspection				
23	Metal Detector				
24	Insert Paper	11.87	1		
25	Inner Box Folding	18			
26	Attach Hang Tag	10.64			
27	Attach UPC	17.77			
28	Wrapping	28.42	1		
29	Packing Shoes	25.7025			
Total Assembly		**700.41**	**14**		

LINE BALANCING

FTY Name	PWJ
Model Name	Suru 365 I
Season	FW22
Model ID	
Upper ID	
Forecast (Pairs)	
Latest Update	17-Dec-21
Inline EOLR	60
LC CTB	131,72
LB Efficiency	92,2%
Theoritical CT Efficiency	87,2%
LLER	94%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Central	14,5	240	2	0,5	120	48%
Pre-coating Insole Central	5,4	2640	4	0,1	660	99%
Stockfitting - Degreaser	22,1	1200	8	0,4	150	92%
Stockfitting - Pre-coating Outsole	102,1	600	18	1,8	33	95%
Cutting Inline	43,6	360	5	0,8	72	87%
Preparation	405,6	360	43	7,0	8	97%
Sewing	403,7	60	9	9,0	7	75%
Assembly	656,7	60	13	13,0	5	84%
SUBTOTAL	**1833,5**	**60**		**33**	**1,84**	**94%**
Water Spider		60		4		
TOTAL Incl WS		**60**		**36,80**	**1,63**	

Suru 365 I WTP

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING IN LINE	15%	Manual (Hyd)	1	Cutting Tongue Gore	5,29	0,5	5,00	375	96%
			2	Cutting Vamp	5,74	0,6			
			3	Cutting 3 Strip	4,54	0,5			
			4	Cutting Vamp Linning	9,51	1,0			
			5	Cutting Collar Padding	5,18	0,5			
			6	Cutting Velcro Loop	6,34	0,6			
			7	Cutting Strap Velcro Hooks	6,97	0,7			
			8	Cutting Heel Cap	4,47	0,4			
			Total		**43,6**	**4,4**	**5**	**375**	**87%**
		EOLR	**WS**	**Deffinition**	**TT**				
		360	0,5		10,0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
SEWING	15%	Gauge	1	Screen gauge Vamp	17,60	1,8	9	361	100%
			2	Gauge Collar Strap	35,19	3,5			
			3	Gauge collar strap lining	19,14	1,9			
			4	Gauge Collar Lining	16,74	1,7			
		Table	5	Attach Tongue Gore to Vamp	19,16	1,9	5	443	81%
			6	Attach Vamp Qtr Lining to Upper	21,51	2,2			
		CS-1510	7	Stitch Tongue Gore to Vamp	19,16	1,9	2	376	96%
		Z/Z MC	8	Stitch Join Upper (Heel)	26,04	2,6	5	362	52%
		CS-1510	9	Stitch strap velcro loop to collar strap lining	23,69	2,4			
		Flat 1N	10	Stitch Collar lining Edge	18,68	1,9	2	386	93%
		Flat 1N	11	Stitch Collar strap lining to collar strap	36,09	3,6	6	376	96%
		Table	12	Reverse Collar strap	21,44	2,1			
			13	Insert Strap Puller to collar strap	19,16	1,9	7	370	97%
		Post 2N	14	Stitch collar strap edge	48,88	4,9			
		CS-1510	15	Stitch tongue tab logo to Collar Strap	19,16	1,9	2	376	96%
			16	Stitch Z/Z tongue tab logo to Collar Strap	24,82	2,5	3	435	83%
		Auto Label	17	Stamping Size Lable to Collar lining	19,16	1,9	2	376	96%
				TOTAL	**405,6**	**41**	**43**	**361**	**95%**
		EOLR	WS		**TT**				
		360	**1**		**10,0**				
					10,0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
SEWING	15%	Post 1N	1	Stitch Collar Strap to Upper	23,7	0,4	1	75	80%
				Stitch Collar Strap to Upper & Reverse	24,2	0,4			
		Post 1N	2	Stitch Collar Strap Deco to Upper 1-4	42,0	0,7	1	86	70%
		Post 1N	3	Stitch Collar Strap Deco to Upper 2-3	47,2	0,8	1	76	79%
		CS-1510	4	Stitch Z/Z Heel Weebing to Upper	14,5	0,2	1	248	24%
		Post 1N	5	Stitch Heel Weebing to Upper	9,9	0,2	1	73	83%
			6	Stitch Heel Cap to Upper	39,7	0,7			
		Post 1N	7	Stitch collar lining to upper	51,5	0,9	1	70	86%
		Hammering Mc	8	Attach Collar padding to upper	19,1	0,3	1	61	99%
			9	Spray collar lining	19,9	0,3			
			10	Reverse Collar Lining &Hammering	20,2	0,3			
		Post 1N	11	Stitch Strap Velcro hooks to Upper	57,5	1,0	1	63	96%
		Post 1N	12	Stitch Lasting Margin (Full)	58,0	1,0	1	62	97%
		Table	13	Finishing,					
			Total		**403,7**	**7**	**9**	**61**	**75%**
		EOLR	**WS**		**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"]	28,58	0,48	1	69	87%
		Vamp press Mc	2	Toe vamp molding,	23,64	0,39			
		Strobel Mc	3	Stitch Strobel,	46,83	0,78	1	77	78%
		Table	4	Setting Laste,	14,52	0,24	1	84	72%
		Kabuki	5	Insert Laste,	14,26	0,24			
		Heel last	6	Heel Last,	14,12	0,24			
		Table	7	Setting Outsole,	6,30	0,11	1	67	89%
		Gauge Marking MC	8	Gauge Marking,	47,24	0,79			
		Table	9	Cleaner Upper,	29,18	0,49	1	62	97%
		Table	10	Primer Outsole	29,03	0,48			
		Table	11	Primer Upper,	56,86	0,95	1	63	95%
		Chamber MC	12	Chamber 1					
		Table	13	Cement Outsole (Tip Only)	35,26	0,59	1	102	59%
		Chamber MC	14	Chamber 2					
		Table	15	Attach Outsole	79,70	1,33	2	69	87%
		Universal Pressing	16	Universal press,	24,36	0,41			
		Chiller MC	17	Chiller					
		Open Laste Mc	18	Open Laste,	16,68	0,28	1	93	65%
		Table	19	Cement & Insert Sockliner,	22,20	0,37			
		Table	20	Finishing	55,55	0,93	1	65	93%
		Table	21	Inspection					
		MD Mc	22	Metal Detector					
		Table	23	Insert Paper	11,87	0,20	1	62	97%
			24	Inner Box Folding	18,00	0,30			
		Table	25	Attach Hang Tag	10,64	0,18			
			26	Attach UPC	17,77	0,30			
		Table	27	Wrapping	28,42	0,47	1	67	90%
		Table	28	Packing Shoes	25,7025	0,43			
		Total			**656,7**	**11**	**13,0**	**62**	**84%**
		EOLR	**WS**		**TT**				
		60	1,25		**60,0**				