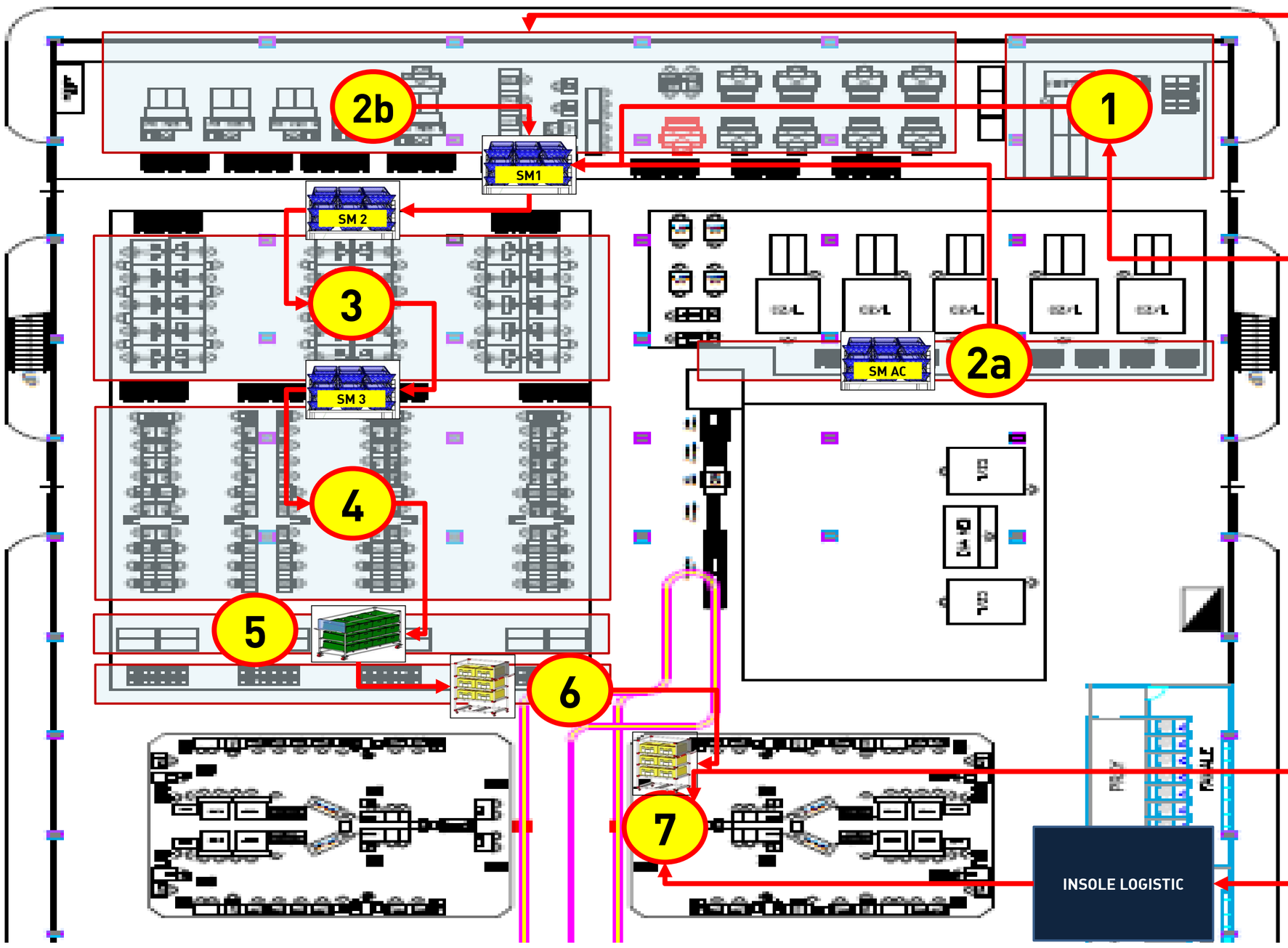
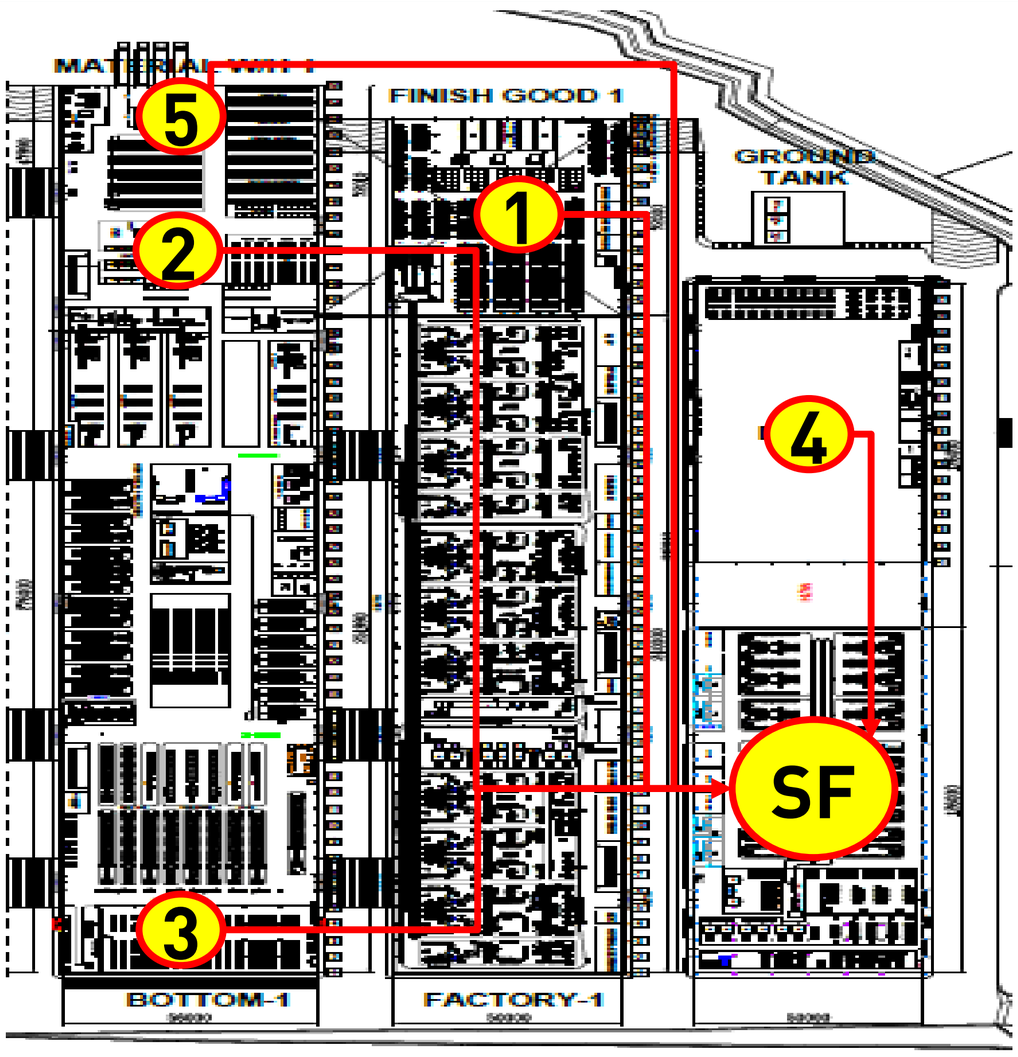
MATERIAL FLOW – SPECIAL FACTORY



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

FTY OVERALL FLOW – SPECIAL FACTOTY



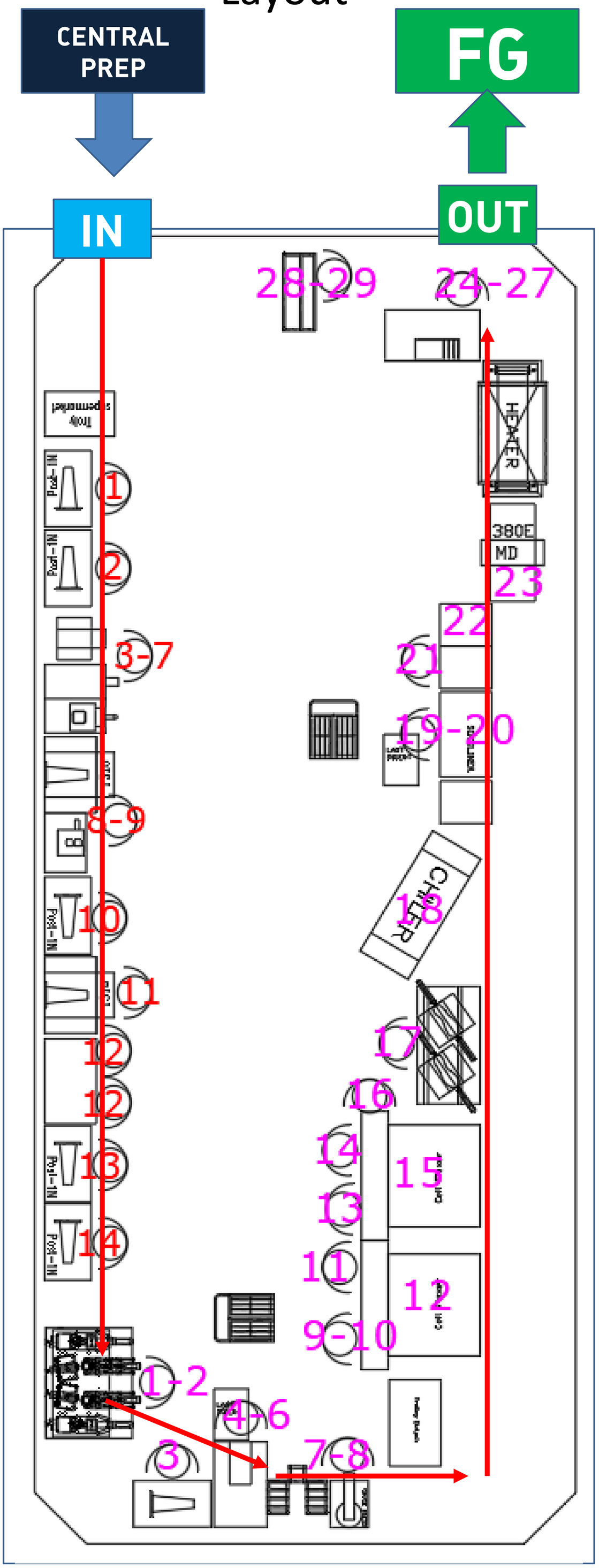
CODE	AREA	MATERIAL
1	WH RAW Material	• RAW material before laminating process • Accesories component (Webbing, Handtag, loop, etc) • Thread • Karton • Inner Box • Wrapping paper
2	Laminating Process	• RAW material after laminating process
3	Bottom Warehouse Stockfit	• Insole • Outsole
4	Inhouse Treatment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

MATERIAL FLOW S2A – SPECIAL FACTORY

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 Linning to Upper,	54.1	1		
3	Attaching Collar Padding 2 Lat/Mad to Upper,	12.1			
4	Spray Upper,	12			
5	Attaching Collar Padding to Upper,	14.4	1		
6	Reverse Collar Lining,	13			
7	Hammer Upper,	8.1			
8	Stitch hole deco to upper	26.1	1		
9	pouncing Hole Deco to upper	28.3			
10	Stitching Lasting Margin,	16.9	1		
11	Stitch Connection Tounge to Upper,	29			
12	Insert Shoe Lace,	79.6	2		
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			
9	Gauge Marking,	28.52	1		
10	Gauge Toe,	23.59			
11	Primer Upper,	54.07	1		
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			
31	Wrapping,	27.2	1		
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 Module**	**EOLR Module**	**MP Module**	**MP Module** 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%
SUBTOTAL	**2110,0**	**60**	**160**	**42**	**1,43**	**84%**
Water Spider		60		4		
TOTAL Incl WS		**60**		**46**	**1,31**	

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	Stampling 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	Theoritical	# 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%**
TOTAL		**EOLR**	**WS**	**Deffinition**	**TT**				
		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