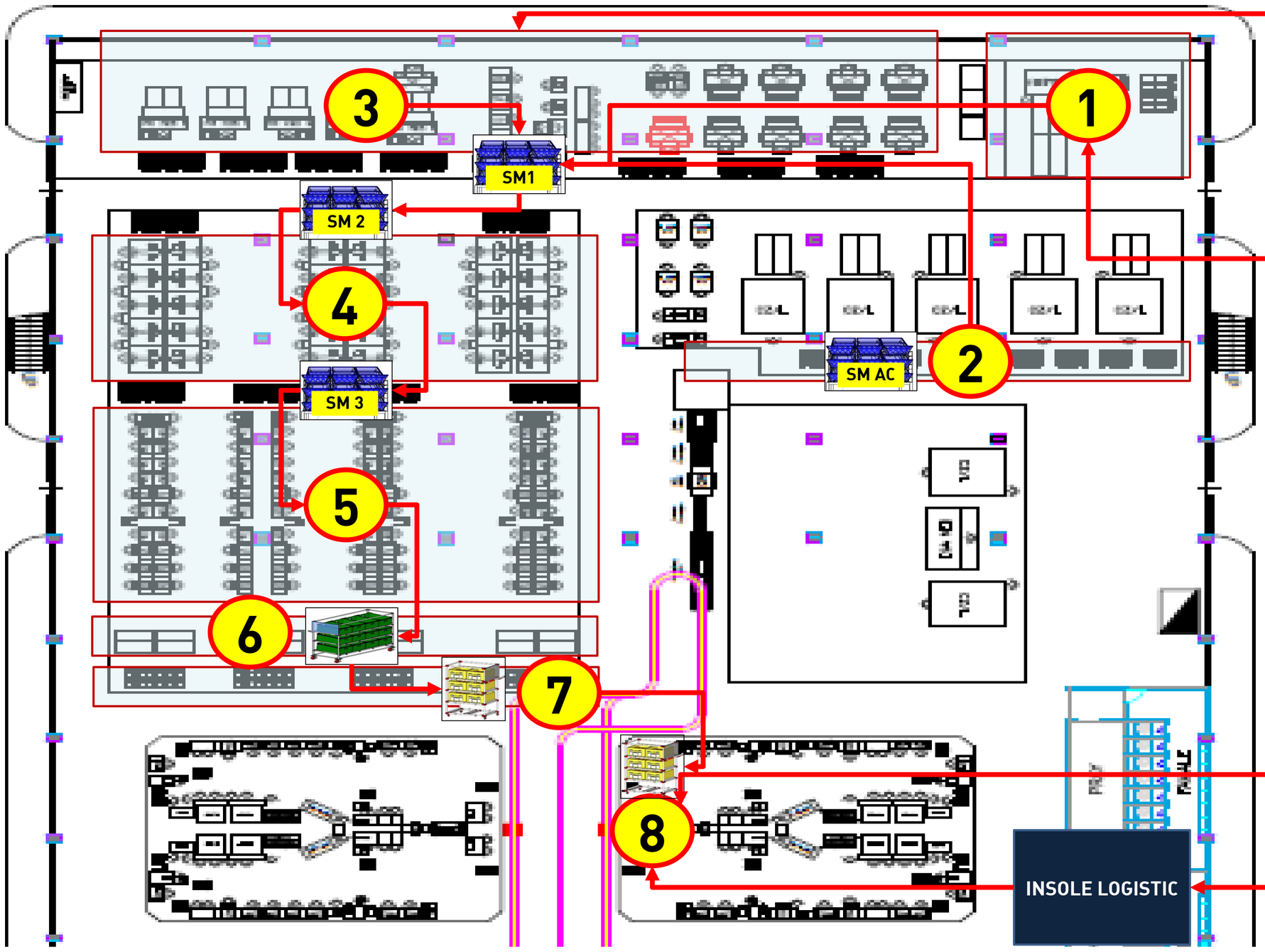
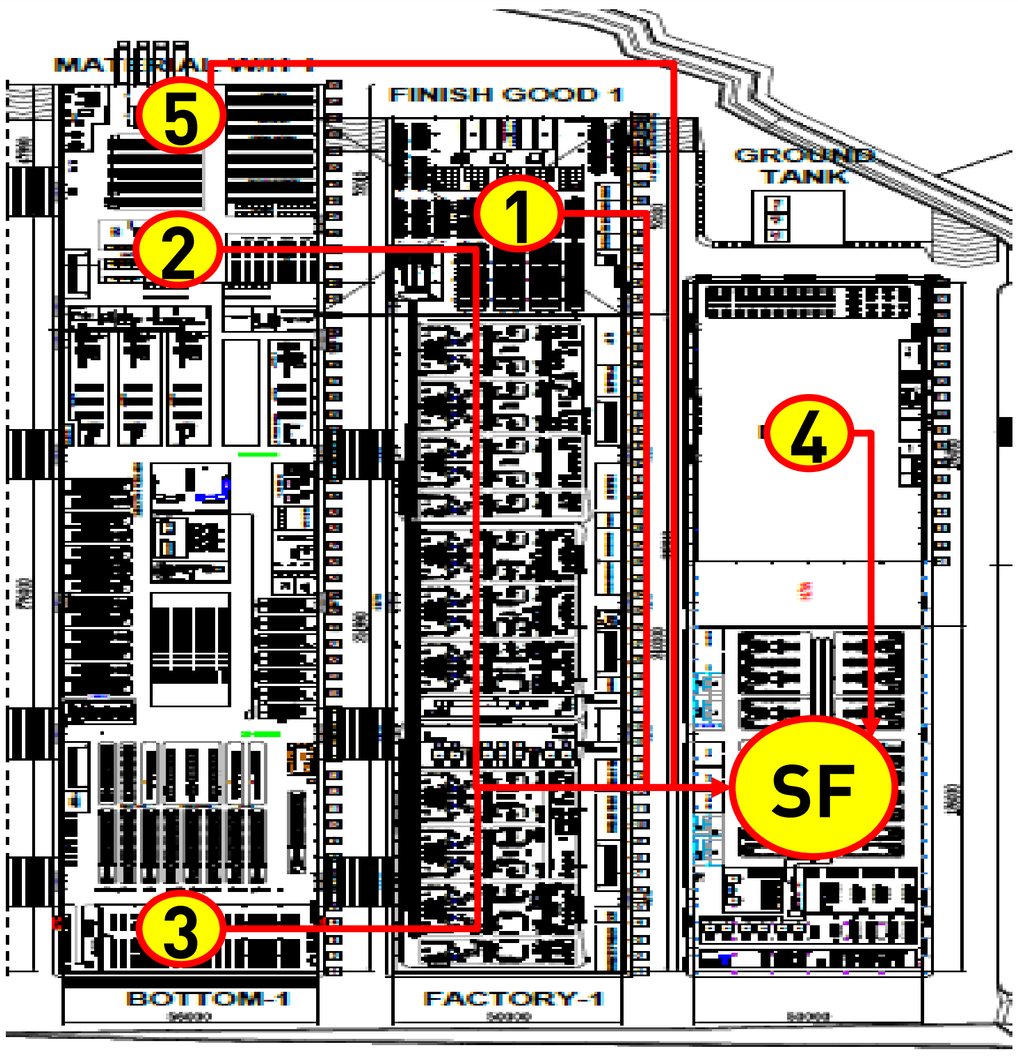
MATERIAL FLOW – SPECIAL FACTORY



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

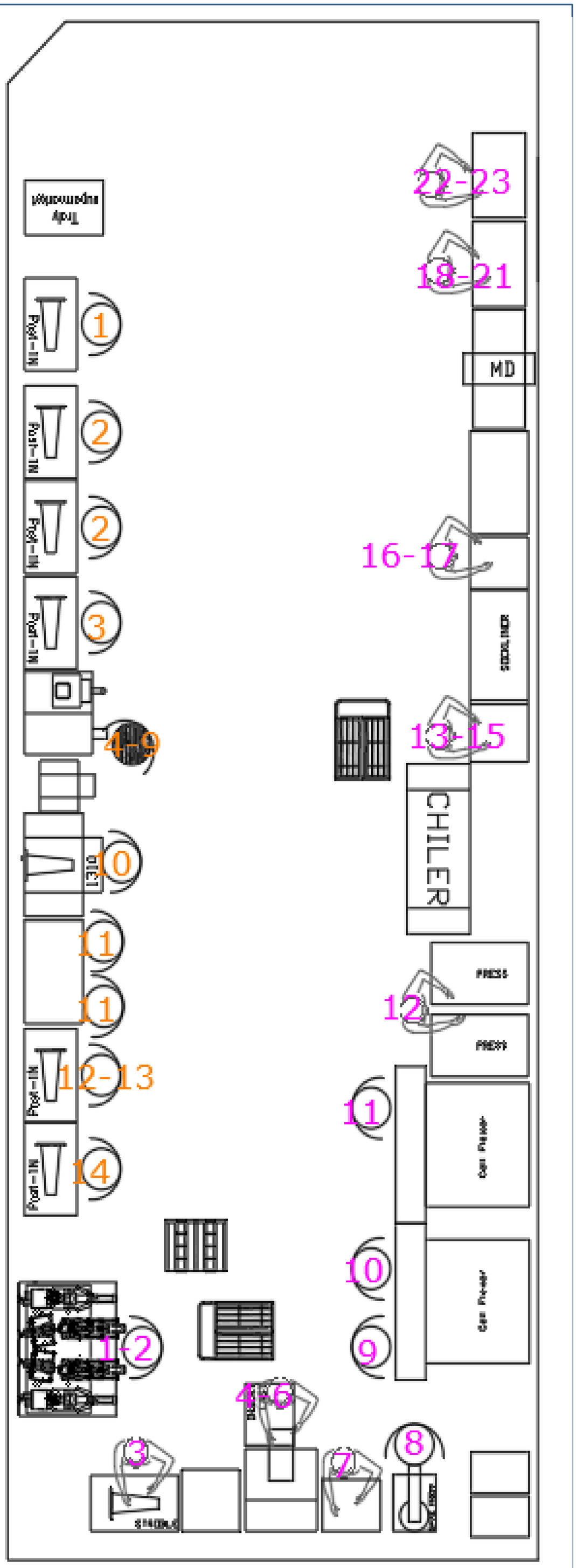


CODE	AREA	MATERIAL	TRANSPORTATION
1	WH RAW Material	• RAW material before laminating process • Accesories component (Webbing, Handtag, loop, etc) • Thread • Karton • Inner Box • Wrapping paper	Taw tractor
2	Laminating Process	• RAW material after laminating process	
3	Bottom Warehouse Stockfit	• Insole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

MATERIAL FLOW S2A – SPECIAL FACTORY

Tracking IE Data Actual

Model : Racer TR 21 I



NO	Process	CT STD	MP Std	MP Act	Remark
1	Stitch Heel Cap To upper,	48.50	1		
2	Stitch Eyestay to Upper,	64.44	2		
3	Stitch Collar Linning to Upper,	47.02	1		
4	Spray Area Padding 2 Lat/Mad to Upper,	9.71	1		
5	Attaching Collar Padding 2 Lat/Mad to Upper,	9.71			
6	Spray Upper,	12.03			
7	Attaching Collar Padding to Upper,	7.64			
8	Reverse Collar Lining,	10.37			
9	Hammer Upper,	9.68			
10	Stitch Connection Tounge to Upper,	29.03	1		
11	Insert Shoe Lace,	79.63	2		
12	Stitch lock lace to upper,	42.83	1		
13	Stitching Lasting Margin,	16.84			
14	Stitch Quarter Deco (Padding 2),	56.63	1		
Total Sewing		**444.03**	**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 Inf**
Season	**FW21**
Model ID	**LLB66**
Upper ID	**41088**
Forecast (Pairs)	
Latest Update	**9-Mar-21**
Inline EOLR	**60**
LC CTB	**147,32**
LB Efficiency	**76,7%**
Theoritical CT Efficiency	**101,7%**
LLER	**81%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Central	10,6	240	1	0,20	300	88%
Pre-coating Insole Central	5,5	2400	4	0,10	600	92%
Stockfitting - Buffing	51,9	300	5	1,00	60	87%
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	261,1	300	25	5,00	12	87%
STOCKFITTING - Painting Outsole	207,9	400	25	3,75	16	92%
Cutting Inline	88,4	360	9	2	40	98%
Preparation	304,3	360	31	5	12	98%
Sewing	444,0	60	10	10	6	74%
Assembly	596,1	60	14	14	4	71%
SUBTOTAL	**2038,9**	**60**	**147**	**42**	**1,43**	**81%**
Water Spider	198,8	60		7		
TOTAL Incl WS		**60**		**49**	**1,21**	

Racer TR21 Inf

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	9,00	366	98%
			2	Cutting Heelcap Reinf	9,46	0,9			
			3	Cutting Tongue Padding,	7,16	0,7			
			4	Cutting Heel Linning Lat/Mad,	6,17	0,6			
			5	Cutting Laceloops,	12,95	1,3			
			6	Cutting Heelcap,	12,91	1,3			
			7	Cutting Collar Padding,	9,33	0,9			
				Cutting Collar Padding 2 Lat/Mad,	11,05	1,1			
			8	Cutting Eyestay Lat/Mad Reinf,	5,30	0,5			
TOTAL					**88,4**	**8,8**	**9**	**366**	**98%**

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	373	97%
			2	Attach Eyestay Laceloops to Eyestay Lat/Mad Reinf	10,7	1,1			
		single Folding Mc	3	Folding vamp area	19,3	1,9	2	372	97%
		Stampling Size label Mc	4	Stampling collar linning,	14,6	1,5	2	370	97%
		Flat 1	5	Stitch Collar Linning Edge,	21,2	2,1	2	374	96%
		Manual	6	Stitch Tongue ,	18,9	1,9	2	361	100%
		Table	7	Attach Tounge Padding	12,9	1,3	2	366	98%
		Flat 1	8	Reverse Tounge	9,7	1,0			
		Flat 1	9	Stitch Tongue Edge,	19,4	1,9	2	370	97%
		Cs 1510	10	Stitch Tounge Logo to Tounge	16,6	1,7	2	369	98%
		Flat 1	11	Stitch Laceloops to tounge	19,1	1,9	2	376	96%
		CS 6040	12	Stitch Eyestay Laceloops Decoration,	39,8	4,0	4	362	99%
		Table	13	Attach Eyestay to Pallet	28,8	2,9	3	363	99%
		Zig-zag MC	14	Stitch Connection Zig-Zag Heel Area,	19,96	2,8	3	367	98%
			15	Stitch Zig-Zag Heel Cap	8,5				
		CS1510	16	Stitch Wabbing 1 to Upper,	16,7	3,6	4	368	98%
			17	Stitch Wabbing 2 to Upper,	19,5				
TOTAL					**304,3**	**30**	**31**	**361**	**98%**

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,	48,5	0,8	1	74	81%
			2	Stitch Eyestay to Upper,	64,4	1,1	2	112	54%
			3	Stitch Collar Linning to Upper,	47,0	0,8	1	77	78%
		Spray MC	4	Spray Area Padding 2 Lat/Mad to Upper,	9,7	0,2	1	61	99%
			5	Attaching Collar Padding 2 Lat/Mad to Upper,	9,7	0,2			
			6	Spray Upper,	12,0	0,2			
			7	Attaching Collar Padding to Upper,	7,6	0,1			
			8	Reverse Collar Lining,	10,4	0,2			
			9	Hammer Upper,	9,7	0,2			
		CS1510	10	Stitch Connection Tounge to Upper,	29,0	0,5	1	124	48%
		Upper Clamp	11	Insert Shoe Lace,	79,6	1,3	2	90	66%
		Post 1N	12	Stitch lock lace to upper,	42,8	0,7	1	60	99%
		Post 1N	13	Stitching Lasting Margin,	16,8	0,3			
		Post 1N	14	Stitch Quarter Deco (Padding 2),	56,6	0,9	1	64	94%
TOTAL					**444,0**	**7,4**	**10,0**	**60**	**74%**

EOLR	WS	Deffinition	TT
60	1		60,0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
		Vamp Press Mc	1	Toe Vamp Molding,	25,99	0,43	1,00	139	43%
		Strobel Mc	2	Stitch Strobel,	49,54	0,83	1,00	73	83%
		Rack laste	3	Setting Laste,	21,90	0,36	1,00	164	36%
		Kabuki	4	Insert Last,	16,93	0,28	1,00	66	91%
		Heel last Mc	5	Heel Last,	10,03	0,17			
		Table	6	Tightening Lace,	27,74	0,46			
		Table	7	Cleaner Upper,	19,60	0,33	1,00	75	80%
		Gauge Marking Mc	8	Gauge Marking,	28,52	0,48			
		Table	9	Gauge Toe,	23,59	0,39	1,00	76	79%
		Table	10	Primer Outsole,	23,83	0,40			
		Table	11	Primer Upper,	54,07	0,90	1,00	67	90%
		Rotary Chamber	12	Chamber 1					
		Table	13	Cement Outsole,	26,75	0,45	1,00	135	45%
		Rotary Chamber	14	Chamber 2					
		Table	15	Attach Outsole,	77,30	1,29	2,00	93	64%
		Universal Press Mc	16	Universal Pressing,	25,13	0,42	1,00	143	42%
		Chiller Mc	17	Chiller					
		Table	18	Open Lace,Open Last,	21,53	0,36	1,00	82	73%
		Sockliner Mc	19	Hotmelt Aplication on Inaysole	22,17	0,37			
		Table	20	Lacing,	28,18	0,47	1,00	60	99%
		Table	21	Finishing,	31,52	0,53			
		Table	22	Inspection,					
		Metal Detector Mc	23	Metal detector					
		Table	24	Innerbox Folding,	17,30	0,29	1,00	64	94%
		Table	26	Attach UPC,	14,61	0,24			
		Table	25	Insert Paper,	11,98	0,20			
		Table	27	Attach Hantag,	12,28	0,20			
		Table	28	Wrapping,	27,20	0,45	1,00	65	92%
		Table	29	Packing,	28,24	0,47			
TOTAL					**596,1**	**10**	**14**	**60**	74%

EOLR	WS	Deffinition	TT
60	1,5		60,0