60 OSA

FTY Name	**PWJ**
Model Name	**ADVANTAGE BASE**
Season	**FW21**
Model ID	
Upper ID	**5749**
Forecast (Pairs)	**1649674**
Latest Update	**6/16/2021**
Inline EOLR	**60**
LC CTB	**124.09**
LB Efficiency	**93.3%**
Theoritical CT Efficiency	**108.5%**
LLER	**86%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversio	**PPH**	**LLER**
Cutting Leather Central	19.3	200	1	0	160	86%
Pre-coating Insole Central	2.7	2640	2	0.0	1320	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	51.0	60	1	1	60	85%
Preparation	388.4	60	7	7	8	89%
Sewing	371.8	60	7	7	9	95%
Assembly	616.8	60	13	13	5	79%
SUBTOTAL	**1574.1**	**60**		**30**	**1.98**	**86%**
Water Spider	193.5	60		4		
TOTAL Incl WS		**60**		**34**	**1.75**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Beam	1	Cutting qtr lat	14.35	0.24	1.00	71	85%
			2	Cutting qtr med	14.35	0.24			
			3	Cutting heel counter,	4.92	0.08			
			4	Cutting collar foam,	5.30	0.09			
			5	Cutting eyestay Reinf	8.99	0.15			
			6	Cutting toe box,	3.07	0.05			
TOTAL					**51.0**	**1**	**1**	**71**	**85%**
		EOLR	**WS**	**Deffinition**	**TT**				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Skiving Counter	1	Skiving heel counter,	13.8	0.2	0.25	65	92%
		Skiving Mc	2	Skiving vamp,	20.2	0.3	1.00	67	89%
			3	Skiving qtr lat/med,	17.5	0.3			
			4	Skiving Heel Tab,	15.8	0.3			
		Roll hotmelt Mc	5	Attach toe box & Roll hotmelt vamp,	11.7	0.2	0.50	71	85%
			6	Roll hotmelt qtr lat/med,	13.7	0.2			
		CS-1510	7	Stitching tongue label,	29.6	0.5	0.50	61	99%
		Auto label	8	Stamping size label,	14.38	0.2	0.25	63	96%
		Flat 1N	9	Stitching tongue to tongue lining,	19.8	0.3	0.50	64	93%
		Tongue forming Mc	10	Reverse tongue,	8.2	0.1			
		Flat 1N	11	Stitch Tongue Edge,	26.6	0.4	0.50	68	89%
		Flat 1N	12	Stitching lace loop,	28.8	0.5	0.50	62	96%
		Post 2N	13	Stitching vamp to tongue,	14.79	0.2	0.50	62	97%
			14	Stitching vamp margin,	14.4	0.2			
		Flat 1N	15	Stitch edge collar lining,	14.58	0.2	0.25	62	97%
		Table	16	Attach Eyestay Reinf	23.55	0.4	0.50	76	79%
		CS-6040	17	Stitch Quarter Lat/Med Deco & Eyestay Deco,	45.5	0.8	1.00	79	76%
		Post 1N	18	Stitch and Turn Quarter lat/med	28.9	0.5	0.50	62	96%
		Double Folding	19	Folded Quarter Heel Area	27	0.4	0.50	68	89%
TOTAL					**388.4**	**6**	**7**	**61**	**89%**
		EOLR	**WS**	**Deffinition**	**TT**				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU	LLER
STITCHING	15%	Post 1N	1	Stitch Heel Tab to Upper,	40.6	0.7	1.00	61	98%
			2	Stitch heel counter to upper,	18.1	0.3			
		Post 1N	3	Stitch collar lining to upper,	57.2	1.0	1.00	63	95%
		Spray Mc	4	Spray upper,	15.6	0.3	1.00	60	100%
			5	Attach collar foam,	10.9	0.2			
			6	Reverse collar lining,	23.6	0.4			
		Hammering Mc	7	Hammer upper,	9.8	0.2			
		Punching Mc	8	Punching upper,	28.8	0.5	0.50	62	96%
		CS-1310	9	Stitch Vamp/Tongue to upper,	59.1	1.0	1.00	61	99%
		Post 1N	10	Stitching lasting margin,	28.7	0.5	0.50	63	96%
		Table	11	Insert shoe lace,	79.3	1.3	1.50	68	88%
TOTAL					**371.8**	**6**	**7**	**60**	**95%**
		EOLR	**WS**	**Deffinition**	**TT**				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding,	28.93	0.48	1.00	62	96%
		Vamp press Mc	2	Toe vamp molding,	28.89	0.48			
		Strobel Mc	3	Stitch Strobel,	43.61	0.73	1.00	83	73%
		Kabuki	4	Insert Laste,	22.26	0.37	1.00	91	66%
		Heel last	5	Heel Last,	17.39	0.29			
		Table	6	Strengthen lace,	28.89	0.48	1.00	62	97%
			7	Prepare Outsole,	29.07	0.48			
		Gauge Marking MC	8	Heel heights matching and inspection	19.24	0.32	1.00	71	85%
			9	Gauge Marking,	31.46	0.52			
		Table	10	Cleaner Upper	54.46	0.91	1.00	66	91%
		Rotary Chamber MC	11	Rotary Chamber 1	42.00				
		Table	12	Primer Upper	57.98	0.97	1.0	62	97%
		Rotary Chamber MC	13	Rotary Chamber 2	42.00				
		Open last Mc	14	Attach Outsole	64.12	1.07	2.00	76	79%
		Table	15	Universal press,	30.87	0.51			
		Chiller MC	16	Chiller	35.00				
		Table	17	Open Lace,	18.06	0.30	1.00	64	93%
		MD Mc	18	Open Laste,	9.78	0.16			
		Table	19	Cement & Insert Sockliner,	28.08	0.47			
		Table	20	Finishing,	57.06	0.95	1.00	63	95%
		Table	21	Finishing Inspection	34.60				
		MD Mc	22	Metal Detector	3.20				
		Table	23	Inner Box Folding	17.30	0.29	1.00	75	80%
			24	Attach Hang Tag	16.33	0.27			
			25	Attach UPC	14.61	0.24			
		Table	26	Wrapping	27.20	0.45	1.00	65	92%
			27	Packing Shoes	28.24	0.47			
TOTAL					**616.8**	**11**	**13**	**62**	**86%**

EOLR	WS	Deffinition	TT
60	1.5		60.0

120 NON OSA

FTY Name	**PWJ**
Model Name	**ADVANTAGE BASE**
Season	**FW21**
Model ID	
Upper ID	**5749**
Forecast (Pairs)	**1649674**
Latest Update	**2/16/2021**
Inline EOLR	**120**
LC CTB	**124.09**
LB Efficiency	**94.9%**
Theoritical CT Efficiency	**103.1%**
LLER	**92%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversio	**PPH**	**LLER**
Cutting Leather Central	19.3	200	1	1	160	86%
Pre-coating Insole Central	2.7	2640	2	0.1	1320	99%
Stockfitting - Degreaser	22.1	1200	8	0.8	150	92%
Stockfitting - Pre-coating Outsole	102.1	600	18	3.6	33	95%
Cutting Inline	51.0	120	2	2	71	100%
Preparation	388.4	120	15	15	8	89%
Sewing	371.8	120	13	13	9	95%
Assembly	708.3	120	26	26	5	91%
SUBTOTAL	**1665.7**	**120**	**84**	**60**	**1.99**	**92%**
Water Spider	193.5	120		7		
TOTAL Incl WS		**120**		**67**	**1.78**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Beam	1	Cutting qtr lat	14.35	0.48	1.7	120	100%
			2	Cutting qtr med	14.35	0.48			
			3	Cutting heel counter,	4.92	0.16			
			4	Cutting collar foam,	5.30	0.18			
			5	Cutting eyestay Reinf	8.99	0.30			
			6	Cutting toe box,	3.07	0.10			
TOTAL					**51.0**	**2**	**2**	**120**	**100%**

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,	13.8	0.5	0.50	131	92%
		Skiving Mc	2	Skiving vamp,	20.2	0.7	2.00	135	89%
			3	Skiving qtr lat/med,	17.5	0.6			
			4	Skiving Heel Tab,	15.8	0.5			
		Roll hotmelt Mc	5	Attach toe box & Roll hotmelt vamp,	11.7	0.4	1.00	142	85%
			6	Roll hotmelt qtr lat/med,	13.7	0.5			
		CS-1510	7	Stitching tongue label,	29.6	1.0	1.00	121	99%
		Auto label	8	Stamping size label,	14.38	0.5	0.50	125	96%
		Flat 1N	9	Stitching tongue to tongue lining,	19.8	0.7	1.00	129	93%
		Tongue forming Mc	10	Reverse tongue,	8.2	0.3			
		Flat 1N	11	Stitch Tongue Edge,	26.6	0.9	1.00	135	89%
		Flat 1N	12	Stitching lace loop,	28.8	1.0	1.00	125	96%
		Post 2N	13	Stitching vamp to tongue,	14.79	0.5	1.00	123	97%
			14	Stitching vamp margin,	14.4	0.5			
		Flat 1N	15	Stitch edge collar lining,	14.58	0.5	0.50	123	97%
		Table	16	Attach Eyestay Reinf	23.55	0.8	1.00	153	79%
		CS-6040	17	Stitch Quarter Lat/Med Deco & Eyestay Deco,	45.5	1.5	2.00	158	76%
		Post 1N	18	Stitch and Turn Quarter lat/med	28.9	1.0	1.00	125	96%
		Double Folding	19	Folded Quarter Heel Area	27	0.9	1.00	135	89%
TOTAL					**388.4**	**13**	**15**	**121**	**89%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU	LLER
STITCHING	15%	Post 1N	1	Stitch Heel Tab to Upper,	40.6	1.4	2.00	123	98%
			2	Stitch heel counter to upper,	18.1	0.6			
		Post 1N	3	Stitch collar lining to upper,	57.2	1.9	2.00	126	95%
		Spray Mc	4	Spray upper,	15.6	0.5	2.00	120	100%
			5	Attach collar foam,	10.9	0.4			
			6	Reverse collar lining,	23.6	0.8			
		Hammering Mc	7	Hammer upper,	9.8	0.3			
		Punching Mc	8	Punching upper,	28.8	1.0	1.00	125	96%
		CS-1310	9	Stitch Vamp/Tongue to upper,	59.1	2.0	2.00	122	99%
		Post 1N	10	Stitching lasting margin,	28.7	1.0	1.00	125	96%
		Table	11	Insert shoe lace,	79.3	2.6	3.00	136	88%
TOTAL					**371.8**	**12**	**13**	**120**	**95%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding,	28.93	0.96	1.00	124	96%
		Vamp press Mc	2	Toe vamp molding,	28.89	0.96	1.00	125	96%
		Strobel Mc	3	Stitch Strobel,	43.61	1.45	2.00	165	73%
		Kabuki	4	Insert Laste,	22.26	0.74	1.00	91	132%
		Heel last	5	Heel Last,	17.39	0.58			
		Table	6	Strengthen lace,	28.89	0.96	1.00	125	96%
		Table	7	Cleaner upper&Cleaner Outsole	29.07	0.97	1.00	124	97%
		Gauge MC	8	Gauge Marking,	27.36	0.91	1.00	113	106%
			9	Transfer to conveyor,	4.53	0.15			
		Rotary Chamber MC	10	Cleaner upper	12.64	0.42	1.00	142	84%
		Rotary Chamber MC	11	Cleaner Outsole	12.64	0.42			
		Chamber MC	12	Rotary Chamber 1					
		Table	13	Primer Upper	47.36	1.58	2.00	152	79%
		Table	14	Primer Outsole	28.54	0.95	1.0	126	95%
		Chamber MC	15	Rotary Chamber 2					
		Table	16	Cement Upper	50.42	1.68	2.0	143	84%
		Table	17	Cement Outsole	26.54	0.88	1.0	136	88%
		Chamber MC	18	Rotary Chamber 3					
		Open last Mc	19	Attach Outsole	55.76	1.86	2.00	129	93%
		Table	20	Universal press,	26.84	0.89	1.00	134	89%
		Chiller MC	21	Chiller					
		Table	22	Open Lace,	18.06	0.60	1.00	129	93%
		MD Mc	23	Open Laste,	9.78	0.33			
		Table	24	Cement & Insert Sockliner,	28.08	0.94	1.00	128	94%
		Table	25	Finishing,	57.06	1.90	2.00	126	95%
		Table	26	Finishing Inspection	34.60				
		MD Mc	27	Metal Detector	3.20				
		Table	28	Insert Paper	14.62	0.49	1.00	113	106%
			29	Inner Box Folding	17.30	0.58			
		Table	30	Attach Hang Tag	16.33	0.54	1.00	116	103%
			31	Attach UPC	14.61	0.49			
		Table	32	Wrapping	27.20	0.91	1.00	132	91%
			33	Packing Shoes	28.244	0.94	1.00	127	94%
TOTAL					**708.3**	**24**	**26**	**91**	**93%**

EOLR	WS	Deffinition	TT
120	2.5		30.0