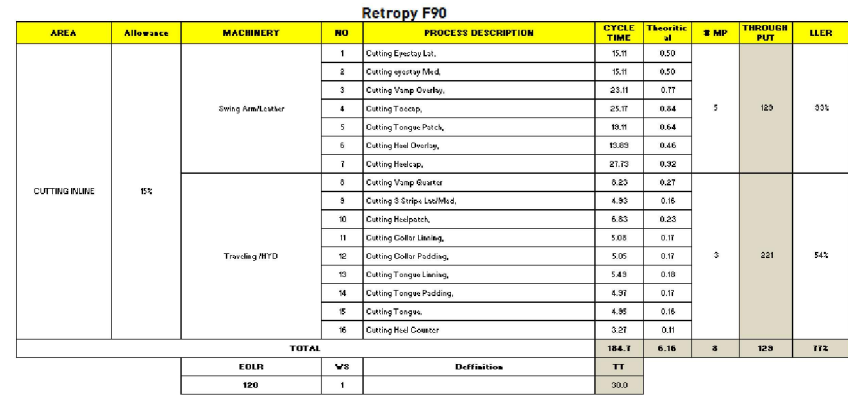
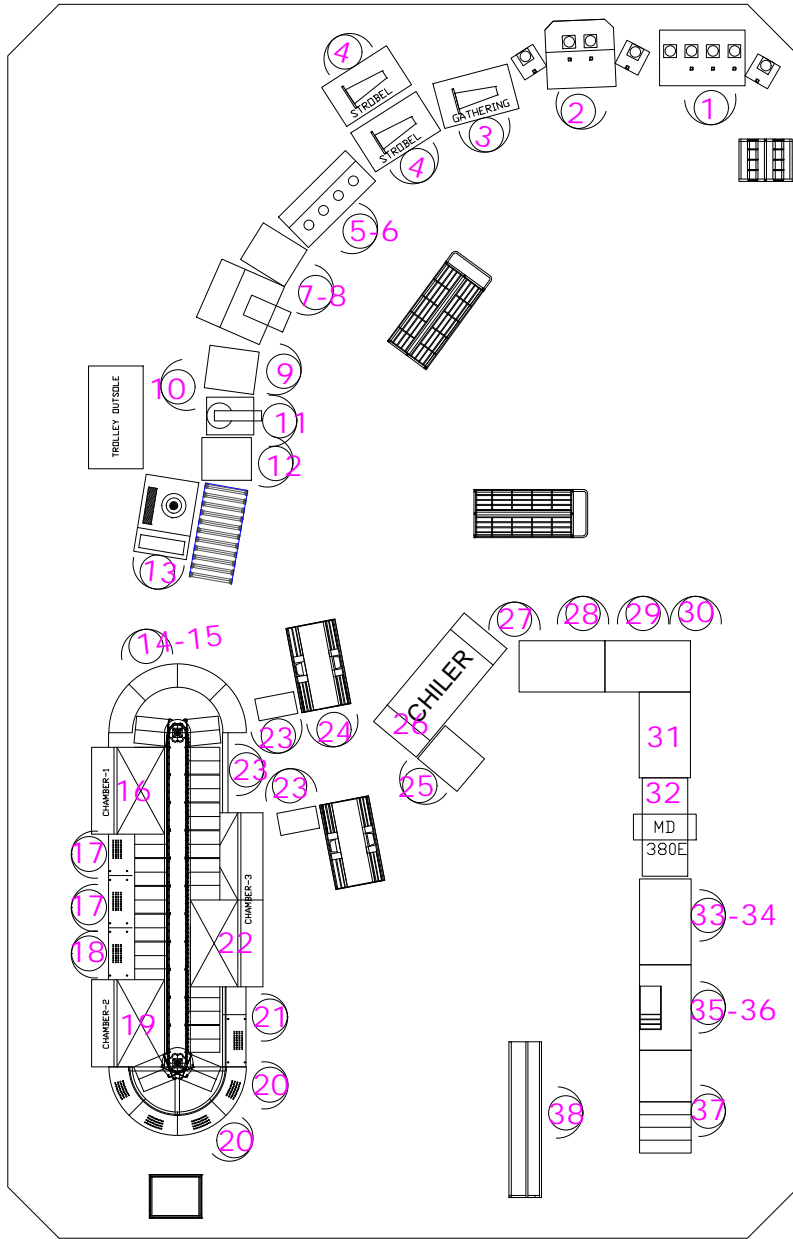


Five identical envelopes are shown in a row. Each envelope has a green label '1-7' above it. The envelopes are white with a black outline and a black circular stamp in the center.



AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical = 1	W.P.P	THROUGH PUT	L/C/R	
PREPARATION UPPER	150	Shining Leather	1	Shining Upper, 1	12.0	0.4	3	148	830	
			2	Shining Vamp Overlay, 1	20.0	0.7				
			3	Shining Heel Overlay, 1	31.4	1.1				
			4	Shining Tongue Patch, 1	8.4	0.3				
		Buffing Ma	5	Buffing Vamp Overlay, 1	24.4	0.8	1	100	916	
			Task Manual	6	Attach Cellular Rubber to Heel Patch, 1	17.0	0.6	2.0	218	940
		7		Attach Heel Edge Rubber to Vamp Overlay, 1	16.8	0.6				
		Full Machine He	8	Attach Heel Rubber to Machine Heel Machine, 1	14.8	0.5	0.8	104	976	
			9	Attach Eway to Overlay to Pull, 1	9.0	0.3	2.0	151	796	
		OS 509	10	Stitch Eway to Overlay Last He to the Eway, 1	20.6	1.2				
		Task Manual	11	Attach Eway to Rubber Heel to the Eway, 1	20.0	0.7	1.0	173	690	
		Task Manual	12	Attach 3 Strips to Pull, 1	43.1	1.4	2.0	167	730	
		OS 5480	13	Stitch 3 Strips to Vamp On, 1	47.2	1.6	2.0	151	880	
		Task Manual	14	Attach Eway to Liner to Vamp, 1	16.5	0.6	1.0	210	880	
		Task Manual	15	Attach Eway to Pull, 1	23.0	1.0	1.0	124	976	
		OS 6040	16	Stitch Eway to Last He to Vamp, 1	31.4	1.3	2.0	167	640	
		Task Manual	17	Attach Vamp Overlay to Pull, 1	21.8	1.3	2.0	117	640	
		OS 6040	18	Stitch Vamp Overlay to Upper, 1	49.0	1.6	2.0	147	620	
		Task Manual	19	Attach Vamp to Toe cap to Pull, 1	99.7	3.0	2.0	123	916	
		OS 6040	20	Stitch Toe cap to Upper, 1	41.4	1.8	2.0	189	776	
		Flat 2/2	21	Stitch 2 Zones Upper (Heel On), 1	14.6	0.5	1.0	241	496	
		Flat 2/2	22	Stitch 2 Zones to the Upper, 1	44.0	1.4	2.0	176	696	
		Flat 2/2	23	Stitch 2 Zones Heel On, 1	16.4	0.5	1.0	219	580	
		Auto Size Label M/c	24	Stamping Tongue Size Label, 1	18.0	0.4	0.5	163	730	
		Task Manual	25	Attach Heel Rubber to Heel Overlay to Pull, 1	21.6	1.0	1.0	126	980	
		OS 509	26	Stitch Heel Rubber to Heel Overlay, 1	24.0	0.8	1.0	150	880	
		Flat 10	27	Stitch Edge Cellular Liner, 1	24.4	0.8	1.0	147	816	
		OS 5360	18	Stitch Tongue Patch to Tongue, 1	23.2	0.8	1.0	185	776	
		OS 5010 Flat 10	19	Stitch Tongue Liner to Tongue, 1	21.4	0.9	1.0	157	980	
		Machine Feed	20	Attach Tongue Patch, 1	14.8	0.5	1.0	100	980	
			21	Reverse Tongue, 1	12.5	0.4				
			Flat 10	22	Stitch Edge Tongue, 1	27.1				0.9
Flat 10	23		Stitch Liner to Tongue, 1	24.4	0.9	1.0				100
TOTAL					974.9	29	39	123	776	
		EOLR	MS	Refinement	IT					
		120	2		30.0					

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORETICAL	8 HP	THROUGH PUT	LLER
STITCHING	150	Post IN	1	Stitch Head Overlay on Upper,	45.2	3.2	4.00	151	73%
		Post 2N	2	Stitch Head cap on Upper,	63.1	3.1	4.00	155	78%
		Post IN	3	Stitch Collar Liner on Upper,	49.2	1.6	2.00	141	82%
		Spray MC	4	Spray Upper,	62.9	0.4			
		Miscel	5	Attach Collar Padding,	1.9	0.3			
		Miscel Tool	6	Remove Collar Lining,	16.0	0.8			
		Spray MC	7	Spray Collar Lining,	1.5	0.2			
		Hammering MC	8	Hammering	12.0	0.4			
		Pounding MC	9	Make Pouches & Cover,	21.6	1.0	1.00	121	35%
		CS 1510	10	Stitch Tension on Upper,	21.0	0.9	1.00	126	83%
		Post IN	11	Stitch Upper Mouth,	21.1	0.9	1.00	131	30%
		Upper Clasp	12	Insert Chances,	67.8	2.4	3.00	124	97%
TOTAL					462.7	15	18	124	86%
		COLR	WS	Definitions	11				
		124	1		34.0				



AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGH PUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding,	23.24	0.37	1.00	123	37%
		Vamp Mold Mc	2	Toe cap Molding,	18.36	0.61	1.00	196	61%
		Gathering Mc	3	Stitch Toe Gathering Tape	25.02	0.83	1.00	144	83%
		Strobel Mc	4	Stitch Strobel,	48.26	1.61	2.00	143	80%
		Table	5	Setting Last,	13.35	0.45	1.00	121	45%
		Steam Box Mc	6	Steam Upper	16.40	0.55			
		Kabuki	7	Insert Last,	14.40	0.48	1.00	146	82%
		Heel Last Mc	8	Heel Last,	10.24	0.34			
		Table	9	Tightening Lace,	27.28	0.31	1.00	132	31%
		Rack Outsole	10	Prepare Outsole,	20.66	0.63	1.00	174	63%
		Gauge Marking Mc	11	Gauge Marking,	23.64	0.39	1.00	121	39%
		Table	12	Gauge Toe,	13.34	0.64	1.00	186	64%
		Handgrinding MC	13	Hand Grinding,	23.40	0.38	1.00	122	38%
		Manual	14	Transfer To Conveyor	3.25	0.31	1.00	127	34%
		Conveyor	15	Cleaner Outsole,	13.02	0.63			
		Chamber 1	16	Chamber 1	25.36				
		Conveyor	17	Primer Upper,	48.30	1.61	2.00	143	81%
		Conveyor	18	Primer Outsole,	23.02	0.37	1.00	124	37%
		Chamber 2	19	Chamber 2	25.36				
		Conveyor	20	Cement Upper,	57.20	1.31	2.00	126	35%
		Conveyor	21	Cement Outsole,	23.22	0.37	1.00	123	37%
		Chamber 3	22	Chamber 3	78.36				
		Conveyor	23	Attach Outsole,	63.44	2.31	3.00	156	77%
		Universal Press Mc	24	Universal Pressing,	26.34	0.88	1.00	137	88%
		Blower Mc	25	Blowing Outsole,	27.16	0.31	1.00	133	31%
		Chiller Mc	26	Chiller	21.36				
		Table	27	Open Lace,Open Last,	28.70	0.36	1.00	125	36%
		Sockliner Mc	28	Hotmelt Application on Inlaysole,	13.12	0.64	1.00	188	64%
		Table	29	Lacing,	23.28	0.38	2.00	156	77%
		Table	30	Finishing,	16.34	0.56			
		Table	31	Finishing Inspection,	28.62				
		Metal Detector Mc	32	Metal detector	4.21				
		Table	33	Insert Paper,	14.68	0.43	1.00	123	37%
		Table	34	Innerbox Folding,	14.43	0.48			
		Table	35	Attach UPC,	13.45	0.45	1.00	129	93%
		Table	36	Attach Hantag,	14.35	0.48			
		Table	37	Wrapping,	13.55	0.65	1.00	184	65%
		Table	38	Packing,	13.23	0.64	1.00	187	64%
TOTAL					\$31.7	24.9	32	121	\$4%
		EOLR	WS	Definition	TT				
		12%	2.5		20.0				