

<b>FTY Name</b>	<b>PWJ</b>
<b>Model Name</b>	<b>STRUTTER</b>
<b>Season</b>	
<b>Model ID</b>	
<b>Upper ID</b>	
<b>Forecast (Pairs)</b>	
<b>Latest Update</b>	<b>10/9/2021</b>
<b>Inline EOLR</b>	<b>120</b>
<b>LC CTB</b>	<b>175.38</b>
<b>LB Efficiency</b>	<b>75.8%</b>
<b>Theoretical CT Efficiency</b>	<b>95.7%</b>
<b>LLER</b>	<b>86%</b>

<b>Module</b>	<b>TCT Module</b>	<b>EOLR Module</b>	<b>MP Module</b>	<b>MP Module conversion</b>	<b>PPH</b>	<b>LLER</b>
Cutting Leather Central	117.8	240	10	5	24	79%
Pre-coating Insole Central	5.2	2260	4	0.2	565	82%
Stockfitting - Buffing	51.7	300	5	2.0	60	86%
Stockfitting - Degreaser	15.8	1200	6	0.6	200	88%
Stockfitting - UV Light	59.0	800	14	2.1	57	94%
Stockfitting - Precoating Insert	30.3	600	7	1.4	86	72%
Stockfitting - Attaching	381.5	300	39	15.6	8	82%
Cutting Inline	71.3	120	3	3	40	79%
Preparation	950.8	120	35	35	3	91%
Sewing	394.5	120	14	14	9	94%
Assembly	753.1	120	31	31	4	81%
<b>SUBTOTAL</b>	<b>2830.9</b>	<b>120</b>	<b>168</b>	<b>110</b>	<b>1.09</b>	<b>86%</b>
Water Spider		120		9		
<b>TOTAL Incl WS</b>		<b>120</b>		<b>119</b>	<b>1.01</b>	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Beam	1	Cutting Vamp/Quarter Lining,	6.66	0.22	3	152	79%
			2	Cutting 3 Stripes,	12.62	0.42			
			3	Cutting 3 Stripes Underlay Lat	3.17	0.11			
			4	Cutting Quarter Overlay L/M,	5.47	0.18			
			5	Cutting Quarter Overlay L/M,	5.47	0.18			
			6	Cutting Toe Box,	3.44	0.11			
			7	Cutting Heel Underlay,	4.97	0.17			
			8	Cutting Heel Counter,	5.02	0.17			
			9	Cutting Collar Lining,	4.91	0.16			
			10	Cutting Collar Padding,	4.91	0.16			
			11	Cutting Tongue top	3.48	0.12			
			12	Cutting Tongue Middle	2.81	0.09			
			13	Cutting Tongue Lining	4.85	0.16			
			14	Cutting Tongue Padding	3.48	0.12			
TOTAL					71.3	2.4	3	152	79%
			EOLR	WS	DEFINITION	TT			
			120	1.5		30.0			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Buffing Mc	1	Buffing Toe Cap,	14.6	0.5	1	125	96%
			2	Buffing Heel Cap,	14.3	0.5			
		Skiving Counter Mc	3	Skiving Heel Counter,	14.4	0.5	0.5	125	96%
			4	Skiving Quarter L/M,	23.3	0.8			
		Skiving Mc	5	Skiving Vamp,	12.4	0.4	2	122	99%
			6	Skiving Eyestay,	13.5	0.5			
			7	Skiving Toe Cap,	10.0	0.3			
		Rollhotmelt Mc	8	Attaching Toe Box with Toe Cap (Rollhotmelt),	15.8	0.5	2	138	87%
			9	Attaching Heel Cap Reinf L/M to Heel Cap,	22.0	0.7			
			10	Attaching heel Counter to Heel Cap	14.3	0.5			
		Table	11	Attaching Vamp/Quarter Lining to Vamp/Quarter,	28.4	0.9	1	127	95%
		Scissors	12	Cutting Quarter Overlay Backer,	4.78	0.2	1	134	89%
		Table	13	Attaching Qtr O'lay Backer to Quarter Overlay,	22.0	0.7			
		Flat bed 1N	14	Stitch Edge Collar Lining,	14.15	0.5	1	255	47%
		Auto size label	15	Stamping Size Label,	14.54	0.5	0.5	124	97%
		Post bed 2N	16	Stitch Tongue Middle with Tongue Top,	29.6	1.0	1	122	99%
		CS-3020	17	Stitch Tongue Middle with Tongue Bottom,	29.6	1.0	1	122	99%
		Flat bed 1N	18	Stitch Tongue Lining to Tongue,	27	0.9	1	131	91%
		Flat bed 1N	19	Stitch Tongue Edge,	14	0.5	1	123	97%
		Flat bed 1N	20	Stitch Laceloop to Tongue,	15	0.5			
		Table	21	Attach Qtr Olay to Quarter	56.4	1.9	2	128	94%
		CS-6040	22	Stitch Quarter L/M Deco,	73.0	2.4	3	148	81%
		Table	23	Attaching 3 Stripes to Pallet,	76.9	2.6	3	140	85%
		CS-6040	24	Stitch 3 Stripes to Quarter,	74.2	2.5	3	146	82%
		CS-3020	25	Stitch Heel Cap Deco,	27.0	0.9	1	133	90%
		Table	26	Attaching Ghilly with Eyestay,	25.1	0.8	1	144	84%
		CS-1510	27	Stitch Ghilly with Eyestay,	29.0	1.0	1	124	97%
		Table	28	Attach Eyestay to Pallet	29.6	1.0	1	121	99%
		CS-6040	29	Stitch Eyestay to Quarter,	63.8	2.1	1	56	213%
		Postbed 1N	30	Stitch Eyestay to Quarter,	112.8	3.8	3	96	125%
		Zigzag M/C	31	Stitch Zigzag Vamp to Quarter L/M,	28.7	1.0	1	126	96%
		Postbed 1N	32	Stitch Heel Underlay to Quarter,	28.2	0.9	1	128	94%
		CS-1510	33	Stitch Heel Pulltab #1 and #2 to Quarter,	28.08	0.9	1	128	94%
TOTAL					950.8	31.7	35	56	91%
			EOLR	WS	DEFINITION	TT			
			120	1		30			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Postbed 2N	1	Stitch Toe Cap to Quarter,	58.3	1.9	2	124	97%
		Postbed 1N	2	Stitch Heel Cap to Quarter,	46.8	1.6	2	154	78%
		Postbed 1N	3	Stitch Collar Lining to Upper,	58.7	2.0	2	123	98%
		Spray Mc	4	Spray Upper,	11.1	0.4	2	127	95%
			5	Attaching Collar Padding to Upper,	19.3	0.6			
			6	Reverse Collar Lining,	12.0	0.4			
		Hammering Mc	7	Hammering,	14.4	0.5	2	123	92%
		Punching Mc	8	Punching Ghilly Eyestay,	28.1	0.9			
			9	Punching Upper,	30.4	1.0			
		CS-1310	10	Stitch Tongue to Upper,	28.4	0.9	1	127	95%
		Postbed 1N	11	Stitch Lasting Margin,	28.2	0.9	1	128	94%
		Upper Clamp	12	Insert Shoe Lace,	58.9	2.0	2	122	98%
TOTAL					394.5	13.2	14	122	94%
			EOLR	WS	DEFINITION	TT			
			120	1		30			

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM Mc	1	Back Part Molding,	23.9	0.8	1	151	80%
		Strobel Mc	2	Stitch Strobel,	44.3	1.5	2	127	95%
		Table	3	Setting Last,	12.6	0.4	2	182	66%
		Kabuki	4	Insert Last,	14.3	0.5			
		Heel Last Mc	5	Heel Last,	12.8	0.4			
		Table	6	Strenghten Lace,	24.5	0.8	1	147	82%
		Table	7	Prepare Outsole	20.3	0.7	1	177	68%
		Table	8	Gauge Toe,	21.5	0.7	1	167	72%
		Gauge Marking Mc	9	Gauge Marking,	25.0	0.8	1	144	83%
		Hand grinding Mc	10	Hand Grinding,	53.6	1.8	2	134	89%
		Conveyor Mc	11	Cleaner Uppert and Transfer Conveyor	28.9	1.0	1	125	96%
		Chamber Mc	12	Chamber 1					
		Conveyor Mc	13	Primer Upper,	52.6	1.8	2	137	88%
			14	Primer Outsole,	21.3	0.7	1	169	71%
		Chamber Mc	15	Chamber 2					
		Conveyor Mc	16	Cement Upper,	52.6	1.8	2	137	88%
			17	Cement Outsole,	21.3	0.7	1	169	71%
		Chamber Mc	18	Chamber 3					
		Conveyor Mc	19	Attach Outsole,	72.8	2.4	3	148	81%
		Universal Press Mc	20	Universal Press,	22.5	0.7	1	160	75%
		Blower Mc	21	Blowing Outsole,	22.2	0.7	1	162	74%
		Chiller Mc	22	Chiller					
		Open laste Mc	23	Open Last, Open laste	28.4	0.9	1	127	95%
		Table	24	Cement & Insert Sockliner,	25.0	0.8	1	144	83%
		Table	25	Fix Lace,	30.5	1.0	2	131	91%
		Table	26	Finishing	24.4	0.8			
		Table	27	Finishing Inspection,					
		Metal Detector Mc	28	Metal detector					
		Table	29	Innerbox Folding,	14.2	0.5	1	151	80%
		Table	30	Insert Paper,	9.7	0.3			
		Table	31	Attach UPC,	11.5	0.7	1	134	126%
		Table	32	Attach Hantag,	15.4	0.5			
		Table	33	Wrapping,	23.7	0.8	1	152	79%
		Table	34	Packing,	23.6	0.8	1	152	79%
TOTAL					753.1	25.5	31	125	82%
		EOLR	WS	DEFINITION	TT				
		120	2.5		30				

FTY Name	PWJ
Model Name	STRUTTER
Season	
Model ID	
Upper ID	
Forecast (Pairs)	
Latest Update	24/06/2021
Inline EOLR	60
LC CTB	175.38
LB Efficiency	69.7%
Theoretical CT Efficiency	101.7%
LLER	74%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Leather Central	117.8	240	10	3	24	79%
Pre-coating Insole Central	5.2	2260	4	0.1	565	82%
Stockfitting - Buffing	51.7	300	5	1.0	60	86%
Stockfitting - Degreaser	15.8	1200	6	0.3	200	88%
Stockfitting - UV Light	59.0	800	14	1.1	57	94%
Stockfitting - Precoating Insert	30.3	600	7	0.7	86	72%
Stockfitting - Attaching	381.5	300	39	7.8	8	82%
Cutting Inline	71.3	120	2	1	50	99%
Preparation	770.2	120	33	17	4	78%
Sewing	433.0	60	10	10	6	72%
Assembly	728.2	60	19	19	3	64%
<b>SUBTOTAL</b>	<b>2663.9</b>	<b>60</b>	<b>149</b>	<b>60</b>	<b>1.00</b>	<b>74%</b>
Water Spider		60		5		
<b>TOTAL Incl WS</b>		<b>60</b>		<b>65</b>	<b>0.93</b>	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING INLINE	15%	Cutting Beam	1	Cutting Vamp/Quarter Lining,	6.66	0.22	2	121	99%
			2	Cutting 3 Stripes,	12.62	0.42			
			3	Cutting 3 Stripes Underlay Lat	3.17	0.11			
			4	Cutting Quarter Overlay L/M,	5.47	0.18			
			5	Cutting Quarter Overlay L/M,	5.47	0.18			
			6	Cutting Toe Box,	3.44	0.11			
			7	Cutting Heel Underlay,	4.97	0.17			
			8	Cutting Heel Counter,	5.02	0.17			
			9	Cutting Collar Lining,	4.91	0.16			
			10	Cutting Collar Padding,	4.91	0.16			
			11	Cutting Tongue top	3.48	0.12			
			12	Cutting Tongue Midle	2.81	0.09			
			13	Cutting Tongue Lining	4.85	0.16			
			14	Cutting Tongue Padding	3.48	0.12			
TOTAL					71.3	2.4	2	121	99%
		EOLR	WS	Definition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Buffing Mc	1	Buffing Toe Cap,	14.6	0.49	1	125	96%
			2	Buffing Heel Cap,	14.3	0.48			
		Skiving Counter Mc	3	Skiving Heel Counter,	14.4	0.48	0.5	125	96%
		Skiving Mc	4	Skiving Quarter L/M,	23.3	0.78	2	122	99%
			5	Skiving Vamp,	12.4	0.41			
			6	Skiving Eyestay,	13.5	0.45			
			7	Skiving Toe Cap,	10.0	0.33			
		Rollhotmelt Mc	8	Attaching Toe Box with Toe Cap (Rollhotmelt),	15.8	0.53	1	228	53%
		Table	9	Attaching Heel Cap Reinf L/M to Heel Cap,	22.0	0.73	2	198	61%
			10	Attaching heel Counter to Heel Cap	14.3	0.48			
		Table	11	Attaching Vamp/Quarter Lining to Vamp/Quarter,	28.4	0.95	1	127	95%
		Scissors	12	Cutting Quarter Overlay Backer,	4.78	0.16	1	134	89%
		Table	13	Attaching Qtr O'lay Backer to Quarter Overlay,	22.0	0.73			
		Flat bed 1N	14	Stitch Edge Collar Lining,	14.15	0.47	0.5	127	94%
		Auto size label	15	Stamping Size Label,	14.54	0.48	1	248	48%
		Post bed 1N	16	Stitch Tongue Middle with Tongue Top,	29.6	0.99	1	122	99%
		CS-3020	17	Stitch Tongue Middle with Tongue Bottom,	29.6	0.99	1	122	99%
		Flat bed 1N	18	Stitch Tongue Lining to Tongue,	27	0.91	1	131	91%
		Table	19	Attaching Tongue Padding with Tongue,	12	0.41	1	132	91%
			20	Reverse Tongue,	15	0.50			
		Flat bed 1N	21	Stitch Tongue Edge,	14	0.47	1	257	47%
		Flat bed 1N	22	Stitch Laceloop to Tongue,	15	0.51	1	237	51%
		Table	23	Attaching Qtr O'lay to Quarter	22.0	0.73	1	163	73%
		CS-6040	24	Stitch Quarter L/M Deco,	73.0	2.43	3	148	81%
		Table	25	Attaching 3 Stripes to Pallet,	76.9	2.56	3	140	85%
		CS-6040	26	Stitch 3 Stripes to Quarter,	74.2	2.47	3	146	82%
		CS-3020	27	Stitch Heel Cap Deco,	27.0	0.90	1	133	90%
		CS-1310	28	Stitch Ghilly with Eyestay,	29.0	0.97	1	124	97%
		CS-6040	29	Stitch Eyestay to Quarter,	57.8	1.93	2	124	96%
		Zigzag M/C	30	Stitch Zigzag Vamp to Quarter L/M,	28.7	0.96	1	126	96%
		Postbed 1N	31	Stitch Heel Underlay to Quarter,	28.2	0.94	1	128	94%
		CS-1310	32	Stitch Heel Pulltab #1 and #2 to Quarter,	28.08	0.94	1	128	94%
TOTAL					770.2	25.7	33	122	78%
		EOLR	WS	Definition	TT				
		120	0.5		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Postbed 2N	1	Stitch Toe Cap to Quarter,	58.3	0.97	1	62	97%
		Postbed 1N	2	Stitch Heel Cap to Quarter,	46.8	0.78	1	77	78%
		Postbed 1N	3	Stitch Collar Lining to Upper,	58.7	0.98	1	61	98%
		Spray Mc	4	Spray Upper,	11.1	0.19	2	110	55%
			5	Attaching Collar Padding to Upper,	21.3	0.35			
			6	Reverse Collar Lining,	19.0	0.32			
		Hammering Mc	7	Hammering,	14.4	0.24	1	62	92%
		Pouncing Mc	8	Pouncing Ghilly Eyestay,	28.1	0.47			
			9	Pouncing Upper,	30.4	0.51			
		CS-1310	10	Stitch Tongue to Upper,	28.4	0.47	1	127	47%
		Postbed 1N	11	Stitch Lasting Margin,	28.2	0.47	1	128	47%
		Upper Clamp	12	Insert Shoe Lace,	88.4	1.47	2	61	74%
TOTAL					433.0	7.2	10	61	72%
		EOLR	WS	Definition	TT				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGH	LLER
ASSEMBLY	15%	BPM Mc	1	Back Part Molding,	23.9	0.40	1	151	40%
		Strobel Mc	2	Stich Gathering Tape,	24.3	0.40	1	148	40%
		Steam Box Mc	3	Stitch Strobel,	44.3	0.74	1	63	95%
			4	Setting Last,	12.6	0.21	1	91	66%
		Kabuki	5	Insert Last,	14.3	0.24			
		Heel last Mc	6	Heel Last,	12.8	0.21			
		Table	7	Strenghten Lace,	24.5	0.41	1	147	41%
		Table	8	Gauge Toe,	21.5	0.36	1	77	77%
		Gauge Marking Mc	9	Gauge Marking,	25.0	0.42			
		Hand grinding Mc	10	Hand Grinding,	53.6	0.89	1	67	89%
		Table	11	Primer Upper,	52.6	0.88	1	68	88%
		Table	12	Primer Outsole,	21.3	0.35	1	169	35%
		Chamber Mc	13	Rotary Chamber 1					
		Chamber Mc	14	Cement Upper,	52.6	0.88	1	68	88%
			15	Cement Outsole,	21.3	0.35	1	169	35%
		Chamber Mc	16	Rotary Chamber 2					
		Conveyor Mc	17	Attach Outsole,	72.8	1.21	2	99	61%
		Universal Press Mc	18	Universal Press,	22.5	0.37	1	160	37%
		Blower Mc	19	Blowing Outsole,	22.2	0.37	1	162	37%
		Chiller Mc	20	Chiller					
		Open laste Mc	21	Open Last, Open laste	28.4	0.47	1	67	89%
		Table	22	Cement & Insert Sockliner,	25.0	0.42			
		Table	23	Fix Lace,	30.5	0.51	1	66	91%
		Table	24	Finishing	24.4	0.41			
		Table	25	Finishing Inspection,					
		Metal Detector Mc	26	Metal detector					
		Table	27	Innerbox Folding,	14.2	0.24	1	71	84%
		Table	28	Insert Paper,	9.7	0.16			
		Table	29	Attach UPC,	11.5	0.19			
		Table	30	Attach Hantag,	15.4	0.26			
		Table	31	Wrapping,	23.7	0.39	1	76	79%
		Table	32	Packing,	23.6	0.39			
TOTAL					728.2	12.1	19	63	64%
		EOLR	WS	Derinition	TT				
		60	1		60.0				