120 NON OSA

FTY Name	**PWJ**
Model Name	**Lite Racer BYD**
Season	**SS22**
Model ID	**FBU79**
Upper ID	
Forecast (Pairs)	**540072**
Latest Update	**Sept 28th, 2021**
Inline EOLR	**120**
LC CTB	**137.16**
LB Efficiency	**86.3%**
Theoritical CT Efficiency	**113.3%**
LLER	**84%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Auto	30.1	240	3	1.5	80	67%
Pre-coating Insole Central	2.7	2400	2	0.1	1333	99%
Stockfitting - Degreaser	15.5	1200	6	1	200	86%
Stockfitting - UV Light	51.2	800	14	2	57	81%
Cutting Inline	43.3	120	2	2.0	60	72%
Preparation	571.2	120	23	23	5	83%
Sewing	374.4	120	14	14	9	89%
Assembly	782.0	120	31	31	4	84%
SUBTOTAL	**1870.5**	**120**	**95**	**74**	**1.62**	**84%**
Water Spider		120		8		
TOTAL Incl WS		**120**		**82**	**1.47**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp / Quarter,	13.19	0.44	2	166	72%
			2	Cutting 3 Stripe	8.22	0.27			
			3	Cutting Eyestay	7.19	0.24			
			4	Cutting Toebox	2.46	0.08			
			5	Cutting Collar Reinf L/M	3.49	0.12			
			6	Cutting Collar padding L/M	6.23	0.21			
			7	Cutting Tongue Padding,	2.56	0.09			
TOTAL					**43.3**	**1.44**	**2**	**166**	**72%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
		Manual	1	Attach Toecap Reinf	12.5	0.4	0.5	144	83%
PREPARATION UPPER	15%	Heating Press	2	Hotmelt Toecap reinf	24.4	0.8	1.0	147	81%
		Size Label Mc	3	Stamping Size lacel to Tongue Collar linning,	14.2	0.5	0.5	126	95%
		Manual	4	Attach Collar padding to Collar linning,	21.0	0.7	1.0	171	70%
		CS 6040	5	Stitch Deco Collar Linning,	25.2	0.8	1.0	143	84%
		Flat 1N	6	Stitch Collar linning Edge,	25.8	0.9	1.0	140	86%
		Flat 1N	7	Stitch Turn Over Collar linning (Qrt Rear Part),	27.0	0.9	1.0	133	90%
		Doublefolding MC	8	Folded & Hamering	14.5	0.5	1.0	248	48%
		CS 1510	9	Stitch Tongue Logo to tongue,	25.0	0.8	1.0	144	83%
		Flat Z/Z	10	Stitch Z/Z Conection Tongue to Vamp,	37.0	1.2	2.0	194	62%
		F 4 N	11	Stitch Deco Tongue,	28.6	1.0	1.0	126	95%
		Post Z/Z	12	Stitch Z/Z Collar L/M,	44.4	1.5	2.0	162	74%
		Post 1 N	13	Stitch Centerline,	25.0	0.8	1.0	144	83%
		CS 1510	14	Stitch puultab to Upper #1,Stitch puultab to Upper #2,	55.2	1.8	2.0	131	92%
		Manual	15	Attach Heel Overlay to Pallet	29.0	1.0	1.0	124	97%
		CS 1510	16	Stitch Heel Overlay to Upper	58.3	1.9	2.0	123	97%
		Flat Z/Z	17	Stitch Z/Z Conection Collar to Vamp,	46.0	1.5	2.0	156	77%
		F 4 N	18	Stitch Deco Z/Z Collar	58.0	1.9	2.0	124	97%
TOTAL					**571.2**	**19**	**23**	**123**	**83%**

EOLR	WS	Deffinition	TT
120	2		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1 N	1	Stitch Tongue Collar linning to Upper,	99.0	3.3	4.00	145	83%
		Manual	2	Attach Tongue Padding	13.0	0.4	3.00	144	83%
		Use Tool	3	Reverse Tongue Area,	11.0	0.4			
		Spray MC	4	Spray Collar Tongue Linning (Tongue Area),	23.0	0.8			
		Use Tool	5	Reverse Collar area,	16.5	0.6			
		Hammering MC	6	Hammering Tongue Area,	11.3	0.4			
		Post 1 N	7	Stitch Lock Collar linning,	29.2	1.0	1.00	123	97%
		Pounching MC	8	Pounching,	26.3	0.9	1.00	137	88%
		Upper Clamp	9	Insert Shoe Lace,	145.1	4.8	5.00	124	97%
TOTAL					**374.4**	**12**	**14**	**123**	**89%**

EOLR	WS	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	Spray MC	1	Spray & Attach Heelcounter,	47.02	1.57	2.00	153	78%
		BPM	2	Back Part Molding,	29.24	0.97	1.00	123	97%
		Vamp Mold Mc	3	Toecap Molding,	18.36	0.61	1.00	196	61%
		Strobel Mc	4	Stitch Strobel,	48.26	1.61	2.00	149	80%
		Table	5	Setting Last,	18.36	0.61	1.00	196	61%
		Kabuki	6	Insert Last,	14.40	0.48	1.00	146	82%
		Heel Last Mc	7	Heel Last,	10.24	0.34			
		Table	8	Tightening Lace,	27.28	0.91	1.00	132	91%
		Gauge Marking Mc	9	Gauge Marking,	29.64	0.99	1.00	121	99%
		Table	10	Gauge Toe,	19.34	0.64	1.00	126	95%
			11	Transfer To Conveyor	9.25	0.31			
		Chamber 1	12	Chamber 1	25.36				
		Conveyor	13	Primer Upper,	48.30	1.61	2.00	149	81%
		Conveyor	14	Primer Outsole,	29.02	0.97	1.00	124	97%
		Chamber 2	15	Chamber 2	25.36				
		Conveyor	16	Cement Upper,	57.20	1.91	2.00	126	95%
		Conveyor	17	Cement Outsole,	29.22	0.97	1.00	123	97%
		Chamber 3	18	Chamber 3	78.36				
		Conveyor	19	Attach Outsole,	69.44	2.31	3.00	156	77%
		Universal Press Mc	20	Universal Pressing,	26.34	0.88	1.00	137	88%
		Blower Mc	21	Blowing Outsole,	18.88	0.63	2.00	200	60%
		Table	22	Cleaning Shoes,	17.10	0.57			
		Chiller Mc	23	Chiller	21.36				
		Table	24	Open Lace,Open Last,	28.70	0.96	1.00	125	96%
		Sockliner Mc	25	Hotmelt Aplication on Inlaysole,	19.12	0.64	1.00	188	64%
		Table	26	Lacing,	29.28	0.98	2.00	156	77%
		Table	27	Finishing,	16.94	0.56			
		Table	28	Finishing Inspection,	28.62				
		Metal Detector Mc	29	Metal detector	4.21				
		Table	30	Insert Paper,	14.68	0.49	1.00	123	97%
		Table	31	Innerbox Folding,	14.49	0.48			
		Table	32	Attach UPC,	13.45	0.45	1.00	129	93%
		Table	33	Attach Hantag,	14.35	0.48			
		Table	34	Wrapping,	19.55	0.65	1.00	184	65%
		Table	35	Packing,	19.23	0.64	1.00	187	64%
TOTAL					**782.0**	**25.2**	**31**	**121**	**81%**
		EOLR	**WS**	**Deffinition**	**TT**				

60 NON OSA

FTY Name	**PWJ**
Model Name	**Lite Racer BYD**
Season	**SS22**
Model ID	**FBU79**
Upper ID	
Forecast (Pairs)	**540072**
Latest Update	**Sept 28th, 2021**
Inline EOLR	**60**
LC CTB	**137.16**
LB Efficiency	**80.4%**
Theoritical CT Efficiency	**115.4%**
LLER	**77%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Auto	30.1	240	3	0.8	80	67%
Pre-coating Insole Central	2.7	2400	2	0.1	1333	99%
Stockfitting - Degreaser	15.5	1200	6	0	200	86%
Stockfitting - UV Light	51.2	800	14	1	57	81%
Cutting Inline	43.3	240	3	0.8	80	96%
Preparation	571.2	240	43	11	6	89%
Sewing	374.4	60	9	9	7	69%
Assembly	747.4	60	17	17	4	73%
SUBTOTAL	**1835.9**	**60**	**97**	**40**	**1.51**	**77%**
Water Spider		60		4		
TOTAL Incl WS		**60**		**44**	**1.37**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp / Quarter,	13.19	0.88	3	249	96%
			2	Cutting 3 Stripe	8.22	0.55			
			3	Cutting Eyestay	7.19	0.48			
			4	Cutting Toebox	2.46	0.16			
			5	Cutting Collar Reinf L/M	3.49	0.23			
			6	Cutting Collar padding L/M	6.23	0.42			
			7	Cutting Tongue Padding,	2.56	0.17			
TOTAL					**43.3**	**2.89**	**3**	**249**	**96%**

EOLR	WS	Deffinition	TT
240	0.5		15.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	Manual	1	Attach Toecap Reinf	12.5	0.8	1.0	288	83%
		Heating Press	2	Hotmelt Toecap reinf	24.4	1.6	2.0	295	81%
		Size Label Mc	3	Stamping Size lacel to Tongue Collar linning,	14.2	0.9	1.0	253	95%
		Manual	4	Attach Collar padding to Collar linning,	21.0	1.4	2.0	343	70%
		CS 6040	5	Stitch Deco Collar Linning,	25.2	1.7	2.0	286	84%
		Flat 1N	6	Stitch Collar linning Edge,	25.8	1.7	2.0	279	86%
		Flat 1N	7	Stitch Turn Over Collar linning (Qrt Rear Part),	27.0	1.8	2.0	266	90%
		Doublefolding MC	8	Folded & Hamering	14.5	1.0	1.0	248	97%
		CS 1510	9	Stitch Tongue Logo to tongue,	25.0	1.7	2.0	288	83%
		Flat Z/Z	10	Stitch Z/Z Conection Tongue to Vamp,	37.0	2.5	3.0	292	82%
		F 4 N	11	Stitch Deco Tongue,	28.6	1.9	2.0	252	95%
		Post Z/Z	12	Stitch Z/Z Collar L/M,	44.4	3.0	3.0	243	99%
		Post 1 N	13	Stitch Centerline,	25.0	1.7	2.0	288	83%
		CS 1510	14	Stitch puultab to Upper #1,Stitch puultab to Upper #2,	55.2	3.7	4.0	261	92%
		Manual	15	Attach Heel Overlay to Pallet	29.0	1.9	2.0	248	97%
		CS 1510	16	Stitch Heel Overlay to Upper	58.3	3.9	4.0	247	97%
		Flat Z/Z	17	Stitch Z/Z Conection Collar to Vamp,	46.0	3.1	4.0	313	77%
		F 4 N	18	Stitch Deco Z/Z Collar	58.0	3.9	4.0	248	97%
TOTAL					**571.2**	**38**	**43**	**243**	**89%**

EOLR	WS	Deffinition	TT
240	1		15.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1 N	1	Stitch Tongue Collar linning to Upper,	99.0	1.7	2.00	73	83%
		Manual	2	Attach Tongue Padding	13.0	0.2	2.00	96	62%
		Use Tool	3	Reverse Tongue Area,	11.0	0.2			
		Spray MC	4	Spray Collar Tongue Linning (Tongue Area),	23.0	0.4			
		Use Tool	5	Reverse Collar area,	16.5	0.3			
		Hammering MC	6	Hammering Tongue Area,	11.3	0.2			
		Post 1 N	7	Stitch Lock Collar linning,	29.2	0.5	1.00	123	49%
		Pounching MC	8	Pounching,	26.3	0.4	1.00	137	44%
		Upper Clamp	9	Insert Shoe Lace,	145.1	2.4	3.00	74	81%
TOTAL					**374.4**	**6**	**9**	**73**	**69%**

EOLR	WS	Deffinition	TT
60	0.5		60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	Spray MC	1	Spray & Attach Heelcounter,	47.02	0.78	1.00	77	78%
		BPM	2	Back Part Molding,	29.24	0.49	1.00	76	79%
		Vamp Mold Mc	3	Toecap Molding,	18.36	0.31			
		Strobel Mc	4	Stitch Strobel,	48.26	0.80	1.00	75	80%
		Table	5	Setting Last,	18.36	0.31	1.00	84	72%
		Kabuki	6	Insert Last,	14.40	0.24			
		Heel Last Mc	7	Heel Last,	10.24	0.17			
		Table	8	Tightening Lace,	27.28	0.45	1.00	132	45%
		Gauge Marking Mc	9	Gauge Marking,	29.64	0.49	1.00	73	82%
		Table	10	Gauge Toe,	19.34	0.32			
		Conveyor	11	Primer Upper,	48.30	0.81	1.00	75	81%
		Conveyor	12	Primer Outsole,	29.02	0.48	1.00	124	48%
		Chamber 2	13	Chamber 1	25.36				
		Conveyor	14	Cement Upper,	57.20	0.95	1.00	63	95%
		Conveyor	15	Cement Outsole,	29.22	0.49	1.00	123	49%
		Chamber 3	16	Chamber 2	78.36				
		Conveyor	17	Attach Outsole,	69.44	1.16	2.00	75	80%
		Universal Press Mc	18	Universal Pressing,	26.34	0.44			
		Blower Mc	19	Blowing Outsole,	18.88	0.31	1.00	100	60%
		Table	20	Cleaning Shoes,	17.10	0.29			
		Chiller Mc	21	Chiller	21.36				
		Table	22	Open Lace,Open Last,	28.70	0.48	1.00	75	80%
		Sockliner Mc	23	Hotmelt Aplication on Inlaysole,	19.12	0.32			
		Table	24	Lacing,	29.28	0.49	1.00	78	77%
		Table	25	Finishing,	16.94	0.28			
		Table	26	Finishing Inspection,	28.62				
		Metal Detector Mc	27	Metal detector	4.21				
		Table	28	Insert Paper,	14.68	0.24	1.00	63	95%
		Table	29	Innerbox Folding,	14.49	0.24			
		Table	30	Attach UPC,	13.45	0.22			
		Table	31	Attach Hantag,	14.35	0.24			
		Table	32	Wrapping,	19.55	0.33	1.00	93	65%
		Table	33	Packing,	19.23	0.32			
TOTAL					**747.4**	**12.5**	**17**	**63**	**73%**

EOLR	WS	Deffinition	TT
60	1.25		60.0