## 120 OSA

FTY Name	PWJ
Model Name	Duramo SL K
Season	FW21
Model ID	LEC86
Upper ID	53395
Forecast (Pairs)	30026
Latest Update	JUNE 18th, 2021
Inline EOLR	120
LC CTB	141.50
LB Efficiency	87.1%
Theoritical CT Efficiency	116.4%
LLER	84%

Module	TCT Module	EOLR Module	MP Module	MP Module conversio	PPH	LLER
Cutting Auto	28.4	240	2	1	120	95%
Pre-coating Insole Central	2.7	2400	2	0	1200	90%
Stockfitting - Buffing	18.4	300	2	1	150	77%
Stockfitting - Degreaser	15.5	1200	6	1	200	86%
Stockfitting - UV Light	51.2	800	14	2	57	81%
Stockfitting - Attaching	315.0	300	30	12	10	87%
Cutting Inline	78.0	120	3	3	40	87%
Preparation	252.8	120	11	11	11	77%
Sewing	417.3	120	16	16	8	87%
Assembly	698.8	120	28	28	4	83%
SUBTOTAL	1878.0	120		75	1.61	84%
Water Spider		120		9		
TOTAL Incl WS		120		84	1.43	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		1	Cutting Vamp/Quarter Top,	5.22	0.17				
			2	Cutting Vamp/Quarter Bottom,	18.15	0.61			
			3	Cutting Collar Padding,	4.82	0.16			87%
			4	Cutting Eyestay Reinf Lat,	3.51	0.12			
	CUTTING INLINE 0.15		5	Cutting Eyestay Reinf Med,	3.51	0.12			
CULTING INLINE		Hydrolic Mc	6	Cutting Heel Counter	2.74	0.09	3.00	138	
COTTING INLINE	0.15		7	Cutting Toe Cap,	5.84	0.19			
			8	Cutting Mudguard Overlay Lat,	8.27	0.28			
			9	Cutting Mudguard Overlay Med,	8.27	0.28			
			10	Cutting Eyestay Lower,	7.83	0.26			
			11	Cutting 3 Stripes Lat,	4.94	0.16			
			12	Cutting 3 Stripes Med,	4.94	0.16			
	TOTAL							138	87%
	EOLR WS Deffinition						•		•

EOLR	ws	Deffinition	TT	l
120	1		30.0	ĺ

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Skiving Counter Mc	1	Skiving Heel Counter,	13.88	0.46	0.50	130	93%
		Size Label Mc	2	Stamping Size label Tonge Linning,	14.24	0.47	0.50	126	95%
		CS-6040	3	Stitch Tongue Overlay to Tongue,	21.57	0.72	1.00	167	72%
		CS-3020	4	Stitch Tongue Linning to tongue,	17.29	0.58	1.00	208	58%
		Reverse Tongue Mc	5	Tongue reverse,	10.66	0.36	1.00	138	87%
PREPARATION UPPER	15%	Flat 1N	6	Stitch Tongue EDGE,	15.44	0.51	1.00	130	0/70
PREPARATION OPPER	15%	Flat 1N	7	Stitch Lace loop to tongue,	13.96	0.47	1.00	258	47%
		Flat 1N	8	Collar linning edge,	18.46	0.62	1.00	195	62%
		Punching Mc	9	Pounching Eyestay #1,	17.46	0.58	1.00	206	58%
		Post 1N	10	Stitch heel cap to Vamp quarter,	55.84	1.86	2.00	129	93%
		Zig-Zag Mc	11	Stitch zig zag heel cap to vamp/ quarter #1	24.68	0.82	1.00	146	82%
		Post 4N	12	Stitch heel cap with vamp/ quarter #2 ,	29.30	0.98	1.00	123	98%
TOTAL					252.78	8.43	11.00	123	77%

EOLR ws Deffinition TT 120 30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Post 1N	1	Stitch eyestay top To vamp/ quarter,	97.34	3.24	4.00	148	81%
		Post 1N	2	stitch heel counter to upper	28.52	0.95	2.00	147	82%
		POSLIN	3	Stitch Collar Linning to Upper,	20.50	0.68	2.00	147	0270
		Spray Mc	4	Spray Upper,	14.56	0.49			
	15%		5	Attaching Collar Padding to Upper,	19.28	0.64	2.00	126	96%
STITCHING			6	Reverse Collar Linning,	10.94	0.36	2.00	120	
SITICHING		Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.54	0.42			
		Punching Mc	8	Pounching Eyestay #2,	29.24	0.97	1.00	123	97%
		Post 1N	9	Stitch Tongue/Eyestay Laceloop to Tongue	29.38	0.98	1.00	123	98%
		CS-1510	10	Stitch Conection Vamp tongue to Upper,	29.16	0.97	1.00	123	97%
		Post 1N	11	Stitch Lasting Margin	28.44	0.95	1.00	127	95%
		Upper Clamp	12	Insert Shoe Lace,	97.36	3.25	4.00	148	81%
TOTAL					417.26	13.91	16.00	123	87%
		EOLR	ws	Deffinition	TT				

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120

2

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		ВРМ	1	Back Part Molding,	29.24	0.97	1.00	123	97%
		Vamp Mold Mc	2	Toecap Molding,	18.36	0.61	1.00	196	61%
		Strobel Mc	3	Stitch Strobel,	48.26	1.61	2.00	149	80%
		Table	4	Setting Last,	18.36	0.61	1.00	196	61%
		Kabuki	5	Insert Last,	14.40	0.48	1.00	146	82%
		Heel Last Mc	6	Heel Last,	10.24	0.34	1.00	140	02 /0
		Table	7	Tightening Lace,	27.28	0.91	1.00	132	91%
		Gauge Marking Mc	8	Gauge Marking,	25.28	0.84	1.00	142	84%
		Table	9	Gauge Toe,	19.34	0.64	1.00	186	64%
		Rack Outsole	10	Prepare Outsole,	17.26	0.58	1.00	209	58%
		Conveyor	11	Cleaner Upper,	22.96	0.77	1.00	157	77%
		Chamber 1	12	Chamber 1	23.52				
		Conveyor	13	Primer Upper,	48.30	1.61	2.00	149	81%
		Conveyor	14	Primer Outsole,	29.14	0.97	1.00	124	97%
		Chamber 2	15	Chamber 2	25.36				
		Conveyor	16	Cement Outsole,	23.08	0.77	1.00	156	77%
ASSEMBLY	0.15	Chamber 3	17	Chamber 3	78.36				
		Conveyor	18	Attach Outsole,	69.44	2.31	3.00	156	77%
		Universal Press Mc	19	Universal Pressing,	26.34	0.88	1.00	137	88%
		Blower Mc	20	Blowing Outsole,	18.88	0.63	1.00	191	63%
		Chiller Mc	21	Chiller	21.36				
		Table	22	Open Lace,Open Last,	28.70	0.96	1.00	125	96%
		Sockliner Mc	23	Hotmelt Aplication on Inlaysole,	19.12	0.64	1.00	188	64%
		Table	24	Lacing,	29.28	0.98	1.00	123	98%
		Table	25	Finishing,	28.88	0.96	1.00	125	96%
		Table	26	Finishing Inspection,	28.62				
		Metal Detector Mc	27	Metal detector	4.21				
		Table	28	Insert Paper,	14.68	0.49	1.00	123	97%
		Table	29	Innerbox Folding,	14.49	0.48		.20	,,,,,
		Table	30	Attach UPC,	13.45	0.45	1.00	129	93%
		Table	31	Attach Hantag,	14.35	0.48		/	, 5 %
		Table	32	Wrapping,	19.55	0.65	1.00	184	65%
		Table	33	Packing,	19.23	0.64	1.00	187	64%
TOTAL					698.8	22	28	123	80%

 EOLR
 WS
 Deffinition
 TT

 120
 2.5
 30.0

## **120 NON OSA**

FTY Name	PWJ
Model Name	Duramo SL K
Season	FW21
Model ID	LEC86
Upper ID	53395
Forecast (Pairs)	30026
Latest Update	JUNE 18th, 2021
Inline EOLR	120
LC CTB	140.04
LB Efficiency	84.2%
Theoritical CT Efficiency	115.9%
LLER	81%

Module	TCT Module	EOLR Module	MP Module	MP Module conversio	РРН	LLER
Cutting Auto	28.4	240	2	1	120	95%
Pre-coating Insole Central	2.7	2400	2	0.1	1200	90%
Stockfitting - Buffing	18.4	300	2	0.8	150	77%
Stockfitting - Degreaser	15.5	1200	6	0.6	200	86%
Stockfitting - UV Light	51.2	800	14	2.1	57	81%
Stockfitting - Attaching	315.0	300	30	12.0	10	87%
Cutting Inline	78.0	120	3	3	40	87%
Preparation	252.8	120	11	11	11	77%
Sewing	417.3	120	16	16	8	87%
Assembly	687.6	120	30	30	4	76%
SUBTOTAL	1866.8	120	116	77	1.57	81%
Water Spider		120		9		
TOTAL Incl WS		120		86	1.40	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		1	Cutting Vamp/Quarter Top,	5.22	0.17				
			2	Cutting Vamp/Quarter Bottom,	18.15	0.61			
			3	Cutting Collar Padding,	4.82	0.16			
			4	Cutting Eyestay Reinf Lat,	3.51	0.12			
			5	Cutting Eyestay Reinf Med,	3.51	0.12			
CUTTING INLINE	0.15	Hydrolic Mc	6	Cutting Heel Counter	2.74	0.09	3.00	138	87%
COTTING INCINE	0.13	Thyurotte Me	7	Cutting Toe Cap,	5.84	0.19	3.00	130	0770
			8	Cutting Mudguard Overlay Lat,	8.27	0.28			
			9	Cutting Mudguard Overlay Med,	8.27	0.28			
			10	Cutting Eyestay Lower,	7.83	0.26			
			11	Cutting 3 Stripes Lat,	4.94	0.16			
			12	Cutting 3 Stripes Med,	4.94	0.16			
	TOTAL							138	87%
		EOLR	ws	Deffinition	TT				

EOLR	ws	Deffinition	TT	l
120	1		30.0	ĺ

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Skiving Counter Mc	1	Skiving Heel Counter,	13.9	0.5	0.5	130	93%
		Size Label Mc	2	Stamping Size label Tonge Linning,	14.2	0.5	0.5	126	95%
		CS-6040	3	Stitch Tongue Overlay to Tongue,	21.6	0.7	1	167	72%
		CS-3020	4	Stitch Tongue Linning to tongue,	17.3	0.6	1	208	58%
PREPARATION UPPER 15%	Reverse Tongue Mc	5	Tongue reverse,	10.7	0.4	1	138	87%	
THE ARATION OF LER	1370	Flat 1N	6	Stitch Tongue EDGE,	15.4	0.5		130	0776
		Flat 1N	7	Stitch Lace loop to tongue,	14.0	0.5	1	258	47%
		Flat 1N	8	Collar linning edge,	18.5	0.6	1	195	62%
		Punching Mc	9	Pounching Eyestay #1,	17.5	0.6	1	206	58%
		Post 1N	10	Stitch heel cap to Vamp quarter,	55.8	1.9	2	129	93%
	_	Zig-Zag Mc	11	Stitch zig zag heel cap to vamp/ quarter #1	24.7	0.8	1	146	82%
		Post 4N	12	Stitch heel cap with vamp/ quarter #2 ,	29.3	1.0	1	123	98%
TOTAL					252.8	8	11	123	77%

EOLR	ws	Deffinition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	N0	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Post 1N	1	Stitch eyestay top To vamp/ quarter,	97.3	3.2	4.00	148	81%
		Post 1N	2	stitch heel counter to upper	28.5	1.0	2.00	147	82%
		POSLIN	3	Stitch Collar Linning to Upper,	20.5	0.7	2.00	147	0270
		Spray Mc	4	Spray Upper,	14.6	0.5		126	96%
			5	Attaching Collar Padding to Upper,	19.3	0.6	2.00		
STITCHING	15%		6	Reverse Collar Linning,	10.9	0.4	2.00		
SITICIINO	1370	Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.5	0.4			
		Punching Mc	8	Pounching Eyestay #2,	29.2	1.0	1.00	123	97%
		Post 1N	9	Stitch Tongue/Eyestay Laceloop to Tongue	29.4	1.0	1.00	123	97% 98% 97% 95%
		CS-1510	10	Stitch Conection Vamp tongue to Upper,	29.2	1.0	1.00	123	97%
		Post 1N	11	Stitch Lasting Margin	28.4	0.9	1.00	127	95%
		Upper Clamp	12	Insert Shoe Lace,	97.4	3.2	4.00	148	81%
TOTAL					417.3	14	16	123	87%
		EOLR	ws	Deffinition	TT		<u> </u>	•	•

30.0

BPM	AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
Strobel Mc   3   Strich Strobel   48 76   1.41   2.00   147   80%     Table   4   Setting Last   118.36   0.41   1.00   196   61%     Kabuki   5   Insert Last   10.24   0.24   1.00   166   82%     Heat Last Mc   6   Heis Last   10.24   0.24   1.00   120   17%     Table   7   Tightening Lece,   27.78   0.91   1.00   132   91%     Gauge Marking Mc   8   Gauge Marking   27.64   0.97   1.00   121   97%     Table   9   Sauge Toe,   19.34   0.44   1.00   186   64%     Table   9   Sauge Toe,   19.34   0.44   1.00   186   64%     Table   10   Prepare Outsole,   17.26   0.88   1.00   2.99   58%     Conveyor   11   Cleaner Upper,   22.96   0.77   1.00   157   77%     Chamber 1   27   Chamber 1   73.57   77%     Conveyor   13   Primer Upper,   48.30   1.61   2.00   149   81%     Conveyor   14   Primer Disable,   29.14   0.97   1.00   124   97%     Chamber 2   15   Chamber 2   27.88   78.35   78.35     Conveyor   16   Cament Outsole,   19.54   0.45   1.00   184   65%     Conveyor   17   Cament Outsole,   19.54   0.45   1.00   184   65%     Chamber 3   18   Chamber 3   78.35   78.35   77%     Chamber 4   20   Universal Precising,   29.34   0.88   1.00   127   88%     Blower Mc   21   Blowle Outsole,   18.88   0.43   1.00   191   43%     Childer Mc   22   Chiller   21.36   0.46   1.00   188   4.45     Table   25   Lecing,   29.28   0.98   1.00   123   98%     Table   26   Lecing,   29.28   0.98   1.00   123   98%     Table   27   Finishing Inspection,   28.52     Meal Cleater Mc   28   Meal Selector   4.21   1.00   184   65%     Table   31   Attach Urc.,   11.45   0.45   1.00   184   65%     Table   32   Attach Harrag,   14.58   0.48   1.00   179   97%     Table   33   Myraping,   19.55   0.46   1.00   184   65%     Table   33   Attach Harrag,   14.55   0.46   1.00   184   65%     Table   34   Attach Harrag,   14.55   0.46   1.00   184   65%     Table   33   Attach Harrag,   14.55   0.46   1.00   184   65%     Table   34   Attach Harrag,   14.55   0.46   1.00   184   65%     Table   34   Attach Harrag,   14.55   0.46   1.0			ВРМ	1	Back Part Molding,	29.24	0.97	1.00	123	97%
ASSEMBLY  Table 4 Setting Last, 18.36 0.61 1.00 196 61%  Kabuki 5 Incort Last, 11.40 0.68  Hotel Last Mc 6 Heat Last, 10.24 0.62  Table 7 Tiphrening Leco, 27.28 0.91 0.00 122 91%  Gauge Marking Mc 8 Gauge Marking, 29.64 0.99 1.00 121 99%  Table 9 Gauge Toc, 11.34 0.64 1.00 186 64%  Rich Dutsolde 10 Prepare dutsole, 17.26 0.68 1.00 229 58%  Conveyor 11 Cleaner Upper, 27.96 0.77 1.00 137 77%  Chamber 1 12 Chamber 1 2.352  Conveyor 14 Primer Upper, 46.30 0.61 1.00 186 64%  Conveyor 15 Chamber 2 25.36  Conveyor 16 Cament Upper, 57.20 1.91 2.00 126 99%  Chamber 2 15 Chamber 2 25.36  Conveyor 16 Cament Upper, 57.20 1.91 2.00 126 99%  Conveyor 19 Attach Outsole, 17.54 0.65 1.00 184 65%  Elowar Mc 21 Blowing Outsole, 18.38 0.63 1.00 137 88%  Elowar Mc 21 Blowing Outsole, 18.38 0.63 1.00 191 6.39%  Chamber 2 25 Chiller  Table 23 Open Laco, Open Last, 28.70 0.96 1.00 123 99%  Table 24 Finishing Inspection, 18.46 0.47 1.00 123 99%  Table 25 Indign. 19.94 0.42 1.00 123 99%  Table 26 Finishing, 19.94 0.45 1.00 123 99%  Table 27 Finishing Inspection, 18.49 0.48 1.00 123 99%  Table 28 Metal detector 4.21 1.00 1.00 1.00 1.00 1.00 1.00 1.00 1			Vamp Mold Mc	2	Toecap Molding,	18.36	0.61	1.00	196	61%
Rabular   S			Strobel Mc	3	Stitch Strobel,	48.26	1.61	2.00	149	80%
Heat Last Mc			Table	4	Setting Last,	18.36	0.61	1.00	196	61%
Heel Last Mc			Kabuki	5	Insert Last,	14.40	0.48	1.00	1//	020/
Gauge Marking Mc			Heel Last Mc	6	Heel Last,	10.24	0.34	1.00	140	02 /0
ASSEMBLY  Table  9 Gauge Toe,  19 34 0.64 1.00 188 6.4%  Rak Outsole  10 Prepare Outsole,  17.26 0.58 1.00 209 58%  Conveyor 11 Cleaner Upper,  22.96 0.77 1.00 157 77%  Chamber 1 22 Chamber 1  22.52  Conveyor 13 Primer Upper,  48.30 1.61 2.00 149 81%  Conveyor 14 Primer Outsole,  29 14 0.97 1.00 124 97%  Chamber 2  Conveyor 15 Chamber 2  Conveyor 16 Cement Upper,  57.20 1.91 2.00 126 95%  Conveyor 17 Cement Outsole,  19 54 0.65 1.00 184 65%  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,  8 Sockliner Mc 21 Blowing Outsole,  18 88 0.03 1.00 191 6.3%  Chiller Mc 22 Chiller  Table 25 Qena Lace Open Last,  Sockliner Mc 24 Hotmetl Aplication on Inlaysole,  19 12 0.64 1.00 188 64%  Table 25 Incing,  7 Phishing Inspection,  Metal Detector Mc 28 Metal detector  Table 29 Insert Paper,  10 184 65%  Table 31 Insert Paper,  10 184 65%  Table 32 Attach Harbag,  Table 33 Wrapping,  19 19 55 0.65 1.00 184 65%			Table	7	Tightening Lace,	27.28	0.91	1.00	132	91%
Rak Outsole   10   Prepare Outsole,   17.26   0.58   1.00   209   58%			Gauge Marking Mc	8	Gauge Marking,	29.64	0.99	1.00	121	99%
ASSEMBLY    Conveyor   11   Cleaner Upper,   22.96   0.77   1.00   157   77%   77%   78   78   78   78   78			Table	9	Gauge Toe,	19.34	0.64	1.00	186	64%
ASSEMBLY    Chamber 1   12   Chamber 1   23.52			Rak Outsole	10	Prepare Outsole,	17.26	0.58	1.00	209	58%
ASSEMBLY    Conveyor   13			Conveyor	11	Cleaner Upper,	22.96	0.77	1.00	157	77%
ASSEMBLY    15%   Conveyor   14   Primer Outsole,   29.14   0.97   1.00   124   97%			Chamber 1	12	Chamber 1	23.52				
ASSEMBLY  15%    Conveyor   16   Cement Upper,   57,20   1,91   2,00   126   95%			Conveyor	13	Primer Upper,	48.30	1.61	2.00	149	81%
ASSEMBLY  15%    Conveyor   16   Cement Upper,   197.   191   2.00   126   95%			Conveyor	14	Primer Outsole,	29.14	0.97	1.00	124	97%
ASSEMBLY    Conveyor   17   Cement Outsole,   19,54   0.65   1.00   184   65%			Chamber 2	15	Chamber 2	25.36				
ASSEMBLY    15%   Chamber 3   18   Chamber 3   78.36			Conveyor	16	Cement Upper,	57.20	1.91	2.00	126	95%
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         1.00         191         63%           Chitler Mc         22         Chitler         21.36         21.36         21.36         21.36         22.36         28.70         0.96         1.00         125         96% <td>ASSEMBLY</td> <td>15%</td> <td>Conveyor</td> <td>17</td> <td>Cement Outsole,</td> <td>19.54</td> <td>0.65</td> <td>1.00</td> <td>184</td> <td>65%</td>	ASSEMBLY	15%	Conveyor	17	Cement Outsole,	19.54	0.65	1.00	184	65%
Universal Press Mc   20   Universal Pressing,   26.34   0.88   1.00   137   88%	ASSEMBET		Chamber 3	18	Chamber 3	78.36				
Blower Mc   21   Blowing Outsole,   18.88   0.63   1.00   191   63%			Conveyor	19	Attach Outsole,	69.44	2.31	3.00	156	77%
Chiller Mc         22         Chiller         21.36         21.36           Table         23         Open Lace, Open Last,         28.70         0.96         1.00         125         96%           Sockliner Mc         24         Hotmelt Aplication on Inlaysole,         19.12         0.64         1.00         188         64%           Table         25         Lacing,         29.28         0.98         1.00         123         98%           Table         26         Finishing,         16.94         0.56         1.00         213         56%           Table         27         Finishing Inspection,         28.62         28.62         28.62         28.62         28.62         28.62         29.6			Universal Press Mc	20	Universal Pressing,	26.34	0.88	1.00	137	88%
Table       23       Open Lace, Open Last,       28.70       0.96       1.00       125       96%         Sockliner Mc       24       Hotmelt Aplication on Inlaysole,       19.12       0.64       1.00       188       64%         Table       25       Lacing,       29.28       0.98       1.00       123       98%         Table       26       Finishing,       16.94       0.56       1.00       213       56%         Table       27       Finishing Inspection,       28.62       2       28.62       2         Metal Detector Mc       28       Metal detector       4.21			Blower Mc	21	Blowing Outsole,	18.88	0.63	1.00	191	63%
Sockliner Mc   24   Hotmelt Aplication on Inlaysole,   19.12   0.64   1.00   188   64%     Table   25   Lacing,   29.28   0.98   1.00   123   98%     Table   26   Finishing,   16.94   0.56   1.00   213   56%     Table   27   Finishing Inspection,   28.62     Metal Detector Mc   28   Metal detector   4.21     Table   29   Insert Paper,   14.68   0.49   1.00   123   97%     Table   30   Innerbox Folding,   14.49   0.48   1.00   123   97%     Table   31   Attach UPC,   13.45   0.45   1.00   129   93%     Table   32   Attach Hantag,   14.35   0.48   1.00   129   93%     Table   33   Wrapping,   19.55   0.65   1.00   184   65%     Table   34   Packing,   19.23   0.64   1.00   187   64%			Chiller Mc	22	Chiller	21.36				
Table 25 Lacing, 29.28 0.98 1.00 123 98%  Table 26 Finishing, 16.94 0.56 1.00 213 56%  Table 27 Finishing Inspection, 28.62  Metal Detector Mc 28 Metal detector 4.21  Table 29 Insert Paper, 14.68 0.49  Table 30 Innerbox Folding, 14.49 0.48  Table 31 Attach UPC, 13.45 0.45  Table 32 Attach Hantag, 14.35 0.48  Table 33 Wrapping, 19.55 0.65 1.00 184 65%  Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	23	Open Lace,Open Last,	28.70	0.96	1.00	125	96%
Table 26 Finishing, 16.94 0.56 1.00 213 56%  Table 27 Finishing Inspection, 28.62  Metal Detector Mc 28 Metal detector 4.21  Table 29 Insert Paper, 14.68 0.49  Table 30 Innerbox Folding, 14.49 0.48  Table 31 Attach UPC, 13.45 0.45  Table 32 Attach Hantag, 14.35 0.48  Table 33 Wrapping, 19.55 0.65 1.00 184 65%  Table 34 Packing, 19.23 0.64 1.00 187 64%			Sockliner Mc	24	Hotmelt Aplication on Inlaysole,	19.12	0.64	1.00	188	64%
Table 27 Finishing Inspection, 28.62  Metal Detector Mc 28 Metal detector 4.21  Table 29 Insert Paper, 14.68 0.49  Table 30 Innerbox Folding, 14.49 0.48  Table 31 Attach UPC, 13.45 0.45  Table 32 Attach Hantag, 14.35 0.48  Table 33 Wrapping, 19.55 0.65 1.00 184 65%  Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	25	Lacing,	29.28	0.98	1.00	123	98%
Metal Detector Mc         28         Metal detector         4.21         30         4.21         30         14.68         0.49         1.00         123         97%           Table         30         Innerbox Folding,         14.49         0.48         1.00         123         97%           Table         31         Attach UPC,         13.45         0.45         1.00         129         93%           Table         32         Attach Hantag,         14.35         0.48         1.00         129         93%           Table         33         Wrapping,         19.55         0.65         1.00         184         65%           Table         34         Packing,         19.23         0.64         1.00         187         64%			Table	26	Finishing,	16.94	0.56	1.00	213	56%
Table       29       Insert Paper,       14.68       0.49       1.00       123       97%         Table       30       Innerbox Folding,       14.49       0.48       1.00       123       97%         Table       31       Attach UPC,       13.45       0.45       1.00       129       93%         Table       32       Attach Hantag,       14.35       0.48       1.00       129       93%         Table       33       Wrapping,       19.55       0.65       1.00       184       65%         Table       34       Packing,       19.23       0.64       1.00       187       64%			Table	27	Finishing Inspection,	28.62				
Table 30 Innerbox Folding, 14.49 0.48 1.00 123 97%  Table 31 Attach UPC, 13.45 0.45 1.00 129 93%  Table 32 Attach Hantag, 14.35 0.48 1.00 129 93%  Table 33 Wrapping, 19.55 0.65 1.00 184 65%  Table 34 Packing, 19.23 0.64 1.00 187 64%			Metal Detector Mc	28	Metal detector	4.21				
Table 30 Innerbox Folding, 14.49 0.48  Table 31 Attach UPC, 13.45 0.45  Table 32 Attach Hantag, 14.35 0.48  Table 33 Wrapping, 19.55 0.65 1.00 184 65%  Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	29	Insert Paper,	14.68	0.49	1 00	122	97%
Table     32     Attach Hantag,     14.35     0.48     1.00     129     93%       Table     33     Wrapping,     19.55     0.65     1.00     184     65%       Table     34     Packing,     19.23     0.64     1.00     187     64%			Table	30	Innerbox Folding,	14.49	0.48	1.00	123	7770
Table     32     Attach Hantag,     14.35     0.48       Table     33     Wrapping,     19.55     0.65     1.00     184     65%       Table     34     Packing,     19.23     0.64     1.00     187     64%			Table	31	Attach UPC,	13.45	0.45	1 00	120	930/
Table 34 Packing, 19.23 0.64 1.00 187 64%			Table	32	Attach Hantag,	14.35	0.48	1.00	127	7570
			Table	33	Wrapping,	19.55	0.65	1.00	184	65%
TOTAL 687.6 24 30 121 79%			Table	34	Packing,	19.23	0.64	1.00	187	64%
	TOTAL					687.6	24	30	121	79%

 EOLR
 WS
 Deffinition
 TT

 120
 2.5
 30.0

## **60 NON OSA**

FTY Name	PWJ
Model Name	Duramo SL K
Season	FW21
Model ID	LEC86
Upper ID	53395
Forecast (Pairs)	30026
Latest Update	JUNE 18th, 2021
Inline EOLR	60
LC CTB	140.04
LB Efficiency	78.8%
Theoritical CT Efficiency	117.4%
LLER	75%

Module	TCT Module	EOLR Module	MP Module	MP Module conversio	РРН	LLER
Cutting Auto	28.4	240	2	1	120	95%
Pre-coating Insole Central	2.7	2400	2	0.1	1333	99%
Stockfitting - Buffing	18.4	300	2	0	150	77%
Stockfitting - Degreaser	15.5	1200	6	0	200	86%
Stockfitting - UV Light	51.2	800	14	1	57	81%
Stockfitting - Attaching	315.0	300	30	6	10	87%
Cutting Inline	78.0	60	2	2	40	87%
Preparation	252.8	60	5	5	13	90%
Sewing	417.3	60	10	10	6	70%
Assembly	664.0	60	17	17	4	67%
SUBTOTAL	1843.2	60	89	41	1.46	75%
Water Spider		60		5		
TOTAL Incl WS		60		46	1.31	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
			1	Cutting Vamp/Quarter Top,	5.22	0.09			
			2	Cutting Vamp/Quarter Bottom,	18.15	0.30			
			3	Cutting Collar Padding,	4.82	0.08			87%
			4	Cutting Eyestay Reinf Lat,	3.51	0.06		69	
		Hydrolic Mc	5	Cutting Eyestay Reinf Med,	3.51	0.06	2		
CUTTING INLINE	0.15		6	Cutting Heel Counter	2.74	0.05			87%
COTTING INLINE	0.15		7	Cutting Toe Cap,	5.84	0.10			
			8	Cutting Mudguard Overlay Lat,	8.27	0.14			
			9	Cutting Mudguard Overlay Med,	8.27	0.14			
			10	Cutting Eyestay Lower,	7.83	0.13	1		
			11	Cutting 3 Stripes Lat,	4.94	0.08			
			12	Cutting 3 Stripes Med,	4.94	0.08			
		TOTAL			78.0	1.30	2	69	87%
· · · · · · · · · · · · · · · · · · ·	·	FOI R	ws	Deffinition	TT		·		

EOLR	ws	Deffinition	TT
60	0.5		60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Skiving Counter Mc	1	Skiving Heel Counter,	13.9	0.2	0.3	78	77%
		Size Label Mc	2	Stamping Size label Tonge Linning,	14.2	0.2	0.3	76	79%
		CS-6040	3	Stitch Tongue Overlay to Tongue,	21.6	0.4	0.4	60	100%
		CS-6040	4	Stitch Tongue Linning to tongue,	17.3	0.3	0.3	62	96%
	REPARATION UPPER 15%	Reverse Tongue Mc	5	Tongue reverse,	10.7	0.2	1	73	82%
PREDARATION LIPPER		Flat 1N	6	Stitch Lace loop to tongue,	14.0	0.2	'		02 /0
THE ANATON OF TER		Flat 1N	7	Stitch Tongue EDGE,	15.4	0.3	1	64	94%
		Flat 1N	8	Collar linning edge,	18.5	0.3	'	04	7470
		Punching Mc	9	Pounching Eyestay #1,	17.5	0.3	0.3	62	97%
		Post 1N	10	Stitch heel cap to Vamp quarter,	55.8	0.9	1	64	93%
		Zig-Zag Mc	11	Stitch zig zag heel cap to vamp/ quarter #1	24.7	0.4	0.5	73	82%
		Post 4N	12	Stitch heel cap with vamp/ quarter #2 ,	29.3	0.5	0.5	61	98%
					252.8	4	5	60	90%
		EOLR	ws	Deffinition	TT				

TOTAL

60

0.5

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		Post 1N	13	Stitch eyestay top To vamp/ quarter,	97.3	1.6	2.00	74	81%
		Post 1N	14	stitch heel counter to upper	28.5	0.5	1.00	73	82%
		POSLIN	15	Stitch Collar Linning to Upper,	20.5	0.3	1.00	/3	02%
		Spray Mc	16	Spray Upper,	14.6	0.2			96%
			17	Attaching Collar Padding to Upper,	19.3	0.3	1.00	63	
			18	Reverse Collar Linning,	10.9	0.2	1.00		
STITCHING	15%	Hammering MC	19	Hammering and Attach Upper to Jig Eva,	12.5	0.2			
STITCHING	15%	Punching Mc	20	Pounching Eyestay #2,	29.2	0.5	1.00	123	49%
		Post 1N	21	Stitch Tongue/Eyestay Laceloop to Tongue	29.4	0.5	1.00	123	49%
		CS-1510	22	Stitch Conection Vamp tongue to Upper,	29.2	0.5	1.00	123	49%
		Post 1N	23	Stitch Lasting Margin	28.4	0.5	1.00	127	47%
		Upper Clamp	24	Insert Shoe Lace,	97.4	1.6	2.00	74	81%
					417.3	7	10	63	70%
		EOLR	ws	Deffinition	TT				
TOTAL		60	0.5		60.0				

60.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP	THROUGHPU T	LLER
		ВРМ	1	Back Part Molding,	29.24	0.49	1.00	7/	700/
		Vamp Mold Mc	2	Toecap Molding,	18.36	0.31	1.00	76	79%
		Strobel Mc	3	Stitch Strobel,	48.26	0.80	1.00	75	80%
		Table	4	Setting Last,	18.36	0.31			
		Kabuki	5	Insert Last,	14.40	0.24	1.00	84	72%
		Heel Last Mc	6	Heel Last,	10.24	0.17			
		Table	7	Tightening Lace,	27.28	0.45	1.00	132	45%
		Gauge Marking Mc	8	Gauge Marking,	29.64	0.49	1.00	121	49%
		Table	9	Gauge Toe,	19.34	0.32	1.00	85	71%
		Conveyor	10	Cleaner Upper,	22.96	0.38	1.00	00	/ 170
		Conveyor	11	Primer Upper,	48.30	0.81	1.00	75	81%
		Conveyor	12	Primer Outsole,	29.14	0.49	0.50	62	97%
		Chamber 2	13	Chamber 1	25.36				
		Conveyor	14	Cement Upper,	57.20	0.95	1.00	63	95%
		Conveyor	15	Cement Outsole,	19.54	0.33	1.00	184	33%
		Chamber 3	16	Chamber 2	78.36				
		Conveyor	17	Attach Outsole,	69.44	1.16	2.00	75	80%
ASSEMBLY	15%	Universal Press Mc	18	Universal Pressing,	26.34	0.44	2.00	/5	80%
		Blower Mc	19	Blowing Outsole,	18.88	0.31	1.00	100	60%
		Table	20	Cleaning Shoes,	17.10	0.29	1.00	100	60%
		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	1.00	75	0070
		Table	24	Lacing,	29.28	0.49	1.00	78	77%
		Table	25	Finishing,	16.94	0.28	1.00	70	7770
		Table	26	Finishing Inspection,	28.62				
		Metal Detector Mc	27	Metal detector	4.21				
		Table	28	Insert Paper,	14.68	0.24			
		Table	29	Innerbox Folding,	14.49	0.24	1.00	63	95%
		Table	30	Attach UPC,	13.45	0.22	1.00	03	7570
		Table	31	Attach Hantag,	14.35	0.24			
		Table	32	Wrapping,	19.55	0.33	1.00	93	45%
		Table	33	Packing,	19.23	0.32	1.00	73	65%
					664.0	12	17	62	72%
		EOLR	ws	Deffinition	TT				

60.0

TOTAL

60

2