120 NON OSA

FTY Name	**PWJ**
Model Name	**GRAND COURT KID**
Season	**FW21**
Model ID	**BTO72, EPF87, GTD71, HJ039, KYS26, KYY68, LER86, LER88**
Upper ID	**5692**
Forecast (Pairs)	**1325560**
Latest Update	**29-Jun-21**
Inline EOLR	**120**
LC CTB	**135.79**
LB Efficiency	**95.7%**
Theoritical CT Efficiency	**101.9%**
LLER	**93%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Central	13.3	120	1	1	109	40%
Pre-coating Insole Central	5.4	2640	4	0	660	99%
Stockfitting - Degreaser	22.1	1200	8	1	150	92%
Cutting Inline	55.4	120	2	2	60	92%
Preparation	525.3	120	21	21	6	85%
Sewing	356.1	120	14	14	9	85%
Assembly	482.1	120	27	27	4	60%
SUBTOTAL	**1833.5**	**120**		**66**	**1.83**	**93%**
Water Spider		120		7		
TOTAL Incl WS		**120**		**73**	**1.64**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING IN LINE	15%	Manual (Hyd)	1	Heel Tab	5.38	0.179	2.00	130	101%
			2	Cutting collar lining,	6.19	0.206			
			3	Tongue	4.92	0.164			
			4	Vamp/Tongue lining	5.01	0.167			
			5	Vamp	4.90	0.163			
			6	Toe box	2.80	0.093			
			7	Qtr lat/med,	15.94	0.531			
			8	Heel counter	4.96	0.165			
			9	Collar foam,	5.30	0.165			
				Total	**55.4**	0.177			
		EOLR	**WS**	**Deffinition**	**TT**	**2.0**	**2**	**130**	**101%**
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
PREPARATION	15%	Skiving Counter Mc	1	Skiving heel counter,	14.38	0.5	0.5	125	96%
		Skiving Mc	2	Skiving qtr lat/med,	9.27	0.3	1.0	152	96%
			3	Skiving Eyestay,	19.64	0.7			
		Table	4	Attach Eyestay Reinf to Eyestay,	24.20	0.8	2.0	164	98%
			5	Attach quarter linning L/M to quarter,	34.55	1.2			
		Roll Hotmelt Mc	6	Attach toe box & Roll hotmelt vamp,	12.31	0.4	0.5	146	82%
		CS-1510	7	Stitching tongue logo,	21.44	0.7	1	168	71%
		Auto Label	8	Stamping size label,	12.44	0.4	0.5	145	83%
		Flat 1N	9	Stitching join tongue to tongue lining,	18.72	0.6	1.0	126	95%
		Tongue Forming Mc	10	Reverse tongue,	9.78	0.3			
		Auto Lace loop	11	Stitching lace loop,	26.59	0.9	1	135	89%
		Flat 1N	12	Stitch Tongue Edge,	16.79	0.6	2.0	186	65%
			13	Stitch edge collar lining,	21.99	0.7			
		CS-6040	14	Stitching vamp to tongue,	55.09	1.8	2	131	92%
		Table	15	placing 3 stripe to pallet	50.14	1.7	2	144	84%
		CS-6040	16	Stitch 3 stripe quarter,	52.95	1.8	2	136	88%
		Table	17	Placing eyestay to Pallet,	25.81	0.9	1	140	86%
		CS-6040	18	Stitch Eyestay & Rear Quarter Deco,	41.98	1.4	2	172	70%
		Flat 1N	19	Stitch Join Quarter L/M,	28.41	0.9	1	127	95%
		Double Folding	20	Turn quarter and Hammering heel area upper,	28.89	1.0	1	125	96%
				TOTAL	**525.3**	**18**	**21**	**125**	**85%**
		EOLR	WS	**DEFINITION**	**TT**				
		120	**1**		**30.0**				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heel tab to Upper,	40.6	1.4	2.0	177	97.9%
		Post 1N	2	Stitch heel counter to upper,	18.1	0.6			
		Post 1N	3	Stitch collar lining to upper,	57.2	1.9	2	397	95.3%
		Spray Mc	4	Spray upper,	15.6	0.5	2	141	85.4%
			5	Attach collar foam,	10.9	0.4			
			6	Reverse collar lining,	10.7	0.4			
		Hammering Mc	7	Hammer upper,	14.0	0.5			
		Punching Mc	8	Punching upper,	28.4	0.9	1	257	94.7%
		Post 1N	9	Stitching lasting margin,	31.1	1.0	2	253	51.8%
		CS-1310	10	Stitch Vamp/Tongue to upper,	55.1	1.8	2	232	91.8%
		Table	11	Insert shoe lace,	74.4	2.5	3	196	82.6%
				Total	**356.1**	**12**	**14**	**141**	**85%**
		EOLR	**WS**	**DEFINITION**	**TT**				
		120	1		**30.0**				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding [Cold, Max 40c/20"]	28.58	0.95	1	126	95%
		Vamp press Mc	2	Toe vamp molding,	23.64	0.79	1	152	79%
		Strobel Mc	3	Stitch Strobel,	46.83	1.56	2	154	78%
		Kabuki	4	Insert Laste,	26.59	0.89	2.0	164	73%
		Heel last	5	Heel Last,	17.39	0.58			
		Table	6	Strengthen lace,	27.30	0.91	1	132	91%
		Gauge Marking MC	8	Gauge Marking,	26.46	0.88	1	136	88%
		Table	9	Cleaner Upper,	29.18	0.97	1	123	97%
		Chamber MC	10	Chamber 1					
		Table	11	Primer Upper,	56.86	1.90	2	127	95%
		Table	12	Primer Outsole	22.13	0.74	1	163	74%
		Chamber MC	13	Chamber 2					
		Table	14	Cement Upper	58.97	1.97	2	122	98%
		Table	15	Cement Outsole,	22.26	0.74	1	162	74%
		Chamber MC	16	Chamber 3					
		Table	17	Attach Outsole	79.70	2.66	3	136	89%
		Universal Pressing	18	Universal press,	24.36	0.81	1	148	81%
		Chiller MC	19	Chiller					
		Open Laste Mc	21	Open Laste,	14.38	0.48	1	#DIV/0!	48%
		Table	22	Cement & Insert Sockliner,	22.20	0.74	1	250	74%
		Table	23	Finishing	47.10	1.57	2	324	79%
		Table	24	Inspection					
		MD Mc	25	Metal Detector					
		Table	26	Insert Paper	11.87	0.40	1.0	303	100%
			27	Inner Box Folding	18.00	0.60			
		Table	28	Attach Hang Tag	10.64	0.35	1.0	127	95%
			29	Attach UPC	17.77	0.59			
		Table	30	Wrapping	22.66	0.76	1	159	76%
		Table	31	Packing Shoes	24.38	0.81	1	148	81%
		Total			**482.1**	**23**	**27**	**#DIV/0!**	**84%**

EOLR	WS	DEFINITION	TT
120	2.5		**30.0**

60 NON OSA

FTY Name	**PWJ**
Model Name	**GRAND COURT KID**
Season	**FW21**
Model ID	**BT072, EPF87, GTD71, HJ039, KYS26, KYY68, LER86, LER88**
Upper ID	**5692**
Forecast (Pairs)	**1325560**
Latest Update	**29-Jun-21**
Inline EOLR	**60**
LC CTB	**135.79**
LB Efficiency	**88.9%**
Theoritical CT Efficiency	**89.6%**
LLER	**87%**

Module	**TCT Module**	**EOLR Module**	**MP Module**	**MP Module** conversion	**PPH**	**LLER**
Cutting Central	13.3	120	1	0.55	109	40%
Pre-coating Insole Central	5.4	2640	4	0.09	660	99%
Stockfitting - Degreaser	22.1	1200	8	0.40	150	92%
Stockfitting - Pre-coating Outsol	102.1	600	18	1.80	33	95%
Cutting Inline	55.4	60	1	1.00	60	92%
Preparation	494.5	120	21	10.25	6	80%
Sewing	356.1	60	8	8.00	8	74%
Assembly	628.5	60	13	13.00	5	81%
SUBTOTAL	**1833.5**	**60**		**35**	**1.71**	**87%**
Water Spider		60		4		
TOTAL Incl WS		**60**		**39.33**	**1.53**	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
CUTTING IN LINE	15%	Manual (Hyd)	1	Heel Tab	5.38	0.090	1.00	65	92%
			2	Cutting collar lining,	6.19	0.103			
			3	Tongue	4.92	0.082			
			4	Vamp/Tongue lining	5.01	0.084			
			5	Vamp	4.90	0.082			
			6	Toe box	2.80	0.047			
			7	Qtr lat/med,	15.94	0.266			
			8	Heel counter	4.96	0.083			
			9	Collar foam,	5.30	0.083			
				Total	**55.4**	**0.9**	**1**	**65**	**92%**
		EOLR	**WS**	**Deffinition**	**TT**				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
PREPARATION	15%	Skiving Counter Mc	1	Skiving heel counter,	14.38	0.5	0.5	125	96%
		Skiving Mc	2	Skiving qtr lat/med,	9.27	0.3	1.0	125	96%
			3	Skiving Eyestay,	19.64	0.7			
		Table	4	Attach Eyestay Reinf to Eyestay,	24.20	0.8	2.0	123	98%
			5	Attach quarter linning L/M to quarter,	34.55	1.2			
		Roll Hotmelt Mc	6	Attach toe box & Roll hotmelt vamp,	12.31	0.4	1	293	41%
		CS-1510	7	Stitching tongue logo,	21.44	0.7	1	168	71%
		Auto Label	8	Stamping size label,	12.44	0.4	1	289	41%
		Flat 1N	9	Stitching join tongue to tongue lining,	18.72	0.6	1.0	126	95%
		Tongue Forming Mc	10	Reverse tongue,	9.78	0.3			
		Auto Lace loop	11	Stitching lace loop,	26.59	0.9	1	368	89%
		Flat 1N	12	Stitch Tongue Edge,	16.79	0.6	2.0	186	65%
		Flat 1N	13	Stitch edge collar lining,	21.99	0.7			
		Post 2 N	14	Stitching vamp to tongue,	24.30	0.8	1	148	81%
		Table	15	placing 3 stripe to pallet	50.14	1.7	2	144	84%
		CS-6040	16	Stitch 3 stripe quarter,	52.95	1.8	2	136	88%
		Table	17	Placing eyestay to Pallet,	25.81	0.9	1	140	86%
		CS-6040	18	Stitch Eyestay & Rear Quarter Deco,	41.98	1.4	2	172	70%
		Flat 1N	19	Stitch Join Quarter L/M,	28.41	0.9	1	127	95%
		Double Folding	20	Turn quarter and Hammering heel area upper,	28.89	1.0	1	125	96%
				TOTAL	**494.5**	**16**	**21**	**123**	**80%**
		EOLR	WS		**TT**				
		120	**1**		**30.0**				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heel tab to Upper,	40.6	0.7	1	89	98%
		Post 1N	2	Stitch heel counter to upper,	18.1	0.3			
		Post 1N	3	Stitch collar lining to upper,	57.2	1.0	1	199	95%
		Spray Mc	4	Spray upper,	15.6	0.3	1	70	85%
			5	Attach collar foam,	10.9	0.2			
			6	Reverse collar lining,	10.7	0.2			
		Hammering Mc	7	Hammer upper,	14.0	0.2			
		Punching Mc	8	Punching upper,	28.4	0.5	1	257	47%
		Post 1N	9	Stitching lasting margin,	31.1	0.5	1	127	52%
		CS-1310	10	Stitch Vamp/Tongue to upper,	55.1	0.9	1	116	92%
		Table	11	Insert shoe lace,	74.4	1.2	2	131	62%
				Total	**356.1**	**6**	**8**	**70**	**74%**
		EOLR	**WS**		**TT**				
		60	0.5		**60.0**				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding [Cold, Max 40c/20"]	28.58	0.48	1	69	87%
		Vamp press Mc	2	Toe vamp molding,	23.64	0.39			
		Strobel Mc	3	Stitch Strobel,	46.83	0.78	1	77	78%
		Kabuki	4	Insert Laste,	26.59	0.44	1	82	73%
		Heel last	5	Heel Last,	17.39	0.29			
		Table	6	Strengthen lace,	31.40	0.52	1	115	52%
		Gauge Marking MC	7	Gauge Marking,	30.43	0.51	1	118	51%
		Table	8	Cleaner Upper,	56.86	0.95	1	63	95%
		Chamber MC	9	Chamber 1					
		Table	10	Primer Upper,	58.97	0.98	1	61	98%
		Chamber MC	11	Chamber 2					
		Table	12	Attach Outsole	79.70	1.33	2	69	87%
		Universal Pressing	13	Universal press,	24.36	0.41			
		Chiller MC	14	Chiller					
		Table	15	Open Lace,	14.84	0.25	1	70	86%
		Open Laste Mc	16	Open Laste,	14.38	0.24			
		Table	17	Cement & Insert Sockliner,	22.20	0.37			
		Table	18	Finishing	47.10	0.79	1	76	79%
		Table	19	Inspection					
		MD Mc	20	Metal Detector					
		Table	21	Insert Paper	11.87	0.20	1	62	97%
			22	Inner Box Folding	18.00	0.30			
		Table	23	Attach Hang Tag	10.64	0.18			
			24	Attach UPC	17.77	0.30			
		Table	25	Wrapping	22.66	0.38	1	77	78%
		Table	26	Packing Shoes	24.38	0.41			
		Total			**628.5**	**10**	**13.0**	**62**	**81%**
		EOLR	**WS**		**TT**				
		60	1.25		**60.0**				