

## 120 OSA

<b>FTY Name</b>	PWJ
<b>Model Name</b>	Duramo SL
<b>Season</b>	FW21
<b>Model ID</b>	LEC86
<b>Upper ID</b>	53395
<b>Forecast (Pairs)</b>	30026
<b>Latest Update</b>	JUNE 18th, 2021
<b>Inline EOLR</b>	120
<b>LC CTB</b>	141.50
<b>LB Efficiency</b>	87.1%
<b>Theoretical CT Efficiency</b>	116.4%
<b>LLER</b>	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%
<b>SUBTOTAL</b>	<b>1878.0</b>	<b>120</b>		<b>75</b>	<b>1.61</b>	<b>84%</b>
Water Spider		120		9		
<b>TOTAL Incl WS</b>		<b>120</b>		<b>84</b>	<b>1.43</b>	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp/Quarter Top,	5.22	0.17	3.00	138	87%
			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			
			6	Cutting Heel Counter	2.74	0.09			
			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					78.02	2.60	3.00	138	87%
		EOLR	WS	Deffinition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	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%
		Flat 1N	6	Stitch Tongue EDGE,	15.44	0.51			
		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	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPU T	LLER
STITCHING	15%	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%
			3	Stitch Collar Linning to Upper,	20.50	0.68			
		Spray Mc	4	Spray Upper,	14.56	0.49	2.00	126	96%
			5	Attaching Collar Padding to Upper,	19.28	0.64			
			6	Reverse Collar Linning,	10.94	0.36			
		Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.54	0.42	1.00	123	97%
		Punching Mc	8	Pounching Eyestay #2,	29.24	0.97			
		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				
		120	2		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	0.15	BPM	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			
		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%
		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			
		Table	30	Attach UPC,	13.45	0.45	1.00	129	93%
		Table	31	Attach Hantag,	14.35	0.48			
		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

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

<b>Module</b>	<b>TCT Module</b>	<b>EOLR Module</b>	<b>MP Module</b>	<b>MP Module conversio</b>	<b>PPH</b>	<b>LLER</b>
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%
<b>SUBTOTAL</b>	<b>1866.8</b>	<b>120</b>	<b>116</b>	<b>77</b>	<b>1.57</b>	<b>81%</b>
Water Spider		120		9		
<b>TOTAL Incl WS</b>		<b>120</b>		<b>86</b>	<b>1.40</b>	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp/Quarter Top,	5.22	0.17	3.00	138	87%
			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			
			6	Cutting Heel Counter	2.74	0.09			
			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					78.0	2.60	3	138	87%

EOLR	WS	Definition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
PREPARATION UPPER	15%	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%
		Reverse Tongue Mc	5	Tongue reverse,	10.7	0.4	1	138	87%
		Flat 1N	6	Stitch Tongue EDGE,	15.4	0.5			
		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%

EOLR	WS	Definition	TT
120	1		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
STITCHING	15%	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%
			3	Stitch Collar Linning to Upper,	20.5	0.7			
		Spray Mc	4	Spray Upper,	14.6	0.5	2.00	126	96%
			5	Attaching Collar Padding to Upper,	19.3	0.6			
			6	Reverse Collar Linning,	10.9	0.4			
		Hammering MC	7	Hammering and Attach Upper to Jig Eva,	12.5	0.4	1.00	123	97%
		Punching Mc	8	Pounching Eyestay #2,	29.2	1.0			
		Post 1N	9	Stitch Tongue/Eyestay Laceloop to Tongue	29.4	1.0	1.00	123	98%
		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%

EOLR	WS	Definition	TT
120	2		30.0

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	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			
		Table	7	Tightening Lace,	27.28	0.91	1.00	132	91%
		Gauge Marking Mc	8	Gauge Marking,	29.64	0.99	1.00	121	99%
		Table	9	Gauge Toe,	19.34	0.64	1.00	186	64%
		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	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 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,	26.34	0.88	1.00	137	88%
		Blower Mc	21	Blowing Outsole,	18.88	0.63	1.00	191	63%
		Chiller Mc	22	Chiller	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				
		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			
		Table	31	Attach UPC,	13.45	0.45	1.00	129	93%
		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%
TOTAL					687.6	24	30	121	79%
		EOLR	WS	Deffinition	TT				
		120	2.5		30.0				

## 60 NON OSA

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

<b>Module</b>	<b>TCT Module</b>	<b>EOLR Module</b>	<b>MP Module</b>	<b>MP Module conversio</b>	<b>PPH</b>	<b>LLER</b>
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%
<b>SUBTOTAL</b>	<b>1843.2</b>	<b>60</b>	<b>89</b>	<b>41</b>	<b>1.46</b>	<b>75%</b>
Water Spider		60		5		
<b>TOTAL Incl WS</b>		<b>60</b>		<b>46</b>	<b>1.31</b>	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
CUTTING INLINE	0.15	Hydrolic Mc	1	Cutting Vamp/Quarter Top,	5.22	0.09	2	69	87%
			2	Cutting Vamp/Quarter Bottom,	18.15	0.30			
			3	Cutting Collar Padding,	4.82	0.08			
			4	Cutting Eyestay Reinf Lat,	3.51	0.06			
			5	Cutting Eyestay Reinf Med,	3.51	0.06			
			6	Cutting Heel Counter	2.74	0.05			
			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			
			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%
		EOLR	WS	Deffinition	TT				
		60	0.5		60.0				

AREA	ALLOWANCE	MACHINERY	N0	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPU T	LLER		
PREPARATION UPPER	15%	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%		
		Reverse Tongue Mc	5	Tongue reverse,	10.7	0.2	1	73	82%		
		Flat 1N	6	Stitch Lace loop to tongue,	14.0	0.2					
		Flat 1N	7	Stitch Tongue EDGE,	15.4	0.3	1	64	94%		
		Flat 1N	8	Collar linning edge,	18.5	0.3					
		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	60.0					

		MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER		
		Post 1N	13	Stitch eyestay top To vamp/ quarter,	97.3	1.6	2.00	74	81%		
AREA	ALLOWANCE	Post 1N	14	stitch heel counter to upper	28.5	0.5	1.00	73	82%		
STITCHING	15%		Spray Mc	15	Stitch Collar Linning to Upper,	20.5				0.3	
		16		Spray Upper,	14.6	0.2					
		17		Attaching Collar Padding to Upper,	19.3	0.3					
		18		Reverse Collar Linning,	10.9	0.2					
		Hammering MC		19	Hammering and Attach Upper to Jig Eva,	12.5	0.2				
		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				



AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP	THROUGHPUT	LLER
ASSEMBLY	15%	BPM	1	Back Part Molding,	29.24	0.49	1.00	76	79%
		Vamp Mold Mc	2	Toecap Molding,	18.36	0.31			
		Strobel Mc	3	Stitch Strobel,	48.26	0.80	1.00	75	80%
		Table	4	Setting Last,	18.36	0.31	1.00	84	72%
		Kabuki	5	Insert Last,	14.40	0.24			
		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			
		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%
		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			
					664.0	12	17	62	72%
		EOLR	WS	Deffinition	TT				
TOTAL		60	2		60.0				