

FTY Name	PWJ
Model Name	Retropy E5
Season	SS22
Model ID	LK077,LK078,LK079
Upper ID	HR1421
Forecast (Pairs)	24269
Latest Update	Friday, November 5, 2021
Inline EOLR	120
LC CTB	146.47
LB Efficiency	70.9%
Theoretical CT Efficiency	95.9%
LLER	81%

Module	TCT Module	EOLR Module	MP Module	MP Module conversion	PPH	LLER
Cutting Central	21.3	240	2.00	1.00	120	71%
Pre-coating Insole Central	5.4	2640	4.00	0.18	660	99%
STOCKFITTING - Buffing	28.7	300	3.00	1.20	100	80%
STOCKFITTING - Degreaser	16.8	1200.00	6.00	0.60	200	93%
STOCKFITTING - Attaching Rubber to B	266.5	300	34.00	13.60	9	65%
Cutting Inline	107.3	120	4.00	4.00	30	89%
Preparation	585.4	120	25.50	25.50	5	77%
Sewing	581.1	120	22.00	22.00	5	88%
Assembly	747.4	120	29.00	29.00	4	86%
SUBTOTAL	2359.9	120		97.08	1.24	81%
Water Spider		120		9		
TOTAL Incl WS		120		106.35	1.13	

AREA	Allowance	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
Cutting Inline	15%	Manual Cutting	1	Cutting Vamp,	15.17	0.51	4.00	134	89%
			2	Cutting Quarter L/M,	14.20	0.47			
			3	Cutting 3 Stripe L/M,	7.90	0.26			
			4	Cutting Heelcap	15.1	0.50			
			5	Cutting eyestay,	18.0	0.60			
			6	Cutting Heelpatch Reinf,	3.0	0.10			
			7	Cutting Collar padding,	4.1	0.14			
			8	Cutting Vamp/Quarter Lining,	7.9	0.26			
			9	Cutting Toecap	18.0	0.60			
			10	Cutting Tongue	4.1	0.14			
TOTAL					107.3	3.6	4.00	134	89%
		EOLR	WS	Deffinition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
		Skiving Leather	1	Skiving Tongue,	8.2	0.3	0.30	132	91%
Preparation	15%	Skiving Leather	2	Skiving Heel Patch,	13.6	0.5	0.50	132	91%
		Auto Size Label	3	Heating Size Label to Tongue,	14.4	0.5	0.50	125	96%
		Roll Hotmelt	4	Attach Heelcounter & Hotmelt,	10.0	0.3	0.40	144	83%
		Manual / Table	4	Attach Eyestay Reinf	12.1	0.4	1.10	125	96%
			5	Attach Heel Patch	19.7	0.7			
		Flat 1 N	6	Stitch Collar lining Edge,	21.9	0.7	1.00	165	73%
		Flat Z/Z	7	Stitch z/z Vamp Extend to Vamp	38.0	1.3	2.00	190	63%
		Flat Z/Z	8	Stitch Z/Z Qrt To vamp	52.9	1.8	2.00	136	88%
		Table	9	Attach Vamp Linning,	92.5	3.1	4.00	156	77%
		Table	10	Attach 3 Stripe to Pallet,	40.3	1.3	2.00	179	67%
		CS 6040	11	Stitch 3 Stripe to Upper,	44.3	1.5	2.00	163	74%
		Table	12	Attach Toecap to Pallet	32.5	1.1	2.00	222	54%
		CS 6040	13	Stitch Toecap to Upper,	54.1	1.8	2.00	133	90%
		Table	14	Attach Ghili Eyestay to Pallet, Attach Eyestay to Pallet,	56.4	1.9	2.00	128	94%
		CS 6040	15	Stitch Ghilli & Eyestay Deco,	29.8	1.0	1.00	121	99%
		Manual/Table	16	Attach Eyestay Linning to Upper,	26.6	0.9	1.00	135	89%
		Z/Z MC	17	Stitch Joining Upper Rear (Heel)	26.5	0.9	1.00	136	88%
TOTAL					585.4	19.5	26	121	77%
		EOLR	WS	Deffinition	TT				
		120	2		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
STITCHING	15%	Post 1N	1	Stitch Heelpatch to Upper,	53.5	1.8	2.00	135	89%
		Post 2N	2	Stitch Heelcap to Upper,	58.8	2.0	2.00	122	98%
		Post 1N	3	Stitch & Turn Collar lining With Upper, and stitch lock collar lining,	52.7	1.8	2.00	137	88%
		Spray MC	4	Spray toecap Area & Attach Vamp,	37.3	1.2	4.00	155	78%
			5	Spray & Attach Collar padding,	14.4	0.5			
		Spray & Reverse	6	Spray Collar lining & than Reverse,	26.5	0.9			
		Hammering MC	7	Hammering,	15.0	0.5			
		Post 1 N	8	Stitch Qrt Deco Padding 2,	52.9	1.8	2.00	136	88%
		Post 1 N	9	Stitch Eyestay to Upper,	104.1	3.5	4.00	138	87%
		Pouching MC	10	Pouching Upper	26.8	0.9	1.00	134	89%
		CS 1510	11	Stitch Tongue to Upper,	21.9	0.7	1.00	165	73%
		Post 1 N	12	Stitch lasting Margin,	28.8	1.0	1.00	125	96%
		Upper Clamp	13	Insert Shoe Lace,	88.6	3.0	3.00	122	98%
TOTAL					581.1	19.4	22	122	88%
		EOLR	WS	Deffinition	TT				
		120	1		30.0				

AREA	ALLOWANCE	MACHINERY	NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP	THROUGHPUT	LLER
Assembly	15%	BPM	1	Back Part Molding Hot & Cold,	29.5	1.0	1	122	98%
		Vampress	2	Molding Vamp,	26.0	0.9	1	138	87%
		Gathering	3	Stitch Toe Gathering	26.9	0.9	1	134	90%
		Strobel Mc	4	Stitch Strobel,	54.2	1.8	2	133	90%
		Manual	5	Setting Laste,	12.2	0.4	2	124	97%
		SteamBox Mc	6	Steam Upper	9.8	0.3			
		Kabuki	7	Insert Last,	21.9	0.7			
		Heel last Mc	8	Heel Lasting,	14.4	0.5			
		Table	9	Tightening Lace & Prepare Outsole,	44.2	1.5	2	163	74%
		Gauge Marking Mc	10	Sole Gauge Marking,	25.0	0.8	1	144	83%
		Table	11	Toe Gauge,	19.6	0.7	1	183	65%
		Chamber Mc	12	Chamber 1					
		Conveyor Mc	13	Primer Upper,	59.8	2.0	2	120	100%
		Conveyor Mc	14	Primer Outsole,	29.6	1.0	1	122	99%
		Chamber Mc	15	Chamber 2					
		Conveyor Mc	16	Cement Upper,	56.6	1.9	2	127	94%
		Conveyor Mc	17	Cement Outsole,	27.6	0.9	1	131	92%
		Chamber Mc	18	Chamber 3					
		Conveyor Mc	19	Attaching Outsole,	79.4	2.6	3	136	88%
		Universal Press Mc	20	Universal Pressing,	27.0	0.9	1	133	90%
		Chiller Mc	21	Chiller					
		Table	22	Open lace,	17.4	0.6	2	220	55%
		Laste Puller	23	Open Lasting,	15.4	0.5			
		Sockliner Mc	24	Hotmelt Aplication on Inaysole	29.9	1.0	1	120	100%
		Table	25	Finishing	29.3	1.0	1	123	98%
		Table	26	Finishing Inspection,					
		Metal Detector Mc	27	Metal detector					
		Easement Heater Set	28	Spray Fungus & Heater Set					
		Table	29	Innerbox Folding,	21.97	0.7	1	164	73%
		Table	30	Insert UPC & Hantag,	21.3	0.7	1	169	71%
		Table	31	Wrapping Shoe,	22.7	0.8	1	158	76%
		Table	32	Final Packing,	25.9	0.9	1	139	86%
TOTAL					747.38	24.91	29	120	86%
		EOLR	WS	Deffinition	TT				

120	2.5		30.0
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