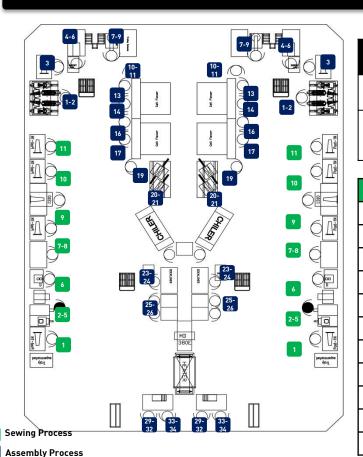
PWJ - PROCESS MODEL



Model Running Run Falcon EL K	
EOLR	60
Layout Type	Direct Stitching – Assembly 60

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP
1	Stitch Turn Over Colar Lining to Upper,	44.7	0.7	1
2	Spray Collar Lining,	10.3	0.2	
3	Attach Colar Pading to Upper,	12.7	0.2	1
4	Roll Back & Punch Tools Upper,	21.0	0.4	
5	Hammering,	12.6	0.2	
6	Punching Eyestay,	41.0	0.7	1
7	Put a Shoelace to Upper,	53.0	0.9	2
8	Sitch Lock Shoe Laces to Upper,	28.3	0.5	2
9	Stitch Tongue to Upper,	28.5	0.5	2
10	Stitch Velcrow Hooks to Upper	38.5	0.6	1
11	Stitch Strap to Upper,	55.7	0.9	1

PWJ - PROCESS MODEL

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritical	# MP
1	Back Part Molding,	25.36	0.4	1
2	Vamp Molding,	21.36	0.4	1
3	Stitch Strobel,	48.72	0.8	1
4	Setting Last,	21.63	0.4	
5	Insert Last,	14.4	0.2	1
6	Heel Last,	14.28	0.2	
7	Teghtening Strap Velcro,	27.28	0.5	
8	Gauge Marking,	28.54	0.5	2
9	Gauge Toe,	28.7	0.5	
10	Prepare Outsole,	27.23	0.5	1
11	Cleaner Upper,	22.96	0.4	1
12	Chamber 1			
13	Primer Upper,	48.7	0.8	1
14	Primer Outsole,	22.7	0.4	1
15	Chamber 2			

16 Cement Upper, 57.2 1.0 1 17 Cement Outsole, 24.7 0.4 1 18 Chamber 3 19 Attach Outsole, 58.0 1.0 1 20 Universal Press, 26.3 0.4 1 21 Blowing Outsole, 29.7 0.5 1 22 Chiller 28.7 0.5 1 24 Cement & Insert Sockliner, 26.9 0.4 1 25 Fix Velcro, 26.5 0.4 1 26 Finishing Shoes, 24.9 0.4 1 27 Finishing Inspection, 1 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 34 Packing, 27.7 0.5			_		
18 Chamber 3 19 Attach Outsole, 58.0 1.0 1 20 Universal Press, 26.3 0.4 1 21 Blowing Outsole, 29.7 0.5 1 22 Chiller 28.7 0.5 1 23 Open Last, 28.7 0.5 1 24 Cement & Insert Sockliner, 26.9 0.4 1 25 Fix Velcro, 26.5 0.4 1 26 Finishing Shoes, 24.9 0.4 1 27 Finishing Inspection, 24.9 0.4 1 28 Metal detector 29 Insert Paper, 14.7 0.2 1 30 Innerbox Folding, 12.4 0.2 1 31 Attach Jute String, 13.5 0.2 1 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	16	Cement Upper,	57.2	1.0	1
19 Attach Outsole, 58.0 1.0 1 20 Universal Press, 26.3 0.4 21 Blowing Outsole, 29.7 0.5 22 Chiller 23 Open Last, 28.7 0.5 24 Cement & Insert Sockliner, 26.9 0.4 25 Fix Velcro, 26.5 0.4 26 Finishing Shoes, 24.9 0.4 27 Finishing Inspection, 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4	17	Cement Outsole,	24.7	0.4	1
20	18	Chamber 3			
21 Blowing Outsole, 29.7 0.5	19	Attach Outsole,	58.0	1.0	1
21 Blowing Outsole, 29.7 0.5 22 Chiller 28.7 0.5 23 Open Last, 28.7 0.5 24 Cement & Insert Sockliner, 26.9 0.4 25 Fix Velcro, 26.5 0.4 26 Finishing Shoes, 24.9 0.4 27 Finishing Inspection, 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4	20	Universal Press,	26.3	0.4	1
23 Open Last, 28.7 0.5 1 24 Cement & Insert Sockliner, 26.9 0.4 1 25 Fix Velcro, 26.5 0.4 1 26 Finishing Shoes, 24.9 0.4 1 27 Finishing Inspection, 24.9 0.4 1 28 Metal detector 29 Insert Paper, 14.7 0.2 1 30 Innerbox Folding, 12.4 0.2 1 31 Attach Jute String, 13.5 0.2 1 32 Attach Hantag, 14.4 0.2 1 33 Wrapping, 26.5 0.4 1	21	Blowing Outsole,	29.7	0.5	1
24 Cement & Insert Sockliner, 26.9 0.4 25 Fix Velcro, 26.5 0.4 26 Finishing Shoes, 24.9 0.4 27 Finishing Inspection, 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	22	Chiller			
24 Cement & Insert Sockliner, 26.9 0.4 25 Fix Velcro, 26.5 0.4 26 Finishing Shoes, 24.9 0.4 27 Finishing Inspection, 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	23	Open Last,	28.7	0.5	1
26 Finishing Shoes, 24.9 0.4 27 Finishing Inspection, 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4	24	Cement & Insert Sockliner,	26.9	0.4	1
26 Finishing Shoes, 24.9 0.4 27 Finishing Inspection, 28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	25	Fix Velcro,	26.5	0.4	1
28 Metal detector 29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	26	Finishing Shoes,	24.9	0.4	1
29 Insert Paper, 14.7 0.2 30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4	27	Finishing Inspection,			
30 Innerbox Folding, 12.4 0.2 31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4	28	Metal detector			
31 Attach Jute String, 13.5 0.2 1 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	29	Insert Paper,	14.7	0.2	
31 Attach Jute String, 13.5 0.2 32 Attach Hantag, 14.4 0.2 33 Wrapping, 26.5 0.4 1	30	Innerbox Folding,	12.4	0.2	1
33 Wrapping, 26.5 0.4 1	31	Attach Jute String,	13.5	0.2	
1	32	Attach Hantag,	14.4	0.2	
	33	Wrapping,	26.5	0.4	1
	2/	Packing.	27.7	0.5	<u> </u>