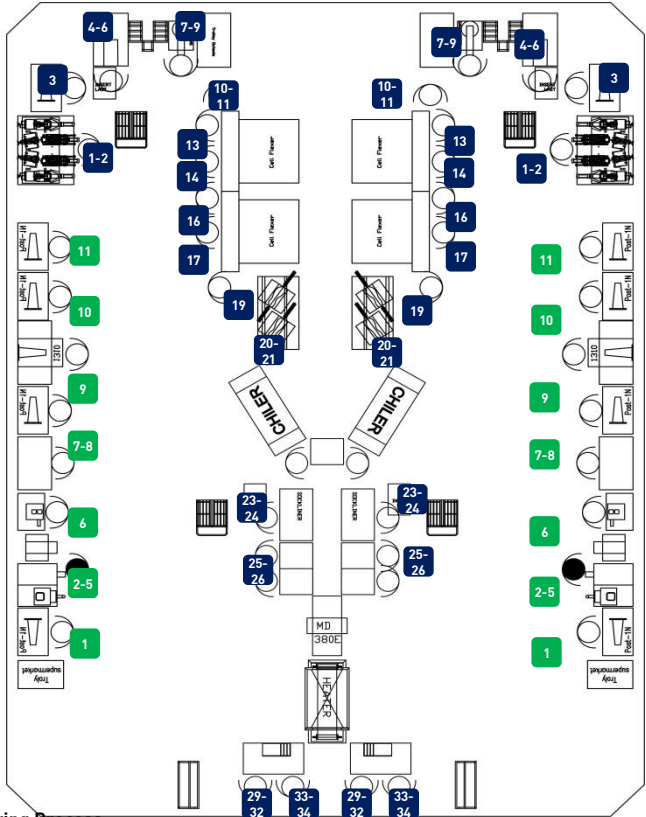


PWJ - PROCESS MODEL



■ Sewing Process
■ Assembly Process

Model Running

Run Falcon EL K

EOLR

60

Layout Type

Direct Stitching – Assembly 60

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP
1	Stitch Turn Over Collar Lining to Upper,	44.7	0.7	1
2	Spray Collar Lining,	10.3	0.2	
3	Attach Collar Pading to Upper,	12.7	0.2	
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	
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	Theoretical	# MP
1	Back Part Molding,	25.36	0.4	1
2	Vamp Molding,	21.36	0.4	
3	Stitch Strobel,	48.72	0.8	1
4	Setting Last,	21.63	0.4	1
5	Insert Last,	14.4	0.2	
6	Heel Last,	14.28	0.2	
7	Teghtening Strap Velcro,	27.28	0.5	2
8	Gauge Marking,	28.54	0.5	
9	Gauge Toe,	28.7	0.5	
10	Prepare Outsole,	27.23	0.5	1
11	Cleaner Upper,	22.96	0.4	
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	
22	Chiller			
23	Open Last,	28.7	0.5	1
24	Cement & Insert Sockliner,	26.9	0.4	
25	Fix Velcro,	26.5	0.4	1
26	Finishing Shoes,	24.9	0.4	
27	Finishing Inspection,			
28	Metal detector			
29	Insert Paper,	14.7	0.2	1
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
34	Packing,	27.7	0.5	