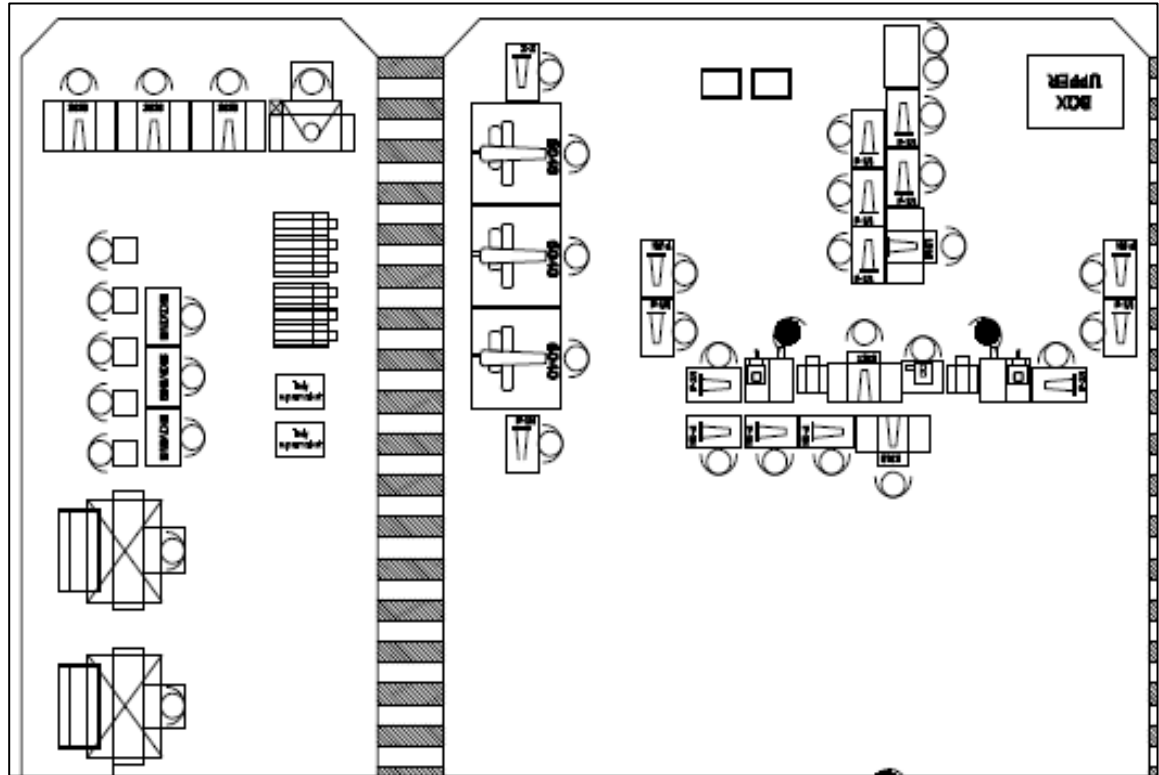


PWJ - PROCESS MODEL

Model Running	NY 90 CF C
EOLR	120
Area	Cutting – Preparation – Sewing



PWJ - PROCESS MODEL

Model Running

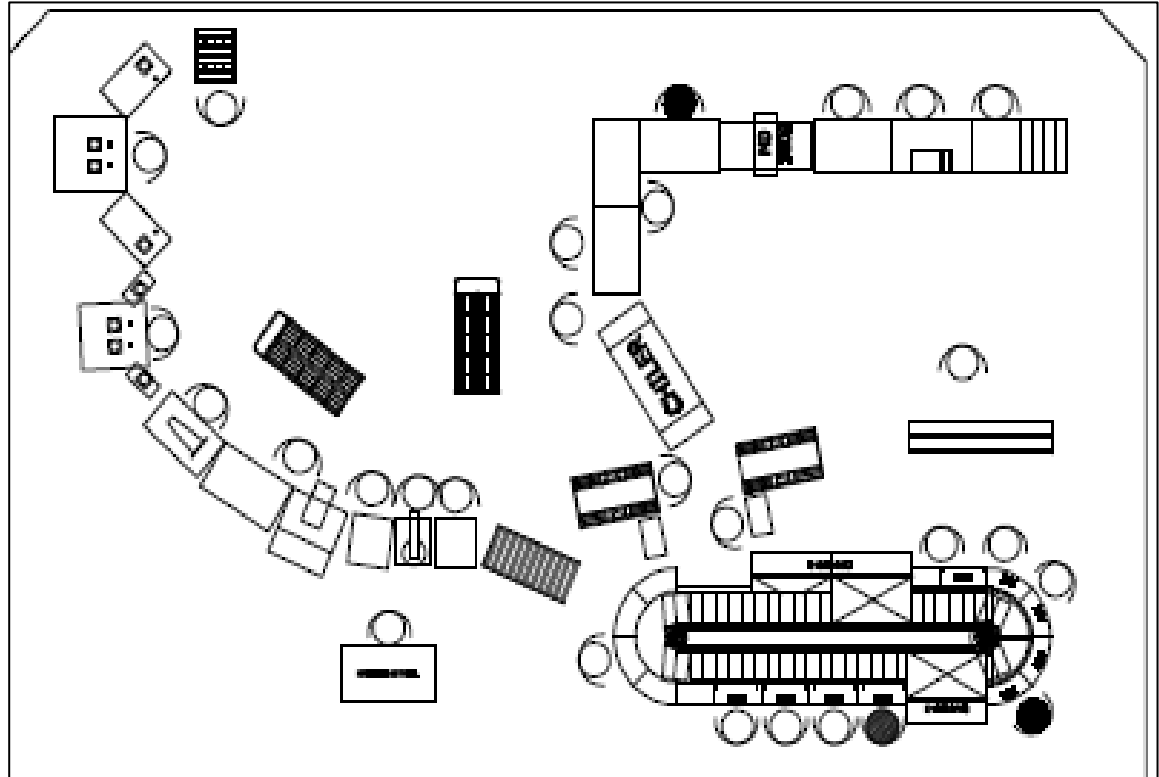
NY 90 CF C

EOLR

120

Area

Assembly



PWJ - PROCESS MODEL (CUTTING)

NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP
1	Cutting 3Stripe	13,16	0,4	4,00
2	Cutting Eyestay L/M,	23,49	0,8	
3	Cutting Heel Accent	13,06	0,4	
4	Cutting Heel	7,22	0,2	
5	Cutting Heel Counter,	6,75	0,2	
6	Collar Padding	6,87	0,2	
7	Cutting Tongue,	6,85	0,2	
8	Cutting Tongue Lining	6,84	0,2	
9	Cutting Stroble,	6,79	0,2	

PWJ - PROCESS MODEL (PREPARATION)

NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP
1	Skiving Vamp/Quarter,	16,42	0,5	1
2	Skiving Heel	12,68	0,4	
3	Skiving Heel Counter,	13,56	0,5	0,5
4	RollHotmelt Toe Box to Toe Cap,	12,50	0,4	1
5	Stamping Size Label to Tongue,	13,70	0,5	0,5
6	Attach Vamp/Quarter to Vamp Lining	14,50	0,5	1
7	Attach Eyestay Reinf L/M to Vamp/Quarter Lining	24,72	0,8	1
8	Stitch Binding Tongue to Tongue	28,60	1,0	1
9	Stitch Tongue Edge (After Binding)	21,30	0,7	1
10	Stitch Tongue Logo to Tongue,	24,30	0,8	1
11	Stitch Decoration Vamp/Quarter	57,30	1,9	2
12	Stitch Decoration Heel,	25,30	0,8	1
13	Stitch Heel Path to Heel	21,84	0,7	1
14	Stitch Zig-Zag Vamp/Quarter (Heel Area),	28,72	1,0	1
15	Stitch Edge Collar Linning,	14,30	0,5	1
16	Attach Strap Velcro Loops and Hooks to Strap	14,44	0,5	1
17	Stitch Strap A	29,30	1,0	1
18	Stitch Strap B	29,30	1,0	1
19	Stitch Strap C	29,30	1,0	1
20	Cut Strap (CNC)	13,44	0,4	1

PWJ - PROCESS MODEL (SEWING)

NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP
1	Stitch Toecap to Vamp/Quarter	78,2	2,6	3
2	Stitch Heel Patch to Heel,	25,0	0,8	2
3	Stitch Heel Counter to Upper,	15,0	0,5	
4	Stitch Collar Lining to Upper,	42,1	1,4	2
5	Spray Upper,	13,2	0,4	2
6	Attaching Collar Padding,	25,1	0,8	
7	Reverse Upper,	10,4	0,3	
8	Hammering Upper,	10,8	0,4	
9	Stitch Hole Strap (Area Hole Top)	28,6	1,0	1
10	Pouncing,	28,5	1,0	1
11	Stitch Tongue to Upper	27,3	0,9	1
12	Stitch Velcro to Upper	105,3	3,5	4
13	Stitch Upper Edge	28,8	1,0	1
14	Insert Velcro	48,3	1,6	2

PWJ - PROCESS MODEL (ASSEMBLY)

NO	PROCESS DESCRIPTION	CYCLE TIME	THEORITICAL	# MP
1	Back Part Molding	23,9	0,80	1
2	Stitch Strobel,	44,3	1,48	2
3	Setting Last,	12,6	0,42	1
4	Insert Last,	14,3	0,48	1
5	Heel Last,	12,8	0,43	
6	Strengthen velcro,	24,5	0,82	1
7	Prepare Outsole,	20,3	0,68	1
8	Gauge Marking,	21,5	0,72	1
9	Transfer to Conveyor,	29,3	0,98	1
10	Chamber 1			
11	Cleaner Upper,	52,50	1,75	2
12	Chamber 2			
13	Primer Upper,	55,90	1,86	2
14	Chamber 3			
15	Attach Outsole,	55,16	1,84	2
16	Universal Press,	22,50	0,75	1

17	Chiller			
18	Open Lace,	26,34	0,88	1
19	Open Last,	12,50	0,42	
20	Insert Sockliner,	20,72	0,69	1
21	Fix Velcro,	27,52	0,92	1
21	Finishing,	24,36	0,81	1
22	Finishing Inspection,			
23	Metal detector			
24	Insert Paper,	14,68	0,49	1
25	Innerbox Folding,	14,21	0,47	
26	Attach UPC,	13,45	0,45	1
27	Attach Hantag,	24,63	0,82	
28	Wrapping,	26,54	0,88	1
29	Packing,	27,65	0,92	1