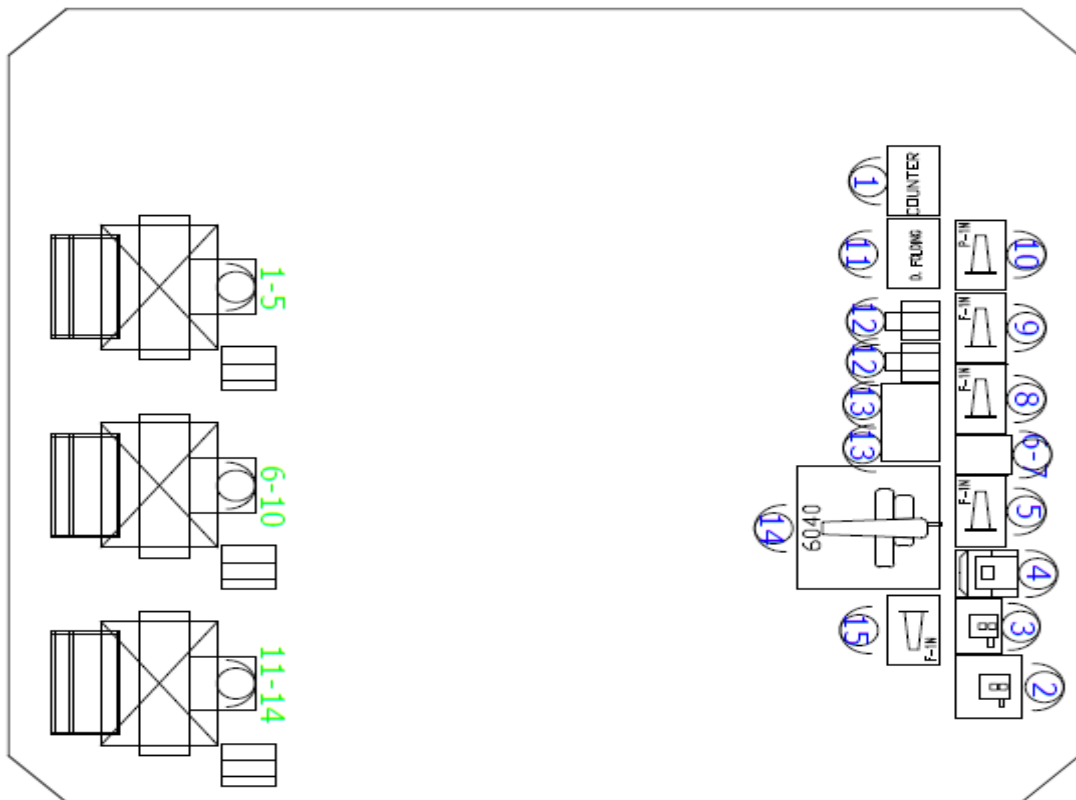


# PWJ - PROCESS MODEL

Model Running	X9000L2
EOLR	120
Area	Cutting - Preparation



# PWJ - PROCESS MODEL

Model Running

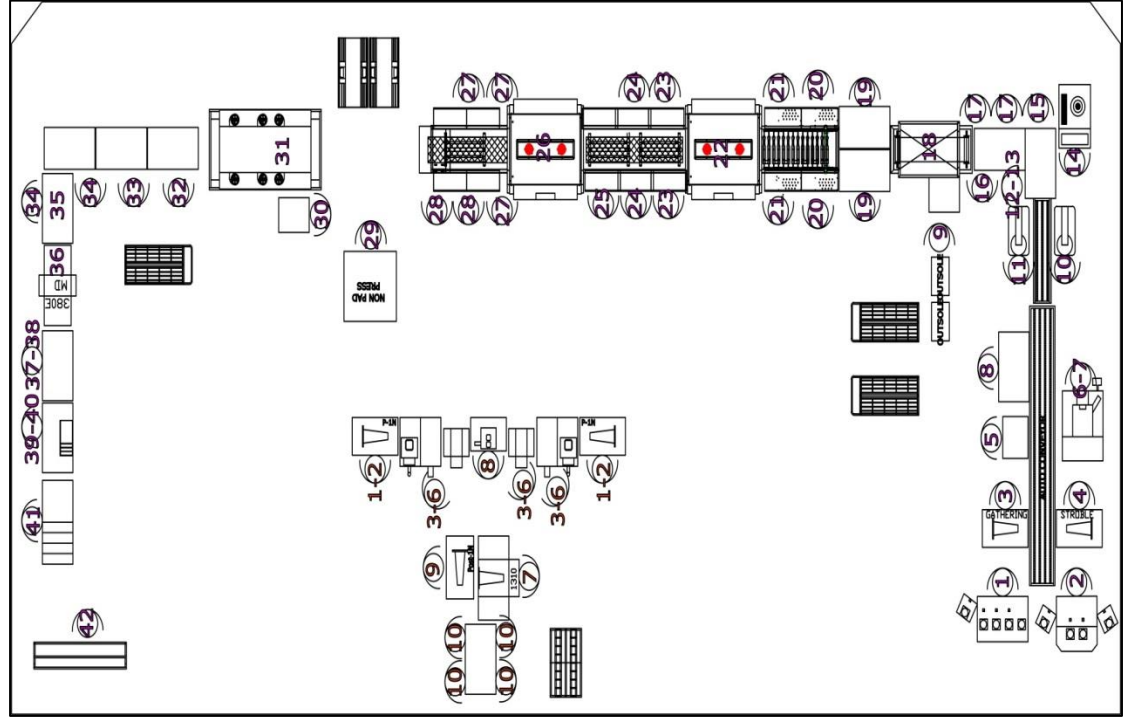
X9000L2

EOLR

120

Area

Sewing –  
Assembly



# PWJ - PROCESS MODEL (CUT – PREP)

<b>Model Running</b>	<b>X9000L2</b>
EOLR	120
Area	Cutting - Preparation

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP
1	Cutting Toe Cap,	7,0	0,2	3
2	Cutting Toebox,	7,0	0,2	
3	Cutting Eyestay,	10,4	0,3	
4	Cutting 3 Stripe,	10,4	0,3	
5	Cutting eyestay Overlay Top L/M,	10,4	0,3	
6	Cutting Eyestay Overlay Mid L/M	6,0	0,2	
7	Cutting eyestay Overlay Bottom,	5,6	0,2	
8	Cutting Collar Reinf	4,9	0,2	
9	Cutting Collar Padding L/M,	4,9	0,2	
10	Cutting Collar Padding Reinf L/M,	4,9	0,2	
11	Cutting Heel Counter,	3,7	0,1	
12	Cutting Collar Padding,	3,7	0,1	
13	Cutting Tongue Padding	3,7	0,1	
14	Cutting Sockliner	4,4	0,1	

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP
1	Skiving Heel Counter,	13,4	0,4	0,5
2	Recutting Vamp,	28,3	0,9	1
3	Pounching Eyestay Vamp,	28,5	1,0	1
4	Stamping Size Label	14,3	0,5	0,5
5	Stitch Tongue to Tongue Lining,	24,2	0,8	1
6	Attach Tongue Padding	18,4	0,6	1
7	Tongue Reverse,	8,3	0,3	
8	Stitch tongue Laceloop,	26,5	0,9	1
9	Attach Vamp Webbing & Stitch Tongue Edge,	22,5	0,8	1
10	Stitch & Turn Join Heel ( Backside Area)	43,2	1,4	2
11	Folded Upper Heel Area,	26,5	0,9	1
12	Hammering after folded Vamp Quarter,	46,5	1,6	2
13	Attach Collar Padding Reinf L/M & Attach to pallet,	45,2	1,5	2
14	Stitch Colar lining Deco	21,0	0,7	1
15	Stich Collar Lining Edge,	25,0	0,8	1

# PWJ - PROCESS MODEL (SEWING)

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoretical	# MP
1	Stitching Collar Lining to Upper,	57,0	1,9	2
2	Stitch Heel Counter to Upper,	18,5	0,6	1
3	Spray on Collar Padding Area (Use Jig Spray),	16,5	0,6	3
4	Attach Collar Padding ,	12,8	0,4	
5	Reserve Collar lining,	29,2	1,0	
6	Hammering,	18,5	0,6	
7	Stitching Tongue to Upper,	29,1	1,0	1
8	Upper Pouching,	28,5	1,0	1
9	Stitching Lasting Margin,	26,4	0,9	1
10	Insert Shoe Lace,	108,2	3,6	4

# PWJ - PROCESS MODEL (ASSEMBLY)

NO	PROCESS DESCRIPTION	CYCLE TIME	Theoritic al	# MP				
1	Back Part Molding,	28,1	0,9	1				
2	Vamp Molding,	28,2	0,9	1				
3	Stitch Gathering Tape,	26,5	0,9	1				
4	Stitch Strobel,	28,7	1,0	1				
5	Setting Last,	18,5	0,6	1				
6	Insert Last,	16,3	0,5	1				
7	Heel Lasting,	12,3	0,4					
8	Tightening Lace,	28,6	1,0	1				
9	Prepare Outsole,	20,4	0,7	1				
10	Sole Gauge Marking,	28,4	0,9	1				
11	Gauge Heelplate area,	27,2	0,9	1				
12	Toe Gauge,	18,5	0,6	1				
13	Transfer to Conveyor,	5,0	0,2					
14	Hand Grinding,	22,5	0,8	1				
15	Cleaner TPU Heel Plate,	13,1	0,4	1				
16	Cleaner Midsole,	11,5	0,4	1				
17	Primer TPU Heelplate	57,0	1,9	2				
18	Chamber 1	29,2						
19	Cement TPU Heelplate	57,0	1,9	2				
20	Primer Upper Heel	57,1	1,9	2				
21	Primer Upper,	55,0	1,8	2				
22	Chamber 2	29,2						
23	Cement Upper Heel	55,2	1,8	2				
24	Cement Upper,	55,0	1,8	2				
25	Cement Outsole,	26,5	0,9	1				
26	Chamber 3	29,2						
27	Attaching Outsole,	85,1	2,8	3				
28	Attach Heel Plate,	52,4	1,7	2				
29	Universal NOn Pad Press,	21,6	0,7	1				
30	Blowing Outsole Use PVC ,	22,0	0,7	1				
31	Chiller	25,1						
32	Open Lace & Open Laste,	26,5	0,9	1				
33	Hotmelt Sockliner,Insert Sockliner,	26,6	0,9	1				
34	Finishing	53,5	1,8	2				
35	Inspection,	27,2						
36	Metal detector	5,0						
37	Innerbox Folding,	8,5	0,3	1				
38	Insert Paper,	16,9	0,6					
39	Attach UPC,	6,2	0,2	1				
40	Attach Hantag,	12,4	0,4					
41	Wrapping Shoe,	23,3	0,8	1				
42	Final Packing,	20,5	0,7	1				