Organizing entity	ASSOCIATION OF INDUSTRIES OF FOOTWEAR AND ESPADILLES OF THE NORTHWEST OF MURCIA
Name of training action	Footwear and espadrilles sewing course
File Number	AC-2017-2662

MODULE 1- Knowledge of the espadrille tradition of Caravaca, work organization, assembly and table operations.

Objective:

Once the origins and traditional techniques of the local product are known, Acquire the capabilities to organize the workspace for the work processes of assembling cut pieces, according to the order of work, respecting the sequence, the times and applying the appropriate techniques and with the established quality parameters.

Duration:

20 hours (5 practices **hours)**

Theoretical-practical contents:

Introduction

UNIT 1. Structure and components of footwear, cutting materials.

UNIT 2. Organization of the job.

UNIT 3. Techniques and procedures for termination.

UNIT 4. Assembly techniques.

UNIT 5. Review, referenced

INTRODUCTION:

A little history

Although in their original form they have been used for several years, the first written reference in which the espadrille is described, as we know it, is produced in a 13th-century Catalan text. In fact, Catalonia, the Pyrenean zone and the south of France constitute key points in their origin and possibly expansion throughout the rest of Europe. At the same time, there are data that prove its existence in America also long before its contact with Europe. Traditionally espadrilles have been linked to rural life and subsequently became part of the folk costumes of several Spanish regions and Latin American countries.

After the Spanish Civil War and with the increasing industrialization they went to the background. However, in the 60s they come back as comfortable summer shoes.

Personalities such as Salvador Dalí, Pablo Picasso and Grace Kelly exhibited them with total naturalness in their wardrobe.

In the 70s and thanks to a casual meeting at the Paris fair of designer Yves Saint Laurent with the owners of a prestigious Catalan firm, he proposes to develop a wedge espadrille for his signature. Time when the ones we know today emerged.

At the beginning of the 21st century, the revolution for the world of espadrilles bequeathed, a trend that endures and evolves year after year. Such is the case that all the first-division fashion firms have included this footwear in their collections. Specifically, some models of the famous Chanel brand stand out, essential in the most influential wardrobes of the fashion industry for several seasons.
Today the espadrilles live a time of splendor and each summer they are renewed with surprising shapes, colors and patterns.

UNIT 1: Structure and components of footwear, cutting materials

1.1 INTRODUCTION

Depending on the model we are going to make, they will be the components we have.
At the time the order reaches us, we must identify:

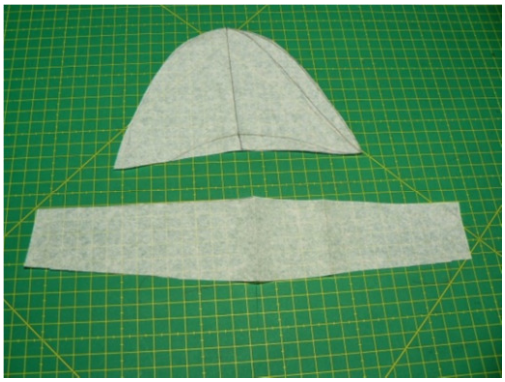
- Model.
- Number of pieces that compose it.
- Number of pairs.
- Time we have available for finishing

From this moment we must structure the work, separating each number with their respective components and if necessary, separating each foot; (case of wearing ornaments, buckles etc.)
Next we will make a brief review of the different models that we are going to make to know its structure and what parts are made up.

1.2 TYPES OF FOOTWEAR

Camping-type shoe:

Pieces that compose it: SHOE SHOVEL AND HEEL



Sometimes these models can wear loops, heel cups, toe cap or some other type of ornament; How can we observe in this model.

Composed of:
-Shovel shoe.
-Heel.
-Heel bag.
-Label.
-Toecap.
-Ornaments.

Materials used:
-Split leather.
- Cotton.
- Linen heel.
- Toecap woven thread.
- Eyelet point thread
-Jute.
-Jute sole.

Salon-type shoe:

Jute platform taupe color:

COMPOSITION: leather, jute and rubber.

In this model we can differentiate three pieces; two that make up the heel and a shovel for the face.

As we can see these pieces are lined in leather, so the first step to follow will have been to glue the leather lining with its corresponding piece of suede, prior identification and classification (as we mentioned earlier) of each number and foot that corresponds.

The next step will be to form the buckle with its corresponding elastic and prepare it for placement.

Once all this process is finished, each number with its separate and well differentiated pieces will pass to the sideboard that will carry out the sewing and buckle.

As we can see in the image model this shoe. On the shoe plant, at the heel, it has a piece called "coulotte" to which we must pass stitching to the edge to fix the glue to the lining (previously laid) or as an ornament.

Once mounted this coulotte will stick on the sole of the shoe as seen in the image.

Other salon-type shoe models:

Blucher type shoe:

English type footwear. Blucher leather woman, color orange. COMPOSITION: Jute, rubber and cowhide.

Sandal-type shoe:

The models of sandals that we can cover are very varied, since the sandal is one of the most demanded products and there is more options to make the different models.

In the market there is a great diversity in terms of shoe design, components and materials used.

We can find wedges of different sizes, platforms, flat, mechanical heel etc. We see some models below.

UNIT 2: Organization of the job

2.1 INTRODUCTION:

The lack of organization of the work area is a reality in the day to day of companies.

Therefore, and as far as possible, we should try to have a well-organized work space.

For this we will always avoid the so-called productivity barriers; since these barriers involve a series of problems such as wasted time, stress on the equipment etc.

2.2 THE PRODUCTIVITY BARRIERS

They are the following:

- 1st The Environment.
- 2nd Difficulty in locating the necessary items.
- 3rd Lack of space.
- 4th Permanent difficulty of access and sharing.

2.2.1 ENVIRONMENT:

The work environment can be defined as everything that involves the worker and, to some extent, conditions him in performing his work daily.

It must be pleasant, well lit, wide as far as possible and comply with safety measures related to the prevention of occupational hazards.

2.2.2. DIFFICULTY TO LOCATE THE ITEMS NEEDED:

The worker will be in charge of having at hand and well located all the articles that he needs to develop the function to perform within his position.

2.2.3 LACK OF SPACE:

To the extent possible, the company will be responsible for providing sufficient space. On the other hand, the worker must make the most of the space assigned to him.

2.2.4 PERMANENT DIFFICULTY OF ACCESS AND SHARING:

It will try to make the work environment as accessible as possible, as well as the common areas to be shared.

2.3 STEPS THAT HELP TO RESOLVE THESE ISSUES AND ORGANIZE THE WORK AREAS.

1st Classification.

Remove from the work areas everything that is not necessary for the processes that are carried out there.

2nd order.

Define the place for each item, according to its frequency of use. In the Organization, the philosophy "a place for everything, everything in its place" must be followed.

3rd cleaning.

Restore the good conditions of the equipment and infrastructure, assuming the motto "clean and inspect". The original operating conditions of the space and equipment must be restored and simple problems must be resolved immediately.

4th Standardization.

Rules must be defined in order to ensure that the new organization will be maintained. It is time to define visual standards to demonstrate the organization and establish rules for the use of materials and equipment.

5th Discipline.

The discipline will lead to compliance with the defined standards. The maintenance and improvement of the organization of the workplace is continuous over time, so everyone should know the rules, apply them daily and improve them whenever possible.

Once the five steps have been completed, there is surely an increase in

productivity through the reduction of search times and the motivation of the teams.

The jobs will be more organized and "transparent", also improving the quality of service.

UNIT 3: Techniques and procedures for termination.

3.1 FOOTWEAR FINISHING PROCESS.

The completion of footwear is a supportive action that facilitates the favorable decision of the consumer, the quality of the finish identifies a careful manufacturing process. Although comfort and convenience are decisive, it must be taken into account that they are factors that are checked only with use. The appearance and presence of a shoe is more visible than the brand or price at the time of purchase.

3.2 TOOLS:

Brushes.- of different dimensions are used to clean the polishing dust. They are circular, there are cloth, bristle, cotton and are used according to the need of the shoe. There are several dimensions used to catch flaws in the shoe using inks.

Sandpaper.- To rectify scrapes or faults that the leather has.

Scissors.- To trim the leftovers of the pieces lined or glued on leather that cannot be done in the refining machine. As well as the threads that may remain during sewing.

3.3 DEFECTS IN THE LEATHER MANUFACTURING AND FINISHING PROCESS.

In the phase of cutting pieces the main cause of claims is the possible lack of uniformity of color that may create subsequent problems.

Before the parting, the cuts have their edges lowered, made in special machines of reduction to reduce the thickness and facilitate the seams.

When these cuts reach our hands, we must verify that they meet a uniformity in color of the tinted, thickness of the recess (if any) flexibility etc.

3.4 BASIC FINISHING OPERATIONS:

For the finishing process once the sewing is finished, proceed:

Trimming leftovers in the lining, if any; This process will be carried out by trimming with scissors manually or with a refining machine. This will depend on the type of model and skin with which the shoe is manufactured.

Trimming threads and threads that may have remained during sewing.

Review of any anomaly.

Cleaning; It is about removing the dirt accumulated during the entire manufacturing process, as well as preparing the cut for the best performance of subsequent works.

Aqueous products or solvents are used, depending on the sensitivity of the fabric and the finish.

Repair; It is about repairing the possible defects that can cause a bad impression when buying the shoe.

This operation is only carried out on the area of the shoe that has suffered some damage during manufacturing, the products used are based on waxes and resins that fill the affected part.

This process will only proceed when the repair is minimal and does not affect the composition or quality of the finish.

Conditioned; Its objective is to finish cleaning and regulate the penetration of the following finishing applications. Products in the aqueous base are used. Sometimes cleaning and conditioning are done in a single operation using the right products.

Base or padding; It is a way to repair shoe defects by filling edges or defects that lead to the soles or edges. This process is normally not performed in the section but in the termination zone after assembly or sewing.

Brightness; This process will be carried out by brushes and brushes to remove dust and dirt, if any, collected through the process of pairing.

UNIT 4: Assembly techniques.

4.1 INTRODUCTION:

In this section we will see the different assembly techniques, as well as the importance of doing a good team work, respecting sequences, times and techniques, to make the footwear with the established quality parameters.

4.2 CUTTING THE COURT:

This stage of the manufacture receives the name of aparado, the main objective is to gather the pieces in a single one, respecting the design of the footwear.

We call the whole process developed between the cut and the assembly of the shoe, in which each piece is worked individually and then joined together.

We call the process of joining the pieces that make up the shoe:

"ASSEMBLY PROCESS."

4.3 ASSEMBLY PROCESS AREAS

There are two areas where this process is carried out:

- Table work.
- Machine work.

4.3.1 TABLE WORK:

The work is done on a table, as its name suggests, concentrates all the operations prepared for sewing.

The tools normally used are:

Brush or brushes. That will serve to queue the different linings or pieces that we have to glue according to the characteristics of the module.

Hammer. That will help us to hit the edges that we have glued and thus be able to strengthen the glue and on the other hand make the edge less thick to facilitate sewing.

Sometimes it is also used to open the stitches of more resistant and hard fabrics and avoid bulges.

Marble. It will help us to hit the hammer on it and thus not damage the table, in addition to being a material more resistant to shocks.

Scissors. They will help us trim the remaining edges once the pairing process is finished, as well as trim threads and other tweaks that may arise.

Sometimes the different pieces come with their adhesive. In these cases the assembly process will be to join each piece of fabric with its corresponding adhesive lining, respecting; feet, numbering, parts, right and left pieces etc.

These linings must always be compatible with the fabric in terms of shapes and sizes. We must verify that this is so. Otherwise we must notify the person responsible for taking the appropriate measures. They should ALWAYS match.

In the table work we will also find the placement of ornaments and fittings for later sewing on the machines by the sideboards or simply placement of rivets, eyelets, etc.

These ornaments are usually;

Accessories that can carry the type of footwear that we are making.

Once we have ready the different parts that make up the shoe we will proceed to the machine assembly process.

4.3.2 MACHINE WORK:

This is one of the most important parts and to a large extent the final quality of footwear will depend on this process.

To do this, the sideboard will check that each number, foot and pieces that compose it are well differentiated and separated from each other.

Depending on the model, this will be the number of machines to be used.

Normally they join the zigzag heels, it is edged or folded to the tail, they are mounted on a flat machine, it is edged around or folded or simply left as is. As we have seen, it will depend on the model we are making.

This work is done in a chain, hence the importance of doing a good team work and that there is a good working environment in the different sections, since it will depend in large part that the finishing is done correctly and following All guidelines and procedures marked.

You should not create false misunderstandings that at any given time if we see that the process prior to ours has not been carried out in the correct way, we must report the failures that we consider will harm the good finish of the shoe, in order to correct them before have no choice, because if we ignore it, the next step will not be correct and so on until creating a more serious problem.

Therefore, at all times of the assembly and sewing process we must check that each job is being done correctly, so as not to damage the quality and finish of the footwear.

After this process, the cut is ready to be mounted, either on the last or sewn to the point of buttonhole.

In this operation (assembled and assembled), a high percentage of footwear manufacturing operations are carried out and the one that requires the most personnel is one of the most important processes, since the result of their work is obvious, due to to which a good device attracts the attention of the client or final consumer.

UNIT 5. Review, Reference, Labeling and grouping of the device.

5.1 INTRODUCTION:

Once the pairing process is finished, we will proceed to check our work.

This is a very thorough and delicate process, since the quality of both our work and the model we have made will depend on it.

5.2 REVISED:

To review is to analyze or examine a thing with attention and care; In addition to testing it to make the necessary corrections.

This work will be grouped in the so-called table work, the person or persons in charge of carrying it out should know the process of modeling said model, as well as each model itself, in case we had missed any of the steps to follow, so like the ornaments and fittings that I could wear.

Concluded this process and if everything is "ok", then proceed to the next step.

5.3 REFERENCED:

To reference is to give precise and objective information of all the materials, color, ornaments, and other clarifications that may be useful to us when referring to the model we have made.

This process will also be called table work. Likewise, the person who performs it must know the models in question.

We will carry out this verification with an order note in hand and verifying that everything indicated in said note is consistent with our model.

We will see it with an example:

<table>
<tr><td colspan="5" rowspan="6">  </td><td colspan="3">MODEL</td></tr>
<tr><td colspan="3">Esparto wedge espadrille woman 5 strings</td></tr>
<tr><td>External lining</td><td colspan="2">Textile</td></tr>
<tr><td>Inner lining :</td><td colspan="2">Leather .</td></tr>
<tr><td>Plantilla:</td><td colspan="2">padded</td></tr>
<tr><td>Shoe floor:</td><td colspan="2">rubber and jute</td></tr>
<tr><td>36</td><td>37</td><td>38</td><td>39</td><td>40</td><td>41</td><td colspan="2"></td></tr>
<tr><td>5</td><td>10</td><td>15</td><td>15</td><td>10</td><td>5</td><td colspan="2"></td></tr>
<tr><td colspan="5"></td><td colspan="2">TOTAL PAIR OF SHOES : 60</td><td></td></tr>
</table>

So, if our model matches the note, everything will be correct and we will move on to the next step.

5.4 LABELING:

It is the process of labeling the product once finished.

The new parameters that must be taken into account by national producers and importers of footwear on labeling are the following:

- All kinds of national and imported footwear that are marketed in the country must have at least one of the shoes of each pair the required information that will be described later.
- This label must be legible and when the shoes are not being worn it must be placed in a visible place so that the consumer can see it.
- The dimensions of the letter of the text on the label should allow the understanding of the information at a glance.
- The information required on the labels must be stamped, sewn, printed or engraved unless for the purposes of the design of the footwear or the material from which it is manufactured, it does not allow it.
- The acceptance or not of the incorporation of the label into footwear by this means of exception will be carried out in accordance with the practices used in external or internal markets or, when so determined, in accordance with the guidelines established by the national regulatory body competent.

- The information on this label must be true and must not have errors or deceptions for the consumer.

Who are responsible for complying with these standards?

Compliance with these regulations will be the responsibility of the importer, manufacturer or retailer and in no case will be in charge of the control entity or the final consumer of the product.

What information should these labels contain according to the new resolution?

According to the new resolution, the label must contain the composition of the footwear by means of textual indications that designate in a generic way or specify the materials used in the elaboration of said footwear, as long as the designation of the material is not for error or deception to the consumer.

The information contained on the label will be assumed as an express statement of the vendor, manufacturer or importer as appropriate, and will serve as evidence for civil and commercial purposes as long as it is legible.

If an administrative investigation is carried out by the competent control body and, the producer or importer fails to demonstrate that the material or materials declared on the label are those that were actually used to make the footwear, the manufacturer or importer, must within of the two years following the date of the aforementioned demonstration, for footwear that is made or introduced to the country and that is made with the material with respect to which the information was proven inaccurate, demonstrate compliance with the technical regulation through Third party certification issued under the batch modality by a certifying body duly accredited or authorized by the competent national authority. This certification must be supported by physical or chemical composition analysis, carried out in an accredited or authorized laboratory for the corresponding purpose by the competent national authority and in accordance with tests contained in international standards or in which the competent national regulator establishes.

All these regulations were approved.