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POSSIBILITIES OF MODERN INNOVATIVE TECHNICAL PROCESSES FOR MANUFACTURING DEMANDED PRODUCTS TAKING INTO ACCOUNT CONSUMER PREFERENCES AND AN UNSTABLE MARKET

Abstract: In an article by the authorsan assortment policy was developed for the formation of competitive men's, women's and children's shoes, taking into account factors affecting consumer demand: compliance with the main fashion trends, economic, social and climatic characteristics of the regions of the Southern Federal District and the North Caucasus Federal District, the production of which using modern innovative technological processes, as well as to meet demand elite consumer, using manual labor, create the basis for meeting the demand for footwear for the buyer of these regions, including the development of innovative technological processes for the production of men's, women's and children's shoes using modern technological equipment with advanced nano technologies, forming the basis for reducing the cost of footwear and providing it with an increase in competitiveness with the products of leading foreign companies, with the possibility of a wide assortment of footwear not only by type, but also by fastening methods, which guarantees its demand in full.

Key words: model, assortment policy, technological innovation process, consumer preferences, demand, demand, profit, unstable market, competitiveness, import substitution, nano technologies, stable financial condition, stable TP.

Language: English

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Introduction

UDC 685: 43 519.17.

To select the optimal capacity, the authors have developed software that allows manufacturers, based on an innovative technological process using universal and multifunctional equipment, to produce the entire assortment of shoes with minimum, average and maximum costs, which creates the basis for varying the price niche, including through a gradual increase in the share of domestic components in the production of leather goods with a significant reduction in the cost of its manufacture. At the same time, as the criteria for a reasonable choice of the optimal power when forming the algorithm, it was justified to choose exactly those criteria that have the greatest impact on the cost of the finished product, namely:

- coefficient of workload of workers,%;
- -productivity of labor of one worker, a pair;
- losses on wages per unit of production, rubles;
- specific reduced costs for 100 pairs of shoes, rub.

Of the four given criteria, in our opinion, the main ones are labor productivity of 1 worker and unit reduced costs

Labor productivity of 1 worker is the most important labor indicator. All the main indicators of production efficiency and all labor indicators, to one degree or another, depend on the level and dynamics of labor productivity: production of products, number of employees, expenditure of wages, level of wages, etc.

To increase labor productivity, the introduction of new equipment and technology, widespread mechanization of labor-intensive work, automation of production processes, advanced training of workers and employees, especially when introducing innovative technological processes based on universal and multifunctional equipment, are of paramount importance.

Specific reduced costs - an indicator of the comparative economic efficiency of capital investments, used when choosing the best option for solving technological problems.

When comparing possible options for solving any technical problem, rationalization proposals, technical

improvements, various ways to improve product quality, the best option, all other things being equal, is the option that requires a minimum of the reduced costs.

Main part

The given costs are the sum of current costs taken into account in the cost of production and one-time capital investments, the comparability of which with current costs is achieved by multiplying them by the standard coefficient of the efficiency of capital investments. Tables 1 and 2 show the calculations of the optimal power for the range from 300 to 900 pairs for men's and women's shoes for the entire range of footwear. Analysis of the characteristics obtained for three variants of a given technological process in the manufacture of the entire assortment of footwear confirmed the effectiveness of the software product for evaluating the proposed innovative technological process using universal and multifunctional equipment. So, with a range of 300 - 900 pairs, the best according to the given criteria is the volume of production of 889 pairs (for men) and 847 pairs (for women). If the production areas proposed by the regional and municipal authorities of the two districts - the Southern Federal District and the North Caucasus Federal District, according to the standard indicators, do not allow the calculated production volumes to be realized, then the option of the optimal capacity is chosen that is acceptable, for example, the production volume of 556 pairs, which corresponds to the standard indicators for the proposed production areas and is characterized by the best values of the designated criteria, which form the cost of the entire assortment of footwear. The authors have developed consolidated technological processes on the side of the blank of the upper of the shoe and for the assembly of shoes, respectively, for 12 models of men's and 12 models of women's shoes (Fig. 1 and 2). Tables 3 and 9 provide an example of the initial technological process for assembling the upper and shoe blanks using the example of a men's winter boot (model D). The summarized volumes of the main costs are shown in Table 10.



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Table 1 - Calculation of the optimal power with a range of 300-900 couples on the example of men's shoes

Power	Equipment	Optimal	Labor	Worker	Losses on	Specific reduced
	type	power,	productivity of 1	load	wages per unit	costs per 100
		steam per	worker, steam	factor,%	of production,	pairs of shoes,
		shift			rub	rub
300-500	1	500	28.09	61.39	13.68	6735.36
500-700	1	556	27.73	69.14	9.83	6404.71
700-900	1	889	28.09	77.20	6.42	5236.17
300-500	2	500	28.09	61.39	13.68	6728.68
500-700	2	556	27.91	68.70	9.97	6083.28
700-900	2	889	28.09	77.20	6.42	5240.72
300-500	3	500	28.09	61.39	13.68	7533.95
500-700	3	700	28.12	67.28	10.56	6734.02
700-900	3	889	28.09	77.20	6.42	5876.59

Table 2 - Calculation of the optimal power with a range of 300-900 couples on the example of women's shoes

Power	Equipment type	Optimal	Performance	Worker load	Losses on	Specific
options		power,	labor of 1	factor,%	wages per	reduced
		steam per	worker, couples		unit of	costs per
		shift			production,	100 pairs of
					rub	shoes, rub
300-500	1	500	27.73	62.18	13.40	6980.5
500-700	1	700	27.73	69.14	9.83	6277.43
700-900	1	847	27.73	74.50	7.54	5673.49
300-500	2	500	24.45	63.90	14.11	7630.92
500-700	2	556	27.73	69.14	9.83	6404.71
700-900	2	812	25.64	75.40	7.77	6060.55
300-500	3	500	27.00	61.74	14.02	7827.12
500-700	3	556	29.32	68.21	9.71	6607.65
700-900	3	847	27.00	74.70	7.66	6341.05



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Table 3 - Characteristics of the equipment for assembling the blanks of autumn women's boots (model E)

	gical	price	ST- B	ST- B	Id1 000,87 I	123500 rub	320,700 rbl
	3 set of equipment for innovative technological process	performan ce	ST-B	ST-B	63 pairs per hour	150 pairs per hour	65 pairs per hour
	ovative s	bower	ST- B	ST- B	0.7 kW	3.1 kW	0.5 kW
	for innov	dimension	ST- B	ST- B	105 0 * 540 * 119	125 0 * 900 * 135 0	900 * 600 * 128 0
ŕ	uipment	manufactu rer	ST-B	ST-B	Swee t (Cze ch Repu blic)	NEV E (Italy)	Swee t (Cze ch Repu blic)
ogen	be jo	Meight	ST- B	ST- B	130 Kg	180 Kg	186 kg
m) sind	3 set	vendor	ST- B	ST- B	011 46 / P5	PR 86 A	012 80 / P1
o s ua	sal	price	ST- B	ST- B	Id1 000, ači	123 150 rub	234500 rub
M M M	igoloni	реггогталсе	ST- B	ST- B	77 pair s/h	150 pair s per hou r	60 pair s per hou r
	ve tecl	ромет	ST- B	ST- B	0.5 kW	0.8 kW	1.0 kW
anks of	or innovati	noisnəmib s	ST- B	ST- B	1050 * 540 * 1160	1800 * 130 * 950	1050 * 550 * 1200
ng the Di	2 set of equipment for innovative technological process	manufactu rer	ST-B	ST-B	Fortun a (Germ any)	Schön (Germ any)	Schön (Germ any)
sem DII	of equip	weight	ST- B	ST- B	140 KG	180 Kg	170 kg
oi the equipment ior assembling the Dianks of autumn women's boots (model E.)	2 set o	coqe vendor	ST-B	ST-B	3SE- RZ	C 1100V	S1031 C
dmb	ical	price	ST- B	ST- B	du1 041 712	KUR 185640	4ur 090 204
	1 set of equipment for innovative technological mocess	performan ee	ST-B	ST-B	75 pairs per hour	150 pairs per hour	60 pairs per hour
CELISTICS	vative t	bower	ST- B	ST- B	1.2 kW	2.1 kW	0.75 kW
Charac	for innov	noisnəmib s	ST- B	ST- B	1050 * 550 * 1030	1430 * 780 * 950	1100 * 550 * 1270
1 a D I e 3 - Characteristics	upment	manufactu 191	ST- B	ST- B	Com	Saba 1 (Ital y)	Sagit a (Ital y)
I a D	st of equ	tdgisw	ST- B	ST- B	135 kg	180 Kg	180 KG
	1 St	vendor	ST- B	ST- B	SS 20	A 200 0	RP 67T E
	the name of the		Receiving and checking the cut	Cutting into production	Lowering the edges of the outer baby top and lining	Duplication of upper details with interlining	Bending with simultaneous application of hot melt glue, notching of curved sections and gluing tape

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Id1 00497	ST-B B wit h	ST- B wit h vyt.	[d1 00497	Id1 21288	Id1 00497
			,,,,,,,,,		
I.	ST-B with vyt.	ST-B with vyt.	ı	ı	1
0.27	ST-B B with	ST-B B with	0.27	0.27 kW	0.27
900 ** \$850	ST-B B with	ST-B B with	900 * * 850	900 * * 850	900 * \$00 850
Pfaff (Ger many)	ST-B with vyt.	ST-B with vyt.	Pfaff (Ger many)	Typi cal (Chi na)	Pfaff (Ger many)
130 Kg	ST-B B wit h vyt	ST-B wit h h	130 Kg	130 Kg	130 Kg
Pfaf f 591 - 726 cl	ST-B B wit h vyt.	ST-B B wit h vyt.	Pfaf f 591 - 726 cl	Typ ical GC 240 26	Pfaf f 591 - 726 cl
dur 0902£[ST-B B wit h	ST-B B wit h	dur 0902£[Id1 21282	dur 0902£[
ı	ST-B B wit h	ST-B B wit h	1	1	1
0.27 kW	ST-B B wit h	ST-B B wit h vyt.	0.27 kW	0.27 kW	0.27 kW
900 * \$ 850	ST-B with	ST-B with	900 * 500 * 850	900 * 500 * 850	900 ** \$500 850
Durko pp Adler	ST-B with vyt.	ST-B with vyt.	Durko pp Adler	Typic al (China	Durko pp Adler
130 Kg	ST-B B with	ST-B B with	130 Kg	130 Kg	130 Kg
4180i- 511 E5 BM00 002	ST-B with vyt.	ST-B with vyt.	4180i- 511 E5 BM00 002	Typica 1 GC24 680	4180i- 511 E5 BM00 002
du1 092 [[S	ST-B B wit h h	ST-B B wit h vyt.	dur 992112	dur 00997	dur 992112
t.	ST-B with vyt.	ST-B with vyt.	i	ī	1
1.76 kW	ST-B B with	ST-B With	1.76 kW	0.27 kW	1.76 kW
520 * 180	ST-B B with	ST-B B with	520 * 180	520 ** 180	520 * 180
Gran ucci (Ital y)	ST-B with	ST-B with	Gran ucci (Ital y)	"PF AFF " Ger m	Gran ucci (Ital y)
130 Kg	ST-B with	ST-B with	130 Kg	130 Kg	130 Kg
491 GR AM AC	ST-B B wit h	ST-B B wit h vyt.	491 GR AM AC	Pfaf f 574 - 900 cl	491 GR AM AC
Adjusting tibia detail 1 to tibia detail 2	Glueing ankle boots and elastic bands for assembly. Drying	Gluing ankle boots on elastic bands	Attaching elastic bands to the ankle boots with the 1st line	Tightening the vamp on the ankle boots	Tapering of the back edges of the ankle boots with a stitching seam



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	ن بار	ب ب			
18000 rb1	ST-B Wit h	ST-B B wit h h vyt.	Id1 00497	Id1 00497	Id1 00497
500 pairs / hour	ST-B with vyt.	ST-B with vyt.	1	1	I.
0.17 5 kW	ST-B B with	ST-B B with	0.27	0.27	0.27
900 ** 510 ** 0	ST-B With	ST-B B with	900 * * 850	900 * * 850	900 * 500 * 850
"Swe et" Czec h Repu	ST-B with vyt.	ST-B with vyt.	Pfaff (Ger many)	Pfaff (Ger many)	Pfaff (Ger many)
135 kg	ST-B B wit h vyt	ST-B B wit h b	130 Kg	130 Kg	130 Kg
012 76 / P12	ST-B B wit h	ST-B B wit h vyt.	Pfaf f 591 - 726 cl	Pfaf f 591 - 726 cl	Pfaf f 591 - 726 cl
Id1 0008 I	ST-B B wit h	ST-B B wit h	132090 rub	dur 0902£[dur 0902£[
500 pair s/ hou r	ST-B Bwit h	ST-B Bwit hh	1	1	t
0.17 5 kW	ST-B B wit h	ST-B B wit h vyt.	0.27 kW	0.27 kW	0.27 kW
900 * 510 * 1380	ST-B B with	ST-B B with	900 * \$00 850	900 * \$00 850	900 * * 850
"Swee t" Czech Repub Iic	ST-B with vyt.	ST-B with vyt.	Durko pp Adler	Durko pp Adler	Durko pp Adler
135 kg	ST-B B with	ST-B B with	130 Kg	130 Kg	130 Kg
01276 /P12	ST-B with vyt.	ST-B with vyt.	4180i- 511 E5 BM00 002	4180i- 511 E5 BM00 002	4180i- 511 E5 BM00 002
KUB 31080	ST- B wit h vyt.	ST- B wit h vyt.	dur 992112	du1 398 [[2	dur 992112
1	ST-B with vyt.	ST-B with vyt.	à	T T	T.
1.7	ST- B with	ST- B with	1.76 kW	1.76 kW	1.76 kW
800 * 1200 * 1740	ST- B with	ST- B with	520 * 180	\$20 * 180	520 * 180
Sare ma (Ital y)	ST- B with	ST- B with	Gran ucci (Ital y)	Gran ucci (Ital y)	Gran ucci (Ital y)
150 Kg	ST-B B with	ST-B B with	130 Kg	130 Kg	130 Kg
DE LT CB	ST-B B wit h vyt.	ST-B B wit h vyt.	491 GR AM AC	491 GR AM AC	491 GR AM AC
Smoothing the back seam while applying the tape	Spreading with glue and gluing ZNR on the heel of the workpiece	Top hemming	Adjustment of ZNR	Adjusting the leather pocket on the lining under the ankle boots	Attaching the leather lining of the ankle boots to the textile lining of the vamp



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190,000 rubles	180 00 rbl	123 500 rub	ST-BBwit	səlqnı 000°061
	500 pairs / hour	150 pairs per hour	ST-B with vyt.	
0.27	0.17 5 kW	3.1 kW	ST-B B with	0.27
900 * 500 * 850	900 * 510 * 138 0	125 0 * 900 * 135	ST-B B with	900 * * 850
Colli (Italy	"Swe et" Czec h Repu	NEV E (Italy	ST-B with vyt.	Colli (Italy)
120 kg	135 kg	180 Kg	ST-B B wit h vyt	120 kg
GP 2	012 76 / P12	PR 86 A	ST-BBwit	GP 2
190,000 rubles	180 00 rbl	123 150 rub	ST-B B wit h vyt.	səldur 000,0961
1	500 pair s/ hou r	150 pair s per hou r	ST-B B wit h vyt.	1
0.27	0.17 5 kW	0.8 kW	ST-B B wit h vyt.	0.27
900 * \$ 500 850	900 * 510 * 1380	1800 ** 130 ** 950	ST-B with	900 * \$ 500 850
Colli (Italy)	"Swee t" Czech Repub Iic	Schön (Germ any)	ST-B with vyt.	Colli (Italy)
120 kg	135 kg	180 Kg	ST-B B with	120 kg
GP 2	01276 /P12	C 1100V	ST-B with vyt.	GP 2
190,000 rubles	RU B 310 80	RU R 185 640	ST-B B wit h	190,000 rubles
ı	ı	150 pairs per hour	ST-B with vyt.	1
0.27 kW	1.7	2.1 kW	ST- B with	0.27 kW
900 * \$500 850	800 ** 1200 ** 1740	1430 ** 780 ** 950	ST-B B with	900 * \$00 * 850
Colli (Ital y)	Sare ma (Ital y)	Saba 1 (Ital y)	ST-B B with	Colli (Ital y)
120 kg	150 Kg	180 Kg	ST-B B with	120 kg
GP 2	DE LT CB	A 200 0	ST-B B wit h vyt.	GP 2
Tearing of the lining at the back edge with a stitch seam and trimming the edges of the lining	Smoothing the back seam of the leather lining	Bonding a thermoplastic toe cap between top and lining	Glueing and gluing the assembly of the outer and inner parts of the top along the edge line	Stitching of the edge of the ankle boots with simultaneous trimming of the edges of the leather lining and attaching the elastic with the second line



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Id1 000,42	ST-	В		ST-	В					
120 pairs per hour	ST-B			ST-B						
1.0 kW	ST-	В		ST-	В					
110 0 * 900 * 140	ST-	В		ST-	В					
"NE VE" Italy	ST-B			ST-B					312	
70 Kg	ST-	В		ST-	В				RUB 1,163,312	
SP7 SA R	ST-	В		ST-	В				RUB	
Id1 000,42	ST-	В		ST-	В					
150 pair s per hou r	ST-	В		ST-	В					
2.2 kW	ST-	Д		ST-	В					
520 * 1100 * 1370	ST-	В		ST-	В					
Leibro ck (Germ any)	ST-B			ST-B						
80 Kg	-LS	В		ST-	В				35,156	
KAR O 1	ST-B			ST-B	ı				RUB 1,035,156	
[d1 000,42	ST-	В		ST-	В					
120 pairs / hour	ST-B			ST-B						
1.9 kW	ST-	В		ST-	В					
760 * 855 * 1480	ST-	В		ST-	В					
GEL	ST-	В		-LS	В				90	
100 Kg	-IS	В		-IS	В				RUB 1,972,560	
G1 2/ 1	ST-	В		ST-	В				RUB	
Cleaning ZVO	Accounting for	production and return by	performer	Acquisition of	ZVO in growth.	assortment,	bundling,	accounting	The amount of	equipment costs

Table 4 - Characteristics of equipment for assembling shoes for autumn women's boots (model E)

gical	price	ST-B	ST-B
3 set of equipment for innovative technologica process	performanc e	ST-B	ST-B
rative t	Dower	ST -B	ST -B
for innov process	anoianamib	ST- B	ST- B
ipment f	manufactur er	ST-B	ST-B
t of equ	Meight	ST- B	ST- B
3 se	vendor code	ST-B	ST-B
cal	price	ST- B	ST- B
inologi	performance	ST- B	ST- B
tive teck	bower	ST- B	ST- B
for innova process	anoisnamib	ST- B	ST- B
2 set of equipment for innovative technological process	manufactur er	ST-B	ST-B
of equi	weight	ST- B	ST- B
2 set	vendor code	ST-B	ST-B
ical	price	ST- B	ST- B
schnologica	performanc e	ST-B	ST-B
vative to	power	ST- B	ST- B
for inno process	anoianamib	ST- B	ST- B
set of equipment for innovative technor process	manufactur er	ST-B	ST-B
t of equ	thgisw	ST- B	ST- B
1 se	vendor code	ST- B	ST- B
the name of the operation		Receiving blanks;	Pads selection and cleaning



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KUB 170,000	280,000 rubles	a-T2	KUB 210,000	KUB 250,000
120 pairs per hour	250 pairs / h	ST-B	150 pairs per hour	150 pairs per hour
12 k Wt	0.2	ST -B	1.8 W	0.4 k W
620 ** 550 ** 123	800 * 900 * 180	ST- B	810 * 700 * 172 0	600 ** 745 ** 0
Stem a (Italy)	"Swe et" Czec h Repu	ST-B	"SEL MA K" Italy	Swee t (Cze ch Repu blic)
100 Kg	650 kg	ST- B	690 kg	120 kg
U17 BFV	0405 4 / P1	ST-B	E 605	0201 5 / P5
KUB 150,000	KUB 250,000	a-T2	130,700 rbl	KUB 250,000
135 pair s per hou	250 pair s/h	ST- B	800 pair s per hou r	150 pair s per hou
12 kWt	0.5 kW	ST- B	2,5 kW	0.4 kW
645 * 2485 * 1700 * 26	800 * 900 * 1800	ST- B	900 ** 500 ** 1900	600 * 745 * 1700
ISM (Germ any)	"BES SER" Italy	ST-B	Schee n Germa ny	Sweet (Czec h Repub lic)
110 Kg	630 kg	ST- B	630 kg	120 kg
URP /2	10/11 /C	ST-B	1005/	0201 5 / P5
1d1 000,1 ES	KUB 250,000	A-T2	KUB 531,720	KOB 520'000
120 per shift	250 pairs / h	ST-B	150 pairs per hour	150 pairs per hour
12 kWt	0.5 kW	ST- B	2,5 kW	0.24 kW
620 * 550 * 1230	800 * 900 * 1800	ST- B	950 * 600 * 1500	600 * 745 * 1700
Stem a (Italy)	"BES SER" Italy	ST-B	Ceri m (Italy	Swee 600 t ** (Czec 745 h ** Repu 1700 blic)
100 Kg	630 kg	ST- B	670 kg	120 kg
12	10/1 1 / C	ST- B	74 670 EE / kg S	020 15 / P5
Humidification of the ZVO	Pre-fastening of the insoles to the last with metal staples	Spreading talcum powder	Insertion of backdrops from thermoplastic materials, premolding of the heel of the blanks	Putting on the shoe upper blank on the last and installing the heel part



 $\begin{array}{ll} \textbf{ISRA} \; (\text{India}) &= \textbf{6.317} \\ \textbf{ISI} \; (\text{Dubai}, \, \text{UAE}) = \textbf{1.582} \\ \textbf{GIF} \; (\text{Australia}) &= \textbf{0.564} \\ \textbf{JIF} &= \textbf{1.500} \end{array}$

SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

KUB 1,586,800	RUB 1,200,000	KUB 1,851,000	dur 048241	Id1 000,221
pairs per hour	180 pairs per hour	200 pairs / h	180 pairs per hour	65- 113 pairs / hour
W W W	2 2	5.5 kw	15. W	8
110 0 * 105 0 * 0 0	640 * 715 * 170	160 0 * 230 * 210 0	966 ** 307 0 * 146 5	580 * 608 * 145 0
Swee (Cze ch Repu blic)	Swee t (Cze ch Repu blic)	"CE RIM " Italy	Swee t (Cze ch Repu blic)	ELV I (Italy
125 0 kg	850 kg	0 kg	0 kg	90 kg
K78 SZ	0221 2 / P1	PIC K24 SZ	1800 42 / P2	SR1 006
RUB 1,577,800	KUB 1,400,000	KUB 1,750,000	du1 048221	974740 Inp
160 pair s per hou r	250 pair s per hou r	250 pair s/h	250 pair s per hou	600 pair s
4.0 kW	3.25 kW	3.25 kW	13.0 kW	6.0
**************************************	1200 * 800 * 2000	1200 * 800 * 1600	1400 * 2100 * 950	450 ** 330 ** 1100
Leibro ck (Germ any)	Schee n Germa ny	Schön (Germ any)	Schön (Germ any)	Leibro ck (Germ any)
120 0 KG	860 kg	900 kg	120 0 kg	80K G
SZH- 9CD	640 TT	640 TM	333E	F1
BUB 1758120	KUB 1,200,000	KUB 1,851,000	du1 048241	RUB 63,000
350 steam per hour	200 steam per hour	200 pairs / h	300 pairs in 8 hours	100 pairs per hour
5.46 kW	5.46 kW	5.5k w	27.9 kW	2.0 kW
* 173 * 1114 * 184	1000 * 1230 * 2055	1600 ** 230 ** 2100	3050 * 1000 * 1450	450 ** 330 ** 1100
Ceri m (Italy	Ceri m (Italy	"CER IM" Italy	IRO N FOX (Italy	IRO N FOX (Italy
135 0kg	900 kg	110 0 kg	125 0 kg	%9 Kg
X 738 TIK	K20 1T	PIC K24 SZ	MV 570 0	RT0
Covering and tightening of the toe-bundle part of the ZVO with hot melt glue with preliminary moistening of the toe-bundle part, insertion and activation of the toe cap	Tightening the gel part of the ZVO with brackets	Tightening the heel of the workpieces	Wet-heat treatment of shoes	Hot air smoothing of creases on shoes



ISRA (India) = 6.317 ISI (Dubai, UAE) = 1.582 GIF (Australia) = 0.564 JIF = 1.500 SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

ST-B	Id1 000, £72	J000001	dur 009721	dur 009721	130000£1
ST-B	180 pairs per hour	120 pairs / hour	150 pairs per hour	150 pairs per hour	250 pairs per hour
ST -B	5.2 5 k W	1.9 k W	2,5 k W	2,5 k W	2.0 k W
ST- B	990 ** 151 0 * 151	760 * 855 * 148 0	650 * 500 * 125 0	650 * 500 * 125 0	600 * 650 * 138 0
ST-B	Swee t (Cze ch Repu blic)	GEL	Swee t (Cze ch Repu blic)	Swee t (Cze ch Repu blic)	Italy
ST- B	190 kg	100 Kg	250 Kg	250 Kg	350 Kg
ST-B	R 254	A20 0/D	0206 8 / P4	0206 8 / P4	133
ST- B	540,000 rubles	120,000,151	dur 009721	dur 009721	130000£ub
ST- B	150 pair s per hou	150 pair s per hou r	150 pair s per hou r	150 pair s per hou r	250 pair s per hou r
ST- B	3.5 kW	1.1 kW	2,5 kW	2,5 kW	2.0 kW
ST- B	700 * 700 * 1030	820 * 360 * 1215	650 * 500 * 1250	650 * 500 * 1250	600 * 650 * 1380
ST-B	Leibro ck (Germ any)	Stema (Italy).	Sweet (Czec h Repub lic)	Sweet (Czec h Repub lic)	Italy
ST- B	150 Kg	120 kg	250 Kg	250 Kg	350 Kg
ST-B	RW2	D510	0206 8 / P4	0206 8 / P4	133
ST- B	du1 004824	du1000001	dur 009721	dui 00972[KUB 900 480
ST-B	100 pairs per hour	120 pairs / hour	150 pairs per hour	150 pairs per hour	250 pairs per hour
ST- B	2.0 kW	1.9 kW	2,5 kW	2,5 kW	1.5k w
ST- B	1480 * 1100 * 750	760 * 855 * 1480	650 * 500 * 1250	650 * 500 * 1250	700 * 700 * 1030
ST-B	Cosm opol (Italy	GEL	Swee t (Czec h Repu blic)	Swee t (Czec h Repu blic)	GRA NUC CI (Italy
ST- B	228 kg	100 Kg	250 Kg	250 Kg	300 Kg
ST- B	CF7 8N	A20 0/ D	020 68 / P4	020 68 / P4	FR2 7 / 2M
Removing braces and tex from insoles	Trimming excess draw-off edge, ruffle draw-in edge, dust removal	Treatment of the slow surface of the soles	First glue on the lingering edge and low-running surface of the sole, drying	The second spreading of glue on the lingering edge and the slow surface of the sole, drying	Activation of adhesive films and gluing of soles

 ISRA (India)
 = 6.317
 SIS (USA)
 = 0.5

 ISI (Dubai, UAE)
 = 1.582
 РИНЦ (Russia)
 = 0.5

 GIF (Australia)
 = 0.564
 ESJI (KZ)
 = 9.5

 JIF
 = 1.500
 SJIF (Morocco)
 = 7.5

 SIS (USA)
 = 0.912
 ICV (Poland)
 = 6.630

 РИНЦ (Russia)
 = 0.126
 PIF (India)
 = 1.940

 ESJI (KZ)
 = 9.035
 IBI (India)
 = 4.260

 SJIF (Morocco)
 = 7.184
 OAJI (USA)
 = 0.350

KUB 1,270,000	du1 008 £82	54,00 0 rbl	3528 00 rub	RUB 1856 00
150 pairs per hour	from 1000 to 2000 pairs / h	120 pairs per hour	250 pairs per hour	150 pairs per hour
1.5 k W	2.0 k W	1.0 k	1.1 k W	0.4 2 k W
760 * 855 * 148 0	110 0x2 800 x17 60	110 0 ** 900 * 140	820 * 360 * 121	550 * 800 * 147 5
Sigm a (Italy	Stem a (Italy).	"NE VE" Italy	Stem a (Italy).	Swee t (Cze ch Repu blic)
450 Kg	500 Kg	70 Kg	120 kg	135 kg
755 PC	TR 22	SP75 AR	LP 1	0422 2 / P1
KUB 1,270,000	Id1 000,89I	847 90 rub	186 ,00 0 rbl	RU B 190 ,20
150 pair s per hou r	900 - 100 0 pair s/h	150 pair s per hou	250 pair s per hou	125 stea m per hou
1.5 kW	1.9 kW	2.2 kW	1.3k w	0.6 kW
760 * 855 * 1480	1500 ** 1500 ** 1760	520 * 1100 * 1370	420 ** 330 ** 1100	800 * 850 * 2100
Sigma (Italy)	RON FOX (Italy)	Leibro ck (Germ any)	Leibro ck (Germ any)	Schön (Germ any)
450 Kg	400 Kg	80 Kg	80 Kg	180 ru
755 PC	FR32 00	KAR O1	ASL-	123L HE
12,700,000 rubles	KUB 204,000	54,0 00 rbl	359 520 rub	RU B 238 740
150 pairs per hour	600 - 800 pairs / h	120 pairs / hour	300 pairs per hour	100 pairs per hour
1.5 kW	2.0 kW	1.9 kW	1.5 kW	0.1 kW
760 * 855 * 1480	1500 * 1000 * 1760	760 ** 855 ** 1480	1130 ** 800 ** 500	700 * 600 * 1900
Sigm a (Italy)	Stem a (Italy).	GELmini	Omsa (Italy)	GRA NUC CI (Italy)
450 Kg	300 Kg	100 Kg	205 kg	140 kg
755 PC	TRI 9	G12 /1	10 2	08S
Bonding soles	Cooling shoes after pressing	Cleaning the top and bottom of shoes	Removing shoes from the last	Attaching heels from the inside



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attac hmen t PES- R	ST-B	[dī 000,42	du1 04286	KUB 32,950	ST-B	ST- UO
attach ment PES- R	ST-B	120 pairs per hour	150 pairs / hour	1200 pairs / 8 hours	ST-B	ST- UO
att ac hm ent PE S-	ST -B	1.0 k W	2.0 k W	0.2	ST -B	ST - U O
attac hme nt PES -R	ST- B	110 0 ** 900 * 140	185 0 * 950 * 100	70 * 800 * 180	ST- B	ST- UO
attac hmen t PES- R	ST-B	"NE VE" Italy	GRA NUC CI (Italy	Swee t (Cze ch Repu blic)	ST-B	ST- UO
attac hme nt PES -R	ST- B	70 Kg	155 kg	110 Kg	ST- B	ST- UO
attac hme nt PES- R	ST-B	SP75 AR	TL 75	0505 4 / P6	ST-B	ST- UO
atta ch me nt PE S-R	ST- B	dur 09748	du1 04286	KUB 40 320	ST- B	ST- UO
atta ch me nt PE S-R	ST- B	150 pair s per hou	150 pair s/ hou r	150 0 chil dre n/ hou	ST- B	ST. UO
atta chm ent PES -R	ST- B	2.2 kW	2.0 kW	0.25	ST- B	ST- UO
attac hme nt PES- R	ST- B	520 ** 1100 ** 1370	1850 ** 950 ** 1000	750 * 600 * 1800	ST- B	ST- UO
attach ment PES-R	ST-B	Leibro ck (Germ any)	GRA NUC CI (Italy)	IRON FOX (Italy	ST-B	ST- UO
atta chm ent PES -R	ST- B	80 Kg	155 kg	115 ra	ST- B	ST- UO
attac hmen t PES- R	ST-B	KAR O 1	TL 75	341 / BF	ST-B	ST- UO
attac hme nt PES -R	ST- B	Id1 000,42	du1 04286	KUB 40 320	ST- B	ST- UO
attac hmen t PES- R	ST-B	120 pairs / hour	150 pairs / hour	1500 pairs / 8h	ST-B	ST- UO
attac hm e nt PES- R	ST- B	1.9 kW	2.0 kW	0.25	ST- B	ST- UO
attac hme nt PES- R	ST- B	760 ** 855 ** 1480	1850 * 950 * 1000	750 * 600 * 1800	ST- B	ST- UO
attach ment PES- R	ST-B	GEL	GRA NUC CI (Italy)	IRO N FOX (Italy	ST-B	ST. UO
atta ch me nt PE S-R	ST- B	100 Kg	155 kg	115 ra	ST- B	ST- UO
atta chm ent PES -R	ST- B	G12 /1	TL 75	341 / BF	ST- B	ST- UO
Checking and cleaning nails inside shoes	Bonding heel pads and insoles	Retouching the top of the shoe	Finishing the upper of the shoe	Shoe marking	Quality control	Shoe packaging



Imi	pact	Fac	tor:
	paci	rac	wi.

ISRA (India)	= 6.317	SIS (USA)	= 0.912
ISI (Dubai, UAE) = 1.582	РИНЦ (Russi	(a) = 0.126
GIF (Australia)	= 0.564	ESJI (KZ)	= 9.035
HF	- 1 500	SHE (Morocc	(0) - 7.184

ICV (Poland)

PIF (India)

IBI (India)

OAJI (USA)

= 6.630

= 1.940

= 4.260

= 0.350

ST-B	
ST-B	
ST -B	930
ST- B	RUB 9,110,930
ST-B ST-	RU
ST- B	
ST-B ST-B B	
ST- B	
ST- ST- B B	
ST- B	20
ST-B	RUB 8,906,320
ST-B	RUB
ST- B	
ST-B ST-B	
I-B ST- B	
ST-B	
ST- B	3,280
ST- B	RUB 10,453,28
ST- ST-B ST- ST-B B B B	RU
ST- B	
ST- B	
Delivery of shoes to the warehouse, paperwork	The amount of equipment costs

Table 5 - Characteristics of the equipment for assembling the workpiece model G (men's boots)

gical	price	22	ST- B	ST-B	Id1 0087 I	320,700 rbl
3 set of equipment for innovative technological process	performanc e	21	ST-B	ST-B	63 pairs per hour	65 pairs per hour
vative t	bower	20	ST- B	ST- B	0.7 kW	0.5 kW
or innov process	anoianamib	19	ST- B	ST- B	105 0 * 540 * 119 0	900 ** 600 ** 128 0
pment f	manufactur er	18	ST- B	ST- B	Swe et (Cze ch Rep ublic)	Swe et (Cze ch Rep ublic)
of equi	tdgisw	17	ST- B	ST- B	130 Kg	186 kg
3 set	vendor code	16	ST- B	ST- B	011 46/ P5	012 80 / P1
gical	əəinq	15	ST- B	ST- B	[d1 0002]	du1 002452
chnolo	performance	14	ST- B	ST- B	77 pair s/ h	60 pair s per hou r
tive te	bower	13	ST- B	ST- B	0.5 kW	1.0 kW
or innova process	anoianamib	12	ST- B	ST- B	105 0 * 540 * 116 0	105 0 * 550 * 120 0
2 set of equipment for innovative technological process	manufactur er	1	ST-B	ST-B	Fortu na (Ger many)	Schön (Ger many)
of equi	weight	10	ST- B	ST- B	140 KG	170 kg
2 set	vendor code	6	ST-B	ST-B	3SE- RZ	\$103 1C
ical	price	~	ST- B	ST- B	Id1 0002 I	dur 090 204
1 set of equipment for innovative technological process	performanc e	7	ST-B	ST-B	75 pairs per hour	60 pairs per hour
ative te	power	9	ST- B	ST- B	1.2 kW	0.75 kW
or innov process	dimensions	5	ST- B	ST- B	105 0 * 550 * 103 0	110 0 * 550 * 127 0
oment fo	manufactur er	4	ST- B	ST- B	Com	Sagi ta (Ital y)
of equit	weight	Э	ST- B	ST- B	135 kg	180 KG
1 set	vendor code	2	ST-B	ST-B	SS 20	RP67 TE
the name of the operation		1	Receiving and checking the cut	Cutting into production	Lowering the edges of the outer baby top and lining	Bending with simultaneous application of hot melt glue, notching of curved sections and gluing tape



ISRA (India) = 6.317 ISI (Dubai, UAE) = 1.582 GIF (Australia) = 0.564 JIF = 1.500 SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

001	<u> </u>	on Locality	on Lean at	ont occur.	on Locate
dur 002521	ST- B wit h	dur 00967	du1 000967	qn1 0096L	qn1 0096L
pairs per hour	ST-B with vyt.	1		ı	t
3.1 kW	ST-B with	0.27 kW	0.27 kW	0.27 kW	0.27 kW
125 0 * 900 * 135 0	ST-B With	\$20 ** 180	520 * 180	\$20 * 180	520 * 180
NEV E (Ital y)	ST-B With	AFF " Ger m	"PF AFF " Ger man y	"PF AFF " Ger man y	"PF AFF " Ger man y
180 Kg	ST-B with	130 Kg	130 Kg	130 Kg	130 Kg
PR 86 A	ST-B with	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl
123 150 rub	ST-Bwith with	1d1 21282	1d1 21282	Id1 2128č	Id1 21282
150 pair s per hou r	ST-B B wit h	ı	ï	ı	t
0.8 kW	ST-B B wit h	0.2 7 kW	0.2 7 kW	0.2 7 kW	0.2 7 kW
180 0 ** 130 **	ST-B with	900 * \$00 850	900 * 850	900 * \$50 850	900 * \$00 850
Schön (Ger many)	ST-B with vyt.	Typic al (Chin a)	Typic al (Chin a)	Typic al (Chin a)	Typic al (Chin a)
180 Kg	ST- B wit h	130 Kg	130 Kg	130 Kg	130 Kg
C 1100 V	ST-B with vyt.	Typi cal GC2 4026	Typi cal GC2 4026	Typi cal GC2 4026	Typi cal GC2 4026
KUR 185640	ST- B wit h	1d1 21282	1d1 21288	Id1 21288	Id1 21288
150 pairs per hour	ST-B with vyt.	ı	ï	ī	ī
2.1 kW	ST- B with	0.27 kW	0.27 kW	0.27 kW	0.27 kW
143 0 ** 780 **	ST- B with	900 * 500 * 850	900 * 850	900 * \$00 850	900 * * 850
Saba 1 (Ital y)	ST- B with	Typi cal (Chi na)	Typi cal (Chi na)	Typi cal (Chi na)	Typi cal (Chi na)
180 Kg	ST- B with vyt.	130 Kg	130 Kg	130 Kg	130 Kg
M107	ST-B with vyt.	Typic al GC24 680	Typic al GC24 680	Typic al GC24 680	Typic al GC24 680
Duplication of upper details with interlining	Spreading with glue and gluing inter-block blocks	Adjusting the sock to the vamp	Glueing and stitching the vamp onto the tongue	Tucking darts on the back	Spreading with glue and stitching the back to the ankle boots



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SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

dur 00997	ST- B wit h	du1 00967	ST- B	[d1 0049 <i>T</i>	Id1 0049T	ST-Bwit
ı	ST-B with vyt.	1	ST-B	1	1	ST-B with vyt
0.27 kW	ST- B with	0.27 kW	ST- B	0.27	0.27	ST- B with
520 ** 180	ST- B with	\$20 * 180	ST- B	900 * 500 * 850	900 * 850	ST-B B with
"PF AFF " Ger man y	ST- B with	"PF AFF " Ger man y	ST- B	Pfaff (Ger man y)	Pfaff (Ger man y)	ST- B with
130 Kg	ST- B with	130 Kg	ST- B	130 Kg	130 Kg	ST-B B with
Pfaf f 574- 900 cl	ST-B B with	Pfaf f 574- 900 cl	ST- B	Pfaf f 591- 900 cl	Pfaf f 591- 900 cl	ST-B B with
1d1 21282	ST- B with vyt.	58212 rbl	ST- B	dur 0902£1	du1 0902£[ST-B with
1	ST-B Bwit wit h	1	ST- B	1	T.	ST-B wit h vyt
0.2 7 kW	ST- B wit h	0.2 7 kW	ST- B	0.2 7 kW	0.2 7 kW	ST- B wit h
900 * * 850	ST- B with	900 * \$00 * 850	ST- B	900 ** \$50 850	900 * \$ 850	ST- B with
Typic al (Chin a)	ST-B with vyt.	Typic al (Chin a)	ST-B	Durko pp Adler	Durko pp Adler	ST-B with vyt
130 Kg	ST- B wit h	130 Kg	ST- B	130 Kg	130 Kg	ST-B B wit h
Typi cal GC2 4026	ST-B with vyt.	Typi cal GC2 4026	ST-B	4180 i-511 E5 BM0 0002	4180 i-511 E5 BM0 0002	ST-B with vyt
1d1 21282	ST- B wit h	1d1 21282	ST- B	dur 898112	du1 398 I I S	ST-B Bwit hh
	ST-B with vyt.	1	ST-B	ı	U	ST-B with vyt
0.27 kW	ST- B with	0.27 kW	ST- B	1.76 kW	1.76 kW	ST- B with
900 * \$00 * 850	ST- B with vyt.	900 * \$ 850	ST- B	\$20 * 180	\$20 * 180	ST- B with
Typi cal (Chi na)	ST- B with	Typi cal (Chi na)	ST- B	Gra nucc i (Ital y)	Gra nucc i (Ital y)	ST-B with
130 Kg	ST- B with	130 Kg	ST- B	130 Kg	130 Kg	ST- B with
Typic al GC24 680	ST-B with vyt.	Typic al GC24 680	ST-B	491 GRA MAC	491 GRA MAC	ST-B with vyt
Adjusting the overhead protectors on the ankle boots	Glueing and gluing the vamp on the ankle boots	Tightening the vamp on the ankle boots while attaching the tongue	Punching holes for lacing	Adjusting the leather pocket on the leather lining under the ankle boots	Adjusting the leather lining under the ankle boots to the textile lining under the vamp;	Spreading with glue gluing the outer and inner nodes of the upper parts



ISRA (India)	= 6.317	SIS (USA)	= 0.912	ICV (Poland)	= 6.630
ISI (Dubai, UAE)) = 1.582	РИНЦ (Russia	a) = 0.126	PIF (India)	= 1.940
GIF (Australia)	= 0.564	ESJI (KZ)	= 9.035	IBI (India)	= 4.260
JIF	= 1.500	SJIF (Morocco	(0) = 7.184	OAJI (USA)	= 0.350

14,000,eI	[d1 000,42	ST- B	ST- B	
	120 pairs per hour	ST-B	ST-B	
0.27	1.0 kW	ST- B	ST- B	
900 * \$500 850	110 0 * 900 * 140	ST- B	ST- B	
Colli (Ital y)	"NE VE" Italy	ST- B	ST- B	_
120 kg	70 Kg	ST-B	ST- B	RUB 694,000
GP 2	SP7 5AR	ST- B	ST- B	RUB
141 000,e1	54,000 rbl	ST- B	ST- B	
I	150 pair s per hou r	ST- B	ST- B	
0.2	2.2 kW	ST- B	ST- B	
900 * \$ \$00 850	520 ** 110 0 ** 0 137	ST- B	ST- B	
Colli (Italy)	Leibr ock (Ger many)	ST-B	ST-B	
120 kg	% N Kg	ST- B	ST- B	da l
GP 2	KAR O 1	ST-B	ST-B	636552 rub
Id1 000,eI	1d1 000,42	ST- B	ST- B	
ı	120 pairs / hour	ST-B	ST-B	
0.27 kW	1.9 kW	ST- B	ST- B	
900 ** \$500 850	760 ** 855 ** 148	ST- B	ST- B	
Coll i (Ital y)	GEL	ST- B	ST- B	
120 kg	100 Kg	ST- B	ST- B	16 438
GP 2	G12 / 1	ST-B	ST-B	RUB 946 438
Stitching the workpiece along the edge line with simultaneous trimming of the edges of the leather lining;	Shoe uppers cleaning	Lacing the shoe upper	Quality control, procurement of blanks, delivery to the warehouse	The amount of equipment costs

Table 6 - Characteristics of equipment for assembling shoes model G (men's boots)

	price	22	ST- B
	реггогтапсе	17	ST-B
pment	power	20	ST- B
type of equipment	snoisnamib	19	ST- B
3 type	manufacturer	81	ST- B
	weight	17	ST- B
	vendor code	91	ST- B
	price	15	ST- B
	performance	14	ST- B
ment	power	13	ST- B
of equip	anoianamib	12	ST- B
2 type of equipmen	manufacturer	11	ST-B
	thgisw	10	ST- B
	vendor code	6	ST-B
	əəinq	8	ST- B
	реггогталсе	L	ST-B
oment	bower	9	ST- B
ype of equipmer	snoisnamib	5	ST- B
1 type	manufacturer	7	ST- B
	y dgiəw	3	ST- B
	vendor code	2	ST-B
the name of the	operation	1	Receiving and checking the cut



ISRA (India) = 6.317 SIS (USA) = 0.912
ISI (Dubai, UAE) = 1.582 РИНЦ (Russia) = 0.126
GIF (Australia) = 0.564 ESJI (KZ) = 9.035
JIF = 1.500 SJIF (Morocco) = 7.184

ICV (Poland)

PIF (India)

IBI (India)

OAJI (USA)

= 6.630

= 1.940

= 4.260

= 0.350

ST- B	Ida 0087 I	320,700 rbl	du1 002821	ST- B wit h	dur 000997	qn1 0096L
ST-B	63 pairs per hour	65 pairs per hour	150 pairs per hour	ST-B swith law tyt.		
ST- S. B	0.7 63 kW pe po ho	0.5 65 kW pe po ho	3.1 15 kW pc pc		0.27 kW	0.27 kW
		XXXX - CT0*				
ST- B	105 0 * 540 * 119 0	900 * 600 0 128	125 0 * 900 * 135 0	ST-B B with	520 * 180	520 * 180
ST- B	Swe et (Cze ch Rep ublic	Swe et (Cze ch Rep ublic	NEV E (Ital y)	ST-B B with	AFF " Ger m	"PF AFF " Ger man y
ST-B	130 Kg	186 kg	180 Kg	ST-B with	130 Kg	130 Kg
ST- B	011 46 / P5	012 80 / P1	PR 86 A	ST-B with	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl
ST- B	[d1 0002 [234500 rub	123 150 rub	ST- B with vyt.	1d1 21282	1d1 21282
ST- B	77 pair s/ h	60 pair s per hou r	150 pair s per hou r	ST-B B wit h	ť	
ST- B	0.5 kW	1.0 kW	0.8 kW	ST-B B wit h	0.2 7 kW	0.2 7 kW
ST- B	105 0 * 540 * 116	105 0 * 550 * 120	180 0 * 130 * 950	ST- B with vyt.	900 * 500 * 850	900 * \$00 * 850
ST-B	Fortu na (Ger many)	Schön (Ger many)	Schön (Ger many)	ST-B with vyt.	Typic al (Chin a)	Typic al (Chin a)
ST- B	140 KG	170 kg	180 Kg	ST-B B wit h	130 Kg	130 Kg
ST-B	3SE- RZ	\$103 1C	C 1100 V	ST-B with vyt.	Typi cal GC2 4026	Typi cal GC2 4026
ST- B	Id1 0002 [du1 090 204	BOR 185640	ST-Bwit	1d1 21282	Id1 21282
ST-B	75 pairs per hour	60 pairs per hour	150 pairs per hour	ST-B with vyt.	I.	-
ST- B	1.2 kW	0.75 kW	2.1 kW	ST- B with vyt.	0.27 kW	0.27 kW
ST- B	1050 * 550 * 1030	1100 * 550 * 1270	1430 * 780 * 950	ST- B with	900 * 500 * 850	900 * \$ 850
ST- B	Com	Sagi ta (Ital y)	Saba 1 (Ital y)	ST- B with vyt.	Typi cal (Chi na)	Typi cal (Chi na)
ST- B	135 kg	180 KG	180 Kg	ST- B with vyt.	130 Kg	130 Kg
ST-B	SS 20	RP67 TE	M107 \R	ST-B with vyt.	Typic al GC24 680	Typic al GC24 680
Cutting into production	Lowering the edges of the outer baby top and lining	Bending with simultaneous application of hot melt adhesive,	Duplication of upper details with interlining	Spreading with glue and gluing inter-block blocks	Adjusting the sock to the vamp	Glueing and stitching the vamp onto the tongue



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du1 000967	qn1 0096L	du1 00967	ST- B wit h	qn1 0096L	ST- B	Id1 00497
1	1	ı	ST-B with vyt.	1	ST-B	1
0.27 kW	0.27 kW	0.27 kW	ST-B B with	0.27 kW	ST- B	0.27
520 * 180	\$20 * 180	520 * 180	ST- B with	\$20 * 180	ST- B	900 * 500 * 850
"PF AFF " Ger man y	"PF AFF " Ger man y	"PF AFF " Ger man y	ST- B with vyt.	"PF AFF " Ger man	ST- B	Pfaff (Ger man y)
130 Kg	130 Kg	130 Kg	ST-B B with	130 Kg	ST- B	130 Kg
Pfaf f 574- 900 cl	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl	ST-B B with	Pfaf f 574- 900 cl	ST- B	Pfaf f 591- 900 cl
Id1 21282	1d1 21282	1d1 21282	ST- B with vyt.	161 21282	ST- B	du1 000281
	1	1	ST- B wit h	1	ST- B	1
0.2 7 kW	0.2 7 kW	0.2 7 kW	ST- B wit h	0.2 7 kW	ST- B	0.2 7 kW
900 * * 850	900 * \$00 850	900 * 850	ST- B with vyt.	900 * \$500 850	ST- B	900 * 500 * 850
Typic al (Chin a)	Typic al (Chin a)	Typic al (Chin a)	ST-B with vyt.	Typic al (Chin a)	ST-B	Durko pp Adler
130 Kg	130 Kg	130 Kg	ST- B wit h	130 Kg	ST- B	130 Kg
Typi cal GC2 4026	Typi cal GC2 4026	Typi cal GC2 4026	ST-B with vyt.	Typi cal GC2 4026	ST-B	4180 i-511 E5 BM0 0002
1d1 21282	Id1 21282	1d1 21282	ST- B wit h	Id1 21282	ST- B	dur 992 [[2
		ı	ST-B with vyt.		ST-B	1
0.27 kW	0.27 kW	0.27 kW	ST- B with	0.27 kW	ST- B	1.76 kW
900 * \$ 850	900 * \$ 850	900 * \$ 850	ST- B with vyt.	900 * \$00 850	ST- B	520 ** 180
Typi cal (Chi na)	Typi cal (Chi na)	Typi cal (Chi na)	ST-B with	Typi cal (Chi na)	ST- B	Gran ucci (Ital y)
130 Kg	130 Kg	130 Kg	ST- B with vyt.	130 Kg	ST- B	130 Kg
Typic al GC24 680	Typic al GC24 680	Typic al GC24 680	ST-B with vyt.	Typic al GC24 680	ST-B	491 GRA MAC
Tucking darts on the back	Spreading with glue and stitching the back to the ankle boots	Adjusting the overhead protectors on the ankle boots	Glueing and gluing the vamp on the ankle boots	Tightening the vamp on the ankle boots while attaching the tongue	Punching holes for lacing	Adjusting the leather pocket on the leather lining under the ankle boots



ISRA (India) **= 6.317** SIS (USA) **= 0.912** ICV (Poland) **= 6.630 ISI** (Dubai, UAE) = **1.582 РИНЦ** (Russia) = **0.126** PIF (India) **= 1.940 GIF** (Australia) = **0.564** ESJI (KZ) **= 9.035** IBI (India) **= 4.260 JIF** = 1.500 **SJIF** (Morocco) = **7.184** OAJI (USA) = 0.350

					I	
Id1 00497	ST-B B wit h h	1d ₁ 000,e1	1d1 000,42	ST- B	SI- B	
1	ST-B with	E.	120 pairs per hour	ST-B	ST-B	
0.27	ST-B B with	0.27	1.0 kW	ST- B	ST- B	
900 * 850	ST-B with	900 * \$00 850	110 0 * 900 * 140	ST- B	ST- B	
Pfaff (Ger man y)	ST-B B with	Colli (Ital y)	"NE VE" Italy	ST- B	SI-B	
130 Kg	ST-B B with	120 kg	70 Kg	ST- B	ST- B	RUB 694,000
Pfaf f 591- 900 cl	ST-B B with	GP 2	SP7 5AR	ST- B	ST- B	RUB (
dur 0902£[ST- B with	[d ₁ 000,e]	[d1 000,48	ST- B	ST- B	
1	ST- B wit h	1	150 pair s per hou r	ST- B	ST- B	
0.2 7 kW	ST- B wit h	0.2	2.2 kW	ST- B	ST- B	
900 * 850	ST-B B with	900 * 850	520 * 110 0 * 137	ST- B	ST- B	
Durko pp Adler	ST-B with vyt	Colli (Italy)	Leibr ock (Ger many)	ST-B	ST-B	
130 Kg	ST- B wit h	120 kg	80 Kg	ST- B	ST- B	rub
4180 i-511 E5 BM0 0002	ST-B with vyt	GP 2	KAR O 1	ST-B	ST-B	636552 rub
dur 962112	ST- B wit h	19,000,e1	54,000 rbl	ST- B	ST- B	
	ST-B with vyt	t.	120 pairs / hour	ST-B	ST-B	
1.76 kW	ST- B with	0.27 kW	1.9 kW	ST- B	ST-B	
520 * 180	ST- B with	900 * \$ 850	760 * 855 * 1480	ST- B	ST- B	
Gran ucci (Ital y)	ST- B with	Coll i (Ital y)	GEL	ST- B	ST- B	
130 Kg	ST- B with	120 kg	100 Kg	ST- B	ST- B	16 438
491 GRA MAC	ST-B with vyt	GP 2	G12/ 1	ST-B	ST-B	RUB 946 438
Adjusting the leather lining under the ankle boots to the textile lining under the vamp;	Spreading with glue gluing the outer and inner nodes of the upper parts	Stitching the workpiece along the edge line with simultaneous trimming of the edges of the leather lining;	Shoe uppers cleaning	Lacing the shoe upper	Quality control, procurement of blanks, delivery to the warehouse	The amount of equipment costs



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rame of operations	Model 1 winter	Model 2 winter	Model 3 winter	Model 4 spring	Model 5 spring	Model 6 spring	Model 7 vears	Model 8 vears	Model 9 vears	Model 10 autumn	Model 11 autumn	Model 12 autumn
	2	3	4	5	9	7	~	6	10	11	12	13
 Receiving and checking the cut 	+	+	+	+	+	+	+	+	+	+	+	+
2. Starting the cut into production	+	+	+	+	+	+	+	+	+	+	+	+
3. Descending the edges of the top parts	+	+	+	+	+	+	+	+	+	+	+	+
4. Bending the edges of the outer parts of the top	+	+	+	+	+	+	+	+	+	+	+	+
5. Duplication of upper details with interlining, vamp - with thermoplastic toe cap	+	+	+	+	+	+	*	+	×	+	+	+
6. Tightening darts on the back	ж	*	÷	+	+	*	*	*	ж	+	*	+
7. Spreading with glue and gluing the back of the ankle	ж	ж	+	+	+	ж	ж	*	ж	+	+	*
8. Adjusting the backs of the ankle boots	*	*	+	+	+	*	*	*	*	+	+	*
9. Adjusting the leather pocket on the leather lining under the ankle boots	+	*	±	+	+	+	*	+	*	+	+	+
10. Glueing and gluing the boot knot and the boot lining knot along the edge	+	*	+	+	+	*	*	*	*	*	*	+
11. Stitching of ankle boots with trimming of leather lining	+	*	+	+	+	*	*	*	¥	*	ж	+

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SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

+	ж	*	+	+	+	+	+	*	*	*	*
*	ж	*	*	*	+	-9c	ж	ж	*	+	÷
+	+	+	+	×	*	*	*	+	+	+	+
*	*	*	*	*	*	*	*	*	*	*	*
+	ж	*	+	×	×	ж	*	+	+	+	+
+	ж	*	ж	*	*	*	*	+	+	ж	+
*	*	*	*	*	*	ж	*	*	*	*	+
+	+	+	+	+	+	+	+	*	*	*	ж
+	+	+	+	+	+	+	+	*	*	*	*
+	ж	*	+	+	+	+	+	+	+	+	*
*	*	*	*	*	*	ж	*	*	*	*	*
+	ж	*	+	+	+	+	+	+	+	+	*
12. Punching holes for laces	13. Spreading with glue and gluing the sock to the vamp	14 attaching the toe to the vamp	15.Adding leather tongue lining to textile vamp lining	16. Spreading with glue and gluing the vamp lining knot and the vamp knot along the edge	17. Stitching the edging of the vamp tongue with simultaneous trimming of the edges of the leather lining	18. Spreading with glue and gluing the back group to the front	19. Tailoring the back group to the front group while sewing the thread bartack	20. Spreading with glue and sticking the tabs on the vamp	21. Tying the reeds onto the vamp	22. attaching the overhead blocks to the ankle boots	23. Spreading with glue and gluing the vamp on the ankle boots

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ж	*	*	*	*	*	*	*	*	*
+	*	*	+	*	*	+	+	+	+
+	+	+	+	-9x	÷	÷	ж	*	×
÷	*	×	*	+	+	·k	ж	÷	×
+	+	+	+	*	*	*	*	*	*
+	*	*	+	*	*	*	*	*	*
+	+	+	+	*	ж	*	*	ж	*
*	*	*	*	*	ж	*	*	*	*
*	*	*		*	*	*	*	*	*
*	*	*	+	*	*	*	*	*	*
*	*	+	*	*	*	*	*	*	*
*	*	×	*	*	ж	*	×	ж	*
24. Attaching the vamp to the ankle boots while attaching the tongue (without tongue)	25.Adding a leather lining under the ankle boots to a textile lining under the vamp	26. Spreading with glue and gluing the outer and inner nodes of the upper parts	27. Stitching the workpiece along the edge line with simultaneous trimming of the edges of the leather lining	28. Spreading with glue and gluing the leather lining on the vamp parts	29. Tightening the leather lining with the upper	30. Shading the details of the ankle boots on the ankle boots	31. Glueing the harness belt, putting on the buckles, gluing the ends of the belt	32. Spreading the belt with glue, gluing the Velcro fastener	33. Attaching the leather lining under the

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harness belt to the												
34. Attaching leather lining under the belt to the belt	*	*	ж	*	*	*	*	*	ж	ж	+	*
35. Adjusting the harness belts on the back	*	ж	*	*	*	*	*	*	*	ж	+	ж
36. Adjusting the belt on the back	*	*	*	*	*	*	*	*	*	*	+	*
37. Tightening the back edges of the ankle boots	*	+	+	*	*	+	+	+	×	ж	+	*
38. Adjustment of ZNR	*	+	*	*	*	*	*	+	*	*	+	*
39. Adjusting the leather podklochnikov on the textile lining of the vamp	*	*	*	*	*	*	*	*	*	*	+	*
40. Adjusting the shtafers on the lining	+	*	+	*	*	*	*	*	*	*	+	*
41. Spreading glue on the upper and front edges of the ankle boots and lining, drying	÷	*	*	*	*	*	*	*	ж	×	+	*
42. Seam ankle boots with a lining under the inverted seam	+	*	*	*	*	*	*	*	*	*	+	*
43. Spreading with glue and gluing a pad of a soft edge, drying	*	ж	ж	*	*	*	*	*	ж	ж	+	*
44. Turning and banding the edge of the ankle boots	*	*	*	*	*	*	*	*	*	*	+	*
45. Finishing the soft edging of the ankle boots	*	ж	*	*	*	ж	*	*	*	ж	+	*
46. Tightening of the ankle boots along the front edge	*	ж	ж	*	*	ж	*	ж	*	×	+	ж

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*	*	*	*	*	*	*	*	*	*	*
*	*	*	*	*	×	*	*	*	*	*
×	*	*	*	*	æ	*	*	*	*	*
×	*	*	*	*	-9x	*	*	*	*	*
*	*	*	*	*	×	*	*	*	*	*
*	*	*	*	*	×	*	*	*	*	*
*	*	*	*	*	*	*	*	*	*	*
ж	*	*	*	*	ox	*	*	*	*	*
*	*	*	÷	ж	*	*	ж	ж	*	*
*	*	*	*	*	*	*	*	ж	*	*
+	+	+	+	+	+	+	+	+	+	+
*	*	*	*	*	ж	*	*	×	*	*
47. Spreading gum and gum parts with glue. Drying	48. Gluing parts of the elastic to the elastic	49. Attaching the details of the elastic to the elastic	50. Gluing the outer boot on the elastic butt to the elastic part	51. Gluing the vamp part to the elastic but butt to the elastic part	52. Tailoring the tibia detail to the knot of the outer tibia with one stitch + trimming with openwork on both sides of the stitching	53 Sewing the workpiece onto the zipper with double stitching	54. Tailoring the inner top to the zipper with the first line	55. Tailoring the inner top to the zipper with the first line	56. Tailoring the vamp on the knot of the ankle boots with a double stitching + one openwork inside	57. Bend of the upper edge of the vamp detail

Impact Factor: ISI (Dub GIF (Au

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	246		70						20	752 554
ж	*	ж	*	*	*	*	*	+	+	+
ж	*	*	*	*	*	*	*	+	+	*
×	ж	*	*	*	*	*	*	+	+	+
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ж	*	ж	*	*	*	*	*	+	+	+
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ж	*	*	*	*	+	*	+	+	+	+
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ж	ж	*	*	+	+	*	*	+	+	+
+	+	+	+	ж	*	*	*	+	+	*
*	ж	×	*	*	×	*	ж	+	+	+
58. Inversion, lining of a soft edging of ankle boots, a flap under a zipper	59. Tailoring the inner top to the zipper with the second line	60. Trimming soft edging, elastic and edging vamp details	61. Adjusting the knot of the lining under the vamp on the resulting group	62. Stitching decorative lines	63. Tucking of the lining along the back edge with a stitching seam	64. Tailoring a leather pocket on ankle boots	65. Attaching the elastic to the vamp with the 1st stitch	66. Trimming Thread	67. Shoe uppers cleaning	68. Lacing blanks

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Model 11 Model 12 autumn		+	+	+	+	+	+	+	+	+	+	+
Model 10 autumn	11	+	+	+	+	+	+	+	+	+	+	+
Model 9	10	+	+	+	+	+	+	*	*	*	*	*
Model 8 vears	6	+	+	+	+	+	+	+	+	+	+	+
Model 7	8	+	+	+	+	+	+	+	+	+	+	+
Model 6 spring	, <u> </u>	+	+	+	+	+	+	+	+	+	+	+
Model 5	9	+	+	+	+	+	+	+	+	+	+	+
Model 4 spring	20	+	+	+	+	+	+	+	+	+	+	+
Model 3 winter	4	+	+	+	+	+	+	+	+	+	+	+
Model 2 winter	3	+	+	+	+	+	+	+	+	+	+	+
Model 1 winter	2	+	+	+	+	+	+	+	+	+	+	+
Name of operations	1	1.Receiving blanks	2. Starting workpieces	3.Moisturizing the workpiece	4. Selection and cleaning of pads	5.Attaching the insoles (insole knots)	6.Smearing pads with talcum powder	7.Inserting backdrops made of thermoplastic materials	8.Pre-forming the heel of the blanks	9. Putting on the shoe upper on the last and installing the heel part	10. Tightening and tightening of the nosebeam part of the ZVO with hot melt glue with preliminary moistening of the nosebeam part and activation of the toe cap	11. Adhesive tightening of the heel

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of shoes 13. Removing staples + + + or tex from insoles 14. Trimming off + + + + excess traction edge 15. Rouging of the + + + + pulling edge, dust removal 16. First of heins of the + + +	+ + + + +	+ + + + + + +	+ + + + + + +	+ + * + + +	+ + + + +	+ + * + +	+ + +	+ +	+
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20.First and second + + + + + spreading glue on the slow surface of the soles, drying	+	+	+	+	+	+	+	+	+
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ISRA (India) **= 6.317** SIS (USA) = 0.912ICV (Poland) **= 6.630** ISI (Dubai, UAE) = 1.582**РИНЦ** (Russia) = **0.126** PIF (India) = 1.940 **GIF** (Australia) = **0.564 = 9.035** IBI (India) **= 4.260** ESJI (KZ) = 1.500 **SJIF** (Morocco) = **7.184** OAJI (USA) **= 0.350 JIF**

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+	+	+	+	+	+
+	+	+	+	+	+
+	+	+	+	+	+
26.Cleaning and repairing shoe defects	27 retouching the upper of the shoe	28. Dressing the upper of the shoe	29. Smoothing out wrinkles on shoes	30 shoe markings	31. Packing shoes

Table 9 - Consolidated innovative technological process for the assembly of the top blank for assortment a row of women's shoes

	,	,		•							•	
Name of operations	Model											
	A1	B2	N_3	G4	D5	E6	F7	Z8	6I	K10	L11	M12
2	3	4	5	9	7	8	6	10	11	12	13	14
Receiving and checking the cut	+	+	+	+	+	+	+	+	+	+	+	+
Cutting into production	+	+	+	+	+	+	+	+	+	+	+	+
Aligning the top parts to thickness	+	+	+	+	+	+	+	+	+	+	+	+
Lowering the edges of the upper parts	+	+	+	+	+	+	+	+	+	+	+	+
Duplication of the outer details of the upper with a midsole and vamp with toe cap	+	+	+	+	+	+	+	*	*	+	+	+
Inserting metal fittings into a decorative belt part	+	*	*	*	*	*	*	*	*	*	*	*
Bending the edges of parts	+	+	+	+	+	+	+	+	+	+	+	+
Sewing decorative stitching on the shaft	+	*	*	*	*	*	*	*	*	*	*	*
Perforation of the upper part of the outer shaft	+	*	*	*	*	*	*	*	*	*	來	*
Adjusting the backs on ankle boot and bootleg rear internal double row stitching	+	+	*	*	*	*	*	*	*	*	*	*
0											1	



10

No.

ISRA (India) = 6.317 SIS (
ISI (Dubai, UAE) = 1.582 РИН
GIF (Australia) = 0.564 ESJI
JIF = 1.500 SJIF

SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

Tightening the front shaft with the rear cuter +			<u> </u>				0					90	27				10	99
Tightening the front shaft with the rear outer + * * * * * * * * * * * * * * * * * *	*	*	*	+	*	*	*	*	*	*	*	*	*	*	*	*	*	+
Trightening the front shaft with the rear outer	*	*	*	+	*	*	*	*	*	*	*	*	*	*	*	*	*	+
Tightening the front shaft with the rear outer shaft and the zipper tupe and inner boot along the collection in Drying to edges of the inner zipped boot and the last stitching to edges of the inner zipped boot and the last stitching to edges of the inner zipped boot and the last stitching to edges of the bootleg.	*	*	*	+	*	*	*	*	*	*	*	*	*	*	*	*	*	+
Tightening the front shaft with the rear outer shaft of the tzipper tape and inner boot along the capes of the inner boot along the capes of the inner boot and the taper tape and inner boot and the statching Bonding the capes of the inner boot and the boot cape of the bootleg to gathering. Diving the vamp and bootleg for gathering. Diving the vamp to the bootleg to gathering. Tightening the vamp to the bootleg to gathering. Diving the vamp to the bootleg to gathering. Diving the vamp to the bootleg to gathering. Tightening the vamp to the bootleg to gathering. The properties of the tape to detail to the staff. The properties of the fail inning at the back edge with a thing the table to gather properties are details of the fail inning along the line of the zipper or the fair. Adjusting the flap under the zipper or the fair. The properties are details of the top and knot of details of the fair. Bording shot outside details of the top and knot of details of the fair. Bording along the line of the zipper. The transpar of the zipper with the 2nd line. The transpar to the zipper with the 2nd line. The transpar to the zipper with the 2nd line. The transpar to the zipper with the 2nd line. The transpar to the zipper with the 2nd line. The transpar to the zipper with the 2nd line. The transpar to the zipper with the 2nd line. The transpar to the zipper with the 2nd line.	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening the front shaft with the rear outer shaft shaft Glue the zipper tape and inner boot along the hooteg Bonding the edges of the inner Zipped boot Attaching the edges of the bootleg Attaching the vamp of the bootleg Applying the vamp to the bootleg Applying the vamp to the bootleg Adjusting the shaft detail to the shaft Adjusting the shaft detail to the fur lining Adjusting the shaft details of the fur lining at the back edge with a Smoothing the seam Flap location under fur lining Adjusting the line of the zipper for assembly. Bonding store to pand the knot of details of the fur lining along the line of the zipper with the 2nd line Hatachment of the zipper with the 2nd line	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening the front shaft with the rear outer shaft Glue the zipper tape and inner boot along the depending the edges of the inner Double to state the state of the bootleg the toper edge of the toper on the fur lining at the back edge with a the toper edge of the toper	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening the front shaft with the rear outer shaft Glue the zipper tape and inner boot along the joint line. Drying Bonding the edges of the inner zipped boot Attaching the zipper with the 1st stitching Re-hemming of the upper edge of the bootleg Glue the vamp and bootleg for gathering. Drying He-hemming of the upper edge of the bootleg Glue the vamp and bootleg for gathering. Drying Applying the vamp to the bootleg Tightening the vamp on the bootleg Tightening the vamp on the bootleg Adjusting the shaft detail to the shaft Adjusting the leather pocket on the fur lining Adjusting the leather pocket on the fur lining Tapering of the fur lining at the back edge with a hand outer fur lining Adjusting the seam Smoothing the seam Flap location under zipper on the fur lining Adjusting the flap under the zipper for assembly. Drying Bonding knot outside Glue the outer knot details of the fur lining along the line of the zipper for assembly. Bonding knot outside Gletails of the top and knot of details of the fur lining along the line of the zipper He hand hand hand hand hand hand hand hand	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening the front shaft with the rear outer shaft shaft Glue the zipper tape and inner boot along the joint line. Drying Bonding the edges of the inner zipped boot Attaching the zipper with the 1st stitching Adaching the zipper with the 1st stitching Applying the vamp of the upper edge of the bootleg Tightening the vamp on the bootleg Tightening the vamp on the bootleg Tightening the vamp on the bootleg Adjusting the shaft detail to the shaft Adjusting the shaft detail to the shaft Adjusting the leather pocket on the fur lining Tapering of the fur lining at the back edge with a the the stitching seam Smoothing the seam Flap location under zipper on fur lining Glue the outer knot details of the fur lining along the line of the zipper of assembly. Drying Bonding knot outside details of the top and knot of details of the fur lining along the line of the zipper vith the 2nd line lining along the line of the zipper with the 2nd line lining along the line of the zipper with the 2nd line	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening the front shaft with the rear outer shaft shaft Glue the zipper tape and inner boot along the joint line. Drying Bonding the edges of the inner zipped boot Attaching the edges of the inner he stitching the zipper and bootleg for gathering. Drying he vamp and bootleg for gathering. Drying he vamp to the bootleg he he he he double-row stitching he vamp to the bootleg he	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening the front shaft with the rear outer shaft shaft Glue the zipper tape and inner boot along the joint line. Drying Bonding the edges of the inner zipped boot Attaching the zipper with the 1st stitching He-hemming of the upper edge of the bootleg Glue the vamp and bootleg for gathering. Drying He-hemming of the upper edge of the bootleg Glue the vamp on the bootleg Tightening the vamp on the bootleg Tightening the shaft detail to the shaft Adjusting the shaft detail to the shaft Adjusting the leather pocket on the fur lining Adjusting the strafers to inner and outer fur lining at the back edge with a stitching seam Smoothing the seam Flap location under zipper on fur lining Glue the outer knot details of the for and the knot of details of the fur lining along the line of the zipper for assembly. Drying Bonding knot outside details of the top and knot of details of the fur lining along the line of the zipper Hatachment of the zipper with the 2nd line + + + + + + + + + - -	*	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
Tightening the front shaft with the rear outer shaft Glue the zipper tape and inner boot along the joint line. Drying Bonding the edges of the inner zipped boot Attaching the zipper with the 1st stitching Re-hemming of the upper edge of the bootleg Glue the vamp and bootleg for gathering. Drying Applying the vamp to the bootleg Glue the vamp on the bootleg Glue the shaft detail to the shaft Adjusting the shaft detail to the shaft Adjusting the shaft detail to the shaft Adjusting the shafters to inner and outer fur lining at the back edge with a stitching seam Smoothing the seam Flap location under zipper on fur lining Adjusting the flap under the zipper on the fur lining Glue the outer knot details of the fur lining along the line of the zipper for assembly. Drying Bonding knot outside details of the top and knot of details of the fur lining along the line of the zipper Attachment of the zipper with the 2nd line	*	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+
1	Tightening the front shaft with the rear outer shaft	Glue the zipper tape and inner boot along the joint line. Drying	Bonding the edges of the inner zipped boot	Attaching the zipper with the 1st stitching	Re-hemming of the upper edge of the bootleg	Glue the vamp and bootleg for gathering. Drying	Applying the vamp to the bootleg	Tightening the vamp on the bootleg double-row stitching	Adjusting the shaft detail to the shaft	Adjusting the leather pocket on the fur lining	Adjusting the shtafers to inner and outer fur lining	Tapering of the fur lining at the back edge with a stitching seam	Smoothing the seam	Flap location under zipper on fur lining	Adjusting the flap under the zipper on the fur lining	Glue the outer knot details of the top and the knot of details of the fur lining along the line of the zipper for assembly. Drying	Bonding knot outside details of the fur lining along the line of the zipper	Attachment of the zipper with the 2nd line
	Ξ	12	13	14	17	18	19	20	21	22	23	24	25	26	27	28	29	30



ISRA (India) **= 6.317** SIS (USA) **= 0.912** ICV (Poland) **= 6.630 ISI** (Dubai, UAE) = **1.582 РИНЦ** (Russia) = **0.126** PIF (India) **= 1.940 GIF** (Australia) = **0.564** ESJI (KZ) **= 9.035** IBI (India) **= 4.260 JIF** = 1.500 **SJIF** (Morocco) = **7.184** OAJI (USA) = 0.350

Explaining of the list under the clasp																						
Cutting the lab moter the classy Hightning Tightning of the booklegs with backs along the Sean smoothing and gluing Webbing Webbing Webbing Webbing Webbing With a stiching seam Turning of the fort lump along the front edge With a stiching seam Turning of the top and Pur Lining Bookling the coure hards Bookling the coure fort of details of the top Assembly. The purpose of the top and Pur Lining Bookling the Coure Top Assembly and Fur Lining Bookling the Coure of the time in the seases of the top Tightening the knot of the outer parts of the top Assembly. The threads Turning fur on a pulling edge The time graves of the time in the seases of the time threads Turning the layers of the time in the sease of the sea	+	1	+	*	*	*	+	*	*	*	+	+	1	+	+	+	+	+	+	*	+	+
Experiment the broadest with backs along the book edge with attenting bettelp under the loss) High through the broadest with a stitching and gluing seam High through the broadest with a stitching seam High through the broadest with a stitching seam High through the broadest with a stitching seam High through the LVO High through the broadest with a stitching seam High through the broadest with a stitching seam High through the seam High through the broadest work and through the seam High through the broadest work and the course work High through the broadest work High through through the broadest work High through thro	+		+	*	*	*	+	*	×	*	+	+	1	+	+	+	+	+	+	*	+	+
Lightning the bottlegs with backs along the bottlegs with a stiching seam class of the bottlegs with backs along the bottlegs with a stiching seam class of the bottlegs with a stiching seam class of the bottlegs with a stiching seam class of the bottlegs of the tont class of the class of the far lining along the front edge of the bottlegs of the far lining along the came of the tont class of the far lining along the came of the class of the far lining along the came of the class of the far lining along the came of the class of the far lining along the came of the far lining the came of	+	*	+	*	*	*	+	*	*	*	+	+	*	+	+	+	+	+	+	*	+	*
Lightening the late broadegs with backs along the back egge with a stitching seam smoothing and gluing Tightening of the byoolegs with backs along the + + + + +	*	*	*	*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	+	*	*	*
Lightning the lap under the clasp +	*	*	*	*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	+	*	*	*
Cutting the flap trader the clasp Tightening of the bootlegs with backs along the hack edge with a stitching seam Seam smoothing and gluing Re-hemming of the upper edge of the bootleg Tapering of the fur lining along the front edge with a stitching seam Turning the seam Turning the seam Turning the tog and knot of details of the fur lining along the edge line. Drying Bonding the Outer Top Assembly and Fur Lining Assembly Tightening the knot of the outer parts of the top Bonding the Cutter Top Assembly and Pur Lining Assembly Tightening the knot of the outer parts of the top Bonding the cutter knot details of the fur lining parts along the edging line while trimming the ends of the Pulling securing and trimming the ends of the Trimming fur on a pulling edge Trimming the insole for assembly. Trimming the insole Glue the layers of the insole for assembly. Adjusting the sock to the vamp Adjusting the backs to the front and back inner Adjusting the backs to the front and back inner Sidesi	*	*	*	*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	+	*	*	*
Culting the lap under the clasp Tightaning of the bootlegs with backs along the back edge with a stitching seam Seam smoothing and gluing Re-hemming of the upper edge of the bootleg Tapering of the turning along the front edge Turning out the ZVO Glue the outer knot details of the fur lining along the edge line. Drying Bonding the Cuter Top Assembly and Fur Lining Tightening the knot of the outer parts of the top and the knot of the fur lining parts along the edge line. Drying Tightening the knot of the outer parts of the top and the knot of the fur lining parts along the edge line. Drying Tightening the knot of the outer parts of the top and the knot of the fur lining parts along the edge line while trimming the excess Pulling. securing and trimming the ends of the the threads Zipper opening Trimming fur on a pulling edge Trimming fur on a pulling edge Trimming the insole Trimming the insole Trimming the insole Trimming the sock to the vamp Adjusting the backs to the front shoulder * + + + + + + + + + + + + + + + + + +	*	*	*	*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	+	+	*	*
Cutting the Iap under the clasp Fightning of the bootlegs with backs along the back edge with a stitching seam swebbing Re-hemming of the upper edge of the bootleg Tapering of the fur lining along the front edge Tapering of the fur lining along the front edge Tapering of the fur lining along the front edge Tapering of the fur lining along the front edge Tapering of the fur lining along the front edge Tapering of the top and knot of details of the fur lining along the edge line. Drying Bonding the Outer Top Assembly and Fur Lining Tapering the knot of the outer parts of the top and knot of the fur lining parts along the edge line. Drying Trimming the knot of the fur lining parts along the edging line while trimming the excess Pulling, securing and trimming the excess Pulling, securing and trimming the excess Pulling, securing and trimming the excess Pulling of insole layers Trimming fur on a pulling edge Trimming the insole Trimming the insole Trimming the sock to the vamp Adjusting the sock to the vamp Adjusting the backs to the front and back timer ** ** ** ** ** ** Adjusting the backs to the front and back timer ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** ** *	*	*	*	*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	+	*	*	*
Cutting the Itap under the clasp lightning of the bootlegs with backs along the lightning and gluing lightning of the upper edge of the bootleg lightning seam lightning light lightning lang the front edge lightning l	*	*	*	*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	+	*	*	*
Lutting the flap under the clasp lightning Tightening of the bootlegs with backs along the back edge with a stitching seam Seam smoothing and gluing Re-hemming of the upper edge of the bootleg Re-hemming of the upper edge of the bootleg Tapering of the fur lining along the front edge with a stitching seam Smoothing the seam Turning out the ZVO Glue the outer knot details of the top and knot of details of the fur lining along the edge line. Drying Bonding the Outer Top Assembly and Fur Lining Assembly Tightening the knot of the outer parts of the top and the knot of the fur lining parts along the edging line while trimming the excess Pulling, securing and trimming the excess Pulling, securing and trimming the ends of the threads Zipper opening Trimming fur on a pulling edge Glue the layers of the insole for assembly. Trimming the insole Glue the layers of the vamp Arimming the insole Cleaning ZVO Quality control Adjusting the sock to the vamp Attaching the sock to the vamp Attaching the backs to the front shoulder Adjusting the backs to the front and back inner sides	+	*	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	*	*	*
lightning Tightening of the bootlegs with backs along the back edge with a stitching seam Seam smoothing and gluing Webbing Re-hemming of the upper edge of the bootleg Tapering of the fur lining along the front edge with a stitching seam Smoothing the seam Turning out the ZVO Glue the outer knot details of the fur lining along the edge line. Drying Bonding the Outer Top Assembly and Fur Lining Assembly Tightening the knot of the outer parts of the top and the knot of the fur lining parts along the edging line while trimming the excess Pulling, securing and trimming the ends of the threads Zipper opening Trimming fur on a pulling edge Glue the layers of the insole Cleaning ZVO Quality control Picking up blanks Adjusting the sock to the vamp Attaching the vamp to the front and back inner sides	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	*	*	*
	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	+	*	*	*
2	Cutting the flap under the clasp lightning	Tightening of the bootlegs with backs along the back edge with a stitching seam	Seam smoothing and gluing webbing	Re-hemming of the upper edge of the bootleg	Tapering of the fur lining along the front edge with a stitching seam	Smoothing the seam	Turning out the ZVO	Glue the outer knot details of the top and knot of details of the fur lining along the edge line. Drying	Bonding the Outer Top Assembly and Fur Lining Assembly	Tightening the knot of the outer parts of the top and the knot of the fur lining parts along the edging line while trimming the excess	Pulling, securing and trimming the ends of the threads	Zipper opening	Trimming fur on a pulling edge	Glue the layers of the insole for assembly. Drying	Bonding of insole layers	Trimming the insole	Cleaning ZVO	Quality control	Picking up blanks	Adjusting the sock to the vamp	Attaching the vamp to the front shoulder	Adjusting the backs to the front and back inner sides
a Lada La La La ladada La La La La La La La Lada la ladala da	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52



ISRA (India) = 6.317 S ISI (Dubai, UAE) = 1.582 F GIF (Australia) = 0.564 F JIF = 1.500 S

SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

_		-	_			_	_	_		_		-	¥				_	
+	+	+	+	+	*	*	+	+	+	*	*	*	*	*	*	+	#	+
+	+	+	+	+	*	*	+	+	+	*	*	*	*	*	*	+	+	+
*	+	+	+	+	*	*	+	+	+	*	*	*	*	*	*	+	+	*
*	*	*	*	*	*	*	+	*	*	+	+	+	+	+	*	*	*	*
*	*	*	*	*	*	*	+	*	*	*	*	+	*	*	*	*	*	*
*	*	*	*	水	*	*	+	*	*	+	+	+	+	+	*	*	*	*
*	*	*	*	*	+	+	-	*	*	*	*	*	*	*	+	+	*	*
*	*	*	*	*	+	*	*	*	*	*	*	*	*	*	+	+	*	*
*	*	*	*	*	+	*	*	*	*	*	*	*	*	*	+	+	*	*
*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
Tightening of the front tibia with the rear outer tibia	Glue the zipper tape and inner boot along the line of their connection. Drying	Gluing the edges of the inner ankle boots with a zipper	Tapering of the back edges of the ankle boots with a stitching seam	Bending of the upper edge of the ankle boots	Adjusting the back of the inner to the vamp	Adjusting the back to the ankle boots	Attaching the leather pocket to the leather lining	Adjusting staples on the inner and outer lining	Tucking of the lining at the back edge with a stitching seam	Fitting through the lifting straps onto the leather lining	Stitching through the lifting straps to the back	Tightening vamp with leather lining	Glue the assembly of the outer parts of the top and the assembly of the lining along the edge, through the lifting strap under the assembly.	Bonding of the outer outer parts of the upper assembly with the lining assembly while bonding through the lifting strap	Tapering the trailing edges of the outer parts of the top	Smoothing the seam and gluing the seam with adhesive tape	Lined zipper flap location	Tightening ankle boots with backs along the back edge with a stitching seam
53	54	55	56	57	58	59	09	61	62	63	64	65	99	19	89	69	70	71



	ISRA (India)	= 6.317	SIS (USA)	= 0.912	ICV (Poland)	= 6.630
Impact Factors	ISI (Dubai, UAE) = 1.582	РИНЦ (Russia	a) = 0.126	PIF (India)	= 1.940
Impact Factor:	GIF (Australia)	= 0.564	ESJI (KZ)	= 9.035	IBI (India)	= 4.260
	JIF	= 1.500	SJIF (Morocco	(a) = 7.184	OAJI (USA)	= 0.350

Model M12

Adjusting a one-sided side bartack on the inner oack	s on the inner	*	*	*	+	+	+	*	*	*	*	*	*
Folding the top edge of the knot outer parts of the top		*	*	*	+	+	+	*	*	*	*	*	*
of the a	Bending of the upper edge of the ankle boots	*	*	*	*	*	*	*	*	*	+	+	+
g the fro	Tucking of the lining along the front edge with a stitching seam	*	*	*	*	*	*	*	*	*	+	+	+
Adjusting the leather pocket on leather vamp lining		*	*	*	+	+	+	*	*	*	*	*	*
Tapering the leading edges leather lining		*	*	*	+	+	+	*	*	*	*	*	*
outer pa lining pa g the exc	Tightening the knot of the outer parts of the top and the knot of the leather lining parts along the edging line while trimming the excess material	¥	*	*	+	+	+	*	×	*	+	+	+
Stitching the edge of the workpiece with simultaneous trimming of the edges of th lining	Stitching the edge of the workpiece with simultaneous trimming of the edges of the leather lining	*	*	*	*	*	*	+	+	+	*	*	*
e in the t	Finishing of the workpiece in the toe-tuft part along the lingering edge	+	+	+	+	+	+	+	+	+	+	+	+

	Table 10 - Conso	solidated in	novative t	echnological	process tor	assembli	ing shoes to	r women's assoi	tment	shoe		
0	Name of operations	Model A1	Model B2	Model IN 3	Model G4	Model D5	Model E6	Model F7	Model Z8	Model I9	Model K10	Model L11
	2	3	4	5	9	7	8	6	10	11	12	13
	Receiving blanks	+	+	+	+	+	+	+	+	+	ŧ	+
~	Pads selection and cleaning	+	+	+	+	+	+	+	+	+	+	+
~	Attaching the insole knots	+	+	+	+	+	+	+	+	+	+	+
+	Spreading talcum powder	+	+	+	+	+	+	+	+	+	+	+
10	Insertion of backdrops made of thermoplastic materials	+	+	+	+	+	+	+	+	+	+	+
100	Pre-molding of the heel of the blanks	+	+	+	+	+	+	+	+	+	+	+
7	Putting on the shoe upper blank on the last and installing the heel part	+	+	+	+	+	+	+	+	+	+	+



No

ISRA (India) = 6.317 ISI (Dubai, UAE) = 1.582 GIF (Australia) = 0.564 JIF = 1.500 SIS (USA) = 0.912 РИНЦ (Russia) = 0.126 ESJI (KZ) = 9.035 SJIF (Morocco) = 7.184

	-		-		-				_	-									
+ +	-	+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
+ +		+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
+ +	-	+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
÷ *		F	+	+	+	4	+	+	+	+	+	+	+	+	+	+	+	+	+
*	-	+	+	+	+	+	+	+	+	+	+	+	+-	+	+	+	+	+	+
+ *	-	+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
+ +	- -	+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
+ +		+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
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+ +		+	+	+	+	+	+	+	*	+	+	*	+	*	*	*	*	*	+
Covering and tightening of the nosebeam part of the ZVO with hot melt glue with preliminary moistening of the nose-beam part and activation of the toe cap Tightening the gel part of the ZVO	cilling the get part of the 2 VO	Tightening the heel of the workpieces	Wet-heat treatment of shoes	Hot air smoothing of creases on shoes	Removing lingering tex	Removing staples from insoles	Trimming excess traction edge	Ruffling the pulling edge, removing dust	Forgiveness of the footprint	First glue on the lingering edge and low-running surface of the sole, drying	The second spreading of glue on the lingering edge and the slow surface of the sole, drying	Flushing the stagnant surface of the soles	Activation of adhesive films and gluing of soles	Pre-attaching heels	Attaching heels	Sanding the edge of the sole	Application of varnish on the edge of leather soles and heels. Drying	Attaching high heels from the inside	Cleaning the top and bottom of shoes
Covering an beam part or glue with p the nose-be the toe cap Tightening		Tigh	Wet	Hot ai shoes	Ren	Ren	Tri	Ruff.	For	Firs low dry	The ling of t	Flush soles	Act glui	Pre	Atte	San	Apj leat	Att	<u>ਹ</u>



ISRA (India) $= 6.3$	17 SIS (USA) = 0.912	ICV (Poland)	= 6.630
ISI (Dubai, UAE) = 1.5	82 РИНЦ (Russia) = 0.126	PIF (India)	= 1.940
GIF (Australia) = 0.5	64 ESJI (KZ) = 9.035	IBI (India)	= 4.260
$\mathbf{JIF} = 1.5$	$00 \qquad \mathbf{SJIF} \; (\mathbf{Morocco}) = 7.184$	OAJI (USA)	= 0.350

28	Removing shoes from the last	+	+	+	+	+	+	+	+	+	+	+	+
0.00.000	Smoothing out wrinkles on shoes	*	*	*	+	*	*	*	+	+	*	*	*
	Checking and cleaning nails inside shoes	+	+	+	+	+	+	+	+	+	+	+	+
31	Bonding heel pads and insoles	+	+	+	+	+	+	+	+	+	+	+	+
	Retouching the top of the shoe	+	+	+	+	+	+	+	+	+	+	+	+
	Finishing the upper of the shoe	+	+	+	+	+	+	+	+	+	+	+	+
	Fastening finished shoes	+	+	+	*	*	*	+	*	+	+	+	+
	Shoe packaging	+	+	+	+	+	+	+	+	+	+	+	+
	Delivery of shoes to the warehouse, paperwork	+	+	+	+	+	+	+	+	+	+	+	+



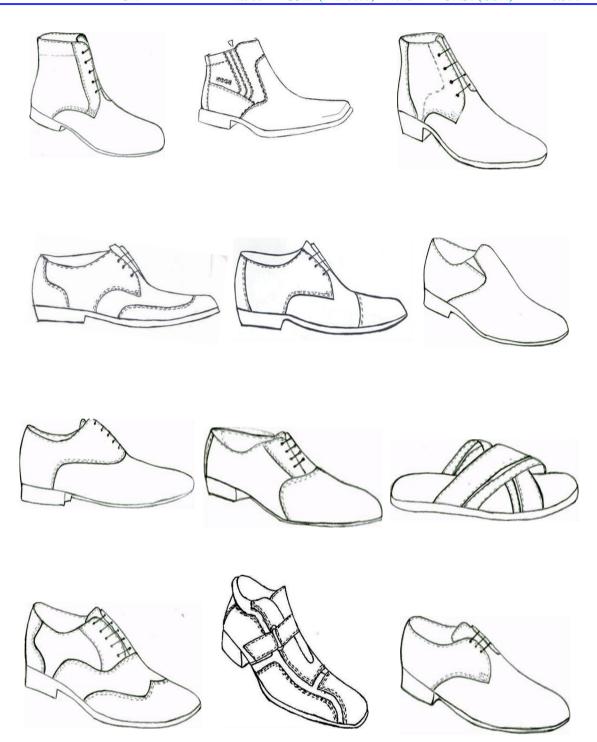


Figure 1 - Assortment of men's shoes

ISRA (India)

ISI (Dubai, UAE) = **1.582**

= 6.317

SIS (USA)

РИНЦ (Russia) = 0.126

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ICV (Poland)

PIF (India)

= 6.630

= 1.940

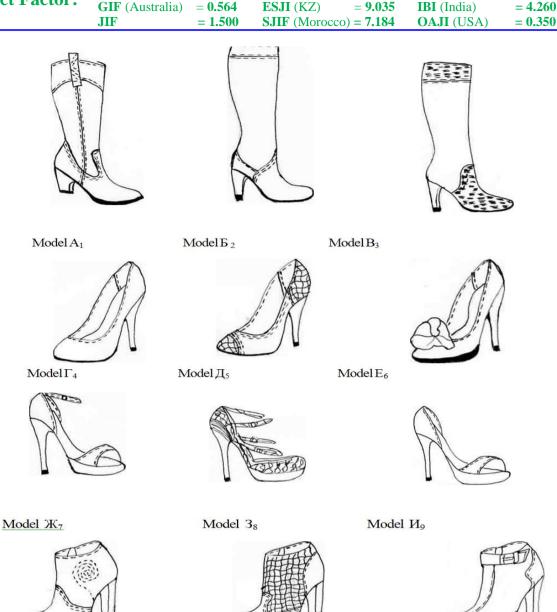


Figure 2 - Assortment of women's shoes

Model Л₁₁

To assess the effectiveness of the production activity of a shoe company, it is necessary to analyze the annual results of the operation of the enterprise for the production of men's and women's assortment of shoes.

Model K 10

These calculations indicate that with 100% of the sale of men's and women's shoes in the specified period of time, not only the costs of production and sales of products are covered, but also a profit of 3,697.4 thousand rubles remains. This testifies to the efficient operation of the enterprise, as well as to the correct marketing and assortment policy. The product profitability is 14.9%.

Table 10 presents the annual results of the shoe enterprise for the production of men's and women's shoe assortment.

Most often, the company sells shoes through stores with payment after the sale, concluding contracts with

the trade indicating the timing of the receipt of funds on the manufacturer's accounts.

Model M₁₂

In this case, if footwear is in demand and is fully sold, then the company receives money on time, which is also needed to pay wages, purchase working capital and other expenses to ensure the development of production.

During the year, the company produces 327,903 pairs of shoes. With 100% sales of these products, the enterprise will receive proceeds in the amount of 392,202.1 thousand rubles. However, this is not always the case.

For example, when selling autumn shoes in the amount of 80% of the production volume, the profit is reduced by 43.15% and amounts to only 1,178 thousand rubles, while the sale of footwear less than 47.4% of the production volume brings losses to the company. Due



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GIF (Australia)	= 0.564	ESJI (KZ)	= 9.035	IBI (India)	= 4.260
JIF	= 1.500	SJIF (Moroco	(co) = 7.184	OAJI (USA)	= 0.350

to the lack of funds, it is necessary to reduce the volume of production, to delay the payment of wages to workers, for which at present the managers of the enterprise can be held accountable, even criminal. If such a situation arises, it is necessary to attract borrowed funds to cover costs and organize the subsequent production of products, which at the moment is associated with certain difficulties: interest on a loan has been significantly increased (up to 18%), loan repayment terms have been reduced, etc., leading to an even greater increase production costs.

Shoe enterprises should focus on both external (consumer enterprises, competition, market conditions, etc.) and internal factors such as sales volume, profitability, coverage of basic costs, etc. However, it is impossible to take into account and foresee all situations that may arise when selling shoes, i.e. some shoe models are no longer in demand at a certain stage. In this case, another, usually not advertised side of marketing should appear: if the shoes, even without taking into account the requirements of the market, have already been produced, then they must be sold. For this purpose, in order to respond to the lower prices of competitors, it is necessary to reduce too large stocks, get rid of damaged, defective shoes, eliminate leftovers, attract a large number of consumers, stimulate shoe consumption, using discounts for this. There are about twenty types of discounts, but for shoes the most common are those types of discounts that are used at various levels of the enterprise, sales organizations, trade. In addition to using discounts, an enterprise can initiate a price reduction in case of underutilization of production capacities, a reduction in market share under the pressure of competition from competing enterprises, etc. In this case, the enterprise takes care of its costs, developing measures to reduce them by improving equipment and technology, introducing new types of materials into production, and constantly improving the quality of products. And all this requires large financial costs from enterprises, but, nevertheless, promotes competitiveness of certain types of leather goods and the enterprise as a whole. In addition, the greater the number of footwear products produced, the more production costs decrease, which leads to lower prices, and most importantly, creates such conditions for the functioning of the market that would not allow other competing enterprises to enter it and would cause a positive reaction from consumers.

The developed software allows the head of the enterprise not only to monitor the flow of funds on a daily basis, but, which is especially important, to predict the replacement of one model, the demand for which has dropped to a critical volume, when funds to cover production costs associated with this model are not

provided, and the transition to production of a new model, the demand for which, based on the analysis of the marketing service, seems to guarantee its viability and demand in a volume sufficient not only to cover the costs of its production, but also to obtain the necessary profit to ensure the production itself without provoking bankruptcy.

Of course, it is good when there is already the necessary supply of this very demand for a new model, namely:

— contracts with consumers for delivery with prepayment;

— a guarantee of branded stores that during the trial sale of the model aroused demand and there is a demand for them within the volumes at which a return of funds spent on their launch will be ensured and a profit will be ensured, which will ensure the enterprise obtain high TEP and stability in the formation and provision consumer of competitive and demanded products.

Thus, taking into account the software for tracking the movement of cash flow and the presence of a well-functioning marketing service that is able to provide the very process of regulating the demand for the company's products, it is always possible to make the right decision to replace one model with another, while creating the basis for obtaining high TEP and preventing the workforce from bankruptcy.

Of course, all this is just a desire, in reality, such work should be carried out daily. To do this, it is necessary to reconsider our attitude to the so-called break-even point, which, as it were, forms the conditions for the implementation of all our conclusions on the formation of competitive industries, providing labor collectives with high TEP and creating the basis for preventing their bankruptcy.

The traditional option of constructing a break-even point provides an understanding that the volume of output of a given model cannot be less than a certain number of pairs of a given model.

But with multi-assortment production, the number of pairs produced is formed by its demand, and if the demand does not ensure its implementation in the volume that provides the enterprise with a return of all funds spent on this model, in this case the manager must decide on the advisability of launching it into production. Therefore, we consider it justified when constructing a break-even point to indicate not only the volume of production of this model, which would guarantee the return of all costs for this model, but also how long it is necessary to replace it with a new one, so that the return of these funds is provided in full and with a profit.



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T~a~b~l~e~1~0~ - The annual results of the work of the shoe enterprise on production of men's and women's shoes

Indicators	Jan.	Feb	March	Apr	May	June	July	Aug	Sep	Oct	Nov	Dec
Sales volume, pairs	26114	26114	29661	29661	29661	28168	28168	28168	25358	25358	25358	26114
Sales proceeds, thousand rubles	45032.84	45032.84	31026.82	31026.82	31026.82	24033.9	24033.9	24033.9	30640.47	30640.47	30640.47	45032.84
Unit cost, rub.	1435.54	1435.54	890.2	890.2	890.2	726.7	726.7	726.7	1024.58	1024.58	1024.58	1435.54
Full cost price, thousand rubles	37487.78	37487.78	26405.04	26405.04	26405.04	20373.34	20373.34	20373.34	25747.78	25747.78	25747.78	37487.78
Profit from sales, thousand rubles	7545.06	7545.06	4621.78	4621.78	4621.78	3660.56	3660.56	3660.56	4892.69	4892.69	4892.69	7545.06
Income tax. thousand rubles	1509	1509	924.36	924.36	924.36	732,112	732,112	732,112	978.5	978.5	978.5	1509
Net profit, thousand rubles	9809	9809	3697.4	3697.4	3697.4	2928,448	2928,448	2928,448	3914.19	3914.19	3914.19	6036
Product profitability,%	16.8	16.8	14.9	14.9	14.9	15.2	15.2	15.2	15.9	15.9	15.9	16.8

Conclusion

An assortment policy has been developed for the formation of competitive men's, women's and children's shoes, taking into account factors affecting consumer demand: compliance with the main fashion trends, economic, social and climatic characteristics of the regions of the Southern Federal District and the North Caucasus Federal District, the production of which using modern innovative technological processes, as well as to meet demand elite consumer, using manual labor create the basis for meeting the demand for footwear for the buyer of these regions.

Innovative technological processes have been developed for the production of men's, women's and children's footwear using modern technological equipment with advanced nanotechnologies, which form the basis for reducing the cost of footwear and

providing it with an increase in competitiveness with the products of leading foreign companies, with the possibility of a wide-range production of footwear not only by type, but and by fastening methods, which guarantees its demand in full.

The layouts of technological equipment have been proposed, on the basis of which it is possible to form a technological process for the production of men's and children's, as well as women's shoes with an optimal capacity from the production area and the form of production organization.

Software has been developed for calculating cash flows from operating activities of shoe enterprises based on assessing the degree of implementation and dynamics of production and sales of products, determining the influence of factors on the change in the value of these indicators, identifying on-farm reserves



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and developing measures for their development, which are aimed at accelerating product turnover and reduction of losses, which guarantees enterprises to obtain stable TEP and prevents them from bankruptcy.

Software has been developed for the formation of the technological process of assembling shoes and determining the cost of producing an assortment of shoes. A computer simulation model has been implemented that describes the dynamics of the shoe assembly process. The proposed methodology and the software implemented on this basis can reduce the duration of the technological preparation of production and increase, due to the rationalization of the technological process, the specific consumer effect of shoes.

Comprehensive indicators of the effectiveness of technological innovative processes of manufacturing have been calculated. Taking into account the production program, promising options for technology and equipment have been formed, the most effective has been selected; the possibilities of streamlining the flow are revealed, allowing to exclude "bottlenecks", to minimize equipment downtime, which is one of the conditions for designing innovative technological processes. The reliability of calculations for assessing the efficiency technological processes by methods of target programming for various technological organizational solutions is confirmed by calculations of indicators of economic efficiency: cost, profit and profitability, etc.

The proposed technique allows to reduce the duration of technological preparation of production and reduce the time of expert work while maintaining the required depth and validity of engineering conclusions. The economic effect of the research is expressed in the intellectualization of the technologist's labor with a reduction in the time spent on developing the range of

manufactured shoes and assessing the effectiveness of technological processes in comparison with a typical economic calculation of the full cost of making shoes.

The analysis of the influence of the forms of organization of production and manufacturing technology on the cost of footwear is carried out on the example of the technological process of manufacturing children's, women's and men's shoes, taking into account the shift program. Theoretical dependencies have been obtained to assess the influence of the factor "organization of production" on individual calculation items as a whole and other technical and economic indicators in order to prevent enterprises from bankruptcy.

An effective solution has been developed to manage the competitiveness of shoe industry enterprises formed into a cluster, through the use of an innovative technological process for the entire product range of the shoe cluster, equipped with universal, highly efficient and multifunctional equipment.

Recommendations have been developed to ensure regulatory documentation for the formation of quality and confirmation of the conformity of footwear within the framework of the Customs Union, which will allow preparing certificates of conformity and declarations of conformity of the Customs Union for the entire assortment range of the shoe cluster.

Proposals for the creation of a testing laboratory within the cluster were substantiated, in which it is planned to test shoes to verify their compliance with the quality and safety indicators established in regulatory documents.

The role and main tasks of the metrological service have been formulated, and its organizational structure has been developed.

Measures have been developed for testing and assessing the quality and safety of footwear.

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