

ID	Operation	Time (seconds)	OSC	Machine
1	2 nd Seam of the bases to the faces	264	11	Sewing machine 4
2	Attachment of the double-adhesive to the lining and the interior	28	2	Workbench
3	Piercing for hand-made small links	80	5	Piercing machine
4	Seam of the bag on the gusset borders	116	11	Sewing machine 5
5	Seam of the bases to the faces by a numerical control machine	180	12	Numerical control sewing machine 1
6	Final seam of the zipper tapes to the head	220	11	Sewing machine 7
7	Seam of the face with two double stitches + Closing of the pouch	150	7	Sewing machine 2
8	Seam of the interior to the lining	135	7	Sewing machine 3
9	Seam of the interior to the lining	200	7	Sewing machine 3
10	Seam of the gusset head	60	7	Sewing machine 1
11	Assembly of the bottom and seam by a numerical control machine	60	12	Numerical control sewing machine 1
12	Seam of the zipper tapes to the head	150	7	Sewing machine 6
13	Seam tacking of the zipper tapes and of the hand-made small links	510	6	Workbench
14	Seam of the pleats	180	7	Sewing machine 2
15	Seam of the lining pouch	250	7	Sewing machine 3
16	Seam of the face head	18	7	Sewing machine 1
17	Packaging + Insertion of the slider in the outside zipper	400	13	Workbench
18	Assembly of the twin on the gusset	47	1	Workbench
19	Insertion of the slider in the inside zipper	20	2	Workbench
20	Gluing of the interior and the foam rubber	30	1	Workbench
21	Gluing of the flesh splits	70	1	Gluing machine
22	Gluing of the interior and the binding strip made of bonded leather	30	1	Workbench
23	Gluing of the gusset	15	1	Workbench
24	Gluing of the outside gusset	15	1	Gluing machine
25	Gluing of the zipper head	70	1	Gluing machine
26	Gluing of the interior borders	48	1	Workbench
27	Gluing to assembly the inner magnets	39	1	Workbench
28	Gluing of the lining face and the fringe	13	1	Workbench

29	Gluing of the whole face	65	1	Workbench
30	Gluing of the face borders	52	1	Workbench
31	Gluing of the face head	18	1	Workbench
32	Gluing of the pouch head to assembly the interior for the inside zipper	60	1	Workbench
33	Gluing of the pouch and the gusset	360	1	Workbench
34	Gluing of the bonded leather and the interior	18	1	Gluing machine
35	Gluing of the interior head	15	1	Workbench
36	Assembly of the bag + Piercing of the zipper tapes	900	10	Workbench
37	Assembly of the magnets	187	1	Workbench
38	Assembly of the zipper tapes to the face	348	10	Workbench
39	Assembly of the flesh splits to the face	278	8	Workbench
40	Assembly of the zipper tapes to the lining face	56	1	Workbench
41	Assembly of the lining to the leather inside gusset	50	1	Workbench
42	Assembly of the zipper to the interior	80	8	Workbench
43	Assembly of the inside zipper to the pouch	100	8	Workbench
44	Assembly of the small links + Preparation of the accessories for the small links	510	1	Workbench
45	Assembly of the base nails	51	1	Workbench
46	Assembly of the face to the leather lining with the magnets	90	8	Workbench
47	Assembly of the finished face to the interior	60	8	Workbench
48	Assembly of the bonded leather and the interior	60	1	Workbench
49	Folding of the bases for the faces	228	2	Workbench
50	Seam tacking and gluing of the bases and the faces	180	3	Workbench
51	Seam tacking of the magnets	100	4	Workbench
52	Seam tacking of the face with two double stitches	60	4	Workbench
53	Seam tacking of the gusset head	45	4	Workbench
54	Seam tacking of the face head	56	4	Workbench
55	Seam tacking of the bag on the gusset borders	130	4	Workbench
56	Binding of the interior	72	2	Workbench
57	Nailing down of the base nails	24	2	Hydraulic press
58	1 st Dyeing of the borders and the zipper tastes of the finished bag	139	14	Small dyeing machine
59	2 nd Dyeing of the gusset head	40	14	Big dyeing machine

60	2 nd Dyeing of the face head	70	14	Big dyeing machine
61	Glazing of the borders and the zipper tastes of the finished bag	165	14	Glazing machine
62	Final dyeing of the borders and the zipper tastes of the finished bag	75	14	Small dyeing machine
63	Seam of the inner magnets to the interior by a numerical control machine	30	12	Numerical control sewing machine 2
64	Seam of the magnets to the lining and the face by a numerical control machine	40	12	Numerical control sewing machine 2
65	2 nd Seam tacking of the bases to the faces	60	4	Workbench
66	Skiving of the gusset head	38	14	Skiving machine
67	1 st Dyeing of the gusset head	20	14	Big dyeing machine
68	Glazing of the gusset head	34	14	Glazing machine
69	Skiving of the face head	20	14	Skiving machine
70	1 st Dyeing of the face head	29	14	Big dyeing machine
71	Glazing of the face head	54	14	Glazing machine
72	Attachment of the film to the base nails	30	2	Hydraulic press
73	Gluing of the zipper tapes	18	1	Workbench
74	Dyeing of the interior for the lining	100	14	Big dyeing machine
75	2 nd Dyeing of the borders and the zipper tastes of the finished bag	68	14	Small dyeing machine
76	Scraping of the zipper tapes	10	2	Workbench
77	Unscrewing of the twin for the gusset	26	2	Workbench
78	Final packaging	70	13	Workbench
79	Seam tacking of the bottom	64	4	Workbench
80	Assembly of the buckle to the base and the gusset	20	1	Workbench
81	1 st Gluing of the base and the gusset	20	1	Workbench
82	2 nd Gluing of the base and the gusset	20	2	Workbench
83	Glazing of the base	22	9	Glazing machine
84	Attachment of the double-adhesive to the base and the gusset	20	2	Workbench
85	Assembly of the base to the gusset	20	1	Workbench
86	Seam of the base to the gusset	66	11	Sewing machine 4
87	Seam tacking of the base to the gusset	14	4	Workbench
88	Drawing of the shoulder-strap	20	7	Workbench
89	1 st Seam of the shoulder-strap	140	11	Sewing machine 1

90	Seam tacking of the shoulder-strap	20	4	Workbench
91	Assembly of the buckle and gluing of the shoulder-strap	50	1	Workbench
92	Folding of the shoulder-strap	20	2	Workbench
93	2 nd Seam of the shoulder-strap	102	11	Sewing machine 1
94	Cleaning and packaging of the small links and the shoulder-strap	600	4	Workbench
95	Dyeing of the base and the gusset	20	14	Big dyeing machine
96	Seam tacking of the inner magnets	187	13	Workbench
97	Assembly of the inner magnets	100	13	Workbench