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

SJIF (Morocco) = **7.184**

ICV (Poland) =6.630PIF (India) IBI (India) OAJI (USA)

= 1.940=4.260= 0.350

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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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Immost Esstern	ISI (Dubai, UAE	(1) = 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
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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 equipment and technology, widespread new 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



320,700 rbl

65 pairs per hour

900 ** 600 ** 0

Swee t (Cze ch Repu blic)

234500 rub

60 pair s per hou r

1050 * 550 * 1200

Schön (Germ any)

170 kg

S1031 C

60 pairs per hour

Sagit a (Ital y)

180 KG

RP 67T E

Bending with simultaneous

0.75 kW

dur 090 204

550 * 1270

application of hot melt glue, notching of curved sections and gluing tape

0.5 kW

186 kg

012 80 / P1

1.0 KW

135

gical	poinq	ST-B	ST-B	178,000 rb1	du1 002521
set of equipment for innovative technological process	performan ce	ST-B	ST-B	63 pairs per hour	150 pairs per hour
ovative s	power	ST- B	ST- B	0.7 kW	3.1 kW
for innor	noisnemib s	ST- B	ST- B	105 0 * 0 540 * 119	125 0 * 900 * 135
ipment	manufactu 191	ST-B	ST-B	Swee t (Cze ch ch Repu blic)	NEV E (Italy
of equ	Jugisw	ST- B	ST- B	130 Kg	180 Kg
3 set	vendor	ST- B	ST- B	011 46 / P5	PR 86 A
cal	price	ST- B	ST- B	Id1 000, 25 I	dur 021 E21
inologi	реггогиялсе	ST- B	ST. B	77 pair s/h	150 pair s per hou
ve tech	power	ST- B	ST- B	0.5 kW	0.8 kW
or innovati process	noiznəmib z	ST- B	ST- B	1050 ** 540 ** 1160	1800 * 130 * 950
set of equipment for innovative technological process	manufactu 191	ST-B	ST-B	Fortun a (Germ any)	Schön (Germ any)
of equip	tdgisw	ST- B	ST- B	140 KG	180 Kg
2 set o	vendor	ST-B	ST-B	3SE- RZ	C 1100V
cal	price	ST- B	ST- B	du1 041 712	OR 185640
1 set of equipment for innovative technological process	performan ce	ST-B	ST-B	75 pairs per hour	150 pairs per hour
ative te	bower	ST- B	ST- B	1.2 kW	2.1 kW
for innov process	noisnəmib s	ST- B	ST- B	1050 * 550 * 1030	1430 * 780 * 950
ipment f	manufactu rer	ST- B	ST- B	Com	Saba 1 (Ital y)
t of equ	tdgisw	ST- B	ST- B	135 kg	180 Kg
1 se	vendor	ST- B	ST- B	SS 20	A 200 0
the name of the operation		Receiving and checking the cut	Cutting into production	Lowering the edges of the outer baby top and lining	Duplication of upper details with interlining



Id1 00497	ST-B B wit h	ST-B with h wyt.	Id1 00497	Id1 21288	[d ₁ 00467
nā.	ST-B with vyt.	ST-B with vyt.	i.	i	i
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 * \$500 850
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	ST- B wit h vyt	130 Kg	130 Kg	130 Kg
Pfaf f 591 - 726 cl	ST-B B wit h vyt.	ST-B Wit h vyt.	Pfaf f 591 - 726 cl	Typ ical GC 240 26	Pfaf f 591 - 726
dui 0902£[ST-B B wit h vyt.	ST-B B wit h vyt.	dur 0902£1	1d1 21282	dur 0902£1
40	ST-B B wit h vyt.	ST-B wit h vyt.	÷	i	i
0.27 kW	ST-B B wit h vyt.	ST- B wit h vyt.	0.27 kW	0.27 kW	0.27 kW
900 * \$ 850	ST-B B with	ST-B B with	900 * * 850 850	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 398 112	ST-B B wit h vyt.	ST-B B wit h vyt.	dui 398 i 11	qn1 0096L	dur 998 [[2
9	ST-B with vyt.	ST-B with vyt.	-1	i i	i
1.76 kW	ST-B B with	ST-B B with	1.76 kW	0.27 kW	1.76 kW
\$20 * 180	ST-B B with	ST-B B with	520 * 180	520 ** 180	520 * 180
Gran ucci (Ital y)	ST-B B with	ST-B B with	Gran ucci (Ital y)	"PF AFF " Ger m	Gran ucci (Ital y)
130 Kg	ST-B B with	ST-B 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



Id1 0008 I	ST-B B wit h vyt.	ST-B B wit h vyt.	191 0046L	Id1 00497	Id1 00497
500 pairs / hour	ST-B with vyt.	ST-B with vyt.	ř.		ji)
0.17 5 kW	ST-B B with	ST-B B with	0.27	0.27	0.27
900 * \$10 * 138	ST-B B with	ST- B with	900 ** 850	900 * \$ 850	900 ** 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 wit h vyt	130 Kg	130 Kg	130 Kg
012 76 / P12	ST-B B wit h vyt.	ST-B B wit h vyt.	Pfaf f 591 - 726 ol	Pfaf f 591 - 726 cl	Pfaf f 591 - 726 cl
Id1 0008 I	ST-B B wit h vyt.	ST-B B wit h vyt.	dur 0902£I	dui 0902£[dur 0902£I
500 pair s/ hou r	ST-B B wit h vyt.	ST-B B wit h vyt.	i.		1
0.17 5 kW	ST-B B wit h vyt.	ST-B B wit h vyt.	0.27 kW	0.27 kW	0.27 kW
900 * 510 * 1380	ST-B With vyt.	ST- B with	900 ** 850	900 * 500 * 850	900 * 500 * 850
"Swee t" Czech Repub lic	ST-B with vyt.	ST-B with vyt.	Durko pp Adler	Durko pp Adler	Durko pp Adler
135 kg	ST- B with	ST- 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 B wit h vyt.	ST-B B wit h vyt.	dur 962112	du1 992 I I S	dur 962112
è	ST-B with vyt.	ST-B with vyt.	j.,	•	6
17	ST- B with	ST-B B with	1.76 kW	1.76 kW	1.76 kW
800 * 1200 * 1740	ST- B with vyt.	ST-B B with	520 ** 180	520 ** 180	520 ** 180
Sare ma (Ital y)	ST- B with vyt.	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 vyt.	130 Kg	130 Kg	130 Kg
DE LT A 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



190,000 rubles	180 00 rbl	123 500 rub	ST-B B wit h vyt.	səldur 000,091
	500 pairs / hour	150 pairs per hour	ST-B with vyt.	4
0.27	0.17 5 kW	3.1 kW	ST- B with vyt.	0.27
900 * * 850	900 * 510 * 138	125 0 * 900 * 135	ST-B B with	900 * * 850 850
Colli (Italy	"Swe et" Czec h Repu	NEV E (Italy	ST-B with vyt.	Colli (Ttaly
120 kg	135 kg	180 Kg	ST-BB with h	kg kg
GP 2	012 76/ P12	PR 86	ST-B B wit b	GP 2
190,000 tubles	180 00 rbl	123 150 rub	ST-B B wit h vyt.	190,000 rubles
A.	500 pair s/ hou r	150 pair s per hou	ST- B wit h	K.
0.27	0.17 5 kW	0.8 kW	ST-B B wit h vyt.	0.27
900 * \$ \$00 850	900 * 510 * 1380	1800 ** 130 **	ST-B B with	900 * * 850 850
Colli (Italy)	"Swee t" Czech Repub Iic	Schön (Germ any)	ST-B with vyt.	Colli (Italy)
120 kg	135 kg	180 Kg	ST- B with	120 kg
GP 2	01276 /P12	C 1100V	ST-B with vyt.	GP 2
səldur 000,001	RU B 310 80	RU R 185 640	ST-B B wit h vyt.	190,000 rubles
1		150 pairs per hour	ST-B with vyt.	,
0.27 kW	1.7	2.1 kW	ST- B with	0.27 kW
900 * \$ 850	800 * 1200 * 1740	1430 ** 780 **	ST-B with	900 ** 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	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 second line



Im	pact	Facto	r:

ISRA (India)	= 6.317
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SJIF (Morocco	(5) = 7.184

ICV (Poland)	= 6.630
PIF (India)	= 1.940
IBI (India)	=4.260
OAJI (USA)	= 0.350

Id1 000,42	ST-B	ST- B	
120 pairs per hour	ST-B	ST-B	
1.0 kW	ST- B	ST- B	
110 0 * 900 * 140	ST- B	ST- B	
"NE VE" Italy	ST-B	ST-B	312
70 Kg	ST-B	ST. B	RUB 1,163,312
SP7 5A R	ST- B	ST-B	RUB
1d1 000,42	ST-B	ST. B	
150 pair s per hou	ST- B	ST- B	
2.2 kW	ST-B	ST- B	
520 ** 1100 ** 1370	ST- B	ST-B	
Leibro ck (Germ any)	ST-B	ST-B	
N Rg	ST- B	ST-B	35,156
KAR 01	ST-B	ST-B	RUB 1,035,156
[d1 000,42	ST- B	ST- B	
120 pairs / hour	ST-B	ST-B	
1.9 kW	ST- B	ST- B	
760 ** 855 * 1480	ST- B	ST- B	
GEL	ST- B	ST- B	90
100 Kg	ST- B	ST- B	RUB 1,972,560
G1 2/ 1	ST-B	ST- B	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 technological process	performanc e	ST-B	ST-B
ative 1	ромег	ST -B	ST -B
or innov process	dimensions	ST- B	ST- B
pment f	manufactur er	ST-B	ST-B
of equi	thgisw	ST- B	ST- B
3 sel	vendor code	ST-B	ST-B
cal	price	ST- B	ST- B
nnologi	performance	ST- B	ST- B
tive tecl	bower	ST- B	ST- B
or innova process	anoianamib	ST- B	ST-B
2 set of equipment for innovative technological process	manufactur er	ST-B	ST-B
of equi	Meight	ST- B	ST- B
2 set	vendor code	ST-B	ST-B
cal	price	ST- B	ST- B
chnological	berformanc e	ST-B	ST-B
set of equipment for innovative technor process	ромет	ST- B	ST- B
for inno process	anoianamib	ST- B	ST- B
upment	manufactur er	ST-B	ST-B
t of equ	Meight	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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rubles KUB 170,000 280,000 **SL-B** KUB 210,000 KUB 250,000 ST-B 250 pairs/ h 150 pairs per hour 150 pairs per hour 120 pairs per hour ¥ k 12 ST 0.4 W W 620 * 550 * 123 800 ** 900 180 \$ \$ 745 170 0 ST-B \$10 * 700 * 172 Stem a (Italy) "Swe et"
Czec
h
Repu
blic Swee t (Cze ch Repu blic) "SEL MA K" Italy ST. B 100 Kg 650 kg 690 kg 120 Kg 0405 4 / P1 U 17 BFV 0201 5 / P5 E 505 KUB 150,000 230,700 rbI KUB 250,000 KUB 250,000 SI-B 250 pair s/h ST-B 135 pair s per hou 800 s s per per hou 150 pair s s per per pour lou ST. B 12 kWt 2,5 kW 0.4 kW 0.5 kW \$00 \$00 1900 645 * 2485 * 1700 * 26 600 * 745 * 1700 ST-B "BES SER" Italy ST-B ST-B Kg 110 630 kg 120 Kg 20 630 kg 1005/ 2 10/11 /C URP /2 0201 5/ P5 231,000 rbl **BUB 250,000** KUB 250,000 ST-B KUB 531,720 ST-B 120 per shift 250 pairs / h 150 pairs per hour 150 pairs per hour 0.24 kW 12 kWt ST-B 0.5 kW 2,5 kW 620 * 550 * 1230 600 * 745 * 1700 800 * 900 * 1800 950 * 600 * 1500 ST-B Stem a (Italy "BES SER" Italy ST-B Ceri m (Italy ST-B S 20 630 kg 670 kg 120 kg 10/1 C ST-B 74 EE S 020 15/ P5 12 Putting on the shoe upper blank on the last and installing the heel part Pre-fastening of the insoles to the last with metal staples Insertion of backdrops from materials, pre-molding of the heel of the blanks Humidification Spreading talcum powder thermoplastic of the ZVO



KOB 1'286'800	RUB 1,200,000	RUB 1,851,000	dur 048241	141 000,221
220 pairs per hour	180 pairs per hour	200 pairs/ h	180 pairs per hour	65- 113 pairs / hour
% × 8 × 3 × 3 × 3 × 3 × 3 × 3 × 3 × 3 × 3	7.7	5.5 kw	15. W W	8 8 .1
110 0 * 0 170 0 0	640 * 715 * 170 0	160 0 * 230 * 210	966 ** 307 0 * 146 5	580 ** 608 ** 145
Swee t (Cze ch Repu blic)	Swee t (Cze ch Repu blic)	"CE RIM " Italy	Swee t (Cze ch Repu Blic)	ELV 1 (Ttaly
125 0 kg	850 kg	0 kg	113 0 kg	%g kg
K78 SZ	0221 2/ P1	PIC K24 SZ	1800 42 / P2	SR1 006
KUB 1,577,800	KUB 1,400,000	RUB 1,750,000	122840 rub	du1 04742 [
160 s s hou r	250 pair s per hou	250 pair s/h	250 pair s s per hou r	600 pair s
4.0 kW	3.25 kW	3.25 kW	13.0 kW	0.9
1700 * 1200 1750	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
SZZH-	640 TT	640 TM	333E	H.
KUB 1758120	KUB 1,200,000	KUB 1,851,000	142840 rub	KUB 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	S.Sk ₩	27.9 kW	2.0 kW
173 * * 114 184	1000 * 1230 * 2055	1600 * 230 * 2100	3050 ** 1000 **	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	80 Kg
738 TIK	K20 1T	PIC K24 SZ	MV 570 0	RTO 7
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-can	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



ST-B	[d1 000,£72	10000001	dur 0009721	dur 000721	du:100000£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 K W	1.9 K	2,5 K W	2,5 k	2.0 k W
ST- B	990 * 151 0 * 151	760 ** 855 ** 148	650 ** 500 ** 125 0	650 * 500 * 125 0	600 * 650 * 138
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	120,000,021	J27900 rub	dui 009721	130000rub
ST- B	150 pair s per hou	150 pair s per hou	150 pair s per hou	150 pair s per hou	250 pair s per hou
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 -G	D510	0206 8 / P4	0206 8 / P4	133
ST- B	dur 004824	J000001	dur 009721	dur 009721	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 **	760 ** 855 ** 11480	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



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RUB 1,270,000	dur 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
W W W	2.0 K W	1.0 K W	1.1 W	4.0.0 W W
760 ** 855 ** 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)
Kg Kg	500 Kg	70 Kg	120 kg	135 kg
755 PC	TR 22	SP75 AR	LP 1	0422 2 / P1
RUB 1,270,000	Id1 000,891	847 90 rub	186 ,00 0 1rbl	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)	IRON 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 O 1	ASL-1	123L HE
12,700,000 rubles	RUB 504,000	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).	GEL	Omsa (Italy	GRA NUC CI (Italy
450 Kg	300 Kg	100 Kg	205 kg	140 kg
755 PC	TRI 9	G12 /1	7 TO	08S An
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	141 000,42	du1 04286	KUB 35,950	ST-B	ST- UO
attach ment PES- R	ST-B	120 pairs per hour	150 pairs / hour	1200 pairs / 8 8 hours	ST-B	ST- UO
att ac hm ent PE S-	ST -B	1.0 W	2.0 K	5.2	ST -B	ST .
attac hme nt PES -R	ST- B	110 0 * 0 8 900 140	185 0 * 0 950 * 100	70 * 800 * 1180	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	du1 09748	du1 04286	KUB 40 320	ST- B	ST- UO
atta ch me nt PE S-R	ST-B	150 pair s per per pour r	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	% Kg	155 kg	п п	ST. B	ST- UO
attac hmen t PES- R	ST-B	KAR 01	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 hme 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 **	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 nnt 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



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Im	pact	Fact	or:

ISRA (India)	= 6.317	SIS (USA)	= 0.912	ICV (Poland)	= 6.630
ISI (Dubai, UAI	E) = 1.582	РИНЦ (Russ	ia) = 0.126	PIF (India)	= 1.940
GIF (Australia)	= 0.564	ESJI (KZ)	= 9.035	IBI (India)	=4.260
JIF	= 1.500	SJIF (Moroco	(co) = 7.184	OAJI (USA)	= 0.350

Delivery of	- Z	Z d	ST- ST- ST-B ST- B B B	SI-	- ST-	12	SI-B B B	SI-B SI-		SI-B	ST-	ST-	- Z	SI-	SI- SI- SI-B SI-B SI-B B	ST-B ST-		STS	ST-B ST-B	SI-B
warehouse,	4	۹	5	4	i i		4		۹			1)	a				7		
The amount of			RU	3UB 10,453,280	3,280					RUB	RUB 8,906,320	0.				RUB	RUB 9,110,930	330		

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

ical	price	22	ST- B	ST- B	1d ₁ 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
rative te	bower	20	ST- B	ST- B	0.7 kW	0.5 kW
or innov process	qimensions	61	ST- B	ST- B	105 0 * 540 * 119	900 ** 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	weight	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	poinq	15	ST- B	ST- B	15600 161	234500 rub
chnolo	performance	14	ST- B	ST- B	77 pair s/ h	60 pair s per hou r
ative te	bower	13	ST-B	ST-B	0.5 kW	1.0 kW
or innov	dimensions	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	11	ST-B	ST-B	Fortu na (Ger many)	Schön (Ger many)
of equi	Meight	10	ST- B	ST- B	140 KG	170 kg
2 set	vendor code	6	ST-B	ST-B	3SE-RZ	S103
cal	price	8	ST- B	ST- B	Id1 0002 I	dur 090 204
chnological	регГогтапс е	<i>L</i>	ST-B	ST-B	75 pairs per hour	60 pairs per hour
ative te	bower	9	ST- B	ST- B	1.2 kW	0.75 kW
or innov process	dimensions	5	ST- B	ST- B	105 0 * 550 * 103	110 0 * 550 * 127 0
1 set of equipment for innovative tec process	manufactur er	4	ST- B	ST- B	Com	Sagi ta (Ital y)
of equip	weight	3	ST- B	ST- B	135 kg	180 KG
1 set	vendor code	2	ST-B	ST-B	SS 20	RP67
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



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dun 002£21	ST-B Wit h	qni 0096L	dur 00087	dur 00087	dur 000867
150 pairs per hour	ST-B with vyt.				11
3.1 kW	ST-Bwith	0.27 kW	0.27 kW	0.27 kW	0.27 kW
125 0 * 900 * 135 0	ST-B with	520 * 180	\$20 ** 180	520 ** 180	\$20 * 180
NEV E (Ital y)	ST-B with vyt.	"PF AFF " Ger m	"PF AFF " Ger man	AFF " Ger man	AFF Ger man
180 Kg	ST-B B with	130 Kg	130 Kg	130 Kg	130 Kg
PR 86 A	ST-Bwith with	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl
dui 021 £21	ST-Bwith with	1d1 21282	Id1 21288	1d1 21282	Id1 21282
150 pair s per hou	ST-B B wit h	ī	ı	i,	i
0.8 kW	ST- B wit h	0.2 7 kW	0.2 7 kW	0.2 7 kW	0.2 7 kW
180 0 ** 130 **	ST-Bwith vyt.	900 * 500 * 850	900 * 850 850	900 * \$50 850	900 * * 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 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	Id1 21282	Id1 21282	Id1 21282
150 pairs per hour	ST-B with vyt.	- (1)		6	d.
2.1 kW	ST- B with	0.27 kW	0.27 kW	0.27 kW	0.27 kW
143 0 * 780 * 950	ST- B with vyt.	900 * 500 * 850	900 * \$ 850	900 * \$00 850	900 * 850 850
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	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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qn1 0096L	ST- B wit h	qn1 0096L	ST- B	[d1 00497	Id1 00497	ST-B wit h
r	ST-B with vyt.	-i	ST-B	i	ī	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 * \$50 850	ST-B with
"PF AFF " Ger man	ST- B with vyt.	AFF " Ger man	ST- B	Pfaff (Ger man y)	Pfaff (Ger man y)	ST-B with
130 Kg	ST-B B with	130 Kg	ST- B	130 Kg	130 Kg	ST-B B with
Pfaf f 574- 900 cl	ST-B with	Pfaf f 574- 900 cl	ST- B	Pfaf f 591- 900 cl	Pfaf f 591- 900 cl	ST-B with
1d1 21282	ST-B with	1d1 21282	ST- B	dui 0902EI	132090 rub	ST-B with
Tr.	ST- B wit h	á	ST- B	1	1	ST-B wit h vyt
0.2 7 kW	ST-B 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 * \$ \$ 850	ST- B	900 * 850	\$00 * * \$00 850	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 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
Id1 21282	ST- B wit h	[d ₁ 21282	ST- B	dur 39č112	dur 992112	ST- B wit h
ī	ST-B with vyt.	1	ST-B	1	1	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 * \$ 850	ST- B with vyt.	900 * \$ 850	ST- B	\$20 ** 1180	\$20 * 180	ST-B with
Typi cal (Chi na)	ST- B with vyt.	Typi cal (Chi na)	ST- B	Gra nucc i (Ital y)	Gra nucc i (Ital y)	ST-B with
130 Kg	ST- B with vyt.	130 Kg	ST- B	130 Kg	130 Kg	ST-B 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



	ISKA (India)	= 0.31/	515 (USA)
Impact Factors	ISI (Dubai, UAE	(2) = 1.582	РИНЦ (Rt
Impact Factor:	GIF (Australia)	= 0.564	ESJI (KZ)
	JIF	= 1.500	SJIF (Mor

 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

Id1 000,eI	Id1 000,42	ST- B	ST-B	
() j	120 pairs per hour	ST-B	ST-B	
0.27	1.0 kW	ST- B	ST- B	
900 * \$ \$00 850	110 0 ** 900 ** 0	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, 61	Id1 000,42	ST- B	ST- B	
i	150 pair s per hou r	ST- B	ST- B	
7.7	2.2 kW	ST- B	ST- B	
\$000 * 850	\$20 ** 110 0 ** 0 *	ST-B	ST- B	
Colli (Italy)	Leibr ock (Ger many)	ST-B	ST-B	
120 kg	88 Rg	ST- B	ST- B	qnu 2
GP 2	KAR O 1	ST-B	ST-B	636552 rub
Id1 000, QI	[d1 000,42	ST- B	ST- B	
- i	120 pairs / hour	ST-B	ST-B	
0.27 kW	1.9 kW	ST- B	ST- B	
900 * \$50 850	760 * 855 * 148 0	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	77	ST- B
	performance	21	ST-B
pment	ромет	20	ST. B
3 type of equipment	dimensions	19	ST- B
3 type	manufacturer	18	ST- B
	Meight	17	ST- B
	vendor code	16	ST- B
	price	15	ST- B
	performance	14	ST-B
ment	power	13	ST-B
f equip	anoianamib	12	ST- B
2 type of equipment	manufacturer	11	ST-B
	weight	10	ST- B
	vendor code	6	ST-B
	price	8	ST- B
	реггогтапсе	L	ST-B
ment	power	9	ST- B
ype of equip	anoianamib	5	ST- B
1 type	manufacturer	7	ST- B
	weight	3	ST- B
	vendor code	2	ST-B
the name of the		1	Receiving and checking the cut



ST- B	Id1 0087 I	320,700 rbl	dur 002521	ST-B Wit h	dur 000997	qn1 0096L
ST-B	63 pairs per hour	65 pairs per hour	150 pairs per hour	ST-B with vyt.	i.	÷
ST- B	0.7 kW	0.5 kW	3.1 kW	ST-B B with	0.27 kW	0.27 kW
ST- B	105 0 * 540 * 119	900 ** 600 128	125 0 * 900 * 135	ST-B B with	\$20 ** 180	520 * 180
ST- B	Swe et (Cze ch Rep ublic)	Swe et (Cze ch Rep ublic)	NEV E (Ital y)	ST-B with	"PF AFF " Ger m	"PF AFF " Ger man
ST- B	130 Kg	186 kg	180 Kg	ST- B with vyt.	130 Kg	130 Kg
ST- B	011 46/ P5	012 80 / P1	PR 86 A	ST-B B with	Pfaf f 574- 900 cl	Pfaf f 574- 900 cl
ST- B	Id1 0002 I	dur 002452	dur 021 £21	ST-B B with	Id1 21282	1d1 21282
ST- B	77 pair s/ h	60 pair s per hou r	150 pair s per hou r	ST-B wit h	Ť	i
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 0	105 0 * 550 * 120 0	180 0 * 130 * 950	ST-B with	900 * \$00 850	900 * \$500 850
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-Bwit	130 Kg	130 Kg
ST-B	3SE-RZ	\$103 1C	C 1100	ST-B with vyt.	Typi cal GC2 4026	Typi cal GC2 4026
ST- B	Id1 0002 I	dur 090 204	KUR 185640	ST- B wit h	1d1 21282	1d1 21282
ST-B	75 pairs per hour	60 pairs per hour	150 pairs per hour	ST-B with vyt.	- i	i
ST- B	1.2 kW	0.75 kW	2.1 kW	ST- B with	0.27 kW	0.27 kW
ST- B	1050 * 550 * 1030	1100 * 550 * 1270	1430 * 780 * 950	ST- B with	900 * \$00 850	900 * \$00 850
ST- B	Com	Sagi ta (Ital y)	Saba 1 (Ital y)	ST-B B with	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	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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dur 000997	qn1 0096L	qn1 0096L	ST- B wit h	qn1 0096L	ST- B	Id1 00497
Ť		Ü	ST-B with vyt.	i i	ST-B	Ť.
0.27 kW	0.27 kW	0.27 kW	ST-B B with	0.27 kW	ST- B	0.27
\$20 * 180	\$20 * 180	\$20 * 180	ST-B B with	\$20 * 180	ST- B	900 * 500 * 850
"PF AFF " Ger man y	"PF AFF " Ger man	"PF AFF " Ger man y	ST-B B with	"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 with	Pfaf f 574- 900 cl	ST- B	Pfaf f 591- 900 cl
1d1 21282	1d1 21282	Id1 21282	ST- B with	Id1 21282	ST- B	dun 0902EI
i	i i	1	ST-B wit h		ST- B	*
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 * \$ \$00 850	900 * * 850	900 * \$ 850	ST-B With	900 * \$ \$00 850	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
Id1 21282	Id1 21282	1d1 21282	ST- B wit h	Id1 21282	ST- B	du1 398 [[S
i			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 * \$00 850	900 * 500 * 850	900 * * 850	ST- B with vyt.	900 * \$ 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	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



IOI DOLCI	r ii	101.000,61	101.000°FC	ST- B	ST- B	
191 00467		19,000 £b1				
i)	ST-B with vyt	*	120 pairs per hour	ST-B	ST-B	
0.27	ST-B with	0.27	1.0 kW	ST-B	ST- B	
900 * \$ 850	ST- B with	900 ** \$500 850	110 0 * 8 900 140	ST-B	ST-B	
Pfaff (Ger man y)	ST-B B with	Colli (Ital y)	"NE VE" Italy	ST- B	ST- B	
130 Kg	ST-Bwith	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
132090 rub	ST-B With	14,000,21	Id1 000,42	ST- B	ST- B	
į.	ST-B 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 * \$00 * 850	ST- B with	900 * * 850	\$20 * 110 0 * 0	ST- B	ST- B	
Durko pp Adler	ST-B with vyt	Colli (Italy)	Leibr ock (Ger many)	ST-B	ST-B	
130 Kg	ST-BB wit	120 kg	% % % % % % % % % % % % % % % % % % %	ST- B	ST- B	dE.
4180 i-511 E5 BM0 0002	ST-B with vyt	GP 2	KAR O 1	ST-B	ST-B	636552 rub
dur 992112	ST-B B wit h	Id ₁ 000,eI	1d1 000,42	ST- B	ST- B	
Ŷ.	ST-B with vyt	i.	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 B with	Coll i (Ital y)	GEL	ST- B	ST- B	
130 Kg	ST-B B with	120 kg	100 Kg	ST- B	ST- B	6 438
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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Table 7	
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Miled White Shings Shin	Name of operations	Model 1	Model 2	Model 3	Model 4	Model 5	Model 6	Model 7	Model 8	Model 9	Model 10	Model 11	Model 12
Explored and the books + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + + +	_	WILITEE 2.	WILIUSI 3	willel 4	Smile 5	Simide 9	2 June 7	years 8	years 9	years 10	autuliiii 11	12.	13
Figure that into the class the cut into the class that class the cut into the class that class the cut into the class that class the class that class the class that class the class that class the class to the class that class that class the class that class that class that class that class the class that	. Receiving and hecking the cut	+	#	+	+	+	+	+	+	+	+	+	+
the topparts of the topparts o	Starting the cut into roduction	+	+	+	+	+	+	+	+	+	+	+	+
ing the edgess	. Descending the dges of the top parts	+	+	+	+	+	+	+	+	+	+	+	+
+ * + + + * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * <td< td=""><td>. Bending the edges of the outer parts of ne top</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td></td<>	. Bending the edges of the outer parts of ne top	+	+	+	+	+	+	+	+	+	+	+	+
* + + + + * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * * <td< td=""><td>Duplication of pper details with terlining, vamp-</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>+</td><td>×</td><td>+</td><td>×</td><td>+</td><td>+</td><td>+</td></td<>	Duplication of pper details with terlining, vamp-	+	+	+	+	+	+	×	+	×	+	+	+
with glue	Tightening darts on	×	*	×	+	+	*	×	*	×	+	*	+
he backs	. Spreading with glue nd gluing the back of ne ankle	ж	*	+	+	+	*	ж	*	*	+	+	*
he ton the ton the under that the ton the under that and the of ankle and the maning of an and the maning of an and the ton that the the that the that the the that the that the that the the that the	Adjusting the backs f the ankle boots	*	*	+	+	+	*	*	*	*	+	+	*
nd gluing +	Adjusting the ather pocket on the ather lining under le ankle boots	+	*	+	+	+	+	ж	+	*	+	+	+
of ankle + * + + + + + * * * * * * * * * * * *	O. Glueing and gluing to boot knot and the oot lining knot along to edge	+	*	+	+	+	*	*	*	*	*	*	+
	1. Stitching of ankle oots with trimming of ather lining	18	*	+	+	+	*	*	ķ	*	*	Эх	+

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+	*	*	+	+	+	+	+	+	+	+	*
*	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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+	+	+	+	æ	÷	ж	*	÷	*
÷	*	*	*	+	+	ж	×	÷	*
+	+	+	+	*	*	*	*	*	*
+	*	*	+	ж	ж	*	*	*	*
+	+	+	+	9¢	ж	*	*	ж	*
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*	*	*		*	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 liming 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



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



	ISRA (India) = 6.317	SIS (USA) = 0.912	ICV (Poland)	= 6.630
Impact Factors	ISI (Dubai, UAE) = 1.58 ?	РИНЦ (Russia) = 0.126	PIF (India)	= 1.940
Impact Factor:	GIF (Australia) $= 0.564$	ESJI (KZ) = 9.035	IBI (India)	=4.260
	IIF = 1.500	SJIF (Morocco) = 7.184	OAJI (USA)	= 0.350

*	*	ж	*	*	ж	*	*	ж	*	*
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+	+	+	+	+	+	+	+	+	+	+
*	*	ж	ж	*	94	*	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



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ж	ж	*	*	*	*	*	*	+	+	+
58. Inversion, liming 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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Name of operations	Model 1	Model 2 winter	Model 3 winter	Model 4	Model 5	Model 6	Model 7	Model 8	Model 9	Model 10	Model 11	Model 12
1	2	3	4	5	9	7	8	6	10	11	12	13
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 nose-beam part of the ZVO with hot melt glue with preliminary moistening of the nose-beam part and activation of the toe cap	+	+	+	+	+	+	+	+	*	+	+-	+
11. Adhesive tightening of the heel part with simultaneous	+	+	+	+	+	+	+	+	*	+	+	+

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tightening of the heel part by tex	12.Wet-heat treatment 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 glueing of the tightening edge, drying	17. Second glueing of the tightening edge, drying	18 matching shoe soles	19. Treatment of low- running surfaces of soles with a solvent	20. First and second spreading glue on the slow surface of the soles, drying	21. Activation of adhesive films and gluing of soles	22. Cleaning the top and bottom of shoes	23. Removing shoes from the last	24. checking and cleaning the nails inside the shoes	25. Bonding of heels and insoles



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

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

Model Model A1 B2 3 4 + + + + + + + + + + + + + + + + + + +	Model M	2 4	Model N Model N + + + + + + + + + + + + + + + + + +		F7 + + + + + + + + + + + + + + + + + + +	Model Z8 Z8 10 + + + + + + + + + + + + + + + + + +	Model I9	Model K10	Model L11	Model M12
A1 B2 3 4 + + + + + + + + + + + + + + + + + + +						Z8 10 + + + +	I1 11	K10	L11	M12
3 + + + + + + + + + + + + + + + + + + +	ν + + + + *	0 + + + + +	r + + + + +	∞ + + + +	0 + + + +	10 + + +	11			
9 + + + + + + + + + + + + + + + + + + +	ν + + + + *	\(\omega\) + + + + + +	r + + + + + +	∞ + + + +	6 + + + +	0 + + +	11			
belt + + + + + + + + + + + + + + + + + + +	+++++*	+ + + + +	+ + + + +	+ + + +	+ + + +	+ + +		12	13	14
belt + + + + + + + + + + + + + + + + + + +	++++*	+ + + +	+ + + +	+ + +	+ + +	+ +	Ь	+	+	+
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+ +	• 11	*	*	*	*	*	*	*	*	*
+	+	+	+	+	+	+	+	+	+	+
Sewing decorative sutching on the shalt	*	*	*	*	*	*	*	*	*	*
Perforation of the upper part of the outer shaft + *	*	*	*	*	*	*	*	*	ж	*
Adjusting the backs on + + + ankle boot and bootleg rear internal double row stitching	*	*	*	*	*	*	*	*	*	*



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*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
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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
=	12	13	14	17	18	19	20	21	22	23	24	25	56	27	28	29	30
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+	+	+	+	+	+		+		+	+	+	+	+	+	+	+	+	+	+	*	*	*
Cutting the flap under the clasp lightning	Lightening 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
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*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*
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	99	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) = 1.58 ?	РИНЦ (Russia) = 0.126	PIF (India)	= 1.940
Impact Factor:	GIF (Australia) $= 0.564$	ESJI (KZ) = 9.035	IBI (India)	=4.260
	IIF = 1.500	SJIF (Morocco) = 7.184	OAJI (USA)	= 0.350

Model M12

Adjusting a one-sided side bartack on the inner oack	*	*	+	+	+	*	*	*	*	*	*
Folding the top edge of the knot * * * * * * * * * * * * * * * * * * *	*	*	+	+	+	*	*	*	*	*	*
Bending of the upper edge of the ankle boots *	*	*	*	*	*	*	*	*	+	+	+
Tucking of the lining along the front edge with a * stitching seam	*	*	*	*	*	*	*	*	+	+	+
Adjusting the leather pocket on * * * leather vamp lining	*	*	+	+	+	*	*	*	*	*	*
*	*	*	+	+	+	*	*	*	*	*	*
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 the leather lining	*	*	*	*	*	+	+	+	*	*	*
Finishing of the workpiece in the toe-tuft part + + along the lingering edge	+	+	+	+	+	+	+	+	+	+	+

	Table 10 - Con	isolidated in	inovative t	ecnnologica	process 101	assembli	ng snoes 10	or assembling snoes for women's assortment snoe	ssortment	snoe		
0	Name of operations	Model	Model	Model	Model	Model	Model	Model	Model	Model	Model	M
		A1	B2	N 3	G4	D2	E6	F7	Z8	I9	K10	Ll
	2	3	4	5	9	L	8	6	10	11	12	
_	Receiving blanks	+	***	+	+	+	+	+	+	+	+	
\alpha_1	Pads selection and cleaning	+	+	+	+	+	+	+	+	+	+	
~	Attaching the insole knots	+	+	+	+	+	+	+	+	+	+	
4	Spreading talcum powder	+	+	+	+	+	+	+	+	+	+	
10	Insertion of backdrops made of	+	+	+	+	+	+	+	+	+	+	
	thermoplastic materials											
,	Pre-molding of the heel of the blanks	+	+	+	+	+	+	+	+	+	+	
7	Putting on the shoe upper blank on the last and installing the heel part	+	+	+	+	+	+	+	+	+	+	



No

+	+	+	+	+	+	+	+	+	+	+	+	*	+	*	*	*	*	*	+
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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	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
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ISI (Dubai, UAE) = 1.582	РИНЦ (Russia) = 0.126	PIF (India)	= 1.940
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$\mathbf{JIF} \qquad = 1.500$	SJIF (Morocco) = 7.184	OAJI (USA)	= 0.350

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





Figure 1 - Assortment of men's shoes

ISRA (India) $= 6.3$	17 SIS (USA)	= 0.912	ICV (Poland)	= 6.630
ISI (Dubai, UAE) = 1.5	882 РИНЦ (Ru	ssia) = 0.126	PIF (India)	= 1.940
GIF (Australia) = 0.5	64 ESJI (KZ)	= 9.035	IBI (India)	= 4.260
$\mathbf{JIF} \qquad \qquad = 1.5$	SOO SJIF (More	(cco) = 7.184	OAJI (USA)	= 0.350



Figure 2 - Assortment of women's shoes

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.

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.

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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ISRA (India)	= 6.317	SIS (USA)	= 0.912	ICV (Poland)	= 6.630
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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 10 - 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 innovative technological of processes 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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ISI (Dubai, UAE) = 1.582	РИНЦ (Russ	ia) = 0.126	PIF (India)	= 1.940
GIF (Australia)	= 0.564	ESJI (KZ)	= 9.035	IBI (India)	=4.260
JIF	= 1.500	SJIF (Moroco	(co) = 7.184	OAJI (USA)	= 0.350

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