



# **Integrating Companies in a Sustainable Apprenticeship System**

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## **Intellectual Output 3A**

# **Learning-teaching activities - Pre-lasting -**

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## 1. Work-Based Pre-Lasting Training

### 1.1. What to prepare

In order to start the work-based training, there is a list of things to prepare:

- Toe puff, stiffener, lasts, insoles, stitched pieces.
- Back-part pre-moulding machine, forepart pre-moulding machine, workplace.



## 2. Activities

- Applying the toe puff. Prepare and attach a set of processed pieces.
- Applying the stiffener. Prepare and attach a set of processed pieces.
- Perform back-part pre-moulding operation. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of pre-moulded back-parts.

Material	Pressure(Atm)	Temperature(oC)	Time (sec)	Possible defects
Cow leather	12	150-160	5	<ul style="list-style-type: none"> <li>• improper fixing of the stiffener</li> <li>• creases and folds</li> </ul>
...	...	...	...	<ul style="list-style-type: none"> <li>• ...</li> </ul>

- Prepare and control the lasts (dimensional verification of the lasts using the controlling templates).
- Conditioning the uppers. Complete the table following the example bellow.

Material	Temperature(oC)	Activation time(sec)
Cow leather	100	15
....	...	...

- Applying the insole to the last.
- Perform forepart pre-moulding operation. Complete the table following the example bellow and identify possible defects. Prepare and attach a set of pre-moulded foreparts.

Material	Pressure(Atm)	Temperature(oC)	Time (sec)	Possible defects
Cow leather	6	150-160	5	<ul style="list-style-type: none"> <li>• the toe is not properly centred</li> </ul>
...	...	...	...	<ul style="list-style-type: none"> <li>• ...</li> </ul>