

# Shoe Maker Interview Questions And Answers Guide.



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# Shoe Maker Job Interview Preparation Guide.

### Question # 1

What is blow molding?

**Answer:-**

The blow molding process begins with melting down the plastic and forming it into a parison or in the case of injection and injection stretch blow moulding a preform. The parison is a tube-like piece of plastic with a hole in one end through which compressed air can pass.

The parison is then clamped into a mold and air is blown into it. The air pressure then pushes the plastic out to match the mold. Once the plastic has cooled and hardened the mold opens up and the part is ejected.

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### Question # 2

What is cement or Board Lasting?

**Answer:-**

A lasting process where the insole board (cardboard or Texon board) is inserted onto the last bottom and the lasting margin (excess) material of the upper is lasted/pulled) onto the board and cemented to the insole board. Shoes of this type are usually stiffer and heavier. A special machine is used pull the upper and cement in place.

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### Question # 3

Compression set or Compression resistance?

**Answer:-**

For foam products in shoe manufacture we like to know how long foam will last if we build it into a footbed or shoe midsole. Simply put the compression set is how much a foam will bounce back after being compressed. Compression set is measured in a Percentage. A foam that resists compression could have a score of 4%, a foam that is badly damaged by impact may have a score of 45%.

Poor quality EVA will have a high compression set value. High quality PU foam will last forever with a very low compression set.

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### Question # 4

What is cutting loss?

**Answer:-**

Cutting loss is the material left over once the shoe parts are cut from a material. Depending on the material type the cutting loss can be between 2% to 15%. The cutting loss also depends on the size and shape of the parts being cut. Mech will have a low cutting loss, leather may be higher. It's important to keep the cutting loss to a minimum as this loss will be added to the cost of the shoe. A skilled cutter will save the factory money!

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### Question # 5

Explain designers or Shoe Designers?

**Answer:-**

Someone has to draw the shoes. Depending on who you ask, this is the easiest part or the hardest. The designer has to draw what people want on their feet. Hmm..

To be a shoe designer, art school would be a great help. A degree in Industrial or Product design is a great place to start. But that said, if you can really draw like a bandit who needs higher education? The designers draw the shoes, then work with the developers to make the prototypes just right. Picking color trends and knowing what is cool are critical skills.

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### Question # 6

What is EVA or CM EVA foam?

**Answer:-**

Compression Molded EVA or Ethylene vinyl acetate. A foamed midsole material that offers good cushioning and compression set. Nike likes to call theirs "Phylon"



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but it is the same stuff whatever you call it. The most common foam for shoe midsoles. easy for for by cutting, molding, injecting. It's light and durable. EVA can be made in many grades depending on the compound. More or less filler, more or less vinyl acetate in the mix. can be made pillow soft or rock hard.

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### **Question # 7**

What is full Grain leather?

**Answer:-**

Full-grain leather refers to hides that have not been sanded, buffed, or snuffed (as opposed to top-grain or corrected leather) to remove imperfections (or natural marks) on the surface of the hide. The grain remains allowing the fiber strength and durability. The grain also has breathability, resulting in less moisture from prolonged contact. Rather than wearing out, it will develop a patina over time. High quality leather furniture and footwear are often made from full-grain leather.

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### **Question # 8**

What is heel Lift?

**Answer:-**

The heel lift of a shoe or shoe last is the dimension specified for the heel height above the ground. This is determined by the last if a shoe. A normal sport shoe will generally have a heel lift of 6 to 8mm above the ball of the foot. This is a standard ergonomic stance that will allow the shoe to have more cushioning under the heel. A casual shoe or sandal may have a lift of zero, then of course a high heel women's shoe last can have a heel lift of 4 inches or more!

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### **Question # 9**

What is lasting?

**Answer:-**

Lasting is the operation that stretches the shoe upper over the foot form or last. Almost all shoe are lasted in some way. With the last inside the upper the outsole can be bonded and pressed into place. Once the outsole is bonded the shoe can be De-lasted. There are several types of lasting operations. Slip lasting, board lasting, toe lasting, waist lasting, heel lasting, string lasting, California lasting and hand lasting.

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### **Question # 10**

What is MTO or Made to Order or Make to Order?

**Answer:-**

Made to order or MTO is a special production run of shoes. The MTO shoes can be for a specific shoe store or international distributor. Usually a special color or material treatment. The MTO product manager will work closely with sales managers, Product line managers, sales reps and Designers to create new products. MTO projects can be brought to market quickly as there is no selling or booking period required. Once the design is confirmed the order can be placed to the factory.

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### **Question # 11**

What is outsole Channel stitch?

**Answer:-**

The shoe outsole will have a small groove or two molded into the rubber sidewall. After the shoe is assembled a heavy duty stitching machine with a special bent arm is used to stitch a heavy thread through the rubber sole and the upper of the shoe. This channel stitch is often used on the toe tip of joggers, the side wall of skate shoe and the bottoms of boat shoes.

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### **Question # 12**

What are product Managers or Product Line Managers?

**Answer:-**

The Product Manager or "PM" is the person that sets designer and developer in motion. It's the PM's job to figure out what to make. The PM will tell the designer what kind of shoe to make. PM's responsibility is to work with the sales team and customers to find out what they need. The PM is also tasked with looking forward. What will people need next year? What color shoes will be trending? Experience in retail or sales is a big help. Designer and developers are often promoted to this position. A marketing degree will help.

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### **Question # 13**

What is mOQ?

**Answer:-**

Minimum order quantity Shoe factories and material makers offer have an MOQ. Based on dye lot size or machine operation. For example, a special mesh may require machine set up so the MOQ may be 500 meters. To dye a stock material may make the MOQ 50 meters.

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### **Question # 14**

What is letter of Credit LC term of payment?

**Answer:-**



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A letter of credit is a promise between businesses to pay. The buyers and sellers contract banks issue letters of credit as a way to ensure that sellers get paid as long as they do what they've agreed to do. The LC is common in international trade even though it's more expensive to transact than a T/T, as it guarantees that a payment will be made if certain conditions are met.

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### **Question # 15**

What is ISNR 20 (TSR 20)?

**Answer:-**

ISNR 20 (TSR 20) is general purpose rubber graded by precise technical standards and not by visual characteristics. Some standards may vary marginally based on the origin. Technically Specified Rubber (TSAR) is used for making tires, tubes, rubber mats, cushion gum stock, raincoat proofings, micro-cellular sheet for upholstery and packing, conveyor belts, footwear and various other rubber products.

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### **Question # 16**

What is grading or Size Grade?

**Answer:-**

Making different shoe sizes. The sample size or development size is usually Men's 9 and Women's 7. Once the sample is confirmed, extreme sizes are made size 5 and size 12. Then all the sizes are graded. The word is a noun and a verb. Can I see the size grade? or, the pattern master is grading the pattern. The pattern grade is now done by computer then checked by the pattern master.

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### **Question # 17**

What is FOB Free On Board Purchase Term?

**Answer:-**

When you negotiate a shoe price you need be clear on where the finished shoe is to be delivered. In most cases the shoe price will be stated as FOB (the nearest freight harbor). In south China it would be FOB Yantian. So the seller is responsible for the inland trucking the goods to the freight terminal. (see Ex-Works Price)

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### **Question # 18**

Explain developers or Shoe Developers?

**Answer:-**

Not a shoe designer but critical to getting the shoes made. It's the footwear developers job is to take a nice drawing and make it into a real shoe you can wear on your feet. The shoe developer is the guy that writes the technical specifications, checks the blue prints, and communicates with the shoe factory.

The shoe developers job is to get the shoe made and keep the free thinking designers from making a beautiful shoe that is cruel to wear. Footwear developers are the shoe prototype engineers and schedule keepers. To be a shoe developer you may start as a designer, an intern or assistant. Be ready to travel!

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### **Question # 19**

Tell me what is eyelet?

**Answer:-**

The most popular shoe-tying is a simple crisscross, each end of the shoelace pulled through the next eyelet on the opposite flap. fastener consisting of a metal ring for lining a small hole to permit the attachment of cords or lines

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### **Question # 20**

Explain shoe parts Cutting Dies?

**Answer:-**

Used to cut out shoe parts. These steel cutting dies look just like cookie cutters. Each die is coated with rust proof paint and marked with the shoe size and model number. Making a shoe requires hundreds of dies. One die for each part, for every size of a shoe.

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### **Question # 21**

What is corrected-grain leather?

**Answer:-**

Corrected-grain leather is any leather that has had an artificial grain applied to its surface. The hides used to create corrected leather do not meet the standards for use in creating vegetal-tanned or aniline leather. The imperfections are corrected or sanded off, and an artificial grain embossed into the surface and dressed with stain or dyes. Most corrected-grain leather is used to make pigmented leather as the solid pigment helps hide the corrections or imperfections. Corrected grain leathers can mainly be bought as two finish types semi-aniline and pigmented.

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### **Question # 22**

What is cold Cement shoe making process?

**Answer:-**



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Bonding process to attach the upper to the outsole that does not require the upper to be placed into an oven. The outsole unit made of rubber and EVA foam is completely cured. PU cement, Water massed of solvent based is used to attached the sole unit to the lasted upper. Cold cementing does require heating tunnels to dry the surface primer and cement. Typically the upper and outsole receive one layer of surface primer and two layers of shoe cement before they are fit together. Once the parts are fit together a hydraulic ram is used to press the parts, typically 3 operations from the top, sides them front to back.

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### **Question # 23**

What is shoe cement Bonding Margin?

#### **Answer:-**

The amount of space required to have a cement bond. If the rubber has only a 2mm bonding margin the outsole may peel off the outsole. A 12mm bonding margin would be better.

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### **Question # 24**

What is action Leather?

#### **Answer:-**

Suede cow leather that is covered with a thin coating of Polyurethane. The coating can be any color and can be embossed with a roller. The final product is generally a solid color leather looking product. This material is still classified as leather for import duty. Almost all white sneakers are made with action leather.

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### **Question # 25**

What is alcantara?

#### **Answer:-**

Microfiber Synthetic Leather. These high quality micro fiber suede materials can be expensive but they are great for use on shoes, gloves, linings and trim.

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### **Question # 26**

What is chamude?

#### **Answer:-**

Microfiber Synthetic Leather. These high quality micro fiber suede materials can be expensive but they are great for use on shoes, gloves, linings and trim.

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### **Question # 27**

What is cosmo?

#### **Answer:-**

The Brand name of a common non-woven upper lining and reinforcement material. Used in all types of sneakers.

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### **Question # 28**

What is clog?

#### **Answer:-**

She was trying to find a new pair of fashion clogs. footwear usually with wooden soles

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### **Question # 29**

What is foam?

#### **Answer:-**

The foam's properties allow the shoe to change with the wearer's foot as it shrinks and swells throughout the day. a lightweight material in cellular form; made by introducing gas bubbles during manufacture

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### **Question # 30**

What is die Cutting?

#### **Answer:-**

Must shoe parts are made by die cutting. The cutting die looks just like a big cookie cutter, but this cookie cutter has a sharpened steel edge. Each shoe part will require it's own cutting die.

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### **Question # 31**

What is eyestay?

#### **Answer:-**



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The part around the lace opening (throat of the shoe). Can feature webbings, eyelets, etc.

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### **Question # 32**

What is last gauge?

**Answer:-**

The pattern shape of the last bottom. This will usually be a paper card.

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### **Question # 33**

What is medial Side?

**Answer:-**

The medial side is the inside or arched side of the shoe. The outside is the lateral.

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### **Question # 34**

What is nBS?

**Answer:-**

NBS is a rating system for rubber wear. A typical rating would be 400, 800 or 1200 NBS

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### **Question # 35**

What is aglet?

**Answer:-**

The Shoe Lace Aglet is that little plastic or metal on the end of the shoe lace.

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### **Question # 36**

What is shoe Collar or Top Line?

**Answer:-**

The opening area of a shoe at the top.

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### **Question # 37**

What is foxing tape?

**Answer:-**

On vulcanized shoes the Foxing Tape is the rubber band that makes the side wall of the shoe sole.

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### **Question # 38**

What is lateral Side?

**Answer:-**

The lateral side is the out side or the non-arched side of the shoe. The inside outside is the shoe.

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### **Question # 39**

What is the Shoe Part Mudguard?

**Answer:-**

The Mudguard is the shoe pattern part along the forward part of the shoe along the edge of the outsole.

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### **Question # 40**

What is overlay?

**Answer:-**

An upper part which is over another part. The Nike Swoosh logo is what I would call an Overlay part.

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### **Question # 41**

What is PU or Poly-Urethane?

**Answer:-**



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Poly-Urethane is Synthetic (plastic) material with minute bubbles or cells and a skin like surface. Used for upper materials, and in a different form for midsoles or padding foam. PU (upper material)

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### **Question # 42**

What is NR?

**Answer:-**

Natural Rubber (NR) is produced from latex obtained from rubber trees in plantations. The most important forms in which NR is processed are the following Sheets, Crepes, Block Rubber and Preserved Latex Concentrates.

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### **Question # 43**

What is lasting Pressure?

**Answer:-**

The lasting pressure is amount of tension required to stretch the upper on the the last form. To much lasting pressure can damage, rip or wrinkle the upper. Too little lasting pressure will result is a soft ill formed, baggy upper. It's upper to the pattern master to get this right, it's a skill as different materials will require different patterns and amounts of lasting pressure to look right.

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### **Question # 44**

What is hi-Skin?

**Answer:-**

Microfiber Synthetic Leather. These high quality micro fiber suede materials can be expensive but they are great for use on shoes, gloves, linings and trim.

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### **Question # 45**

What is footbed?

**Answer:-**

Footbed or insole is the foam padded mesh that your foot stands on. May be removable or may be cemented in. High end shoes will be molded EVA of PU foam. Low end shoes will be die cut EVA. Also called Sockliner.

[Read More Answers.](#)

### **Question # 46**

What is durometer?

**Answer:-**

Durometer is the hardness of a material. You will need to specify the durometer of all the shoes rubber, foam and plastic parts. You will need a 2 different durometer testers. Asker "C" is the EVA standard. 25 "C" is very soft, 55 "C" is a standard midsole 85 "C" like wood. For rubber plastic you will need a Shore "A" tester. For a rubber outsole Shore "A" 55 is good for rubber. Above 60 your rubber will be stiff, heavy and slippery. The durometer scale was defined by Albert Ferdinand Shore, who developed a measurement device to measure Shore hardness in the 1920s.

Shore 20A = Rubber Band, Shore 40A = Pencil Eraser, Shore 60A = Car Tire Tread, Shore 80A = Leather Belt, Shore 100A = Shopping Cart Wheel

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### **Question # 47**

What is cutting Yield?

**Answer:-**

Sort of the reverse of the cutting loss but not exactly. A large shape cut from a small piece of material will be low yield. A small part cut form a big piece of material will be high yield. The larger the width of a material roll can increase the cutting yield.

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### **Question # 48**

What is colour swatch?

**Answer:-**

He's using the colour swatch to choose different materials and colours to make all the shoes of his order.

sample pieces of several materials and colours used to make the shoes

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### **Question # 49**

What is brannock device?

**Answer:-**

You've seen this tool in every shoe store. This is the standard for measuring feet. If you're developing footwear, you must have a Brannock device in your office. When a tester says a shoe fits loose or tight the first thing you need to do is measure their feet against the machine. The Brannock device will give you the length and width measurements. Remember to measure both left and right Feet! Also use your flexible measuring tape to measure the ball girth.

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**Question # 50**

What is primer?

**Answer:-**

Primer is a cleaning product, solvent or water based, used to prepare surfaces for bonding. The primer clears away any oil or mold released from parts which is critical for a good cement bond.

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**Question # 51**

What is outsole or sole unit?

**Answer:-**

The bottom component of a shoe that provides grip and traction. The outsole is commonly rubber, but can be high density PU or EVA foam. Dress shoes may have leather bottoms.

[Read More Answers.](#)

**Question # 52**

What is amara?

**Answer:-**

Microfiber Synthetic Leather. These high quality micro fiber suede materials can be expensive but they are great for use on shoes, gloves, linings and trim.

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**Question # 53**

Explain containers or Shipping containers, Ocean containers?

**Answer:-**

The standard 40 foot long ocean container the size of a 40 foot trailer on a semi truck. The standard size is 40 feet by 8 feet by 8 feet and holds about 5000 pairs of shoes. There is the half size 20 footer and the Extra Large 40 foot High Cube (about 1 foot taller than the standard 40).

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**Question # 54**

What is buckle?

**Answer:-**

The buckle of that shoe is the most beautiful of the whole collection. fastener that fastens together two ends of a belt or strap; often has loose prong

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**Question # 55**

What is die Cut EVA Midsole?

**Answer:-**

The die cut EVA midsole is simple way to add cushioning foam into the bottom of a shoe. The shoe sole will have a cavity molded into the rubber. A piece of die cut foam is simply glued into the cavity. The Die Cut EVA midsole can be flat or the EVA can be profile cut. This EVA is not visible from the outside of the shoe. It will be surrounded by the sole unit and it will be under the lasting board or stroble sock.

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**Question # 56**

What is grade?

**Answer:-**

Grade is the quality of an item. A-Grade is good. B-Grade has flaws can be sold at a discount. C-Grade can't be sole, must be destroyed or repaired if possible.

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**Question # 57**

What is ortho-Lite?

**Answer:-**

Ortho-lite is brand name for a crystallized PU foam footbed. Lite, Flexible and comfortable. This footbed came be found in High end running shoes.

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**Question # 58**

What is amortization or Amortize?

**Answer:-**

A factory customer and the factory agree to pay for shoe tooling piece by piece. The tooling is amortized ,but adding a small charge to each pair of shoes. For Example a \$10,000 tooling bill make be payed by adding \$.50 to the first 20,000 pairs sold.

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**Question # 59**





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What is cut and Buff Midsole?

**Answer:-**

The cut and buff shoe midsole is the classic running shoe construction. The Nike Cortez and many New Balance classic use this assembly method. A cut and Buff midsole is made by cementing of profile cut EVA to a flat rubber midsole. The profile of the EVA makes the toe tip thinner and the heel thicker. Once the EVA is bonded to the rubber the parts are die CUT to the correct outline shape. The assemble is taken to an angled grinding stone to have the side angle BUFFED.

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**Question # 60**

What is heel?

**Answer:-**

She prefers to buy shoes with high heels.  
the back part of a shoe or boot that touches the ground

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**Question # 61**

What is girth?

**Answer:-**

The girth is the measurement around an object. When measuring a last you need to know the Ball Girth, Instep Girth and Heel Girth.

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**Question # 62**

What is lasting board?

**Answer:-**

A fabric or paper board sheet used to make the bottom of the shoe upper.

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**Question # 63**

What is rubber BR-9000?

**Answer:-**

Butadiene (Polymer) Synthetic rubber made from petro chemicals Rubber SBR1502  
Styrene-butadiene (Polymer) a common ingredient in synthetic rubber.

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**Question # 64**

Explain shoe parts Cutting?

**Answer:-**

Traditionally called 'clicking' or 'clicker cutting) is simply the cutting of shoe materials. There is an art to cutting leather due to the nature of the materials' grain. The cutting is made by a cutting die.

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**Question # 65**

What is double lasting?

**Answer:-**

Double lasting is when a single shoe undergoes two lasting operations during assembly. The lasting operations maybe to pull a leather lining tight with no wrinkles or to pull a water proofing lining tight. The second lasting operation would be the shoe upper. Double lasting is often used to "hide" a molded foam midsole inside the shoe.

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**Question # 66**

What is linings of a shoe?

**Answer:-**

- \* Quarter Lining horseshoe shape around back part of shoe
- \* Vamp Lining inside upper of forepart and toe of shoe
- \* Sock Lining covering all OR part of the top surface of the insole.

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**Question # 67**

What is heel counter?

**Answer:-**

Internal or external, the heel counter is the pattern part that covers the heel of the shoe. The internal heel counter can be made of rubber (for vulcanized shoes), thermo plastic (for cold cement shoes), chemi-sheet (for really cheap shoes), or leather for dress shoes. Depending on the shoe type the counter can be thin and soft or stiff and sturdy.



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### **Question # 68**

What is design Brief?

**Answer:-**

The Shoe Design Brief contains all the critical information for the footwear designer. Information like, who is this shoe for? What sport is the shoe designed for? What price is planned for the finished item? For What country? A detailed design brief will contain much of the information the shoe designer will need to get started.

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### **Question # 69**

What is ankle boot (noun)?

**Answer:-**

She prefers to wear an ankle boot than a high boot. footwear that covers the whole foot and ankle

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### **Question # 70**

What is buff or Buffing?

**Answer:-**

To remove material by a sanding or roughing process. For example, EVA midsoles are buffed before assembly to help break the smooth surface for better adhesion to the upper. The shoe factory will use a metal or stone wheel.

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### **Question # 71**

Tell me what is parting line or outsole parting-plane?

**Answer:-**

The line in an outsole mold is made by the closing edges of the tooling. The tooling is split at the parting line. A mold may have one or 2 parting planes. Extra rubber may spread out of the parting line, this will be need to be trimmed off. A narrow tight parting line or parting plane is a sign of quality tooling.

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### **Question # 72**

What is midsole?

**Answer:-**

The component of a shoe between the upper and outsole used to provide cushioning, fit, comfort and support. Will be made of EVA or PU foam.

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### **Question # 73**

What is lasting margin?

**Answer:-**

The upper material part that when lasted folds over the edge of the last onto the bottom, overlapping the insole board. A lasting margin may be 15 to 20 mm wide.

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### **Question # 74**

What is heel stabilizer?

**Answer:-**

The shoe heel stabilizer is can be rubber, plastic or leather. The stabilizer is bonded to the upper and midsole on the outside of the shoe as a functional and style part. Very common on the classic cut and buff style midsole type.

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### **Question # 75**

What is EVA?

**Answer:-**

Ethylene vinyl acetate is the copolymer of ethylene and vinyl acetate. The weight percent vinyl acetate usually varies from 10 to 40%, with the remainder being ethylene. The most common foam used for shoe cushioning. EVA can be hot pressed or cold pressed, can be made in any color, in a range of hardnesses. This material can also be made by injection. EVA is the most common midsole padding but is also used in shoe uppers.

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### **Question # 76**

What is binding (noun)?

**Answer:-**

Usually binding is made of the same material as the material of the upper.



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strip sewn over or along an edge for reinforcement or decoration

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### **Question # 77**

Explain me shoe Cement or Contact Cement?

**Answer:-**

Shoe cement is usually solvent or water based PU contact cement. Each part is coated with the cement and allowed to dry. The surfaces are then pressed together. Pressing is critical for a good bond. The PU cement cures in minutes, but a full cure may take days.

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### **Question # 78**

What is fashioned?

**Answer:-**

Those clients bought fashioned shoes. planned and made or designed artistically

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### **Question # 79**

What is lace Loop?

**Answer:-**

Usually made of Nylon webbing. A very common way to attached laces also called a ghilly loop. This style can be sewn under the eye stay to make a hidden lace loop

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### **Question # 80**

What are pantone colors & Pantone Chips & Pantone Books?

**Answer:-**

Pantone Inc. is a corporation headquartered in Carlstadt, New Jersey. The company is best known for its Pantone Matching System (PMS), a proprietary color space used in a variety of industries, primarily printing, though sometimes in the manufacture of colored paint, fabric, and plastics. It's the only way to make sure your colors match.

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### **Question # 81**

Explain me what is eyelet?

**Answer:-**

A hole through which you lace up a shoe.

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### **Question # 82**

What is fitting?

**Answer:-**

The fitting of the shoe is approved. making or becoming suitable; adjusting

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### **Question # 83**

What is chemi-Sheet?

**Answer:-**

A non-woven reinforcement material that is impregnated with a chemical hardener that sets with application of heat or another chemical. Used commonly for heel counter reinforcement on really cheap shoes.

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### **Question # 84**

What is shoe Parts the Mustache?

**Answer:-**

The Mustache is the shoe part attached to the shoe above the heel counter part. The classic sneaker will have a Mustache

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### **Question # 85**

What is egg Crate Rubber Midsole?

**Answer:-**

The Egg crate pattern of square or diamond shape walls may fill the heel of a solid rubber boot sole. They save weight but allow for sturdy sole unit. Egg crate may



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also be used to replace foam inside the midsole of an inexpensive shoe. Egg crate may also be used to level the inside surface of a rubber outsole to allow sheet cut midsole to fit properly.

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### **Question # 86**

What is cuff?

**Answer:-**

The cuff alignment allows the boot cuff to follow the line of the leg in the boot. the lap consisting of a turned-back hem encircling the end of a material

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### **Question # 87**

What is rubber sole Color Dam?

**Answer:-**

A color dam on a shoe bottom is a raised ridge and/or groove in a mold to stop the flow of rubber. A sneaker shoe bottom will have color dams dividing all the colors on the sole.

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### **Question # 88**

What is cotton?

**Answer:-**

A new cotton material was used to produce that special part of the shoe. fabric woven from cotton fibres

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### **Question # 89**

What is glue allowance or Glue Line?

**Answer:-**

The standard glue allowance is 2mm. The outsole glue may be applied up to 2mm above the outsole top edge. This allows a good bond - but too much can turn yellow later and not looks good.

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### **Question # 90**

What is colorway?

**Answer:-**

A color/material combination. A model of a shoe may have many colorways.

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### **Question # 91**

What is cupsole or Cupsole unit?

**Answer:-**

A shoe outsole type made of one piece of rubber. Called a cup sole as the sole unit "cups" the upper. Inside the cup can be EVA foam for rubber ribs egg crate pattern.

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### **Question # 92**

What is heel Notch?

**Answer:-**

At the back of shoe shoe's top line, above the heel counter the shoe may have a dip in the center. This is the heel notch.

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### **Question # 93**

What is last?

**Answer:-**

The Shoe last is the foot form that is used to set the shape shoes. The shoe last can be made of plastic, Metal or wood.

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### **Question # 94**

What is nu-Buck leather?

**Answer:-**

This is the top, full grain layer of the hide, but the outer surface has been "brushed" away leaving a very soft nape suede like surface.



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### **Question # 95**

What is insole Board?

#### **Answer:-**

Insole Board A paper based board used to provide structure inside a shoe. For example, a stiff hiking boot will have a thick plastic lasting board. Also called Sockliner

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### **Question # 96**

What is cutting interlock loss?

#### **Answer:-**

Interlock loss is the material lost when a big pattern part is cut. For example a classic one piece hiking boot pattern can't fit closely on the hide. The material in-between the parts is lost.

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### **Question # 97**

What is insole?

#### **Answer:-**

Footbed or Insole is the foam padded mesh that your foot stands on. May be removable or may be cemented in. High end shoes will be molded EVA of PU foam - Low end shoes will be die cut EVA.

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### **Question # 98**

What is the Shoe Master Carton?

#### **Answer:-**

The Master Carton or Case pack for Production shoes is usually a 10 or 12 pack depending on the size of the shoe and shoe inner box. In the master carton the Inner boxes will be arranged so the warehouse worker can see shoe box end labels for size and color information.

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### **Question # 99**

What is LOP or Labor Overhead and Profit?

#### **Answer:-**

LOP is a critical part of the shoe factories price for a shoe. The factory will add up all the material costs then add the Labor Rate, Overhead and Profit required. The LOP for a shoe can be 30% of the total cost of a shoe. Just a few dollars for a simple skate shoe up to \$10 or \$15 for a snowboarding boot. Some factories will add a percentage on to the material cost to account for the LOP. Other factories carefully calculate each component.

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### **Question # 100**

What is ex-Works Price Purchase Term?

#### **Answer:-**

When you negotiate a shoe price you need be clear on where the finished shoe is to be delivered. Ex-Works means the Price does not include any shipping. The buyer would be responsible for collecting the product from the factory.

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### **Question # 101**

What is denier?

#### **Answer:-**

Denier is how thread weight is measured. 1 denier = 1 gram per 9000 meters of thread. Typical deniers are 110D for very light weight fabric, 420D to 600D are common in shoes, 1000D for boots & bags.

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