OUTSIDE OF PLANT

1. DESIGN
- contractors create design
- build prototype to show marketing department

1st & 2nd FLOOR OF PLANT

2. ROUGH-MAKING
- cut wood, make parts
- labor intensive

3. LUMBER-CUTTING
- measure lumber
- place wood on machines for cutting

4. GLUE LUMBER
- takes 1-1.5 hr
- can be done manually or by machine (3 times faster)

5. MOLDING
- 4 molders
- 80% of wood go through molders
- one of the most important procedures

6. SHAPING
- cut wood in desired shapes

7. CNC ROUTER
- computerized numerical controlled router

8. SANDING
- wide-belt sander

ASSEMBLY DEPARTMENT

9. ASSEMBLY
- put furniture parts together
- spray paint furniture by hand

10. CLEAN UP & INSPECTION
- add final touches to furniture
- identify and repair flawed furniture

11. FINISHING
- labor intensive, can take up to 28 steps

12. PACKAGE
- furniture is packaged into customized boxes
- ship to customers