

Production Improvements

Fabric relaxing



Before



Fabric relaxation is not properly done.

Fabric relaxing

After

Fabric should have information tag mentioning date and time to follow up when it's ready for cutting and should be spread apart.



Relaxing	Ready
June 10 th	June 11 th
10:00 am	10:00 am

In case responsible labor is ill, colleagues are informed since when the fabric is relaxing and when it's ready for cutting.



To assure clean surrounding and to save space, you can also use fabric relaxation boxes.

Accessories Ware House

Before



There is no tag on racks.

Nobody can easily find the needed accessory without information tag on racks.

Accessories Ware House

After



Racks need to have label tag including all necessary information.
So everybody can easily find needed accessories according to the label on racks and boxes.
Custer name, order number, style number,.....

Lighting system

Before



Lights should be set up exactly at the necessary work place area.
There are so many lights at one particular area unnecessarily.
Every lights are switch on all together.
It consumes a lot of energy and costs so many over head costs.

Light setting

After



- Unneeded lights should be removed or switched off.
- Lights should be set up only at necessary place and at particular work areas.
- Alternative switch on method / individual switch should be applied for more efficiency.
- Avoid using one switch for all lights.

Production flow / Target / Operation Plan

Before



The bundle tag has no proper information and doesn't record which tailor has complete
The procedure to trace back in case of rejection.
Nor the efficiency of the tailors can be identified.

Bundle Tag

Only one bundle tag system should be used.

It gives transparency to the efficiency of each tailor and can be used for the payment of wages.

In case of rejected or rework pcs, with this system it's easily to find out the particular tailor.

Once the tailor has completed it's sewing, the tailor cuts it's particular coupon and writes the name on it. Coupons will be collected every day / evening.

After

No.		Procedure	Operation	Target	Pcs	Name
35	Export carton	Assortment	5,00	10		
34	Packing	hanger	6,00	10		
33	Iron	steam	5,00	10		
.				10		
.				10		
.				10		
.				10		
.				10		
.				10		
.				10		
.				10		
.				10		
3	2ndl O/L	yoke cover	2,00	10		
2	Top stitch	yoke	3,50	10		
1	Top stitch	Brand & size label	4,00	10		

Cleaning Surrounding

Before



The wastages is thrown on the floor, workers can easily slip-out and fall.

Cleaning Surrounding



After



- Working areas should be clean, to avoid accidents.
- A clean surrounding protects the product to remain clean
- And gives a good impression to customers.

Bundles storage for sewing

Before



Bundles are laying on the floor, can get dirty, get lost and inline in charge can lose overview of production input and output.

Bundles storage for sewing

After

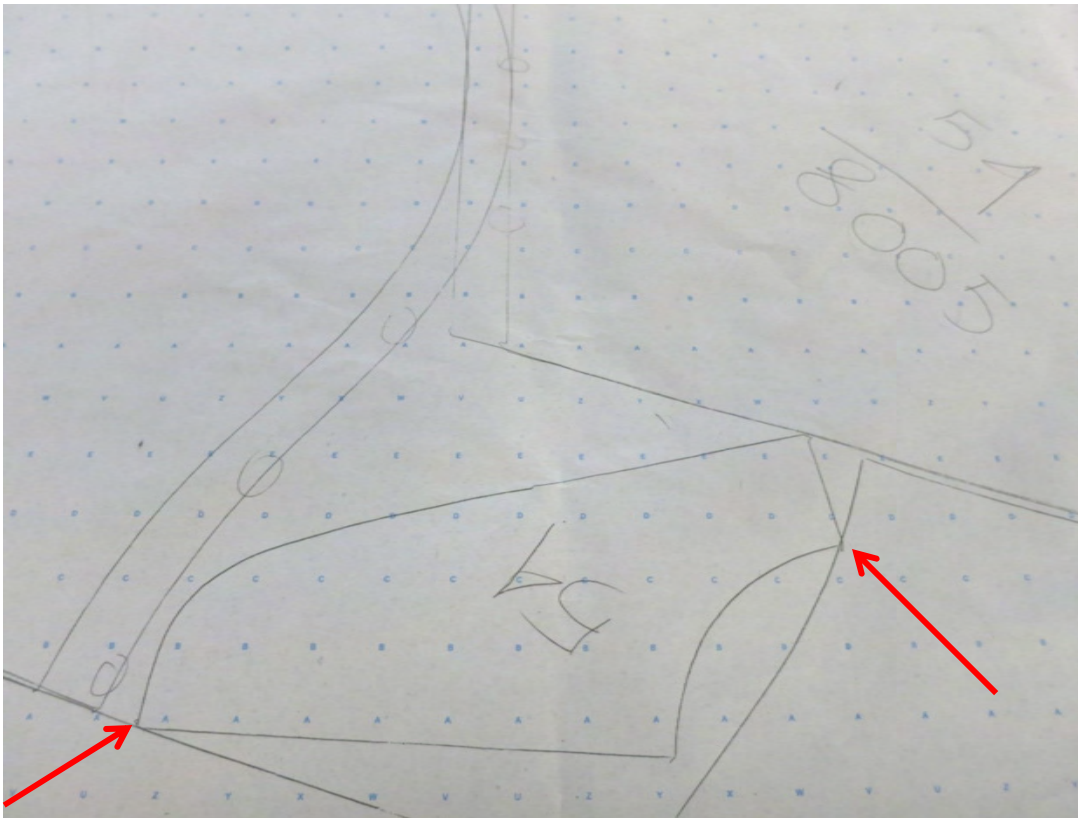


Bundles should be placed on a table, in a rack or in boxes.
So it can easily be taken and is protect from dust and stain.

Mini Mark

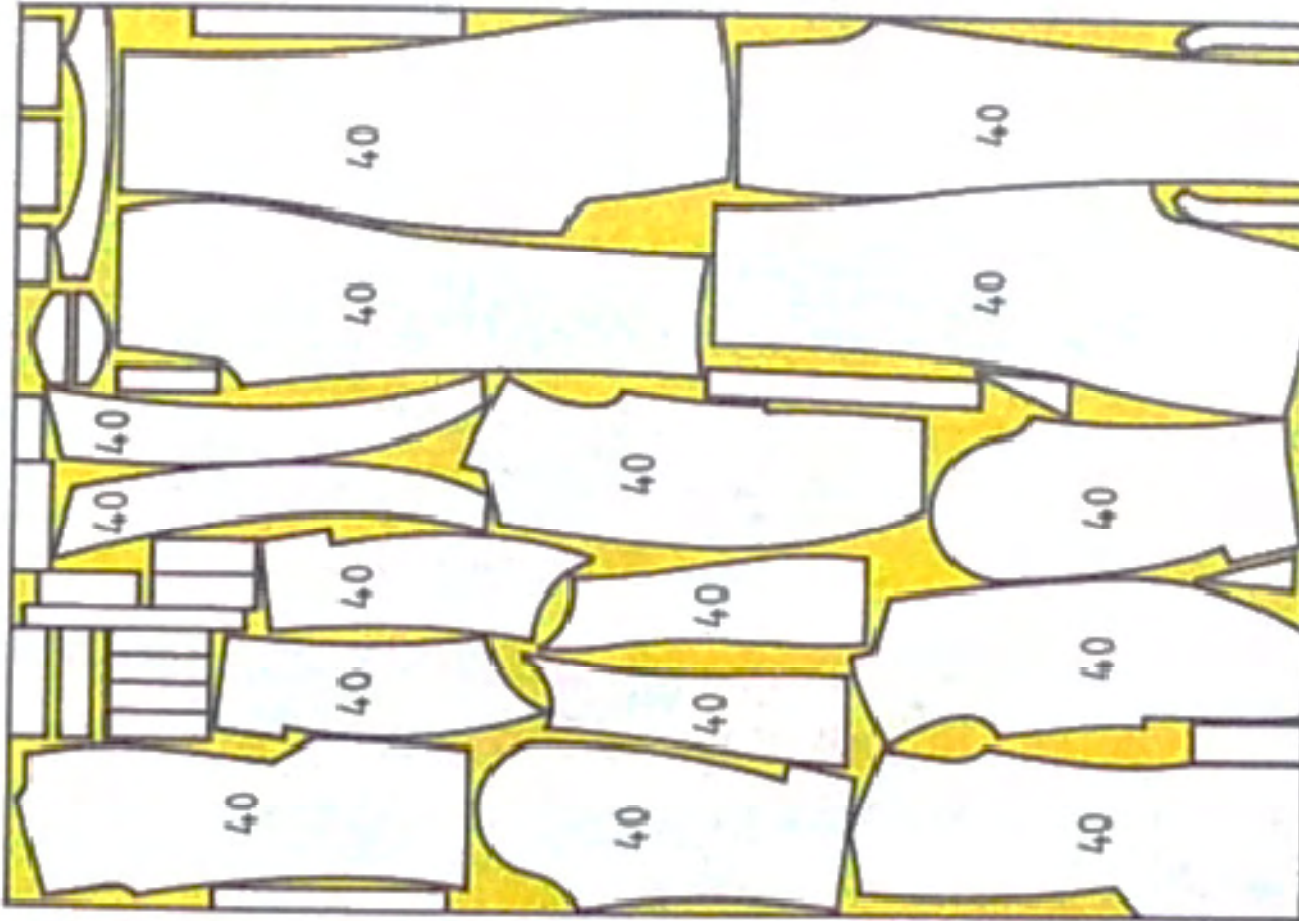
Before

There is no gap between the patterns on the mini mark.
This is very dangerous for cutting because cutting operator can cut accidentally other patterns.



Mini Mark

After



In the Mini Mark its very important to leave a gap of 1-2 mm, to avoid damaging other cut panels.

Workmanship - Puckering

Before



This fabric is very thin and high in elongation.
When the tailors sew, they easily pull irregularly and puckering appears.

Workmanship - Puckering

After



For tailors better handling, notches should be placed on long sewing distances for orientation. These notches should not be longer than 1-2 mm to assure inside seam allowance.

No Inline QC

Before

Factory has no inline QC,

- The factory can't control the quality during production.
- After checking five machines, we found five defects, on each machine one within 5 minutes.
- The factory can correct / re-work these defects only at the finished stage.
- It is very difficult to repair the item and takes too much time which can quickly over top actual CMP total quotation.
- In worst case the garment is not re-workable and the lost for customer and producers turnover.

Factory has no inline in charge,

- Factory can not managed proper working organization.
- Some tailors are waiting for sewing.
- It can not smooth the production flow.

No Inline QC

After

Factory should have inline QC.

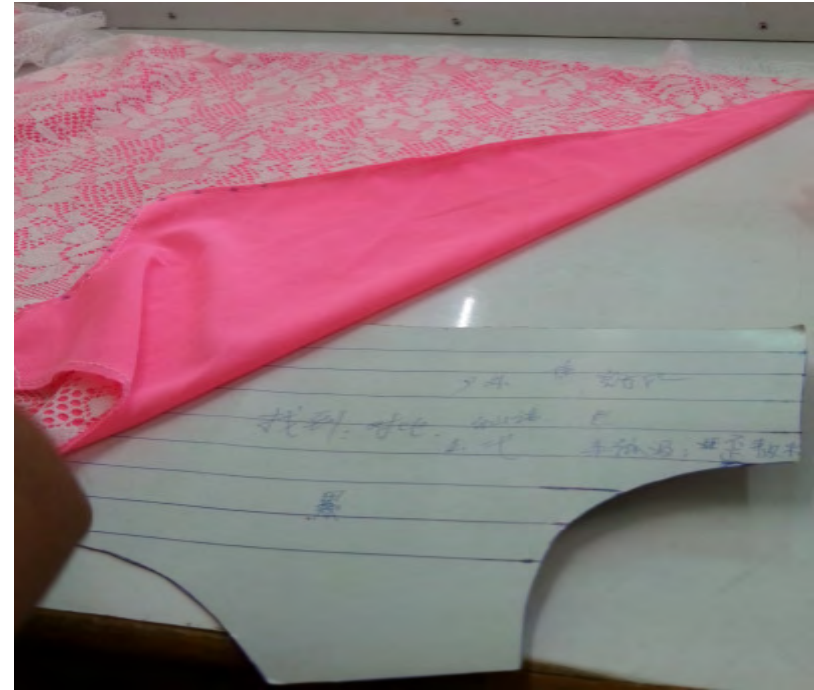
- Sewing quality can easily be improved.
- If they find the defects, they can rework immediately.
- They can solve easily detect reason of defect.
- This way is very effective and also can reduce the time for reworking.

Factory should have inline in charge,

- It may be one inline in charge is responsible for two sewing lines.
- Factory can improve the proper working organization.
- It will increase the production rate.

Marking technique

Before

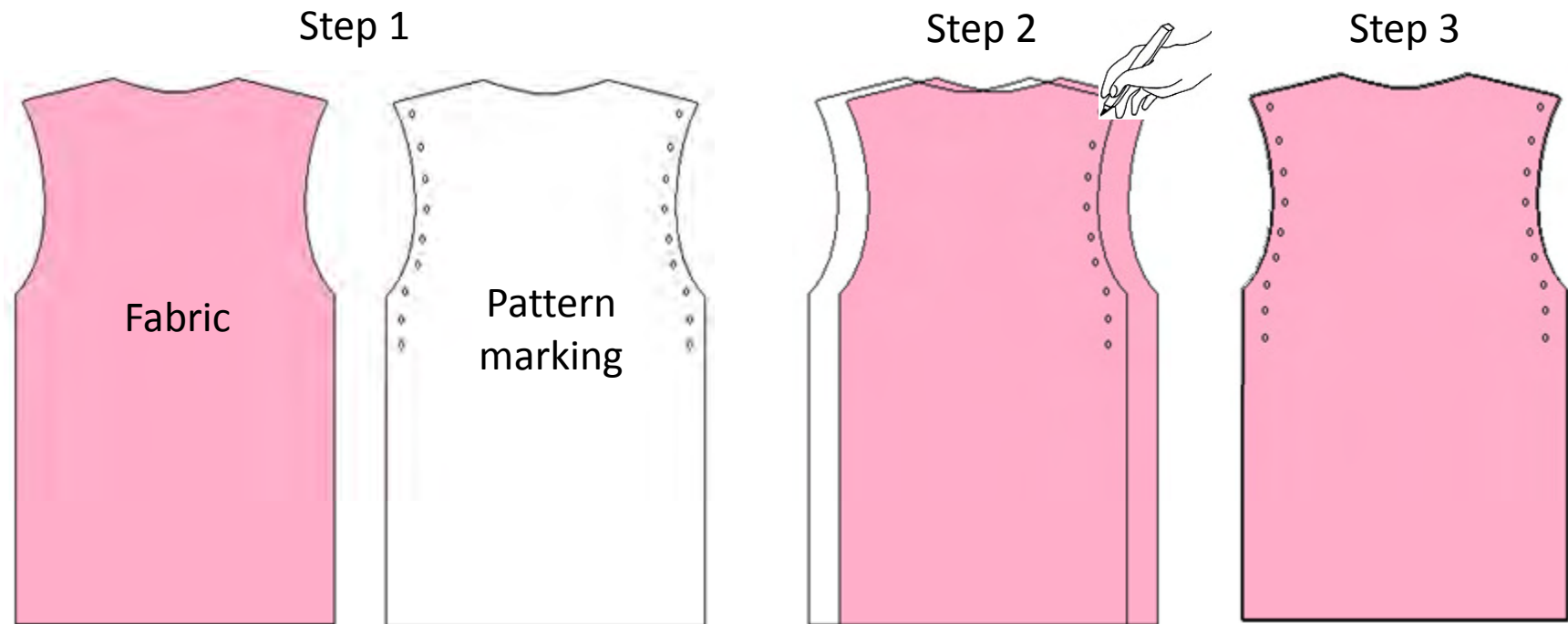


A helper is marking the points with a marking pattern. She is using the pattern underneath the fabric to make sure the points are at right position.

But because the pattern is underneath the fabric, she has to lift the fabric to see the marking position . Therefore she needs a lot of time.

Marking technique

After



Step 1: There are fabric and pattern marking with holes at exact points to be marked.

Step 2: Put the pattern marking above the fabric to be marked.

Step 3: Using textile marker, marks the points on the fabric according to the holes on the pattern marking.

Checking before sewing

Before



Before they sew body and sleeve hem, each pcs gets checked on straight hemming. In case it's not straight, a helper cuts the fabric by hand.

Checking before sewing

After

- It takes around 2 minutes per item which is not in realization to the effort of cutting.
- Tailors must be good trained for proper handling, and orientation notches must be placed To avoid uneven stretching when sewing.
- This will avoid the unevenness and the additional expensive checking and hand cutting can be avoid.



Production Flow

Before



Sewing line is crowded with many bundles. They have no enough space to put the bundles, so they put the bundles beside of them. Therefore, they have no space for proper handling.

Production Flow

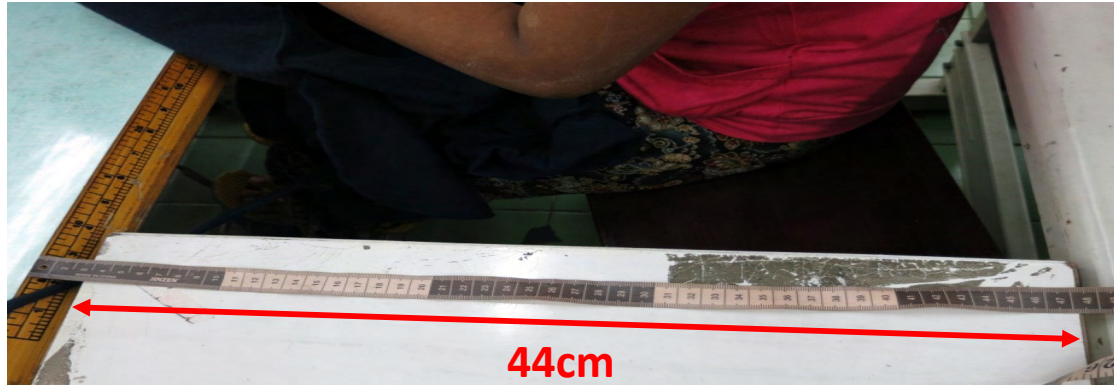
After



Every sewing lines should have the middle table to put the bundles. This supports to get the proper space in the sewing lines and move freely for the tailors.

It's in responsibility for inline in charge to control and coordinate production feeding, for input and output.

Working area



There is no proper work space for the tailors. So, tailors are not comfortable for sewing.

Before



Working area

After



Tailors should have enough working space for proper handling and feeding.

Proper Production Flow

Before

Same tailor



Different section

Same process

Two tailors sewing the same process but are not at same position.

Proper Production Flow

After

Same process, Same section



The two same processes should be placed at the same area or group. So that, the output can be calculated easily. The proper production flow is more efficient. And the tailors can learn from each other.

Work conditions

Before



Workers don't have enough space for proper handling.
Working with wastebaskets between the legs over hours, days, months,..... is abnormal.

Work conditions

After



Wastebaskets belong on the floor, a slide for sewing wastage must be installed.

Safety

Before



Knives, drink bottles and other equipments or personal belongings to not belong in wastebaskets.

It's too dangerous, when wastage falls inside and sharp items are underneath.

Safety

After



The factory should secure knives with fabric strings and hang onto the table.

Ironing

Before



The fabric cloths of iron tables are very dirty and in case of bright colored garments especially for white garment, the stain and dirt could get spread onto.

Ironing

After



Cover should be regularly changed to be cleaned.

Suggestion



To reduce labor fluctuation in factory, we advice to install a suggestion box.

Everyone who wants to share it's difficulty or idea for improvement, can place their suggestion letter in a box without including any personal information or ID.

Organization Plan for mechanic



There should be organization plan for mechanics in garment factory. Mechanics need clear instructions what to do. Following should be included in their daily / weekly plan.

- Oil check
 - Needle check
 - Stitch - amount
 - tension
 - Knife - damaged
 - sharp
 - Step foot
 - Plate, Teeth (Transporter)
 - Shuttle (Under thread)
 - Table condition/ surrounding, and
- So on....

Mechanic should check all machines regularly. For example, machines in line 1 and line 2 have to be checked on every Monday. Or, all over lock machines and flat seam machines have to be check on every Friday.

Mechanics should check machines during the time when tailors don't work. For example, morning before work, lunch break, tea break, after work, so on.

Mechanics should keep records and documentation.

These reports should be passed to production manager.

Repaired machines should be listed. Outside service can be called for machines that are not repairable by the house mechanic after several times. Or, damaged machines must be replaced.

Sitting Position/ Health

Before



Tailor is sitting in poor position.

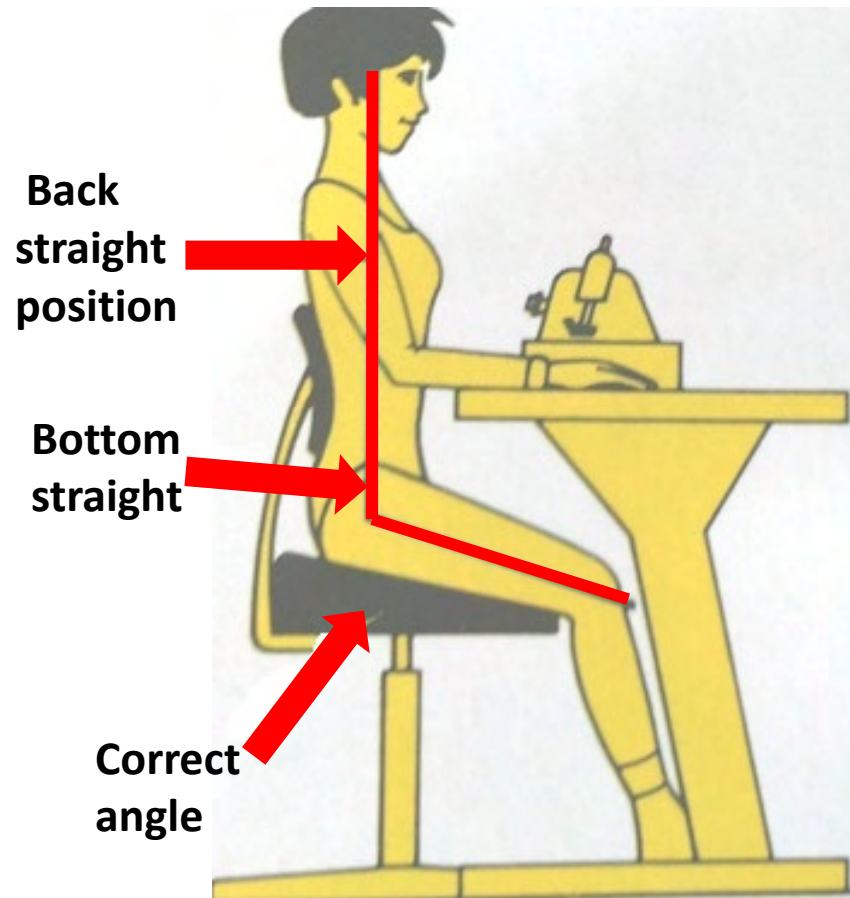
This kind of working position is not healthy.

The space requires comfort working.

The staff (inline in charge) should inform the tailor to sit up straight.

Sitting Position/ Health

After



In this picture, the tailor is in proper position.

The table should have a surface area appropriate to the size of the components being sewn.

Health and safety is very important for everyone in working area.