

List of References

References

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Appendix A

A. Quality Standards

Defect ID	SEW 04
Effective date	16/12/2000
Defect Name	UNEVEN WIDTH ON PLACKET TOP STITCH.
Section	SEWING
Main Causes	* CARELESSNESS * LACK OF SKILL OF MACHINE OPERATOR * THICKNESS OF FABRIC
Decision	REJECTED
Remarks	SUBJECT TO JUDGED ACCORDING TO THE APPEARANCE

Diagram and Illustration

UNEVEN WIDTH

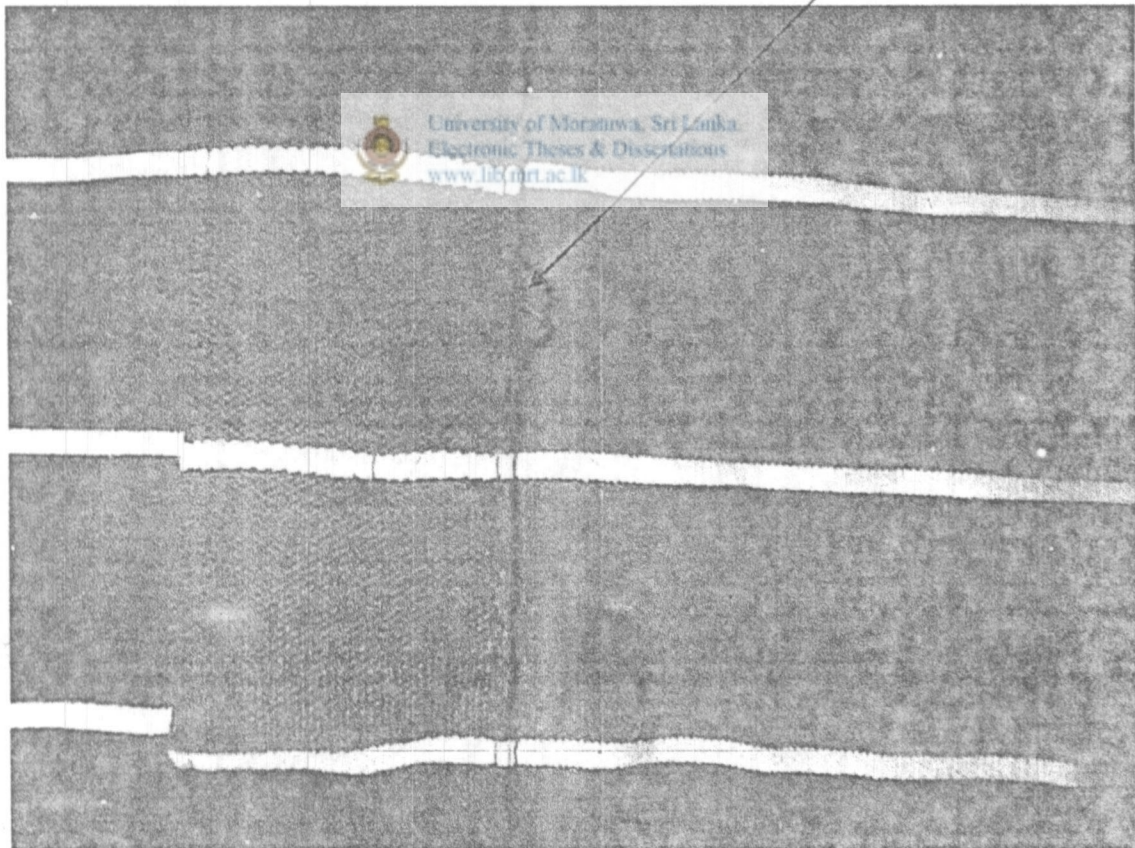


B. Quality Standards

Defect ID	SEW 081
Effective date	20/01/2001
Defect Name	NOT CAUGHT PLACKET.
Section	SEWING
Main Causes	* CARELESSNESS OF MACHINE OPERATOR.
Decision	REJECTED
Remarks	

Diagram and Illustration

NOT CAUGHT PLKKT



Appendix B

JOB KNOWLEDGE FOR MAIN ASSEMBLY

<p>1. MAIN ASSEMBLY – ATTACH SLEEVE</p>
<p>Job Knowledge Description</p>
<p>A) Operation Process :-</p> <ol style="list-style-type: none"> 1. Remove both sleeves on clamp and place on lap 2. Both hands pick up right sleeve from lap and under presser foot (face to face within body). 3. Both hands pull up body and place under presser foot. 4. Stitch down. 5. Cut thread. 6. Repeat process for the other sleeve.
<p>B) Quality Awareness :-</p> <p>When a new CT is being sewn :-</p> <ol style="list-style-type: none"> 1. Refer to the sewing swatches for sewing information. 2. Adjust the setting of the sewing machine following buyer's requirement. 3. Center alignment should be made especially for check and stripe fabric. 4. Ensure that the SPI(stitch per inch) is correct especially for new CT order.
<p>2. MAIN ASSEMBLY – ATTACH SLEEVE</p>
<ol style="list-style-type: none"> 5. Avoid the following defect areas :- <ul style="list-style-type: none"> - Loose Thread - Skip Stitch - Raw Edge - Pleated, - Open Seam - Over Tension At Curve - Puckering, - Seam Gapping - Uneven Surface - Twisted 6. Obtain the approval from the supervisor when the first piece of a new order is sewn.

C) Skills Development (% Of F.P.Y.) :-

Mth 1	Mth 2	Mth 3	Mth 4	Mth 5	Mth 6	>Mth 6
50%	60%	70%	80%	90%	100%	100%
Passing Rate = 93%						

D) Productivity Development (% Of Output Based On 80% Efficiency) :-

Mth 1	Mth 2	Mth 3	Mth 4	Mth 5	Mth 6	>Mth 6
25%	35%	50%	70%	85%	100%	100%
Passing Rate = 80%						

E) Basic Machine Maintenance



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1. Machinery : O/L Machine
 2. Use of air blowing is not allowed in the sewing floor. Air gun cannot be used to clean the sewing machine.
 3. Clean Feed-dog, rotary hook and throat plate before leaving the factory every Saturday.
 4. Apply the machine cleaning procedures again especially when the order is changed from dark color fabric to light color fabric.
- Refer to the Sewing Operators Standard Machine Maintenance Procedures for the maintenance of sewing machine

3. MAIN ASSEMBLY – ATTACH SLEEVE

F) Roles And Responsibility

1. Able to comply to the requirement of the job according to the following areas :-
 - Correct operation process.
 - Quality standard.
 - Productivity standard.
 - Basic machine maintenance method.
 - Communicate with colleague.
 - And easily adapt to the working environment.

JOB KNOWLEDGE FOR MAIN ASSEMBLY

4. MAIN ASSEMBLY – TOPSTITCH SLEEVE

Job Knowledge Description

A) Operation Process :-

7. Both hands pick up right body and sleeve. Then, place it under presser foot.
8. Stitch down for approximately 9 seconds with both hands pressing out the seam and aligning to the edge of the presser foot.
9. Cut thread.
10. Repeat process for the other side.
11. Both hands remove body and sleeve from clamp. Then, place it under the presser foot.
12. Stitch down for approximately 9 seconds with both hands pressing out the seam and aligning to the edge of the presser foot.
13. Cut thread.
14. Insert garment to the clamp.
15. Press control button.

B) Quality Awareness :-

When a new CT is being sewn :-

7. Refer to the sewing swatches for sewing information.
8. Adjust the setting of the sewing machine following buyer's requirement.
9. Center alignment should be made especially for check and stripe fabric.
10. Ensure that the SPI(stitch per inch) is correct especially for new CT order.

5. MAIN ASSEMBLY – TOPSTITCH SLEEVE

11. Avoid the following defect areas :-

- Loose Thread
 - Skip Stitch
 - Raw Edge
 - Armpit Mismatched
 - Pleated
 - Poor Stitch Tension
 - Puckering
 - Uneven Surface
 - Twisted.
12. Obtain the approval from the supervisor when the first piece of a new order is sewn.

C) Skills Development (% Of F.P.Y.) :-

Mth 1	Mth 2	Mth 3	Mth 4	Mth 5	Mth 6	>Mth 6
60%	80%	100%	100%	100%	100%	100%

Passing Rate = 83%

D) Productivity Development (% Of Output Based On 80% Efficiency) :-

Mth 1	Mth 2	Mth 3	Mth 4	Mth 5	Mth 6	>Mth 6
25%	35%	50%	70%	85%	100%	100%

Passing Rate = 80%

E) Basic Machine Maintenance

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- Machinery : Juki Model 328 – Auto Sewing Machine
 - Use of air blowing is not allowed in the sewing floor. Air gun cannot be used to clean the sewing machine.
 - Clean Feed-dog, rotary hook and throat plate before leaving the factory every Saturday.
 - Apply the machine cleaning procedures again especially when the order is changed from dark color fabric to light color fabric.
- Refer to the Sewing Operators Standard Machine Maintenance Procedures for the maintenance of sewing machine.

6. MAIN ASSEMBLY – TOPSTITCH SLEEVE

F) Roles And Responsibility

- Able to comply to the requirement of the job according to the following areas :-
 - Correct operation process.
 - Quality standard.
 - Productivity standard.
 - Basic machine maintenance method.
 - Communicate with colleague.
 - And easily adapt to the working environment.

