Researching Projects for Production and Business of Orders Veston Male Children in the Garment Industry.

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Abstract: *The textile and garment industry has always been one of Vietnam's key export industries for many years, with the development of technology, an increasingly large proportion of skilled labor and incentives from foreign countries. According to state policies, the textile and garment industry has achieved many encouraging results, both creating value for export goods and ensuring domestic and export demand. However, most garment enterprises in Vietnam are following the CMT production method, which is the method that brings the lowest added value in the global garment industry value chain. Therefore, shifting from the CMT method to a production method that brings higher value such as FOB or ODM is the way to help Vietnam's textile and garment industry increase added value and sustainability in integration.*
Keywords: *Textile, vest*


I. Pose the problem

In recent years, Vietnam's textile and garment industry has made positive developments in both production and export. In particular, the average growth rate of textile and garment production in the period 2016 - 2020 reached 7.9% / year, in 2018 alone it increased by more than 33%. In 2020, the textile industry is one of the industries that is negatively and prolongedly affected by the Covid-19 outbreak.

Kim ngạch xuất khẩu hàng dệt, may trong quý I, giai đoạn 2010-2023 (tỷ USD)
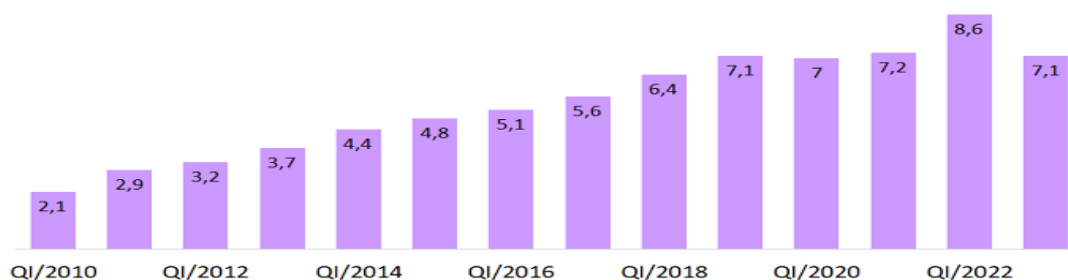
Target market selection For suits, the minimalist trend is one of the increasingly popular trends. Vest trend in 2023: is a men's children's vest combined with long pants and waistcoat with tulle fabric, a slim fit to ensure politeness and neatness while still maintaining comfort for the baby, neutral color scheme is main color. - With the development of the market economy in general as well as the textile industry in particular, fashion trends are constantly changing. To be able to create products that meet customer needs, the project needs to research the latest trends to update customers.
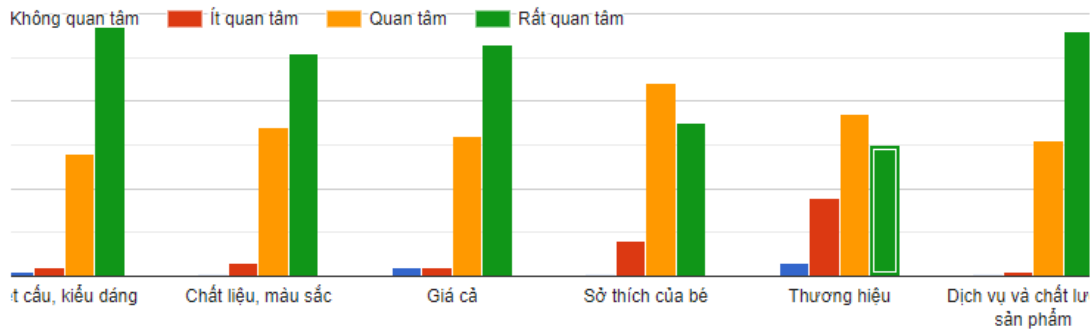
II. Components of Control system.

Slim model design:

Cut two fabric samples measuring 60x60cm. Draw on fabric size 50x50cm. Patch the two fabric samples together and sew the seam onto the lined frame. Measure parameters after machining. Apply the formula to calculate fabric shrinkage according to the formula:

$$L2 (\%) = (Lo – L1)/ Lo \times 100\%$$

In there:

L2: Fabric shrinkage.

L0: Length of fabric sample before sewing.

L1: Length of fabric sample after sewing.

Cut the sample to size 60x60cm. Draw on fabric size 50x50cm. Press the mosquito net onto the drawn frame on the fabric sample using a press. Measure parameters after machining. Apply the formula to calculate fabric shrinkage according to the formula:

$$L2 (\%) = (Lo – L1)/ Lo \times 100\%$$

In there: L2: Fabric shrinkage.   L0: Length of fabric sample before ironing.   L1: Length of fabric sample after ironing.
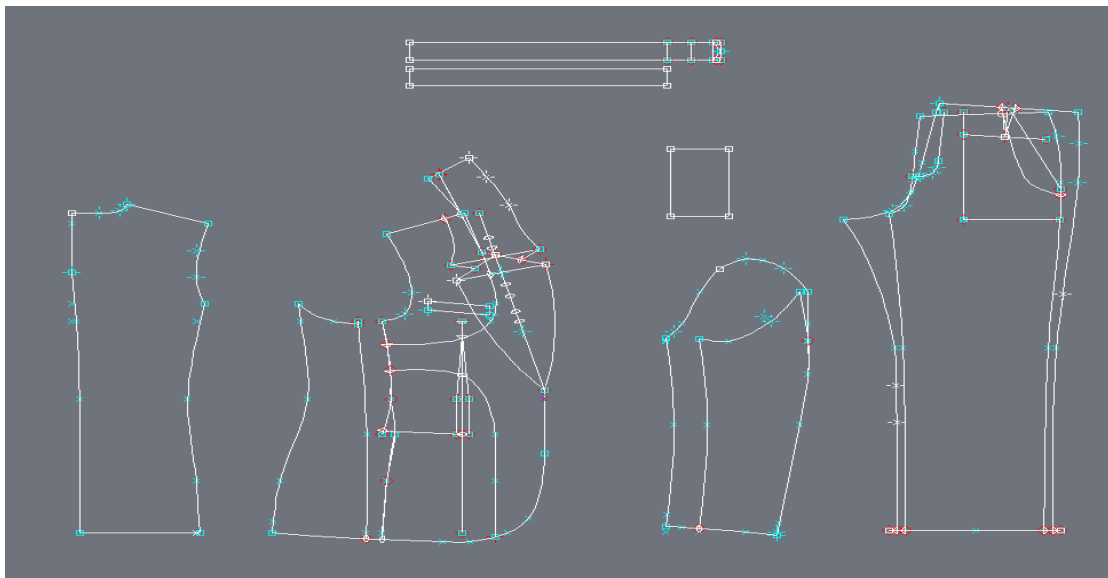
III. System selection and design

The number of products of product code HTQ159369 is 3150 products of men's children's suits. Production time includes the following steps: Material ordering time; technical preparation; spreading and cutting fabric; sewing; complete.

❖Production plan for men's children's suits, product code HTQ159369: - Production plan from June 19, 2022 to July 12, 2023.

❖Determine time for preparation steps:

Standard model design, product code HTQ159369

- Standard sample design is the process of developing a sample product based on testing so that the finished product meets the correct specifications according to the technical documents.
- Standard sample design process:

Step 1: After testing, comment, evaluate, and edit the parameter table.

Step 2: After having accurate parameters, edit the design according to standard parameters.

Step 3: When the finished product sample meets standards, the final design is drawn up and put into production.

Sample sizes of product code HTQ159369 using Lectra Modaris V7R2 software.

❖ Size jump facility:

- The average size model is size M.
- Based on the difference in measurements between those sizes is the jump from which the jump coefficient is calculated.
- Based on rendering methods and rendering calculation formulas.

Standard cupping diagram

+ Graphing is a process of arranging details of one or more products in the same size or multiple sizes on the surface of the fabric (paper), so that the usable area is minimum and meets the requirements. product specifications.

+ Trim the sample according to regulations regarding the fiber direction of the details in the product (the fiber size of the details depends on the product design and customer requirements).

+ The diagram's cupping norms must be less than or equal to the customer's norms but must ensure enough detail and conform to technical requirements.

+ In the absence of customer norms, the sample cupping diagram must ensure the efficiency of use of raw materials, achieving the highest economic efficiency.

Cupping method:

+ Check and compare the information on the form, technical documents, and samples to be consistent.

+ Check the number of details on the sample according to the statistical table. Automatic cupping on Maker making seed V6R2

Calculate the number of equipment workers:

- Number of orders: 3150 products / Production plan: X = 3150 products. - -- Production time: C = 12 days / Number of shifts in 1 day: 1 shift.

Stop time for 1 shift: 9 hours / Break time between shifts is 1 hour Number of products produced in 1 shift: P = X/C = 3150/12 = 263 products.

Break time during production shift is 1 hour Tca = 10 hours = 36000 seconds; Td = 1 hour = 3600 seconds.

$$R = \frac{Tca - Td}{P} = \frac{36000 - 3600}{263} = 123.1 \text{ s}$$

$$N = \frac{Tsp}{R} = \frac{4183}{123.1} \approx 34 \text{ People}$$

+ *Xác định số lượng lao động mỗi loại từ đó biết được số lượng công cụ và thiết bị từng loại tham gia giây chuyền sản xuất áo veston trẻ em*

+ Total product processing time (Tsp = 4183 seconds)

+ Total machining time of 1 needle (T1K = 2119 seconds)

+ Total manual manual time (Tmanual= 733 seconds)

+ Total processing time with iron (Tiron = 962 seconds)

+ Total buttonhole making time (Tbuttonhole = 78 seconds)
+ Total time to attach buttons (T attach = 56 seconds)
+ Total processing time with the extractor (Tvex= 235 seconds

IV. Conclusion

At the end of my research project, I have learned the entire process of building and developing a new product code, applying and consolidating all the knowledge of the subjects in the learning process, the knowledge that teachers teach, along with experiences learned during internships at manufacturing companies in the essay. One measure proposed for the industry today is to constantly innovate styles, designs, colors, etc. to keep up with global trends. The textile industry needs to try to be self-sufficient in raw material sources to avoid shortages due to climate changes.

References

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