

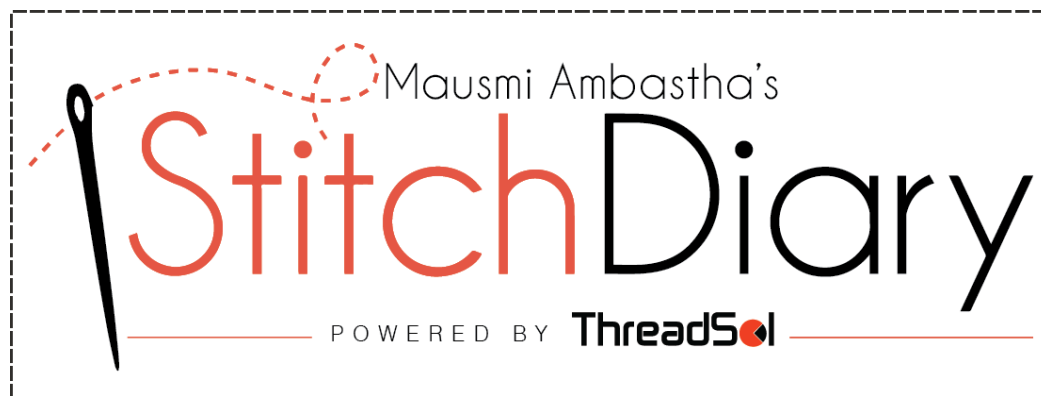
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6 Good Practices of the  
Cutting Floor

6裁剪间里的良好做法

We talk about measures or practices which can eventually work towards increasing productivity as it is the ultimate goal every manufacturer aims to achieve. But we disregard a very basic reality that working towards this goal demands incorporation of certain actions in the mainstream processes. Cutting room in a garment factory is one such extent which needs to abide by these fundamental actions. It is the last place where we want errors. Despite this, we come across situations, daily, where finding a roll or a small piece of fabric becomes a task, where plans go haywire due to on-floor variations and where a loss of even a miniscule 1m fabric can sometimes cost a hefty amount. So what basic practices can be followed, which may ease our work and trim the jumble on the cutting floor? Let us look at some of them:

我们谈论了最终可以提高生产力的措施或做法，因为它是每个制造商想实现的最终目标。但是，我们忽视了一个非常基本的现实就是为了实现这一目标而努力，我们需要在主流过程中纳入某些行动。

服装厂裁剪间需要遵守这些基本行动。这是我们想避免错误的最后一个地方。尽管如此，我们每天遇到的情况，和由于车间里找到一卷或一小块面料的变化，会令到整个计划走向混乱，甚至在1米的面料，甚至有一块微小的面料的损耗上花费大量的钱。

那么可以跟随那一些基本的做法呢来减轻我们的工作呢？然后在裁剪间层面上减少混乱？

我们来看看其中的一些方案：

### **1. Measuring roll lengths and width**

Fabric rolls may not always arrive in the same meter-age and width as ordered. There would be differences. Measuring the length and width of rolls every time they arrive in the factory becomes a significant pre-requisite. This is because knowing the actual yardage of fabric available before laying reduces the chances of fabric/garment components falling short at a later stage. Also, knowing the roll width drastically eases the

marker making process and avoids any on-floor surprises of in-roll width variations. It also helps in knowing the supplier performance.

How: 怎么样 :

### 1.测量布长度和宽度

布卷可能并不总是按照相同的米长和宽度到达工厂。每次到达工厂时会有差异，所以测量布料的长度和宽度会成为重要的先决条件。这是因为知道在裁剪前可用的布料的实际码数降低了布料/服装组合在稍后生产阶段产生短缺的机会。此外，知道面料宽度会大大加快唛架制作过程，并避免任何车间上布匹宽度变化的问题。它也有助于了解供应商的表现。

How : 怎么样 :

- Ensure that each roll is checked for yardage and width during roll inspection before going into production (100% roll inspection).
- Make a roll list report which shows the excess/shortage in each roll.

·在进行生产（100%检查布料）之前，确保每卷布料的码数和宽度检查都被检查。

·制作卷列表报告的时候，显示每卷中的多余和不足。

Benefits: 优点 :

- Knowledge of actual fabric yardage in hand.
- 了解实际面料的码数。
- Optimized marker utilization and redundancy in marker making when width variation is encountered.
- 当遇到宽度变化时，优化唛架利用率和制作中的重复。
- Lesser chances of incomplete components being cut.
- 不完整的组合被裁剪的可能性比较小。

- Provides a better view of supplier performance due to the actual known roll length.
- 从实际已知的卷长度来更好地了解供应商的表现。

## 2. Segregation of rolls by Shade/Shrinkage/Width

In my last blog, I reiterated the **benefits of grouping fabric** on the floor. Once the roll lengths and width are determined, the fabric rolls can be segregated or grouped together on the basis of next area of deviation, i.e., by shade/shrinkage/width. These differences occur from roll to roll, and are highly crucial to the quality of the end product.

How:

### 2.通过色调/缩水率/宽度的分别

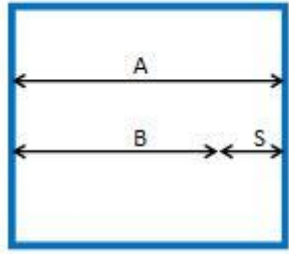
在我的最后一个博客中，我重申了将面料分组的好处。一旦确定了布匹的长度和宽度，布料可以再细分色调/缩水率/宽度来再分配。这些差异在每一卷都有发生，对最终产品的质量至关重要。

How : 怎么样 :

- Check for shade variation within a roll as well as from roll to roll.
- Ensure that visual observations are carried out under standardized conditions.
- Quality Tests of shade using standard samples.
- 检查每卷以及卷与卷之间的色调变化。
- 确保在标准条件下进行视觉观察。
- 使用标准样品来进行色度测试。

The concept of shrinkage templates can be used effectively, where, a sample area is cut from the main fabric, marked for dimensions, washed and then checked again for dimensional changes.

有效地使用缩水率测试模板的概念，我们用主要的面料然后按照样板的尺寸来裁剪样品，标记尺寸，洗涤，然后再次检查尺寸的变化。



A = Distance between gauge marks before washing

A = 洗涤前的标记距离

B = Distance between gauge marks after washing

B = 洗涤后的标记距离

S = % shrinkage.

S = 缩水率%。

- Practicing width segregation through 100% fabric inspection before sending it out for production.
- 通过100%的面料检查来实行宽度分类，然后发送出去进行生产。

Benefits:

- Increased utilization of fabric.
- Adhere to the highest quality standards.
- Reduce rejection percentage.

优点：

- 增加面料的利用率。
- 坚持最高质量标准。
- 降低排除率。

### 3. Conform to standard end loss

End loss is a necessary allowance given at the end of each ply to facilitate cutting. The standard end loss is defined by the factory for a particular type of fabric. But, if this standard margin is not maintained during laying, it either ends up with more end loss- increasing the end loss wastage or lesser than what was mentioned on the layslip- putting the cutting ease at risk. Thus, careful maintenance of margins by following standard end loss becomes essential during spreading of fabric rolls.

### 3.符合标准头尾损失

头尾损耗是铺布后每层便于裁剪补片的头尾布, 每一种特定类型的布料都有由工厂为特定义的标准损耗。但是, 如果在裁剪过程中不保持这一标准差额, 最终会导致更多的布料损耗, 从而增加头尾损耗的浪费, 或者较之前的**铺料明细表**少。因此, 通过遵循标准头尾损耗来维护布料的铺展过程是必不可少的。

优点

·避免不必要面料浪费。



How:

怎么样:

- By use of automatic spreader for laying fabric instead of manual laying, wherever possible.
- By training the layer person to conform by the standard end loss.
- 尽可能使用自动铺布机来铺布而不是用手工来铺布。
- 通过培训拉布人员按标准来控制头尾损耗。

## Benefits

### 优点

- Avoid unnecessary wastage of fabric.
- 避免不必要的面料浪费。

## 4. Record all on floor data

In my past blog I have emphasized on the eminent **need of feedback** in order to effectively control material usage in the cutting room. It becomes important to keep a record of the on floor data with vigilance of a supervisor. This would include: lay details, marker details, allowances (edge and splice allowances), remnant lengths and their processing, defect alteration (before and after cutting), cutting instructions.

### 4.记录所有车间数据

在过去的博客中，我强调了**反馈意见**的重要性，以及有效地控制裁剪间的材料使用。重要的是要保持裁剪数据的记录，并保持监督。这将包括：拉布细节，唛架细节，缝份（边缘和拼接口剩下的长度），残余长度以及其处理，缺陷修正（裁剪前后），裁剪说明。

How:

怎么样：

- By developing proper formats for recording on-floor data.
- By maintaining worksheets
- By using smart phone applications for recording data.

- 通过开发用于录制裁剪数据的适当格式。
- 通过维护工作表
- 通过使用智能手机应用程序记录数据。

Benefits:

- The supervisor will have a better know-how of the work progress at all times.
- Keeps a check on which work is overdue and needs attention.
- Easy access to reports and real-time performance.

优点：

- 主管将随时掌握工作进展情况。
- 检查哪些工作已逾期，需要注意。
- 轻松查看报告和实时表现。

## 5. Keep roll ends safely

If often happens that after completion of a lay, short lengths of material is left over. This generally takes place because the roll length is not an exact multiple of the cutting ply length. Now, if there is a considerable difference between the two, these rolls can be further made use of. Hence, we can store these roll ends safely for reuse and reduce wastage significantly.



## 5.保存好零头布

How:

怎么样：

- By maintaining proper end bit racks
- By measuring the end bits
- By proper tagging of end bits: length, roll no., shade and shrinkage
  - 保存好零头布架
  - 测量所有零头布
  - 适当标记好零头布：长度，卷号，色调和縮水率

Benefits:

优点

- Track every inch of fabric
- Cleaner cutting room due to proper management of end bits.
  - 跟踪每一英寸的面料
  - 由于正确管理零头布，使裁剪間更整潔。

## 6. Use end bits for smaller markers

6.用较小的标记来使用零头布

In order to minimize the fabric loss, it's important to use the fabric available in hand judiciously. Now, what can be done to use the remaining fabric which generally goes into end bit loss post cutting? If we store these end bits wisely,

smaller markers can be taken out from them. So instead of adding this remaining fabric to end bit loss, we can utilize it to the maximum!

这些是一些简单在裁剪间的实践，如果利用好，我们可以证明这有利于优化面料的使用，节省时间，降低成本和提高生产率。

那么，你什么时候检查过这些工厂？

为了最大限度地减少布料的损耗，能够使用手中可用的布料是很重要的。现在，使用剩下的面料我们可以做些什么，这面料通常会成为零头布？如果我们明智地存储这些零头布，或许可以从中取出较小的唛架。而我们可以最大限度地利用它，而不是添加余料及零头布。

How:

怎么样：

- By selecting usable bits keeping in mind the smallest marker.
- 用最小的唛架和可以用的余料。

Benefits:

优点：

Maximum utilisation of end bits

- 最终利用所有的零头布

Minimum wastage due to usage of small bits

- 由于使用余料而导致的最小废料

Rest of the fabric can be saved in roll form and be used for different orders.

其余面料可以以卷式来保存，并可用于不同的订单。

Well, these are some simple cutting room practices which if taken care of can prove beneficial in optimizing fabric usage, saving time, cost and increasing



productivity.

So, when are you checking your factory for these?

这些是一些简单的裁剪间实践，如果照顾好可以证明有利于优化面料的使用，节省时间，成本和提高生产率。

那么，你工厂是否会考虑此软件？