






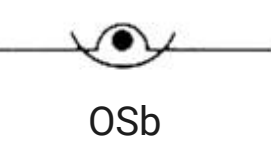















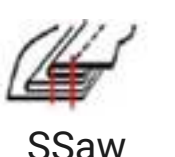









































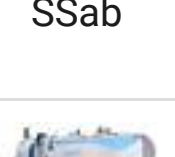

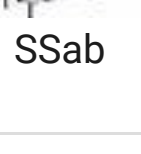

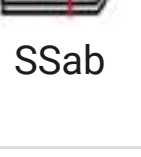

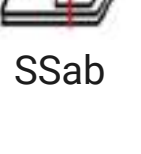

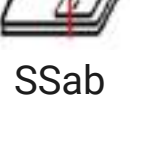

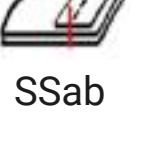



































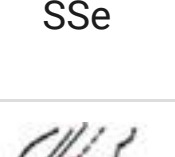

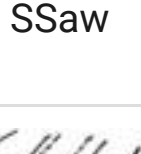



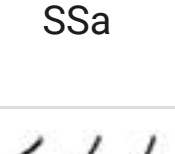




Table stages for production of overall

the number	stages	Type of machinery or equipment	The shape of the machine or equipment	Operation form	Production time (sec)	
					min	sec
1	Ironing a gray reflective cloth that is attached to the chest	industrial iron				42
2	Sewing the reflective cloth in gray on the chest of the workers' overalls	Single Needle		 SSat		37
3	Overlock stitching for some jumpsuit tops	3 threads overlock		 EFd	1	41
4	Reinforcing the pockets with a rope or string (Cord .).	Single Needle Knitting Machine		 OSb	2	14
5	Install fasteners for all pockets	Single Needle Knitting Machine		 SSa	2	21
6	The top connected with the bottom of the overalls	Single Needle Knitting Machine		 SSa		17
7	Ironing the chest pockets fabric	industrial iron			2	33
8	Chest pocket stitching on the top of the overalls	Single Needle Knitting Machine		 SSat	2	3
9	The side pocket has arrived	Single Needle Knitting Machine		 SSa	1	34
10	Knitting the side pocket of the workers' overalls	Single Needle Knitting Machine		 SSa	1	19
11	Overstitching at the edges of the side pocket	Overedge 3 Needle Knitting Machine		 EFd		27
12	How to install the velcro for the flap (flap) of the pocket cover	Single Needle Knitting Machine		 SSaw	2	15
13	Equip (Flaps) Flap (flap) foldable pocket	manually				47
14	Sewing pockets, linings and flap for the back pockets of the jumpsuit	Single Needle Knitting Machine		 SSaw	2	24
15	Sewing (Flaps) for the back pocket and the large cargo pocket	Single Needle Knitting Machine		 SSaw	2	37
16	Preparing the front part that covers the zipper of the jumpsuit	manually			1	26
17	Back stitching for workers' overalls	Single Needle Knitting Machine		 SSa	2	27
18	Sewing the Zipper Fly	Single Needle Knitting Machine		 SSe	2	10
19	Back stitching in the shape of a letter (T .) .)	Single Needle Knitting Machine		 OSa		21
20	Back (seat) stitching for jumpsuits	Single Needle Knitting Machine		 SSa		44
21	Rear Overalls Parts Connected	Single Needle Knitting Machine		 SSa		17
22	Fabricate and sew the edges of the pockets	Single Needle Knitting Machine		 EFm	1	9
23a	Iron the back pockets and the front parts of the overalls	industrial iron			3	47
23b	waist belt ironing	industrial iron				26
24	Overlock stitching for pocket flap	Overedge 3 Needle Knitting Machine		 EFd		29
25	Velcro fastening for all regular pockets and cargo (wide) pockets?	Single Needle Knitting Machine		 SSaw	2	9
26a	Sewing the back pockets and the cover (flaps)	Single Needle Knitting Machine		 SSe	2	38
26b	Sewing and fixing the flap to the back pocket of the overalls	Single Needle Knitting Machine		 SSe		37
27	Connect and sew the top of the jumpsuits with the bottom	Single Needle Knitting Machine		 SSa		34
28a	Central stitching on the front of the jumpsuits	Single Needle Knitting Machine		 SSa		39
28b	Sewing in the middle of the jumpsuit from the back	Single Needle Knitting Machine		 SSa		32
29a	Sewing and fixing the waist belt with overalls	Single Needle Knitting Machine		 SSab	2	31
29b	waist belt sew	Single Needle Knitting Machine		 SSab	1	35
30	Fastening and stitching the reinforcing rope or qaitan (Cord .) .)	Single Needle Knitting Machine		 SSab	3	13
31	Installing the main front zipper on an outer fabric strip	Single Needle Knitting Machine		 SSab	2	48
32	Installing and installing the front zipper tape on the overalls	Single Needle Knitting Machine		 SSab	3	38
33a	Sewing the gusset on the chest	Single Needle Knitting Machine		 SSab	2	46
33b	Front zipper end stitching	Single Needle Knitting Machine		 SSab		38
34	shoulder stitching	Single Needle Knitting Machine		 SSa	2	39
35	Shoulder strap stitching, cleaning and adjustment	Single Needle Knitting Machine		 SSab	2	37
36a	Sewing the epaulettes that are placed on the shoulder of the jumper	Single Needle Knitting Machine		 SSab	1	33
36b	Installing the velcro tape	Single Needle Knitting Machine		 SSab		18
37	Shoulder stitching and shoulder tape	Single Needle Knitting Machine		 SSab	1	23
38	sew jumpsuit sleeve	Single Needle Knitting Machine		 SSa	1	8
39	Sew the armhole and secure it with the overalls	Single Needle Knitting Machine		 SSa	2	23
40	Closing and sewing the side part of the overalls	Single Needle Knitting Machine		 SSa	2	3
41a	Sewing the big pockets of jumpsuits	Single Needle Knitting Machine		 SSa	2	18
41b	Sewing the big pockets of jumpsuits	Single Needle Knitting Machine		 SSa	1	12
42	jumpsuit collar ironing	industrial iron				27
43a	Separate collar stitching	Single Needle Knitting Machine		 SSa	2	43
43b	Collar Extension Sewing	Single Needle Knitting Machine		 SSa	1	14
43c	Adhesive Velcro Fixing for Collar Extension	Single Needle Knitting Machine		 SSe		35
44	The collar expansion part has arrived	Single Needle Knitting Machine		 SSa		11
45	Connecting and sewing the collar, laying down the washing instructions and sewing the collar	Single Needle Knitting Machine		 SSe	3	25
46	Large pocket and flap stitching (pocket cover)	Single Needle Knitting Machine		 SSaw	4	24
47	Fixing and sewing Velcro on the shoulder	Single Needle Knitting Machine		 SSat	1	4
48	Sewing both ends of the jumpsuits	Single Needle Knitting Machine		 SSa		38
49	Twist and bend the stitching of the sleeves and the legs of the jumpsuits	Single Needle Knitting Machine		 EFm	3	13
50	Making the fixing stitches (farmatora) for the pockets, zippers, and cover the pockets	fermator machine		 Fsf	3	11
51	Clean all sewing areas	hand scissors			1	32
	Total				75	1596
	Total in minutes				101.6	