ARTÍCULO CIENTÍFICO

TEMA:

“IMPROVING THE PROCESS OF GARMENT PRODUCTION ASSOCIATION COOPER-ACCION OF ALPACHACA”

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I. Overview

The present work aims to improve the process for preassembled in the workshop of COOPER-action Association, this partnership is a provider of school kits to children in the Government tax settlements. Participation in previous processes have not had the expected results in terms of economic gains for the members of the Association as well as also have been quality problems at the time of passing the controls on the delivery of uniforms.

Prior to this intervention of improvement, the members of the Association had a theoretical training that entails the entire clothing and in turn analysed all the problems that they had in their processes, this in order to identify existing problems and make account corrections to improve its competitiveness and ensure adequate utilities that allow to maintain the sustainability and sustainability of the workshop.

At the stage of training topics such as types of clothing, took stages of the process, quality control, production planning, production lines rolling. All this is aimed at addressing the new manufacturing practices that were implemented in the clothing workshop. It should be noted that earlier work in this workshop performed it is empirically so it intends to implement and to inform the members of the Association working proven methods applied in clothing companies.

In the practical part. We begin by identifying the problems that are evident to their respective solution, of these can enter:

*High percentage of waste*. For this item is to get a table suitable for laying and cutting of fabric, also proceeds to digitize patterns to make the stroke with the help of software optimizing raw.

*Problems in the measures of the garments*. Having digitized MOULDMAKING proceeds to assemble samples prior to the stroke, and final cut, this guarantees us that we will obtain the required measures. Another aspect to consider is the rest of the fabric mattress.

*Not-distribution of work and bad work environment*. To correct this phase proceeds to implement continuous modular production system that will enable us to equitable distribution of work and optimize available resources.

*Time by reprocessing and defective items*. By implementing the modular production system can be an auto quality
control and if there is a fault in this Assembly is detected immediately and will thus avoid reprocessing of garments as also the presence of faults.

**Failure in delivery dates.** By implementing the modular production system, information is obtained as time standards, these allow us to know times for production and make decisions to meet delivery dates.

## II. Presentation

The ‘Spinning development’ programme, carried out since 2007, the free delivery of school uniforms, while promoting a model of economic inclusion, through links with the traditional manufacturing sector.

Alpachaca Cooper-action Association is one of the providers of these uniforms, improvement of the production process of the clothing workshop ensures that persons performing this activity to improve their standard of living, and the Association is not a business model to be followed by other associations which are doing the same work.

To improve the process of clothing is needed to take into account all stages, the resources that are needed for the manufacture of garments as well as the administrative tools; all these points are discussed in the following chapters:

Chapter 1: This chapter describes the program spinning development which is part the Association, career and organization of the Association as also an analysis of the craft and entrepreneurial sector in the Ecuador.

Chapter 2: Process and machinery clothing, described all the steps needed to carry out the manufacture of garments, different types of machines that are required for such manufacture, occupational hazards and diseases and ways to prevent them.

Chapter 3: Productivity, explores the tools that are used to make a change and improve productivity as: strategic planning, process reengineering, continuous improvement, engineering methods and production planning which are a guide to the changes and take control of the process for decision-making based on real information.

Chapter 4: quality control, this with the purpose of knowing the methods of control and prevention of defects of quality in the products.

Chapter 5: a description of the process is done before implementing the improvement
and methods or areas are identified to intervene.

Chapter 6: executes the required changes to achieve improvement and implemented formats and technologies needed for this purpose. These being:

- Use of technical data sheets.
- Use of design software and scaling.
- Use of software tracing.
Calculation of raw formats.

Routing table.

Cutting method.

Waste control.
Cost of labor.

Takes time and production lines rolling.

Fuente: Cooper-acción.
Efficiency achieved.

The percentages of waste are within the standards for this type of process, contributes to the economic results expected at the end of the year. (See table 29-32).

Without a doubt one of the most notorious results of the application of this set of tools and processes organization, it is the Elimination of rework and almost free of defects in the garments. Because the planning, order and control is maintained throughout the process of manufacture of these school uniforms.

The efficiency of 75% obtained in this process, is acceptable to be the first time that it is done is of marera technical and with the proper use of resources which has the Association. (See table 41).

The achieved profitability of 50% on the investment is more than enough to ensure the sustainability and sustainability of the workshop of the Association and to encourage other associations and people entering to form part of this sector of the clothing to implement these methods of work. (See chart 46).

Socialization and pre-employment training to members of the Association had were of vital importance to achieve these results, since they had a clear idea of the changes to be executed. As your time during this stage determined the shortcomings and problems that had in previous processes. At this stage they made of the importance of making the change and pledged to put all of his party to have a good finish. (See attached pictures).

The use of programs design and stroke that were used to develop the moulds and respective strokes were of great help for ease and accuracy that provide such tools for this work.

Working with a modular production system is used all the resources in a proper manner and distributed work in an
equitable manner, which helps to maintain a good working environment. As well as help develop the skills of its members in an accelerated manner.

➢ The availability of tools and machinery maintenance are of vital importance to maintain working efficiency and quality of the products manufactured.

➢ By adopting this modular work system, lack of planning in terms of the availability of materials in the amount and at the right time can cause a significant decrease in efficiency, so you should take precautions to avoid it.

IV. References.


V. Web pages.

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