

ERKAKLAR PIDJAGI MAYDA DETALLARIGA TEXNOLOGIK ISHLOV BERISH TARTIBI TAHLILI.

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Annotasiya: Ushbu maqolada tikuvchilik sanoati eng dolzarb va tikish bo‘yicha juda katta mehnat talb etiladigan kiyim turidan biri erkaklar pidjagining ayrim mayda detallaridan: yoqa, yeng, va cho‘ntakka qanday texnologik ishlov berish tartibi bo‘linmas operatsiyalar ketma-ketligida haqida kerakli ma’lumotlar yoritilgan.

Kalit so‘zlar: bo‘linmaydigan operatsiya, ishlab chiqarish, jarayon, hakllariga, usul, o‘zgartirish, soni, detal, uzellar, mehnat sarfi, kostonim va v.h.k.

Abstract: This article provides necessary information about the technological procedure for processing some small details of a men's jacket, one of the most important and labor-intensive types of clothing in the garment industry: collar, sleeves, and pockets, in a sequence of inseparable operations.

Keywords: inseparable operation, production, process, methods, changes, number, details, nodes, labor consumption, costume, etc.

Аннотация: В данной статье представлена необходимая информация о технологическом процессе обработки некоторых мелких деталей мужской куртки, одного из наиболее важных и трудоемких видов одежды в швейной промышленности: воротника, рукавов и карманов, в последовательности неразрывных операций.

Ключевые слова: неразрывная операция, производство, процесс, методы, изменения, количество, детали, узлы, трудозатраты, костюм и др.

Kirish. Respublikamiz taraqiyotining hozirgi bosqichi har qaysi soha oldiga murakkab, miqiyosi misilsiz yangi masalalarni qo‘ydi. Yengil sanoat xodimlari korxonalarini qayta qurish, uskunalarni zamonaviylashtirish, ishlab chiqarishni kompleks mexanizatsiyalashtirish va avtomatlashtirish, yuqori sifatli, chiroyli kiyimlarning ommaviy turlarini tikadigan yuksak unumli, tezda qayta moslanuvchi yangi potok linyalarini qurish yo‘li bilan ishni tubdan yaxshilashlari kerak.

Avtomatlashtirilgan integratsiyalashgan sifat nazorati tizimlarida zamonaviy axborot texnologiyalarining rivojlanishi to‘qimachilik materiallari, matolar sifatini nazorat qilishning uzluksiz jarayonini amalga oshirishga imkon beradi[1].

Tikuvchilik sanoatida bu vazifalarni bajarish uchun avvalo texnologiyani takomillashtirish balab qilinadi. Yangi kam operatsiyali texnologiyalar yaratish tikuvchilik buyumlariga ishlov berishni takomillashtirishdagi istiqbolli yo‘nalish hisoblanadi. Kiyimning (umuman tikuvchilik buyumlarining), kiyim detallari va uzellarining konstruksiyasida choklarni iloji boricha ko‘proq kamaytirish, namlab isitib ishlov berish usullarining vibromanika singari bir jarayonli turlarida materiallarga ularning termoplastik xususiyati hisobiga shakil berish, birlashtirish va

bezash jarayonlarini birlashtirish (masalan, mag'iz, tesma qo'yishda), yelim materiallaridan keng foydalanish va h. k. ana shunday kam operatsiyali texno-logiyaga kiradi.

Kiyim sifatini yaxshilash uchun kimyoviy materiallarning yangi turlaridan foydalanish kerak bo'ladi. To'qimachilik va trikotaj, sun'iy mo'yna, sun'iy teri va sun'iy zamsha, sun'iy gazlama va sun'iy trikotaj, plyonka qoplangan materiallar, noto'qima materiallar, yelim qoplmali maxsus qotirmalar, xilma-xil furnituralar va h. k. Ana shunday material turlaridan hisoblanadi[3].

Asosiy qism. Texnologik hisoblash quyidagilarga asoslanishi kerak:

1. Zamonaviy uskunalar, zamonaviy texnologiya, texnologik jrayonlarni mexanizatsiyalashtirish va avtomatlashtirish. Uskunalarni tanlashda ularni unifikatsiya qilishga intilmoq kerak, chunki bu ishni tashkil qilishni, uskunalariga xizmat ko'rsatish va ularni ta'mirlashni yengillashtiradi.
2. Ishlab chiqarishni tashkil qilishning eng ko'p samarali ilg'or shakllari (masalan, bichiqchilikda universal kompleks brigadalar tashkil qilish, tikish tsexlarida guruhlangan agregat potok uyushtirish, kiyimlarni so'ngi namlabqisitib ishlashni markazlashtirish va hokozo).
3. Ilg'or texnika, iqtisodiy ko'rsatkichlar, texnik asoslangan ilg'or ish normalari.
4. Ishlab chiqarishni aniq ixtisoslashtirish.
5. Ilg'or ish usullari, ish vaqti bekor ketishini bartaraf etadigan, nuqsonlarni mashinalar bo'sh qolishini qisqartiradigan ilg'or ish usullari, ish o'rinlarini oqilona tashkil etish.
6. Ish sharoiti xavfsiz va ozoda bo'lishi, og'ir hamda ko'p mehnat sarf bo'ladigan ishlarni mexanizatsiyalashtirish. Mexanizatsiyalashtirish vositalarini tanlashda yuklarni bir joydan boshqa joyga kamroq tashiladigan bo'lishiga erishish kerak. Bu yordamchi ishchilarni kamaytirish imkonini beradi. Bundan tashqari mexanizatsiyalashtirish vositalarini ixtisoslashgan muassasalar chiqarayotgan tipik uskunalariga mo'ljallab tanlash lozim.
7. Korxonalar imorati texnologik jarayonini iqlim sharoitini hisobga olib, eng ratsional tipda qurilishi. Chunki imoratning tipi va ustunlar orasidagi masofa uskunalarining qanday joylashtirilishiga anchanina ta'sir etadi[2].

Materiallarni tanlash va asoslash: Gazlama tejamlir oq ishlatilishi uchun ma'lum qoidalarga rioya qilish zarur. Masalan, katak yoki yo'l-yo'l gulli gazlamalarni bichish uchun mo'ljallangan bo'rlama tayyorlanganda andozalarni shunday joylashtirish kerakki, kiyim tikilgandan keyin ham uning bo'laklaridagi rasmlar o'zaro mos tushsin. Tvid, velvet, bahmal, kabi tukli gazlamalardan tikilgan pidjaklar barcha bo'laklarining tuki yuqoriga yo'nalgan bo'lishi kerak, aks holda kiyim ko'p ishqalanadigan joylari yaltirab qoladi.

Gulsiz sidirg'a gazlamalarni bichishga mo'ljallangan bo'rlama tayyorlash uchun andozalarni qarama-qarshi joylashtirsa ham bo'ladi. Agar bichiladigan gazlama yo'l - yo'l yoki katak bo'lsa, tikilayotganda yo'llari yoki kataklarini to'g'ri keltirish uchun bo'laklar mo'ljallangandan kattaroq qilib bo'rlanadi. Bunda bo'lak bichiladigan gazlama qaysi usulda to'shalishi, bo'lak tayyor kiyimning qaysi joyida qanday joylashishini hisobga olish kerak[8]. Shunda kiyim bo'laklarining hamma tomonini barobar kengaytirmay, balki bir tomonini kengaytirib bo'rlash kifoya bo'ladi. Old bo'lakning bort tomoni, adipning bo'yin o'miziga yaqin tomoni, yoqaning qaytarma va uchlarini kengaytirib bo'rlanadi[6].

Gazlama sidirg`a bo`lsa, chiqindi kamroq, guldor yoki tukli bo`lsa, ko`proq chiqadi, chunki tukli yoki guldor gazlamalar uchun andazalar joylashtirishda kengaytirib bo`rlash kabi qator shartlarni hisobga olish kerak. Andazalarni zichroq joylashtirish uchun, oldin katta bo`laklarni qo`yib, ular orasiga mayda bo`laklar joylashtiriladi.

Joylashmani bajarishda ayniqsa bichiq bo`laklar soniga e`tibor berish zarur. Simmetrik bo`laklar bir tomonga qarab qolmasligi uchun 1-jadvaldagi bo`laklarning simmetriya belgisiga katta ahamiyat beriladi. Aks holda bitta bo`lak ikki marta bichib qo`yilishi mumkin. Andozalar gazlama ustiga joylashtirilib bo`rlanadi. Joylashmadan chiqindi kam chiqishi uchun adipga, yeng astariga uloq qo`yilishi, adip ikki yoki uch bo`lakdan iborat qilib bichilishi mumkin. Bo`rlamada bo`r chizig`ining qalinligi 1-2 mm dan oshmasligi kerak. Bo`rlamada albatta kertiklar o`rni bo`rlanishi shart[4].

Kiyim tikish texnologik tartibini tuzish: Texnologik jihatdan bo`linmaydigan operatsiya tikish jarayonining mumkin bo`lmagan yaxlit elementidir. Har bir tur kiyimni ishlab chiqarish jarayonidagi bo`linmas operatsiyalarning mazmuni va miqdori jarayonining tashkiliy shakllariga bog`liq emas. Kiyim tikish usul o`zgartirish bilan birga texnologik jihatidan bo`linmaydigan operatsiyalarning soni va mazmuni ham o`zgaradi. Kiyimlarning tikilishi qanchalik murakkab, undagi detal va uzellar qanchalik ko`p, mehnat sarfi qanchalik yuqori bo`lsa texnologik jihatidan bo`linmas operatsiyalar shunchalik ko`p bo`ladi[7].

Masalan, pal`to yoki kostyum tikishda 300 dan ortiq texnologik bo`linmas operatsiyalar bo`ladi. Texnologik jihatdan bo`linmaydigan operatsiyalar tanlangan eng maqbul tikish usullari asosida fabrikaning eksperimental sexda tuziladi[5].

Xulosa. Ushbu operatsiyalarni ishlab chiqish tikish usulini aniqlashdan, ishlatiladigan uskunalardan kichik mexanizatsiya vositalarini, asboblarni, tikishning texnologik rejimini tanlashdan, ishlarning qaysi razryadga oidligini va operatsiyalarni bajarish uchun zarur vaqtni belgilashdan iboratligi 1-jadvalda faqat erkaklar kostuyminig ayrim detallaridan: yoqa, yeng va listochkali cho`ntakning tikilish ketma-ketligi 50 yaqin tartibda yoritildi. Texnologik jihatdan bo`linmaydigan operatsiyalarning texnologik tartibini tuzishda barcha detallari olinmadi. Bu formaning har qaysi operatsiya qanday uskunada bajarilishi qisqartirib yoziladi: D-dazmol, M-mashina, MM-mahsus mashina, PR-press Q-qo`lda va bosh -qa usullar asosida.


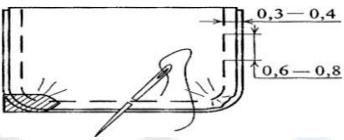
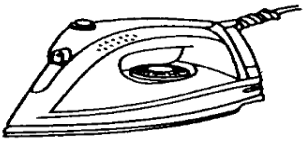

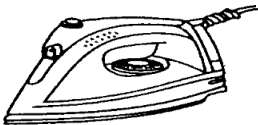
Bir modelli oqimda buyumga ishlov berishning texnologik tartibi

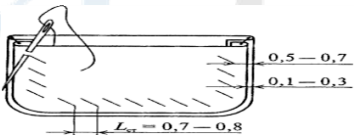
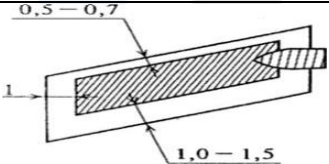
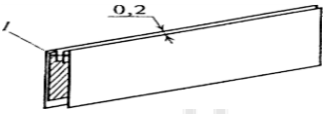
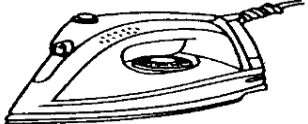
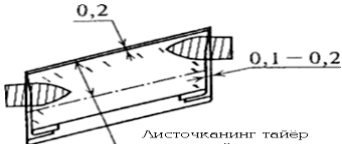
1 -jadval

№	Texnologik (bo`linmas) operatsiyalar nomi	Detallar ko`rinishi	Sarf vaqt	Asbob-uskuna (moslamalar)
1	2	3	5	6
1	Bichiqqlarni qabul qilish .		15	Qo`lda

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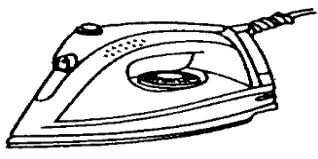
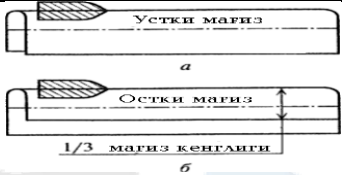
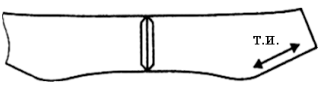
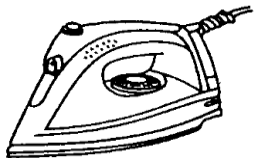

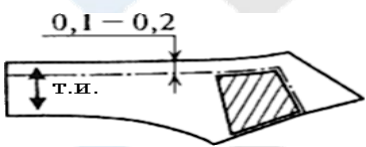
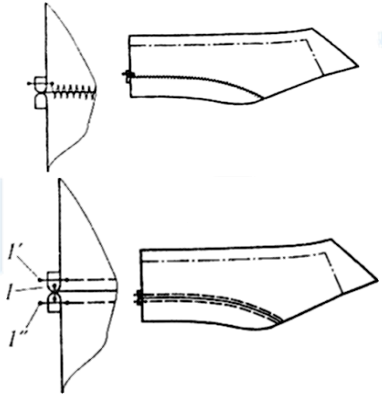
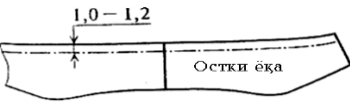
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2	Choʻntak qopqoqqa qotirma yopishtirish.		20	<u>HSL-KS-01S</u> - <u>Hasel</u> dazmol va dazmol stoli
3	Ostki choʻntak qopqoqni ustki choʻntak qopqoqqa koʻklash.		15	Qoʻlda, igna-ip
4	Choʻntak qopqoqni dazmollash.		20	<u>HSL-KS-01S</u> - <u>Hasel</u> dazmol va dazmol stoli
5	Choʻntak qopqoqni tikish.		20	<u>Jack A6F-E-Q</u>
6	Choʻntak qopqoqni gazmollash.		15	<u>HSL-KS-01S</u> - <u>Hasel</u> dazmol va dazmol stoli

7.	Choʻntak qopqoqni oʻngiga agʻdarish.		20	Qoʻlda
Listochkaga ishlov berish				
8.	Listochkaga qotirma yopishtirish.		25	<u>HSL-KS-01S</u> - <u>Hasel</u> dazmol va dazmol stoli
9.	Listochkaning yuqori qirqimini tikish.			<u>Jack A6F-E-Q</u>
10.	Listochkani oʻngiga agʻdarish va dazmollash.		30	<u>HSL-KS-01S</u> - <u>Hasel</u> dazmol va dazmol stoli
11.	Listochkaning yuqori qirqimini tikish.		20	<u>Jack A6F-E-Q</u>

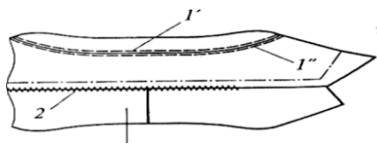
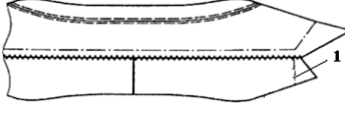
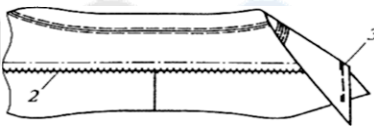
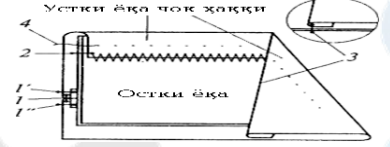
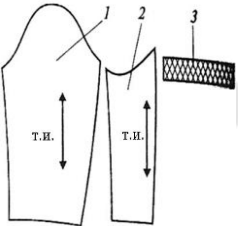

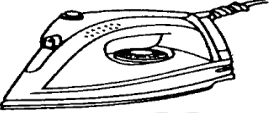
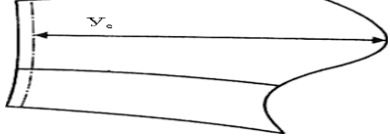
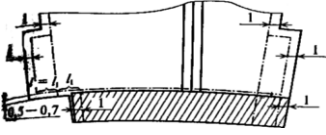
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12.	Listochkani o'ngiga ag'darish va dazmollash.		20	HSL-KS-01S - Hasel dazmol va dazmol stoli
13.	Ostki va ustki mag'izlarni dazmollash.		25	HSL-KS-01S - Hasel dazmol va dazmol stoli
Ostki yoqaga ishlov berish				
14.	Ikki bo'lakdan iborat ostki yoqani tikish.		10	Jack A6F-E-Q
15.	Ostki yoqani dazmollash.		10	HSL-KS-01S - Hasel dazmol va dazmol stoli
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Ustki yoqani ostki yoqaga ulash				
19.	Ostki yoqaga ustki yoqani ulash chizig'ini belgilab olish.		0.5	Qo'lda bo'r va sm

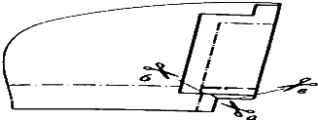
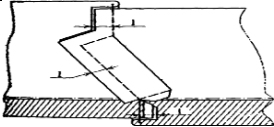
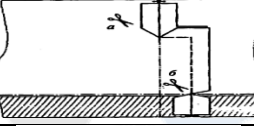
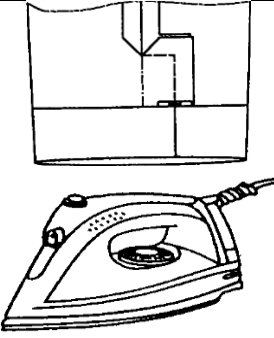
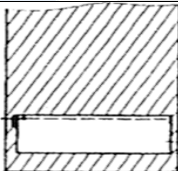
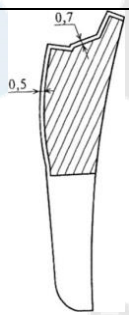

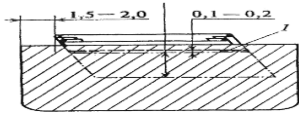
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22.	Ustki yoqani ostki yoqa belgi chizig'i ustiga biriktirish.		10	Qo'lda bo'r va sm
23.	Yoqaga ishlov berish.		10	Qo'lda ko'klash
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25.	Yengning old qirgimlarini ko'klash.		10	Qo'lda
26.	Yengning old qirgimlarini biriktirib tikish.		10	<u>Jack A6F-E-Q</u>
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Yengni pastki qirgimiga ishlov berish				
28.	Yengni uzunligini aniqlab olish.		0.5	Qo'lda bo'r va sm
29.	Yengni pastki qirgimiga qotirma yopishtirish.		15	<u>HSL-KS-01S</u> - Hasel dazmol va dazmol stoli

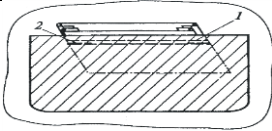
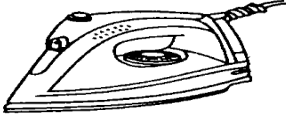
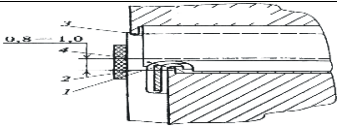
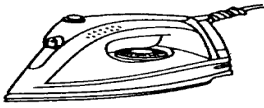
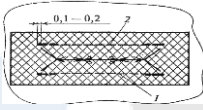
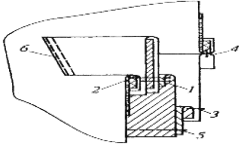
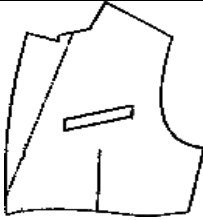
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