

**O`ZBEKISTON RESPUBLIKASI  
OLIV VA O`RTA MAXSUS TA'LIM VAZIRLIGI**

**NAMANGAN MUXANDISLIK TEXNOLOGIYA INSTITUTI**

**«TIKUV BUYUMLARI TEXNOLOGIYASI» FANIDAN**

Mavzu: Erkaklar pidjagi mayda detallariga texnologik ishlov berish va texnologik tartibini tuzish.

# Kurs loyihasi

**Bajardi:**

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**NAMANGAN-2014**



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 qoplpmali maxsus qotirmalar, xilma-xil furnituralar va h. k. Ana shunday material turlaridan hisoblanadi. Paralell ishlov berish uskunalarida ultratovush yordamida payvandlash sintetik materiallardan va sintetik tola aralash materiallardan tayyorlanadigan kiyim detallarini birlashtirishning eng samarali usulidir.

Ayrim detallarni, uzellar va eng jo`n buyumlarni tola massasining yoki polemer eritmaning bevosita o`zidan shakil berib yasash texnologiyada eng istiqbolli yo`nalish bo`ladi. Bunday texnologiyada mahnat unimdorligi, avtomatlashtirish imkoniyatlari anchagina ortadi. Bundan tashqari, umuman kiyimni yoki uning ayrim qisimlarini eskirishiga qarshiligi ortadigan, turg`un shakilli, ezilmaydigan, muhofaza qilish xususiyati yaxshilanadigan va h. k. qilishda kimyoviy materiallarning imkoniyatlari juda katta. Hozirda shim, yubka, erkaklar ko`ylagi, plash, sport kiyimlari va maxsus kiyimlarga ishlov berishda gazlamalarni «forniz» usulida ezilmaydigan qilib pardozlash keng tarqalmoqda.

Yuqori sifatli kiyimlarni ommaviy tikishning kompleks avtomatlashgan korxonalarini yaratish, jumladan, ishlab chiqarishning tayyorlov-bichuv, tikish va pardozlash uchustkalaridagi; tayyor mahsulotni o`rash va saqlash joylaridagi asosiy texnologik jarayonlar uchun hisoblash texnikasi, mikroprotssessor vositalaridan keng foydalaniladigan maxsus ixtisoslashtirilgan sistemalar, linyalar, robotokomplekslar, yangi yarim avtomat tikuv uskunalarini ishlab chiqarishdan iborat.

Kiyim konstruktsiyasini yaratishdan boshlab to tayyor mahsulot sotilgunga qadar barcha bosqichlarda ishlab chiqarishning qayta moslashuvchanligini ta`minlash uchun avtomatlashtirilgan boshqaruv sistemasini mahalliy tarmoqlarga birlashtirilgan EHMLar bazasida takomillashtirish ham katta vazifalardan biridir.

Yangi korxonalarini loyihalashda va ishlab turganini qayta qurishda tashkiliy-texnologik xulosalarning muhim ahamiyati bor. Chunki bo`lajak korxonaning qanchalik samarali bo`lishi shu xulosalarga bog`liq. Bunda mehnat

unimini oshirishga, mahsulot sifatini yaxshilashga, ishlab chiqarish maydoni va texnikadan to'la foydalanishga yordam beradigan maslalani hal etishga alohida ahamiyat berilmog'i kerak.

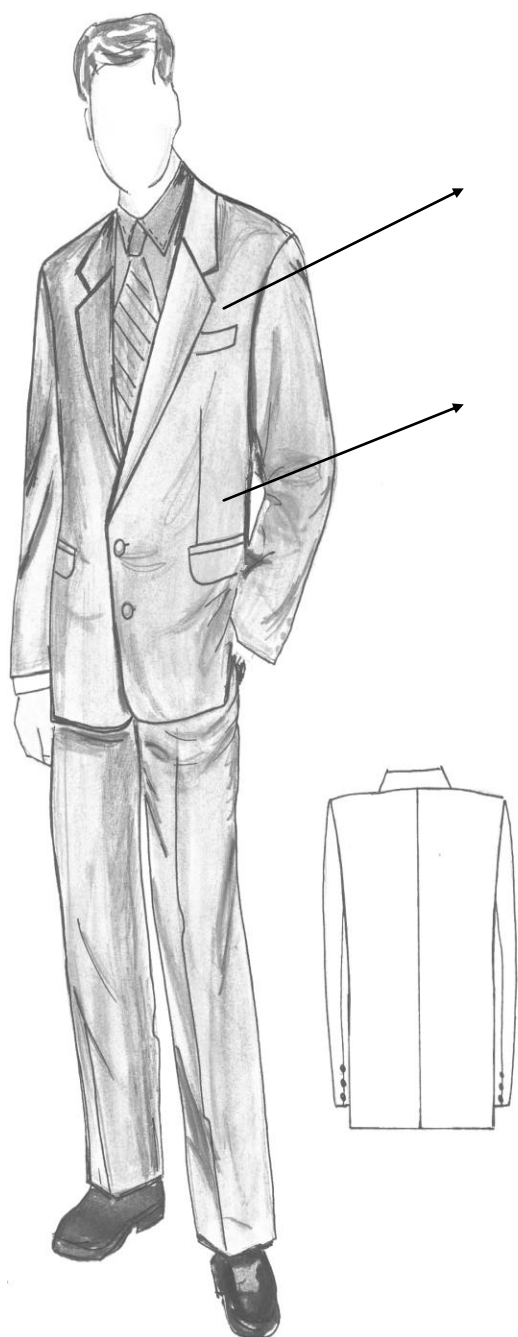
Texnologik hisoblash quyidagilarga asoslanishi kerak:

1. Zamonaviy uskunalar, zamonaviy texnologiya, texnologik jrayonlarni mexanizatsiyalashtirish va avtomatlashtirish. Uskunalarni tanlashda ularni unifikatsiya qilishga intilmoq kerak, chunki bu ishni tashkil qilishni, uskunalarga 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 xokozo).
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 uskunalarga mo'ljallab tanlash lozim.
7. Korxonalar imorati texnologik jarayonini iqlim sharoitini hisobga olib, eng ratsional tipda qurilishi. Chunki imoratning tipi va ustunlar orasidagi masofa uskunalarning qanday joylashtirilishiga anchanina ta'sir etadi.

Эркаклар пиджак майда деталларига технологик ишлов бериш ва технологик тартибини тузиш

## ***2. Model tanlash va asoslash.***

Erkaklar pidjagi mayda detallariga texnologik ishlov berish va texnologik tartibini tuzish.



## ***3. Materiallarni tanlash va asoslash.***

Gazlama tejamliroq 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. 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 uchlari kengaytiribroq bo`rlanadi.

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.

Bichishga mo`ljallangan gazlama ko`rikdan o`tkaziladi, to`qimachilik nuqsonlari aniqlanadi, dekatirovka qilinib (suv purkab yoki namlab) dazmollanadi.

Joylashmaning sifatini baholovchi ko`rsatkich chiqindi qiymatidir.

Korxonada andozalar joylashmasi namunaviy sxemalar bo`yicha bajariladi. Namunaviy sxemalar-gazlamaning ma`lum eniga mo`ljallangan, kiyim andozalari turli razmer va bo`yi bo`yicha o`zaro moslashtirilgan, kam chiqindi chiqish imkonini beruvchi joylashmadir.

Hozirgi vaqtda zamonaviy korxonalarda turli model va bichimdagi kiyim andozalarini har xil enli gazlama ustiga ratsional joylashtirish bo`yicha tavsiyalar mavjud bo`lib, ularning aksariyati joylashmani bajarishdagi texnik shartlarda o`z aksini topgan.

#### ***4. Asbob-uskunalar tanlash va tikish usullari.***

#### ***5. Kiyim tikish texnologik tartibini tuzish.***

Texnologik jixatdan 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 jixatidan bo`linmaydigan operatsiyalarning soni va mazmuni xam o`zgaradi. Kiyimlarning tikilishi qanchalik murakkab, undagi detal va uzellar qanchalik ko`p, mexnat sarfi qanchalik yuqori bo`lsa texnologik jihatidan bo`linmas operatsiyalar shunchalik ko`p bo`ladi. Masalan, palto 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.

Bu operatsiyalarni ishlab chiqish tikish usulini aniqlashdan, ishlatiladigan uskunalardan kichik mexanizatsiya vositalarini, asboblarini, tikishning texnologik rejimini tanlashdan, ishlarning qaysi razryadga oidligini va operatsiyalarni bajarish uchun zarur vaqtni belgilashdan iborat. Texnologik jixatdan bo`linmaydigan

operatsiyalarning texnologik tartibini tuziladi. Bu formaning har qaysi operatsiya qanday uskunada bajarilishi qisqartirib yoziladi

D-dazmol

M-mashina


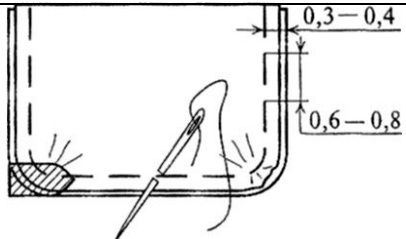
MM-mahsus mashina

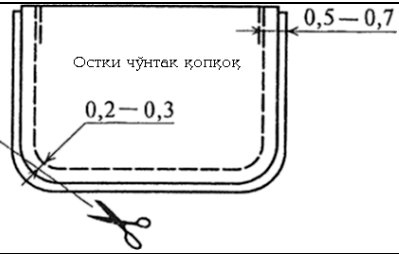
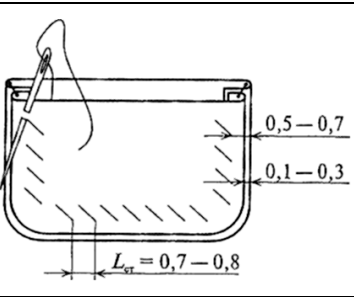
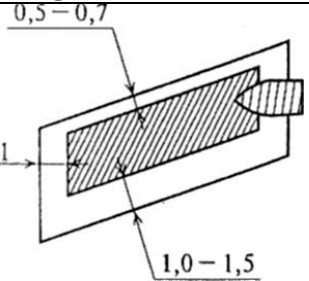
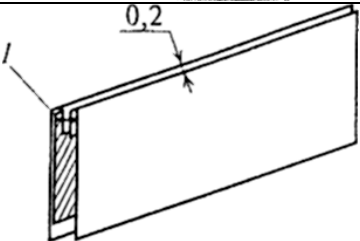
PR-press

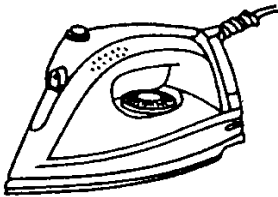
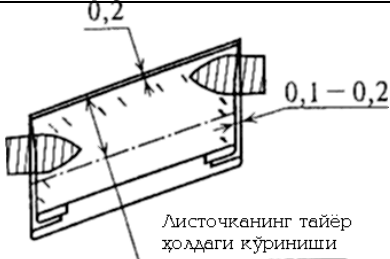
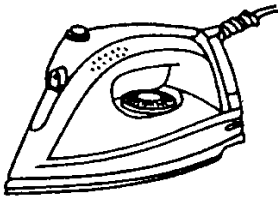
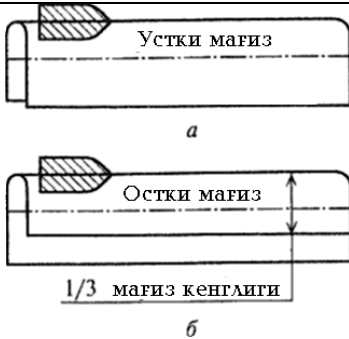
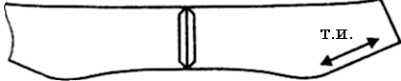
Q-qo`lda.

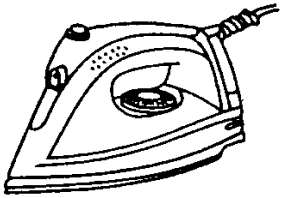
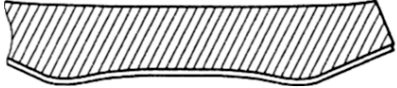
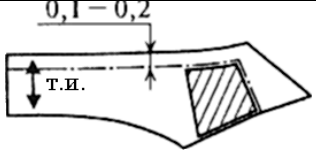
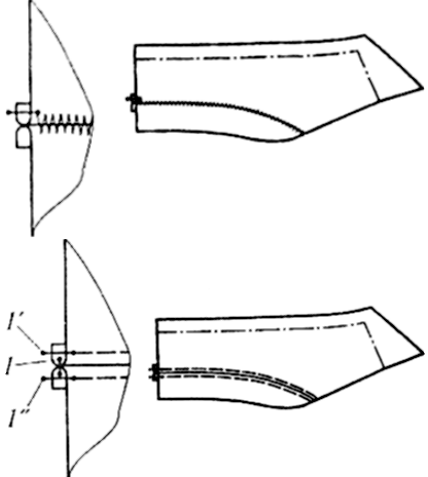
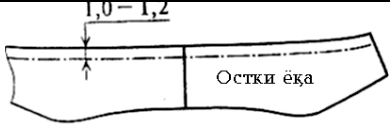
*Bir modelli oqimda buyumga ishlov berishning texnologik tartibi*

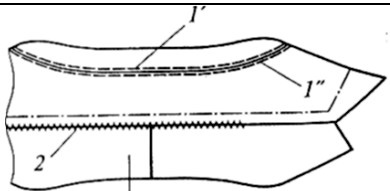
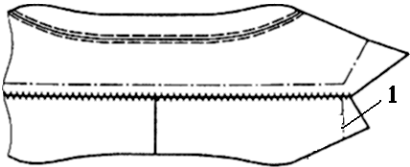
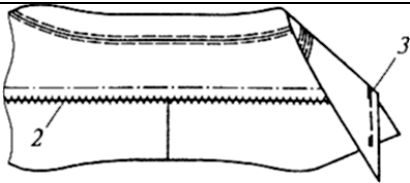
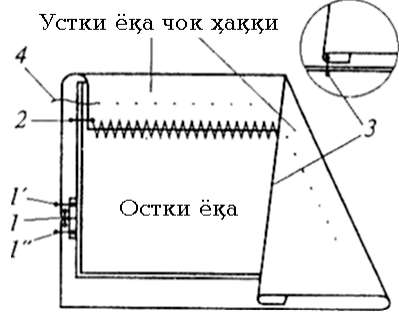
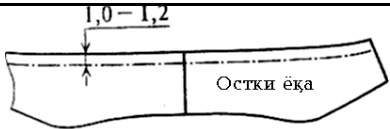
**5.1 -jadval**

T.r	Texnologik operatsiyalar nomi (bo`linmas)	Ixti SOS	Sarf vaqt	Asbob-uskuna (moslamalar)
1	2	3	5	6
1	Bichiq larni qabul qilish	Q	15	qulda
2	Cho`ntak qopqoqqa qotirma yopishtirish.		20	UTP
3	Ostki cho`ntak qopqoqni ustki cho`ntak qopqoqqa ko`klash.		15	UTP
4	Cho`ntak qopqoqni dazmollash.		20	JUKI DLN-9010SS

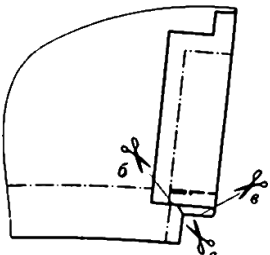
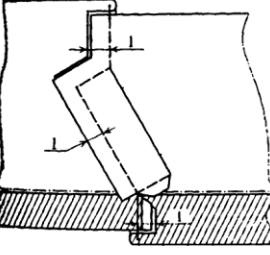
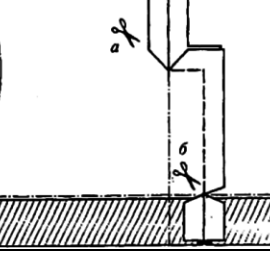
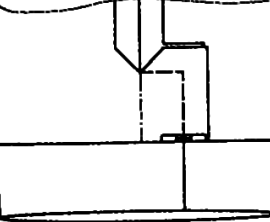
5	Cho`ntak qopqoqni tikish.		20	UTP
6	Cho`ntak qopqoqni gazmollash		15	JUKI DLN-9010SS
7.	Cho`ntak qopqoqni o`ngiga ang`darish.		20	Qo`lda
<b>Listochkaga ishlov berish</b>				
8.	Listochkaga qotirma yopishtirish.			
9.	Listochkaning yuqori qirqimini tikish.			
10.	Listochkani o`ngiga ag`darish va dazmollash.			

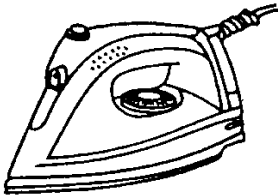

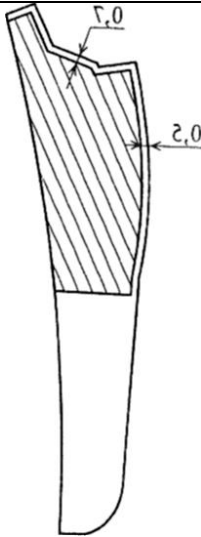
				
11.	Listochkaning yuqori qirqimini tikish.			
12.	Listochkani o'ngiga ag'darish va dazmollash.			
13.	Ostki va ustki mag'izlarni dazmollash.			
<b><i>Ostki yoqaga ishlov berish</i></b>				
14.	Ikki bo'lakdan iborat ostki yoqani tikish.			

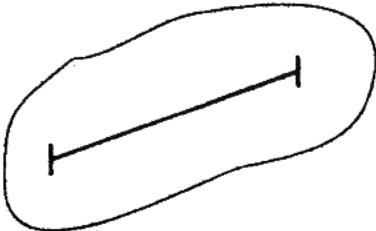
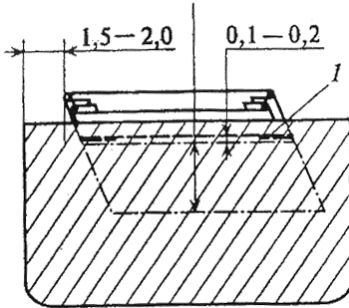
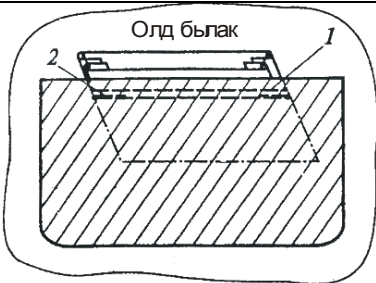
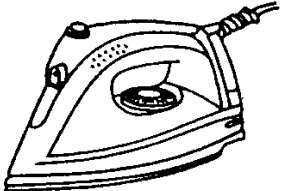
15.	Ostki yoqani dazmollash.			
16.	Ostki yoqaga qotirma yopishtirish.			
<b><i>Ustki yoqaga ishlov berish</i></b>				
17.	Yoqa uchlariga qotirma yopishtirish.			
18.	Ko'tarmani ustki yoqaga ulash.			
<b><i>Ustki yoqani ostki yoqaga ulash</i></b>				
19.	Ostki yoqaga ustki yoqani ulash chizig`ini belgilab olish.			
20.	Ustki yoqani ostki yoqaga qayirib qo'yiladigan cheti (otlyot) ni			

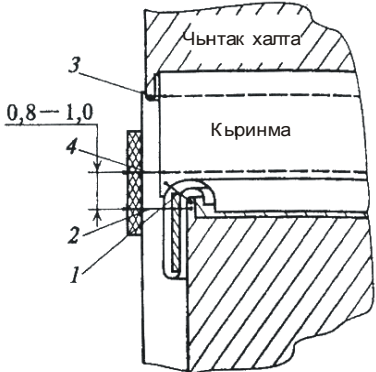
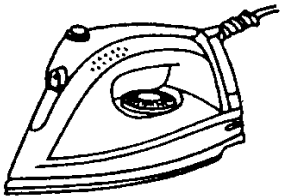
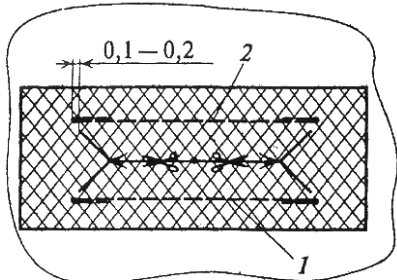
	tikish.	 <p>Остки ёқанинг юза томони</p>		
21.	Ostki va ustki yoqa uchlarini belgilash.			
22.	Ustki yoqani ostki yoqa belgi chizig`i ustiga biriktirish.			
23.	Yoqaga ishlov berish.	 <p>Устки ёқа чок ҳаққи</p> <p>Остки ёқа</p>		
24.	Ostki yoqaga ustki yoqani ulash chizig`ini belgilab olish.	 <p>1,0-1,2</p> <p>Остки ёқа</p>		
<b>Chokli yengga ishlov berish</b>				

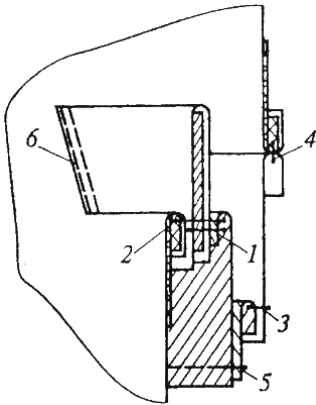
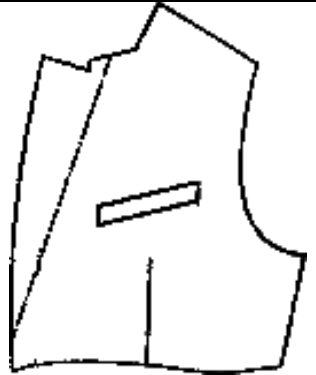


31.	Ustki yeng shlitsa burchagini hosil qilish.			
32.	Ostki va ustki yengni tirsak choklarini tikish.			
33.	Shlitsa burchaklariga ishlov berish.			
34.	Yengni buklov chizi'i bo'yicha buklab dazmollash.			

				
<i>Cho'ntak xaltaga ishlov berish.</i>				
35.	Cho'ntak xaltaga ko'rinmani tikish.			
<i>Adipga ishlov berish.</i>				
36.	Adipga qotirma yopishtirish.			
37.	Cho'ntak o'rini belgilash.			

				
38.	Listochkani cho'ntak xalta bilan biriktirish.			
39.	Old bo'lakka listochkani ko'klab ulash.			
40.	Listochkani old bo'lakka tikish.			
41.	Listochka ulangan chokni dazmollash.			
42.	Ko'rinmani cho'ntak xaltaga biriktirish.			

43.	Old bo'lakka ko'rinmani ulash			
44.	Ko'rinma ulangan chokni dazmollash.			
45.	Listochka va ko'rinmaning to'g'ri tikilganligini tekshirish.			
46.	Cho'ntak og'zini qirqish.			

47.	Listoch-kani burchagini qotirish.	 <p>A technical drawing showing a cross-section of a corner joint assembly. The drawing includes several numbered components: 1 is a vertical post, 2 is a horizontal post, 3 is a small rectangular block, 4 is a small rectangular block on the right side, 5 is a horizontal base, and 6 is a large, angled piece that fits into the corner. The drawing uses hatching to indicate different materials or sections.</p>		
48.	Ko'klash ishlarini ol tashlash.	 <p>A technical drawing of a piece of material, possibly a board or sheet, with a rectangular hole cut out of it. The drawing shows the irregular shape of the material and the precise rectangular cutout.</p>		
49.	Cho'ntakka namlab isitib ishlov berish.			