

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

**NAMANGAN MUXANDISLIK TEXNOLOGIYA INSTITUTI**

«TIKUV BUYUMLARI TEXNOLOGIYASI» FANIDAN

Mavzu: Ayollar plashini texnologik ishlov berish, texnologik tartibini tuzish.

# Kurs loyihasi

**Bajardi:**

**15au-11 guruhi talabasi**  
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## 1 Kirish

O'zbekiston to'qimachilik va yengil sanoat rivojlanishi uchun katta miqdorda tabiiy xom ashyo resurslari mavjud. Ushbu resurslardan tayyor mahsulot olib chiqarib, avvalo ichki bozorni to'ldirib, so'ngra sifatli va raqobatbardosh buyumlar bilan jahon bozoriga chiqish respublikamiz iqtisodiyotining yetakchi yo'nalishlaridan biridi.

Yuqori sifatli tikuv buyumlarini loyihalashtiri, ularni ishlab chiqarishning zamonaviy iqtisodiy xususiyatlariga to'g'ri yondashib, mutaxassislikka oid murakkab masalalarni yechishga qodir va estetik qonunlarni mukammal egaldlagan yuqori malakali kadrlarni tayyorlash muhim vazifadir. Shu sababli kadrlar tayyorlash milliy dasturida va milliy modelda ilmiy uzluksiz ta'limning mazmunini va tashkiliy rivojlanishiga doir strategik yo'nalish asaoslangan holda aniq belgilangan.

Yengil sanoatdagi o'zgargan vaziyatlar, kichik firma va qo'shma korxonalarni tashkil etish, assortimentni tez-tez yangilanadigan va tez moslashadigan texnologik «tugallangan tsikllar» kompleksini yaratish (ya'ni, tolalarni qayta ishlashdan boshlab tayyor buyum chiqarishgacha) sohasi bo'yicha mutaxassislar tayyorlash jarayoniga yangicha yondashuvini talab qiladi. Zamonaviy mutaxassis bir vaqtning o'zida dizayner, konstruktor, texnolog, marketolog va o'z mahsulotini muvaffaqiyatli sotuvchi kabi vazifalarni bajarish kerak.

Tikuvchilik sanoati oldiga qo'yiladigan masalalarni yechishda kiyimni amaliy va ilmiy jihatdan konstruksiyalash ishlarietaksi o'rini egallaydi, chunki loyihalashning ayni shu bosqichida kiyim va uning sifatiga qo'yiladigan barcha ijtimoiy va texnik-iqtisodiy talablar to'liq hisobga olinishi kerak.

Respublikamiz taraqqiyotining hozirgi bosqichi har qaysi soha oldiga murakkab, miqiyosi misilsiz yangi masalalarni qo'ydi. yengil sanoat xodimlari korxonalarni qayta qurish, uskunalarni zamonaviylashtirish, ishlab chiqarishni kompleks mexanizatsiyalashtirish va atomatdlashtirish, yuqori sifatli, chiroyli

kiyimlarning ommaviy turlarini tikadigan yuksak unumli, tezda qayta moslanuvchi yangi potok linyalarini qurish yo'li bilan ishni tubdan yaxshilashlari kerak.

Tikuvchilik sanoatida bu vazifalarni bajarish uchun avvalo texnologiyani takomillashtirish talab 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, biriktirish va bezash jarayonlarini birlashtirish (masalan, mag'iz, tesma qo'yishda), yelim materiallaridan keng foydalanish va h. k. ana shunday kam operatsiyali texnologiyaga 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 qoplamali 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 biriktirishning 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 pardoqlash keng tarqalmoqda.

Yuqori sifatli kiyimlarni ommaviy tikishning kompleks avtomatlashgan korxonalarni 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 uskunalari ishlab chiqarishdan iborat.

Kiyim konstruksiyasini yaratishdan boshlab to tayyor mahsot sotilgunga qadar barcha bosqichlarda ishlab chiqarishning qayta moslashuvchanligini ta'minlash uchun avtomatlashtirilgan boshqaruv sistemasini mahalliy tarmoqlarga birikkan EHMLar bazasida takomillashtirish ham katta vazifalardan biridir.

Yangi korxonalarni 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 shakillari (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. Korxona 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.

Hozirgi vaqtda yangi korxonalar qurish bilan birga ishlab turganlarini qayta qurishga ham katta ahamiyat berilmoqda. qayta qurishni loyihalashdagi asosiy vazifa mahsulot ishlab chiqarish hajmini anchagina oshirishdan iborat.

Qayta qurish loyihasining tashkiliy-texnika qismidan unchalik farq qilmaydi. Biroq uskunalarni joylashtirishda ilgari qurilgan bino ichidagi ustunlar oralig'ini, mavjud tsexlarning bo'yi va enini, imorat balandligini va boshqalarni hisobga olish kerak bo'ladi.

Ishlab chiqarish imoratini qayta qurishda ixtisoslashtirish uskunalarini modernizatsiyalashtirish, uskunalarini yangilash, og'ir va ko'p mehnat qiladigan ishlarni mexanizatsiyalashtirish, texnologik jarayonni tashkil qilish formasini o'zgartirish masalalarini eng avval hal qilib olish kerak bo'ladi.

qayta qurish loyihasining qanchalik samarali ekani bu ishga ketadigan xarajatlar qiymati va mahsulot tannarxini kamayishiga qarab belgilanadi. Shuning uchun sarflangan kapital mablag' tezroq qoplanadigan va mahsulot ishlab chiqarish jadallashishi mumkin bo'lgan korxonalarni birinchi navbatda rekonstruktsiya qilgan maqul.

## 2. MODEL TANLASH VA ASOSLASH.

Ayollar plashi to'g'ri, yarim yopishgan va trapetsiya formalı bo'lishi mumkin. Ayollar plashi ishlanish jihatdan kam ishlanishli, kam mehnat sarf qilinadigan texnologiya hisoblanadi. Plashni tikishda bir va ikki ignali mashinadan, avtomat tarzda to'xtaydigan ignali mashinada bosib ko'tarma lapkali, ip uzgichli, chokning oxiri va boshida puxtalovchi mashinalardan; yarim avtomat mashinalardan tugma puxtalashda, izmani puxtalashda foydalaniladi.

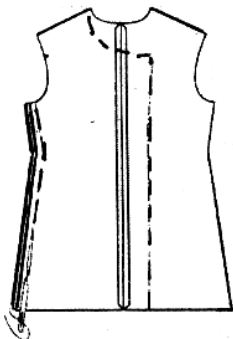
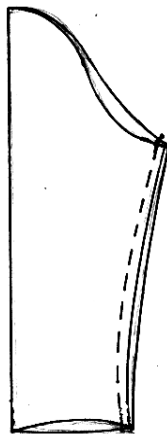
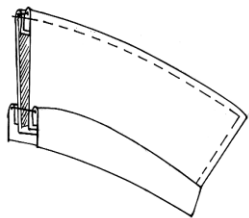
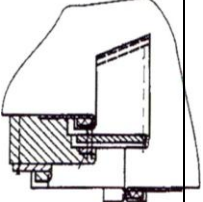
Bo'laklarga yelimli qotirma yopishtirishda namlab isitib ishlov berish asbob uskunalari to'plami ishlatiladi. Ayollar plashining razmerini doimiyligini ta'minlash uchun, bo'laklar shaklini saqlash uchun yelimli qotirma adipga, yoqaga, listochkaga, pat koketka obtachkasiga va boshqa mayda bo'laklariga dazmol yoki press yordamida yopishtiriladi.

Mayda bo'laklarga yelimli qotirma yopishtirilgandan so'ngra ular tikib tayyorlanadi.

Ustki va ostki patni o'ngini o'ngiga qo'yib 0.5-0.7 sm kenglikda ag'darma chokda tikiladi. Patlar shakli jihatdan turli xil bo'lishi mumkin. Patning bir uch tomoni burchak shaklida, aylana, to'g'ri va hokazo bo'ladi. Ag'darma chokda tikilgan pat bir tomon burchaklari kesilib o'ngiga ag'dariladi va ustki pat ziy chiqarib dazmollanadi.

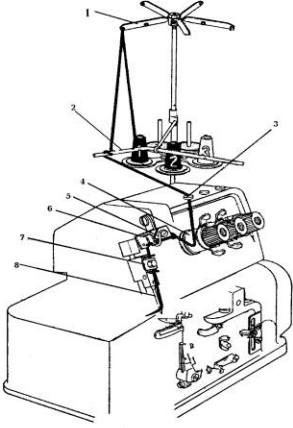
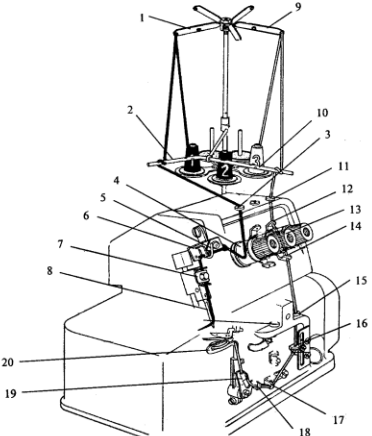
Plash belbog'lari yaxlit bichiqli yoki 2 bo'lakdan iborat bo'lishi mumkin. Yaxlit bichiqli belbog'ni tikishda, belbog' ikkiga bukilib o'ngi ichiga olinadi va ikki tomoni biriktirib tikiladi. Agar belbog' bir tomon burchak shaklda bo'lsa, u holda burchaklari ag'darma chokda 1.0 sm kenglikda tikiladi va burchaklari qirqilib belbog' ochiq bir tomonidan o'ngiga ag'dariladi. Shlyovka kiyimda belbog'ni sifatli va chiroyli turishini ta'minlaydi. Belbog' shlyovkalarini tikish texnologiyasi bo'yicha ikki, uch xil bo'ladi. Keng bichiqli shlyovkalar ikkita bo'lakdan shlyovka va astandan iborat. Avra va astar shlyovka teskari tomondan ag'darma chokda tikilib o'ngiga ag'dariladi va dazmollanadi. Ensiz shlyovkalar esa universal mashinada maxsus lapka orqali yoki maxsus mashinalarda ishlanishi mumkin.

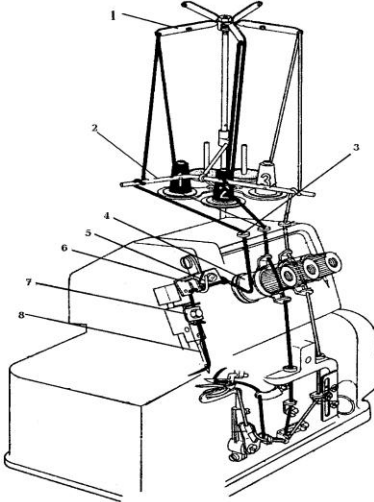
# BUYuM MODELLARIGA KONSTRUKTIV TA'RIF.

| Tartib<br>raqami. | Modelning<br>qisqacha<br>tasnifi                                                                                                                                                                                       | Modelning<br>xomaki rasmi                                                          | Detallar nomi                                                                      |                                                                                    |                                                                                      |                                                                                     |                                                                                     |   |    |
|-------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|---|----|
|                   |                                                                                                                                                                                                                        |                                                                                    | Ort bo`lak                                                                         | Old bo`lak                                                                         | Yeng                                                                                 | Yoqa                                                                                | Cho`ntak                                                                            |   |    |
| 1                 | 2                                                                                                                                                                                                                      | 3                                                                                  | 4                                                                                  | 5                                                                                  | 6                                                                                    | 7                                                                                   | 8                                                                                   | 9 | 10 |
|                   | <p>Kurs loyihasida tanlangan model, ayollar uchun mo`ljallangan. Old bo`lagi ikki tugmali qilib tayyorlangan. Yeng qismida kamartutgichli. Yengi o`taqazma yengli, yeng uchi kamar tutgichli. Bel qismi belbog`li.</p> |  |  |  |  |  |  |   |    |

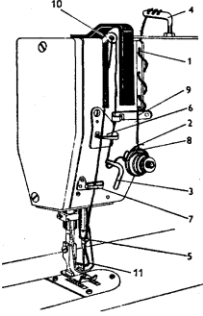
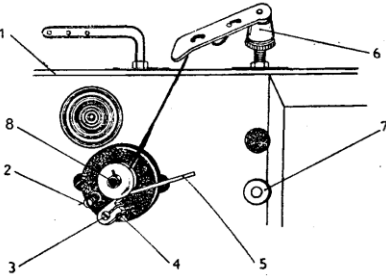
### 3. Gazlama tanlash va asoslash.

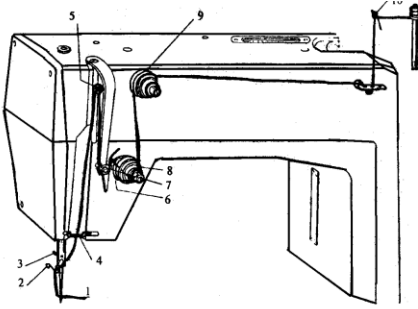
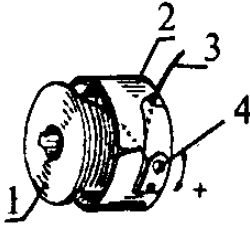
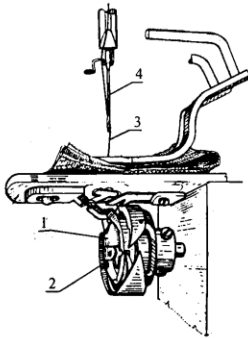
### 4. Asbob-uskuna va tikish usullarini tanlash va asoslash.

| Texnologiya asosida faoliyat turlari                                          | Mashina mexanizmlari                                                                                                                                                                                                                                                                    | Rasm                                                                                 | Standart asosida operatsiyani bajarish tartibi                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |
|-------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| I                                                                             | II                                                                                                                                                                                                                                                                                      | III                                                                                  | IV                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
| <b>«Zinger» firmasining 1831 U 012-3 yo'rmash tikish mashinasi</b>            |                                                                                                                                                                                                                                                                                         |                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| 1. Yo'rmash tikish mashinasiga iplarni taqish (1-g'altak)                     | 1-ip yo'naltiruvchi richag;<br>2-burchaklik;<br>3-ip yo'naltiruvchi vtulka;<br>4-ip taranglik rostlagichi shaybalari;<br>5-sim ip yo'naltirgich;<br>6- ip yo'naltirgich;<br>7-qo'shimcha taranglik rostlagich plastinasi;<br>8-igna.                                                    |   | Ipni g'altakdan chiqarib, yuqoridan pastga tomon ip yo'naltiruvchi richagning teshigidan, burchaklikning ikkita teshigidan birin ketin o'tkaziladi, ip yo'naltiruvchi vtulkadan o'tkazib, ip taranglik rostlagichi shaybalari orasidan aylantirib olib, o'ngdan chapga tomon igna mexanizmini yopib turadigan shchit tagiga kiritiladi. Keyin ip sim ip yo'naltirgich ilgagidan, ip yo'naltirgichning ikkita teshigidan o'tkaziladi, yuqoridan pastga tomon qo'shimcha taranglik rostlagichi plastinasi tagidan olib o'tib, tikuvchidan narigi tomon yo'naltirib, igna ko'ziga taqiladi. |
| 2. Yo'rmash tikish mashinasining chap chalishtirgich ipini taqish (3-g'altak) | 9-richag;<br>10-burchaklik;<br>11- ip yo'naltiruvchi vtulka;<br>12- ip yo'naltiruvchi teshik;<br>13-Taranglik rostlagichi shaybalari;<br>14-ip yo'naltiruvchi teshik;<br>15-ip yo'naltiruvchi vtulka;<br>16-ip yo'naltirgich;<br>17-ip yo'naltirgich;<br>18,19- ip uzatgich;<br>20-chap |  | Chap chalishtirgich ipini g'altakdan richag, burchaklik teshiklaridan o'tkazib, yuqoridan pastga tomon ip yo'naltiruvchi vtulkaga, ip yo'naltiruvchi teshikka kiritib, taranglik rostlagichi shaybalari orasidan aylantirib, ip yo'naltiruvchi teshikdan keyin ip yo'naltiruvchi vtulkadan o'tkaziladi va ip yo'naltirgich teshigiga kiritiladi, o'ngdan chapga tomon ip yo'naltirgich teshigiga va pastdan yuqori tomon ip uzatgich teshiklaridan o'tkaziladi. Maxovik g'ildirakni burab                                                                                                |

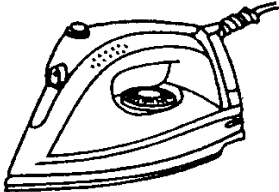
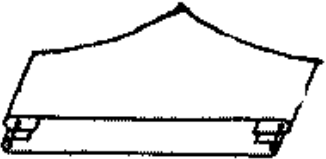
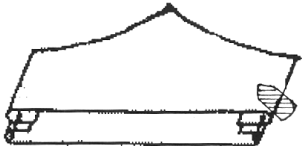
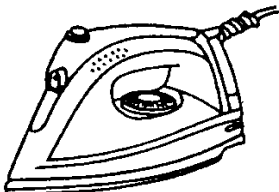
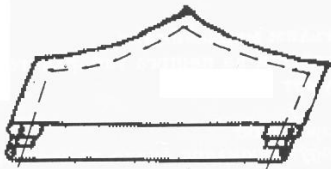
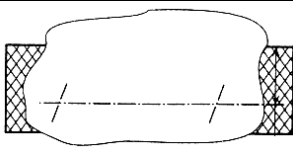
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|-----------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|                                                                                   | chalishtirgich                                                                                                                                                                                                                              |                                                                                     | chap chalishtirgichni chap chekka holatga keltirib, ipni pintset yordamida chalishtirgichning 3 ta teshigiga taqiladi.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |
| 3. Yo'rmas h tikish mashina sining o'ng chalishtirgich ipini taqish (2-g'altyuak) | 21. Richag;<br>22-ip yo'naltiruvchi vtulka;<br>23 ip yo'naltiruvchi teshik;<br>24-taranglik rostlagich shaybalari;<br>25-ip yo'naltiruvchi teshik;<br>26-ip yo'naltiruvchi vtulka;<br>27,28,29-ip yo'naltirgich;<br>30-o'ng chalishtirgich. |  | O'ng chalishtirgich ipi g'altakdan ortdan oldinga tomon richaglarning teshigidan o'tkaziladi, burchaklikning 2 ta teshigidan, yuqoridan pastga tomon ip yo'naltiruvchi vtulkadan o'tkazilib, ip yo'naltiruvchi teshikka kiritiladi, taranglik rostlagichi shaybalari orasidan aylantirib, ip yo'naltiruvchi teshikka kiritiladi. Keyin ip ip yo'naltiruvchi vtulkadan, ip yo'naltirgichning teshigidan o'tkaziladi, o'ngdan chapga tomon ip yo'naltirgichning keyingi teshigiga va ip uzatgich teshigiga kiritilib, old tomondan ip yo'naltirgichning teshigidan o'tkaziladi. Maxovik g'ildirakni burib o'ng chalishtirgichni o'ng chekka holatga keltirib, pintset yordamida uning teshigiga ip taqiladi. |

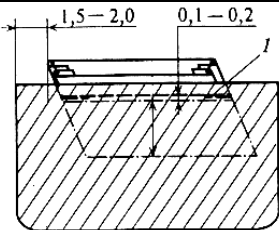
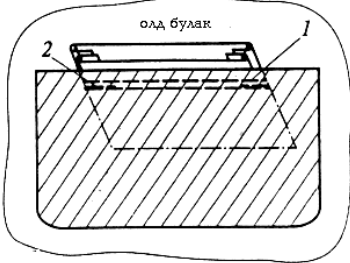
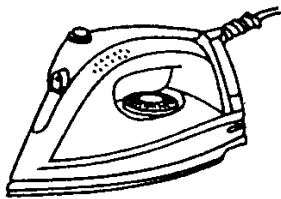
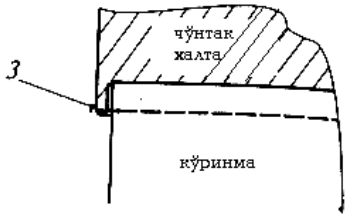
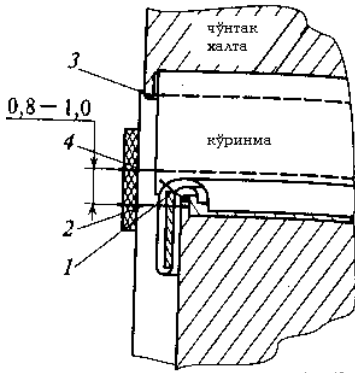
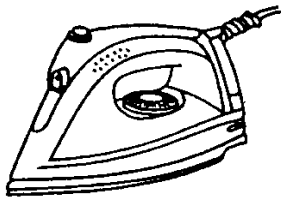
### SINIQ BAXYAQATOR YURITIB TIKUVCHI 72527-101 «MINYERVA» MASHINASI

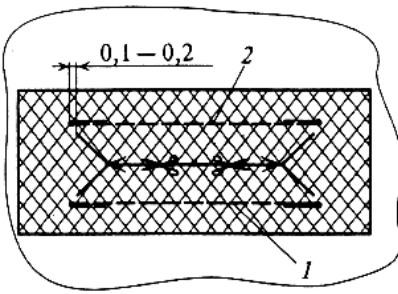
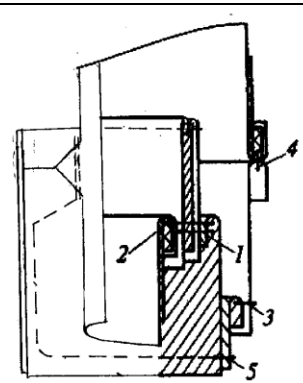
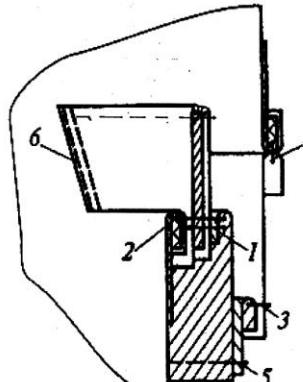
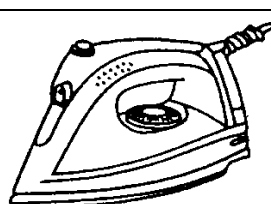
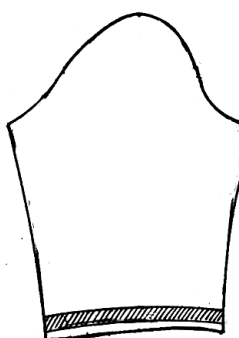
|                                                      |                                                                                                                                                                         |                                                                                      |                                                                                                                                                                                                                                                                                                                                                   |
|------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1. 72527-101 tikuv mashina siga ustki ipni taqish    | 1-ip yo'naltirgich;<br>2-taranglash prujinasi;<br>3,4,5,6,7-ip yo'naltirgich;<br>8-taranglash plastinasi;<br>9-cheklovchi yo'naltirgich;<br>10-ip tortgich;<br>11-igna. |   | Ipli g'altak tayanchga o'rnatilib ip yo'naltirgichlar teshigidan hamda taranglash plastinalari orasidan o'tkaziladi. Keyin taranglash prujinasi orqali ip yo'naltirgich atrofidan aylantirilib cheklovchi yo'naltirgich orqali ip tortgich ko'zdan o'tkaziladi. Ip tortgichdan o'tgan ip yo'naltirgichlar orqali old tomondan ignaga o'tkaziladi. |
| 2. 72527-101 tikuv mashina sida naychaga ipni o'rash | 1-mashina tanasi;<br>2-prujina;<br>3-tsapfa;<br>4-ip o'rash qurilmasi;<br>5-richag;<br>6-ip yo'naltirgich;<br>7-vint;<br>8-naycha.                                      |  | Naychaga ipni o'rash uchun mashinada maxsus ip o'rash qurilmasi o'rnatilgan. Ip g'altakdan mashina tanasiga o'rnatilgan ip yo'naltirgich orqali naychaga yo'naltiriladi va prujinaga tortiladi. Naycha, richag, siljtilib, o'rash qurilmasiga o'rnatiladi va                                                                                      |

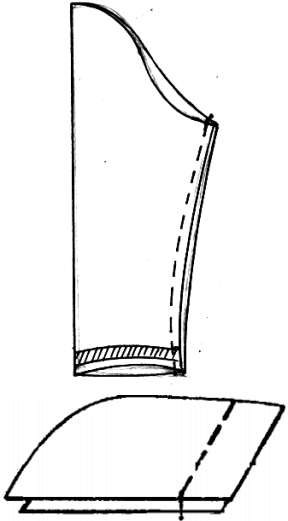
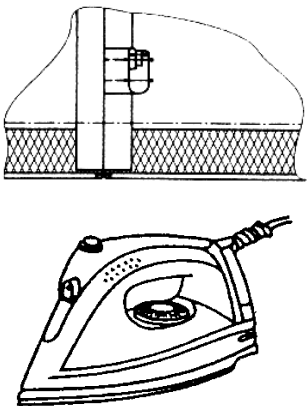
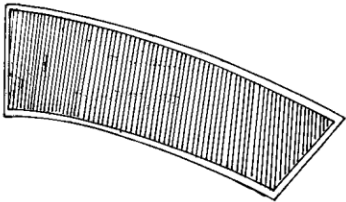
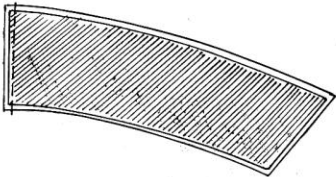
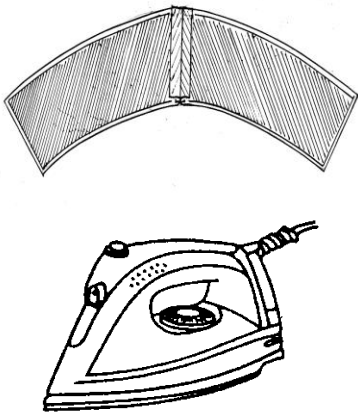
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|----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| qurilmasi.                                                                       |                                                                                                                                                                                                                                |                                                                                      | mashina ishga tushiriladi. Richag tsapfaga o'rnatilgan. Naychaga ip o'ralgandan so'ng richag naychadan chetga chiqadi va o'rash mexanizmi to'xtaydi. To'ldirilgan naycha moki qurilmasiga o'rnatiladi.                                                                                                                                                                                                                                                                                                                      |
| <b>«PANNONIYA» (VYENGRIYA) FIRMASINING CS 1652K-303A PUXTALAMA YARIMAVTOMATI</b> |                                                                                                                                                                                                                                |                                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| 1. CS 1652K-303A yarimavtomatiga ustki ipni taqish                               | 1-igna;<br>2-plastinasimon prujina;<br>3-igna yuritgich;<br>4-ip yo'naltirgich skoba;<br>5-ip tortgich;<br>6-ip yo'naltirgich ilgak;<br>7-ip tortgich prujina;<br>8,9-taranglik rostlagich shaybalari;<br>10-ip yo'naltirgich. |    | G'altakdan tushgan ipni o'ngdan chapga tomon sim ip yo'naltirgichdan o'tkaziladi, qo'shimcha taranglik rostlagichi shaybalari orasidan o'ngdan chapga asosiy taranglik rostlagichi shaybalari orasidan aylantirib, ip tortgich prujinasining halqasiga kiritiladi va ip yo'naltirgich ilgagining ortiga o'tkaziladi. Keyin ip o'ngdan chapga ip tortgichning qulog'idan ip yo'naltirgich skobasiga kiritiladi, igna yuritgichga mahkamlangan plastinasimon prujina tagidan olib o'tib chapdan o'ngga igna ko'ziga taqiladi. |
| 2. CS 1652K-303A yarimavtomatiga ostki ipni taqish.                              | 1-naycha;<br>2-naycha qalpog'i;<br>3-ip;<br>4-naycha qalpog'idagi vint;                                                                                                                                                        |  | Naycha naycha qalpog'iga shunday o'rnatilishi kerakki, ip soat mili harakatiga qarama-qarshi yo'nalishda o'ralgan bo'lishi kerak. Ip naycha qalpog'idagi ariqchadan va taranglash plastinasi ostidan olib o'tilib. Naycha qalpog'i teshigidan o'tkazildi. Ipning tarangligi naycha qalpog'idagi vintni burab rostlanadi.                                                                                                                                                                                                    |
| 3. CS 1652K-303A yarimavtomatiga ostki ipni taqish.                              | 1-naychali qurilma;<br>2-markaziy sterjen;<br>3-ustki ip;<br>4-igna.                                                                                                                                                           |  | Ip o'ralgan naychali qurilma mokining markaziy sterjeniga kiritiladi. Moki uchi ignaning eng ostki holatida 1,5-2.0 mm ko'tarilganida ustki halqasini ilib olishi kerak. Agar ostki ip noto'g'ri to'ldirilgan, igna noto'g'ri tanlangan, igna igna yuritgichga noto'g'ri o'rnatilgan bo'lib, moki uchi va igna orasidagi masofa kattalashgan bo'lsa, ostki ipning uzilishi sodir bo'ladi.                                                                                                                                   |

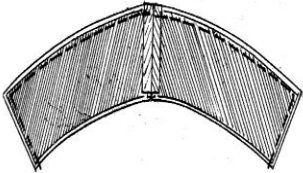
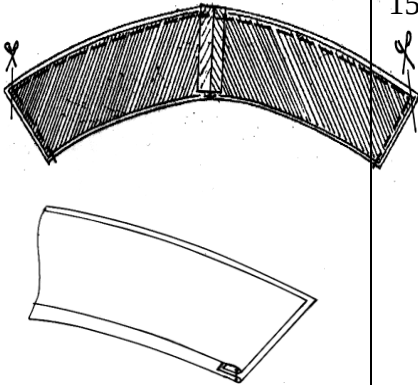
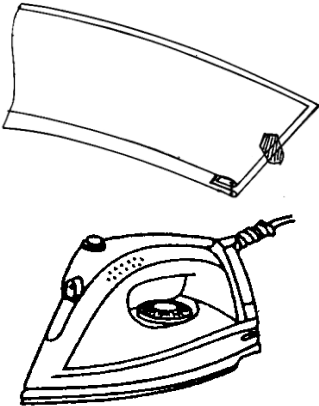
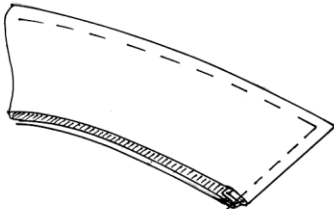
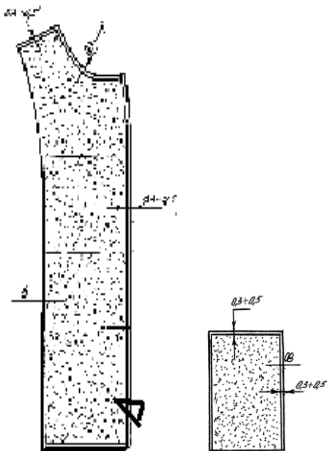
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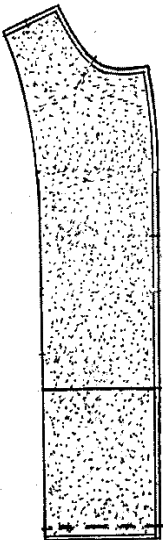
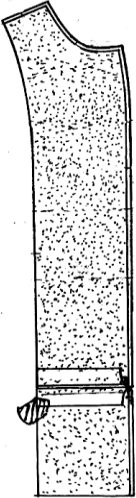
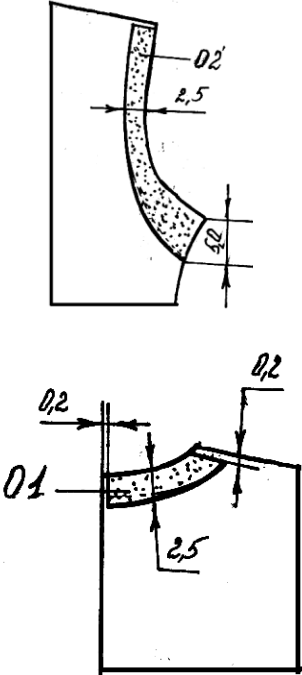
| t/r | Opertsyalar nomi                         | Texnologik sxema                                                                                                                                                         | Sarflangan vaqt | Tanlangan jixoz  |
|-----|------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|------------------|
| 1.  | Listochkaga yelimli qotirma yopishtirish |        | 20              | Dazmol           |
| 2.  | Listochkani ag'darma chokda tikish       |                                                                                         | 20              | UM               |
| 3.  | Listochkani o'ngiga ag'darish            |   | 10              | Dukcha, igna, ip |
| 4.  | Listochkani dazmollash                   |    | 20              | Dazmol           |
| 5.  | Listochkaga bezak baxyaqator yuritish    |                                                                                      | 30              | UM               |
| 6.  | Cho'ntak o'rnini belgilash               |                                                                                       | 30              |                  |

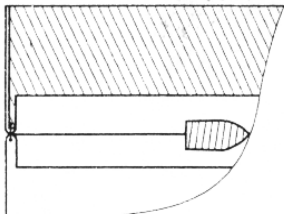
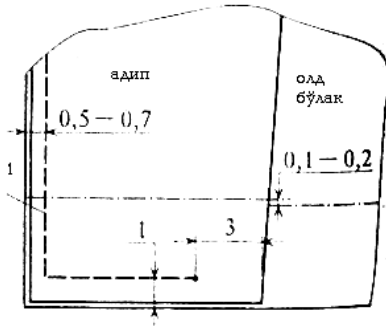
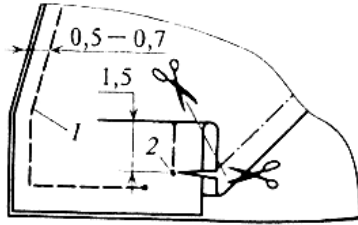
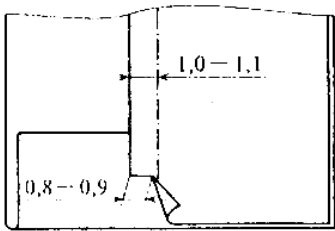
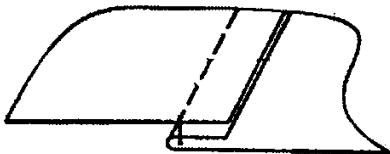
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| 7. | Listochkani cho'ntak xalta bilan biriktirib tikish |     | 55 |                  |
| 8. | Listochkani old bo'lakka tikish                    |    | 45 | UM               |
| 9. | Listochka chokini dazmollash.                      |     | 20 | UM               |
| 10 | Cho'ntak xaltaga ko'rinmani biriktirib tikish      |   | 35 | Dazmol           |
| 11 | Old bo'lakka ko'rinmani tikish                     |  | 20 | UM               |
| 12 | Ko'rinma tikilgan chokni dazmollash                |   | 15 | UM               |
| 13 | Cho'ntak o'rini qirgish                            |                                                                                      | 10 | Chizg'ich, bo'r. |

|    |                                                                       |                                                                                     |    |              |
|----|-----------------------------------------------------------------------|-------------------------------------------------------------------------------------|----|--------------|
|    |                                                                       |   |    |              |
| 14 | Listochkani ko'klash va cho'ntak xalta qirqimlarini biriktirib tikish |    | 40 | Qaychi       |
| 15 | Listochka burchaklarini puxtalash                                     |   | 10 | Igna, ip, UM |
| 16 | Tayyor cho'ntakni dazmollash                                          |  | 20 | UM           |
| 17 | Yeng uchlariga yelimli qotirmani yopishtirish                         |  | 20 | Dazmol       |

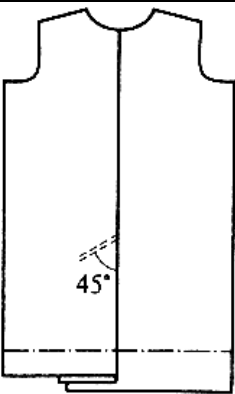
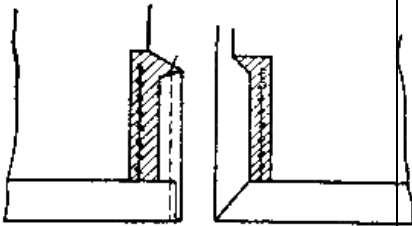
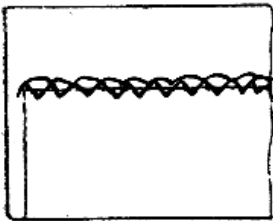
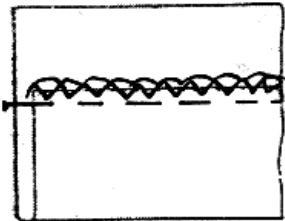
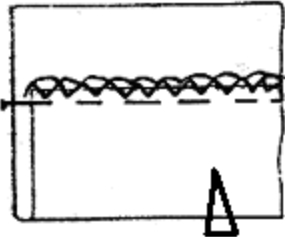
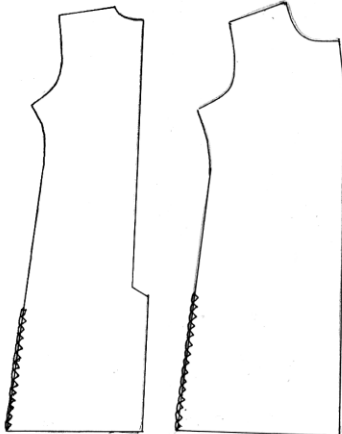
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|----|----------------------------------------------------------|--------------------------------------------------------------------------------------|----|--------|
| 18 | Yeng qirqimlarini<br>biriktirib tikish                   |     | 30 | UM     |
| 19 | Yeng choklarini<br>dazmollash                            |   | 15 | Dazmol |
| 20 | Ostki yotqizma yoqaga<br>yelimli qotirma<br>yopishtirish |  | 20 | Dazmol |
| 21 | Ostki yotqizma yoqa<br>bo'laklarini biriktirib<br>tikish |  | 25 | UM     |
| 22 | Ostki yotqizma yoqa<br>choklarini dazmollash             |  | 15 | Dazmol |

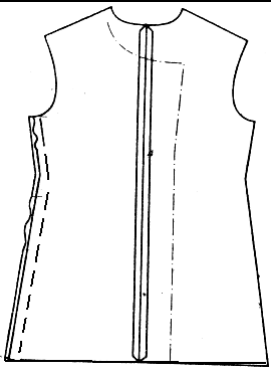
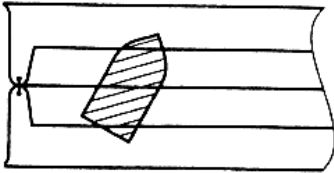
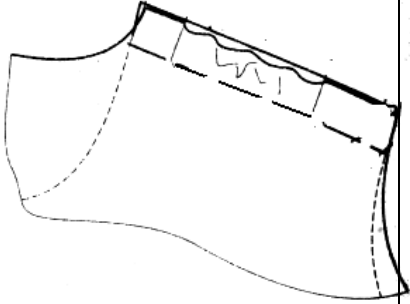
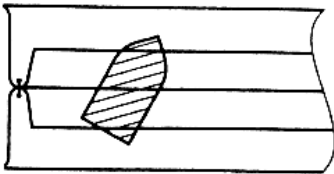
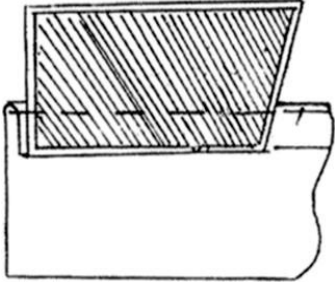
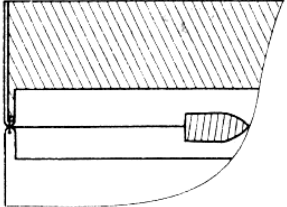
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| 23 | Ustki va ostki yotqizma yoqani ag'darma chokda tikish |     | 30 | UM     |
| 24 | yotqizma yoqani o'ngiga ag'darish                     |    | 15 | Qaychi |
| 25 | Yotqizma yoqani dazmollash                            |   | 25 | Dazmol |
| 26 | Yotqizma yoqaga bezak baxyaqator yuritish             |  | 25 | UM     |
| 27 | Adipga yelimli qotirmani yopishtirish                 |  | 40 | Dazmol |

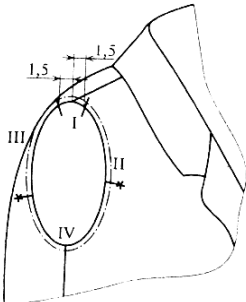
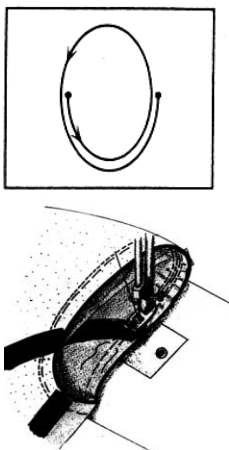
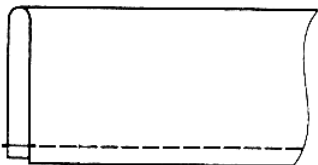
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| 28 | Adip bo'laklarini birlashtirib tikish                            |     | 45 | UM     |
| 29 | Adip choklarini dazmollash                                       |    | 20 | Dazmol |
| 30 | Old bo'lak yoqa va yeng o'mizlariga yelimli qotirma yopishtirish |  | 45 | Dazmol |

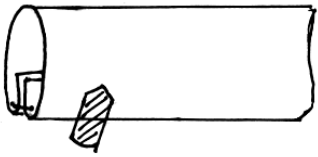
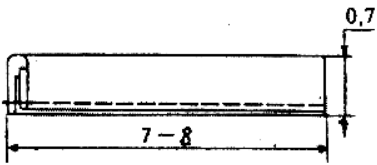
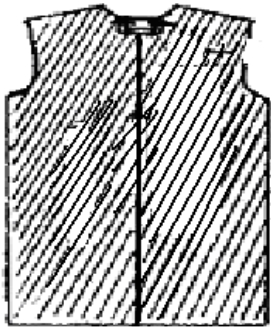
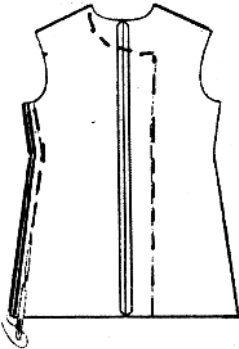
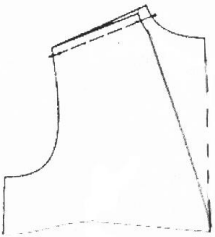
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|-----|------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|----|-------------------------|
| 31  | Bortga adipni ag'darma chokda tikish                                                           |     | 65 | UM                      |
| 32  | Ag'darma chokni dazmollash                                                                     |     | 35 | Dazmol                  |
| 33  | Ko'tarma astarli bort burchagining ishlanishi<br>Bort pastki burchagini ag'darma chokda tikish |   | 25 | UM, igna, ip            |
| 34  | Adip ichki burchagining ishlanishi                                                             |  | 20 | UM                      |
| 45  | Bortni dazmollash                                                                              |  | 45 | Dazmol                  |
| 36. | Ort bo'lak bichuvini tekshirish                                                                |  | 35 | Andoza, chizg'ich, bo'r |
| 37. | Kesimni belgilash                                                                              |                                                                                      | 15 | Andoza, chizg'ich       |

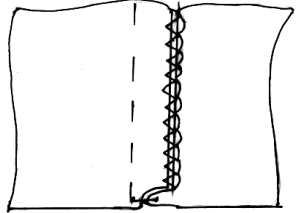
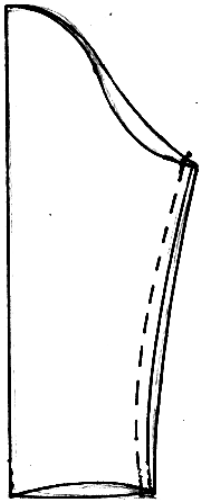
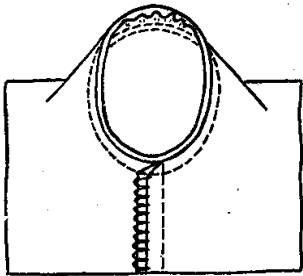
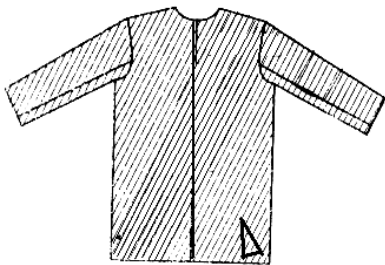
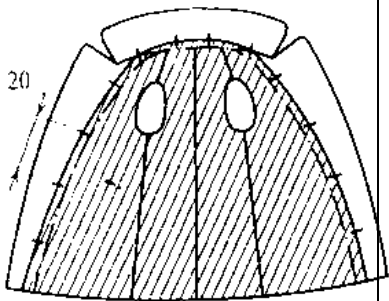
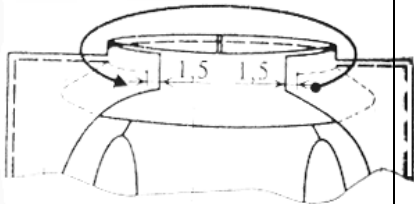
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|-----|------------------------------------------------|--|----|--------|
|     |                                                |  |    |        |
| 38. | Kesimga yelimli qotirma yopishtirish           |  | 30 | Dazmol |
| 39  | Ort bo'lak o'rta qirgimini birlashtirib tikish |  | 25 | UM     |
| 40  | O'ng tomon kesimini tikish                     |  | 45 | UM     |

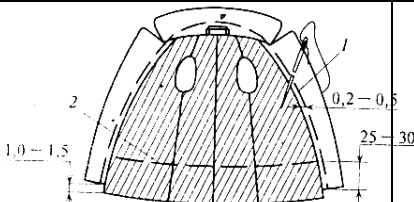
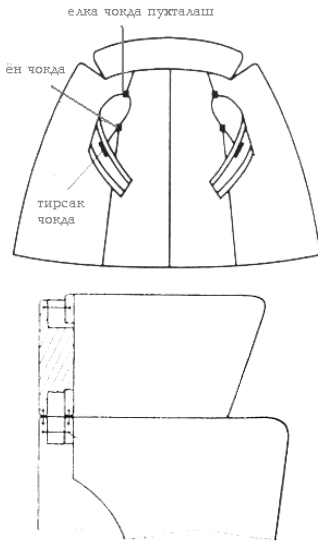
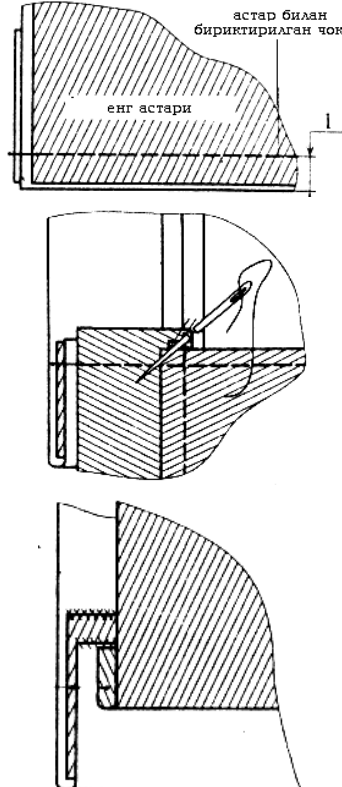
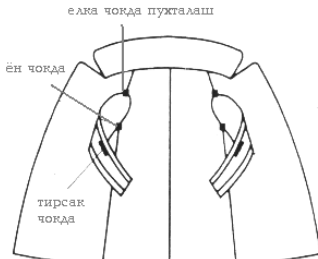
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|----|---------------------------------------------|--------------------------------------------------------------------------------------|----|-------------------------------------------------|
| 41 | O'ng tomondan kesimni puxtalash             |     | 15 | UM                                              |
| 42 | Ort bo'lak kesim burchaklarining ishlanishi |    | 20 | UM                                              |
| 43 | Plash etagini yo'rmalash                    |    | 35 | MM<br>1831 U 012-3<br>yo'rmash tikish mashinasi |
| 44 | Plash etagshini buklab ko'klash             |   | 40 | Igna, ip, UM.                                   |
| 45 | Plash etagini dazmollash                    |   | 35 | Dazmol                                          |
| 46 | Yon qirqimlarni yo'rmalash                  |  | 60 | UM<br>1831 U 012-3<br>yo'rmash tikish mashinasi |

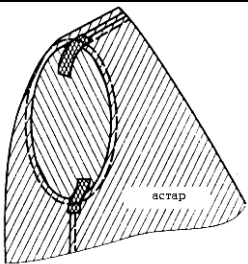
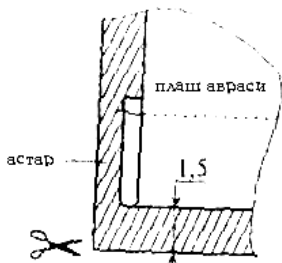
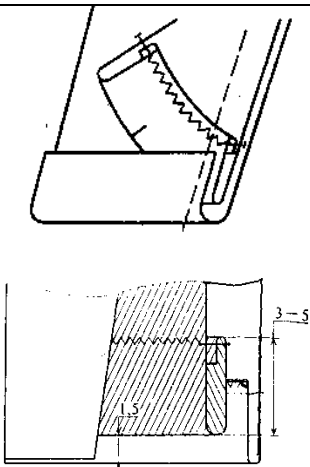
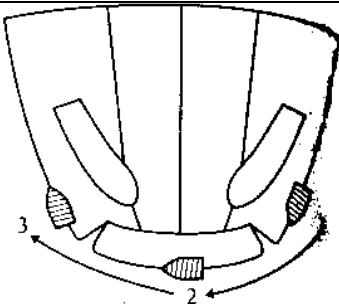
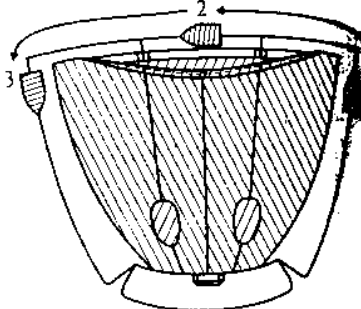
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|----|----------------------------------------------------------|--------------------------------------------------------------------------------------|----|--------|
| 47 | Yon qirgimlarini<br>biriktirib tikish                    |     | 60 | UM     |
| 48 | Yon choklarini<br>dazmollash                             |    | 40 | Dazmol |
| 49 | Yelka qirgimini tikish                                   |   | 20 | UM     |
| 50 | Yelka choklarini<br>dazmollash                           |  | 25 | Dazmol |
| 51 | Yoqani yoqa o'miziga<br>biriktirib tikish                |  | 60 | UM     |
| 22 | Yoqani yoqa o'miziga<br>o'tkazilgan chokni<br>dazmollash |   | 60 | Dazmol |

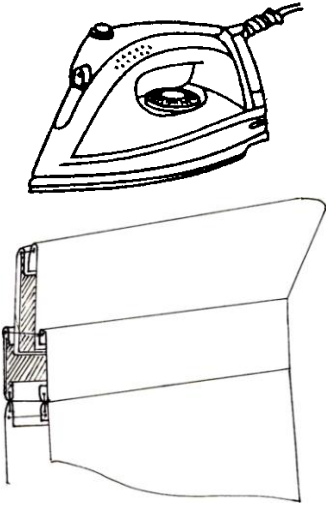
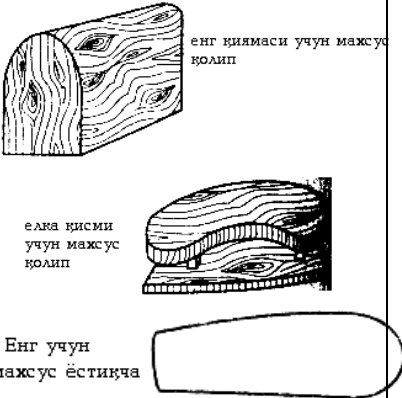
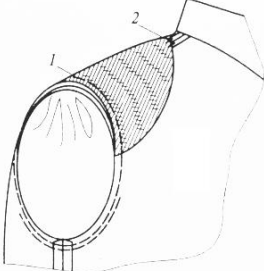
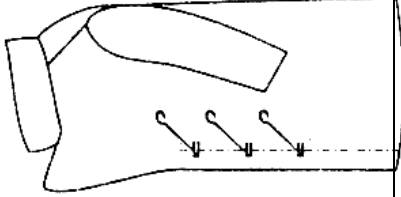
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|----|---------------------------------------|-------------------------------------------------------------------------------------------------------------------------|----|---------------------|
| 53 | Yeng o'mizini tekshirish              |                                        | 90 | Andoza, sm<br>lenta |
| 54 | Ko'klab o'tkazilgan yengni tekshirish |                                        | 20 | Maneken             |
| 55 | Yengni yeng o'miziga o'tkazish        | <p>енгни ўмизга ўтказиш чизмаси</p>  | 80 | UM                  |
| 56 | Yeng chokini dazmollash               |                                      | 45 | Dazmol              |
| 57 | Bar tutgichni tayyorlash.             |                                     | 10 | UM                  |

|    |                                            |                                                                                     |    |                |
|----|--------------------------------------------|-------------------------------------------------------------------------------------|----|----------------|
| 58 | Barni o'ngiga ag'darish va dazmollash      |   | 10 | Maxsus moslama |
| 59 | Ilgichni tikish                            |   | 10 | UM             |
| 60 | Ilgichni yoqa o'miziga puxtalash           |    | 15 | UM             |
| 61 | Ort bo'lak o'rta qirqimini tikish          |   | 35 | UM             |
| 62 | Astar bilan yon qirqimlarini tikish        |  | 90 | UM             |
| 63 | Astar yelka qirqimlarini biriktirib tikish |  | 20 | UM             |

|    |                                    |                                                                                      |    |                                                 |
|----|------------------------------------|--------------------------------------------------------------------------------------|----|-------------------------------------------------|
| 64 | Astar choklarini yo'rmalash        |     | 60 | MM<br>1831 U 012-3<br>yo'rmash tikish mashinasi |
| 65 | Yeng astar qirgimlarini tikish     |     | 45 | UM                                              |
| 66 | Yengni yeng o'miziga o'tkazish     |    | 60 | Qaychi, andoza, bo'r                            |
| 67 | Astarni dazmollash                 |  | 35 | UM                                              |
| 68 | Astar qirgimlarini aniqlash        |  | 30 | Igna, ip                                        |
| 69 | Avraga astarni birlashtirib tikish |  | 65 | MM<br>1831 U 012-3<br>yo'rmash tikish mashinasi |

|    |                                                    |                                                                                      |    |                                                     |
|----|----------------------------------------------------|--------------------------------------------------------------------------------------|----|-----------------------------------------------------|
| 70 | Plashni o'ngiga ag'darish                          |    | 15 | UM, MM<br>1831 U 012-3<br>yo'rmash tikish mashinasi |
| 71 | Yoqa choklarini mustahkamlash                      |    | 20 | UM                                                  |
| 72 | Avra yeng uchini yeng uchi bilan biriktirib tikish |   | 30 | Qaychi                                              |
| 73 | Astarni yeng o'miz va yon choklariga mustahkamlash |  | 25 | MM, UM<br>1831 U 012-3<br>yo'rmash tikish mashinasi |

|    |                                                               |                                                                                      |    |                      |
|----|---------------------------------------------------------------|--------------------------------------------------------------------------------------|----|----------------------|
|    |                                                               |     |    |                      |
| 74 | Astar etagini tekislab qirgish                                |     | 45 | UM                   |
| 75 | Astar etagini buklab tikish                                   |   | 65 | Qaychi, andoza, bo'r |
| 76 | Plashni tozalash                                              |                                                                                      | 30 | Qaychi               |
| 77 | Plash latskani va yoqasiga oxirgi ishlov berish               |  | 35 | Dazmol               |
| 78 | Plash borti, etagi va kesim (shlits) lariga oxirgi NII berish |  | 35 | Dazmol               |

|    |                                                |                                                                                                                                                                                             |    |                           |
|----|------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|---------------------------|
| 79 | Astarni dazmollash                             |                                                                                                           | 45 | Dazmol                    |
| 80 | Yeng va yelka qismlarini dazmollash            |  <p>енг қиямаси учун мажсус қолип</p> <p>елка қисми учун мажсус қолип</p> <p>Енг учун мажсус ёстиқча</p> | 45 | Dazmol, maxsus qolip      |
| 81 | Yelka yostiqchasini puxtalash                  |                                                                                                          | 25 | MM                        |
| 82 | Knopka o'rnini belgilash va knopkani puxtalash |                                                                                                         | 30 | Maxsus moslama 1652K-303A |

6. Texnik iqtisodiy ko`rsatkichlarni tahlili

7. Xulosa

8. Kurs loyihasini rasmiylashtirish

9. Kurs loyihasini himoya qilish