



1.
- Marker lay made according to cutting ticket. Marker lay checked 100 %.
2.
- Marker and material delivered to spreading operation.
3.
- Machine knife cut.
4.
- Die cutting small parts.
5.
- Cut parts delivered to plant.
6.
- Collar department: Fuse stays. Run collar tops, trim points. Turn and press (shape), top stitch, trim tops. Hem bands, stitch lining to bands. Band collar. Turn band ends. Top stitch bands. Trim and baste. Quarter mark band. Buttonhole. Button sew.
7.
- Cuff department: Hem cuff, run cuff. Shape cuff, topstitch. Buttonhole. Button sew.
8.
- Under fronts: Baste neck. Crease front. Hem button stay. Button sew. Set pocket. Set flap.
9.
- Upper fronts: Baste neck. Crease front. Center pleat. Buttonhole. Set pocket. Set flap.
10.
- Sleeves: Piece binding. Bind sleeve. Tack binding.
11.
- Backs: Pleat. Backs.
12.
- Yokes: Label. Sew.
13.
- Attach yoke backs.
14.
- Assemble completed bundles of parts, any size, section, ply number and/or shade.
15.
- Join shoulder seam.
16.
- Join collar to shirt.
17.
- Set sleeve, join side and underarm seams (side fell).
18.
- Cuff attach, hem shirt, trim threads.
19.
- Button shirt, roll collar, press, fold.
20.
- Pack.

Figure 11-4 Flow Chart