

Garment factory solutions

From the roll to the rail in one system

Markers laid on the real outlines of the pieces, cloth a garment kept apart from marker efficiency, lays checked against plan, and a sewing line balanced to its bottleneck.

Real-outline markers

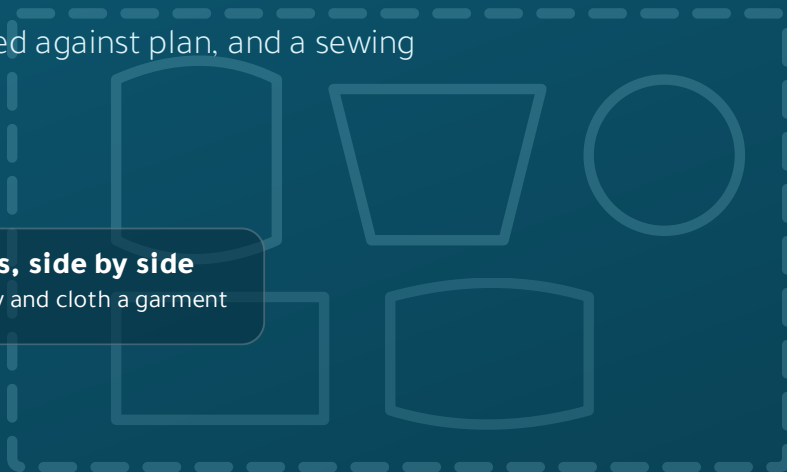
Not bounding boxes

Two numbers, side by side

Marker efficiency and cloth a garment

Line balancing

The bottleneck and its remedy priced



Two businesses in one factory – each in its own unit

The cutting room works in metres of cloth and the sewing line in minutes. VLUERP keeps both – from style and marker to lay, bundle and line – tied to the stores and the accounts.



Markers on the real shape

Pieces are nested on their true outlines, not rectangles – a sleeve wastes 18.6% of its own bounding box, and a rectangle nester hides that.



Efficiency vs cloth a garment

Marker efficiency says how much of the cloth is garment; cloth a garment says what the store issues. Both are shown, with the no-waste floor.



Lays against plan

Every lay's issued cloth is compared with its own plan, ply by ply – and a bundle from the wrong shade lot is caught before it is sewn.



Balanced to the bottleneck

Stations are balanced over a fixed operation order, and the remedy is priced: two operators on the slowest job, and the output that buys.

18.6%

sleeve waste in its box

5 mm

marker raster cell

4

orderings tried per marker

87

garments a day, from 81

A marker a cutter knows – on the real outline

The marker engine rasterises every piece at 5 mm, drops the big pieces in first, tucks the small ones into the holes – and keeps the shortest of four tries.



Laying the marker

- Pieces are rasterised on their real polygons in **5 mm** cells, with the cutting gap added as a true offset of their edges.
- Four orderings are tried – by area, height, width and length – and the shortest marker is kept.
- Grain rules respected: one-way, two-way and asymmetric prints; a freer rule never lays a longer marker than a stricter one.
- Compare ratios before laying: the same style in different size mixes, each with its length and efficiency.



Two numbers, kept apart

- Marker efficiency:** how much of the marker's cloth is garment.
- Cloth a garment:** what the store issues for each garment that leaves.
- A marker of extra-larges can be the most efficient in the building and the dearest way to cut – so both are on every screen.
- The **floor** – pieces edge to edge, no waste – is the one mix-neutral yardstick, shown as “over the floor”.



Four tries made every marker shorter

In testing, laying each marker four ways and keeping the shortest took an S+M shirt marker from **78.40%** to **81.31%** efficiency. Rasterising can only overstate the cloth – by about **1.25%** at 5 mm – so a costing built on it is conservative.

Cloth priced both ways

Price per metre and per kg checked against width and weight; prices that disagree are flagged.

Cloth before cutting

Rolls failing inspection or not yet relaxed are listed before they reach a lay.

Trims costed

Trims per style with supplier, unit, price, lead days and minimum, at full precision.

From the lay to the line – each against its plan

Lays are checked ply by ply against the marker that planned them, shade lots are kept together, and the sewing line is balanced to its real bottleneck.



Lays and shade lots

- Planned, issued and against plan for every lay – per ply and per garment – counted only for lays actually issued.
- In the example, a 110-ply lay ran **3.76%** over plan – and all of it was the ends.
- Every bundle carries its shade lot; one from a different lot than its lay is flagged before sewing.



Line balancing

- Stations are filled by searching for the smallest bottleneck over a fixed operation order – a collar before it is attached.
- Output, rejects, minutes paid and minutes made give the line's efficiency for each recorded day.
- The remedy is priced: in the example, two operators on the **3.4-minute** job take the day from **81** to **87** garments.

What each measure answers

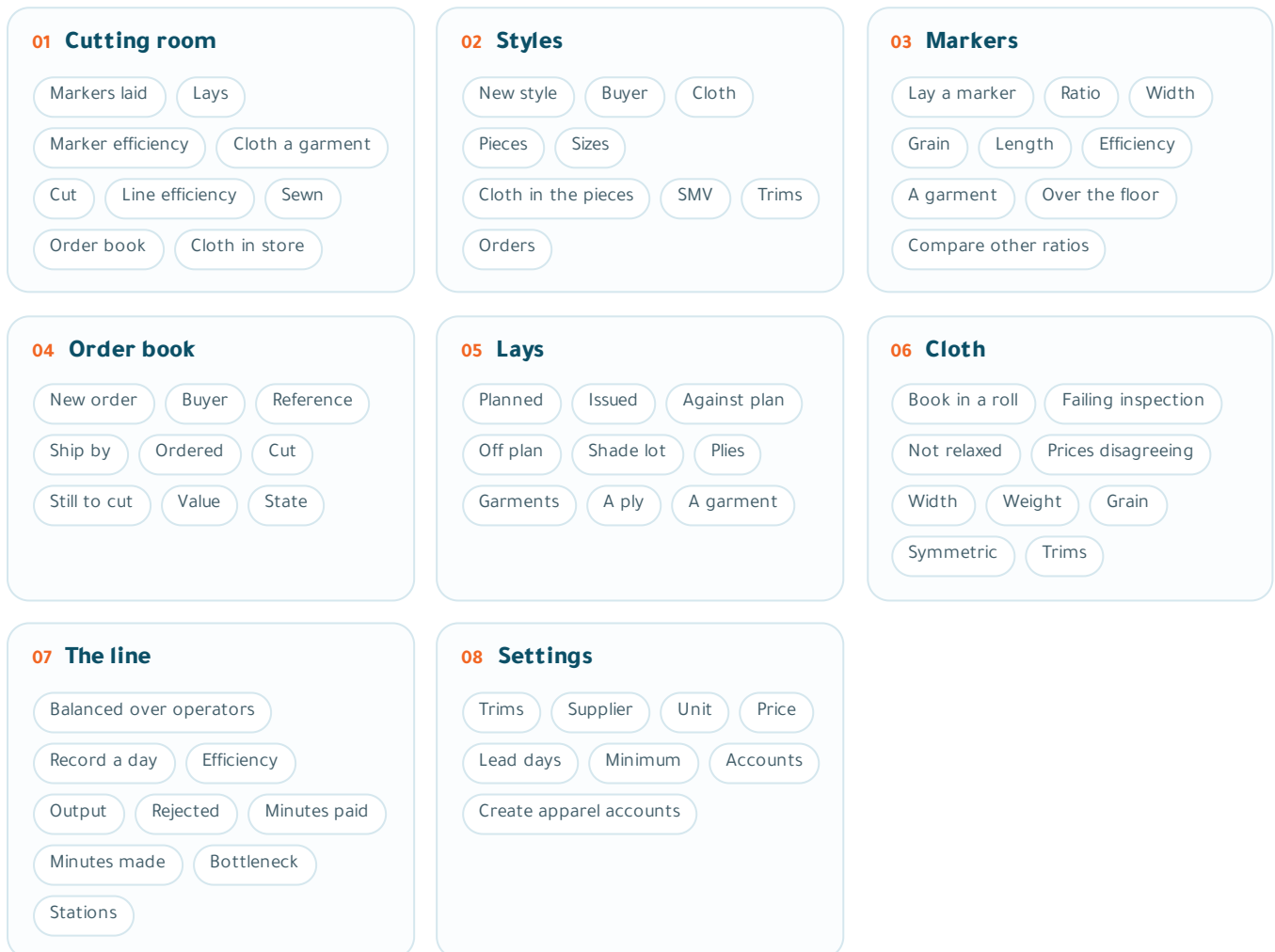
Measure	The question it answers	Unit
Marker efficiency	How much of the marker's cloth is garment	%
Cloth a garment	What the store issues for each garment	m per garment
Over the floor	Cloth beyond the pieces laid edge to edge	%
Against plan	A lay's issued cloth against its marker	%
Line efficiency	Minutes made against minutes paid	%

Marker efficiency and cloth a garment are shown side by side and never merged: they answer different questions.

Every screen in the module – and what is on it

Read off the running application – the panels, columns and figures that are actually there.

8 **71**
screens functions



Not a separate program – a complete business system

The trade module sits on top of a complete ERP: everything it does lands directly in the accounts, the stores and the reports – no double entry.



Accounting

Editable chart of accounts, automatic entries from every transaction, VAT and financial statements.



Financial dimensions

Cost centres, departments, business lines and sites – with statements per factory.



Inventory

Warehouses and bins, batches and serials, moving average, FIFO or standard cost.



Purchasing & sales

RFQs, purchase orders and receipts, quotations, invoices and ageing.



Maintenance & assets

Equipment register, preventive maintenance, work orders and depreciation.



Access & language

Roles and rights per module, audit trail, full Arabic and English interface.

Methods built into the module

Raster nesting

Real outlines laid in 5 mm cells

Multi-start

Four orderings, shortest marker kept

Miter offset

Cutting gap as a true edge offset

Floor

Pieces edge to edge, no waste

Min bottleneck

Line balanced on a fixed operation order

These are calculations the module runs itself, as working methods. They are not claims of conformity to any published standard.

See your own styles **on a marker**

Book a session and we'll set up the demo with one of your styles and cloths, lay its markers, and walk your cutting room and line through it.

Request a demo

Website

www.vluerp.com

Demo request

www.vluerp.com/#demo

Email

hello@vluerp.com

- 1 Cutting room:** markers, lays, marker efficiency and cloth a garment side by side.
- 2 Lay a marker:** watch a style laid on its real outlines, then compare it against other ratios.
- 3 Lays:** issued against plan for each lay, and a bundle from the wrong shade lot.
- 4 The line:** a style balanced over its operators, with the bottleneck and its remedy priced.

Switched on from Add-ons with a free seven-day trial, and it runs on the same general ledger.