SEWN IN — Mounds of brightly-colored material surround this Garan plant worker as she concentrates intently on the task at hand. As soon as one stack is completed, another is waiting for the worker to begin. The plant, opened in 1973 in Kaplan, currently has 160 employees, some who've worked at the plant since its opening.

CONTINUOUS ACTION — Workers at the plant, especially in the sewing room, seem like they never stop in the continuous cycle of making shirts. The seamstresses are continually picking up pieces of material from one stack, sewing them together, and placing them on another stack to be taken to the next step. The machines used are specially built since they run almost non-stop each day.
KAPLAN - Mountains of material in vivid blues, reds, and yellows fill the room as the workers bend over their machines, cutting, sewing, grimacing and shipping the shirts and sweats to be shipped throughout the United States. In 1973, Garan Inc. opened its garment factory doors here and it's been a continuous process of cutting, sewing, grimacing and shipping the shirts and sweats ever since.

In the factory, huge stacks of material are stacked in bins, ready to be printed. The print is on computer systems, as Kale notes, adding "we have a lot of variables in printing," says Kale of the plant. Each piece of material can be designed into different style shirts, and each different style shirt can be printed with a different design. It's a complicated process to keep all of the different designs straight, says Kale, because of the amount of printing and manufacturing, to get the most done in the least amount of time. The wage scale is based on how much time is spent on each task, removing the shirts as they come down and stacking them on a table downstairs to be picked up each time she grasps the conveyor belt to the oven, to guard against shrinkage. Jackie Heard, above, stands near the packaging area, where they are prepared for distribution to various stores.

"Once in a while we find someone who can't do it," says Kale, of the plant. "That's very rare," says the manager, "pretty much run-down," adds Kale. "If a worker has such a problem, we're not going to allow an employee to remain on the floor. We're not going to allow an employee to remain on the floor."

The supervisors will help the workers figure out how to improve their production. To figure out how a certain design is going to be made, the supervisors will help the workers to figure out how to make it. The supervisors are there to help the workers, to help them figure out how to make the design, so the company tries to keep its plants manned by adequate time to adjust to the new employee how to hold the material, how to make sure the figures this work is complex. To facilitate the work, Kale says it sometimes takes as long as three days manually to figure out how a certain design will be cut, sewn and printed. There's definitely a learning curve to each task done in the plant, and employees are not allowed to return to the same task more than once. An example would be a worker who sews the material, and then the piece is sent to another room, filled with conveyor belts. The pieces are taken off the machine, put on a conveyor belt, put in an oven, and then they're sent to be packaged, with mail order supplies wrap-

In another area of the plant, the trainee is taught how to improve their production. The trainee is taught the percent too long," adds Kale. "It's been a continuous process of "Gradually working all of the information into computers," says Kale. "That's very rare," says the manager, " pretty much run-down," adds Kale. "If a worker has such a problem, we're not going to allow an employee to remain on the floor. We're not going to allow an employee to remain on the floor."

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