Long-run economic growth is associated with changes in the structure of economies that depend on the global context and its own internal conditions. In the cases of China and Mexico, their paths of economic growth since the late twentieth century have faced a global manufacturing production environment in which the segmentation of production dominates. The aim of this paper is to examine the patterns of structural change in both economies, highlighting the role of manufacturing exports, the evolution of its internal organization and its relationship with the international segmentation of production (ISP). Data used are from the national Input-output tables (NIOT) of the World Input-Output Database (WIOD). Using input-output methods that identify the determinants of growth and structural change, associated with final demand, exports, import substitution and technological change, this study estimates their relative contribution; it also analyses the sources of these changes in relation to domestic conditions and industrial policies implemented from 1995 to 2011, associated with their specific form of integration into the international segmentation of production.