



Faculty of Engineering
Department of Textile Engineering

Thesis Report on
Investigation on the pre-shipment inspection (PSI)
reports of a denim garment industry

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Submitted by:
Tasfia Jahan ID: 201-23-900
Md Tariqul Islam Illion ID: 201-23-916

Supervised by:
Md. Abdullah Al Mamun
Associate Professor
Department of Textile Engineering

A thesis submitted in partial fulfillment of the requirements for the degree of
Bachelor of Science in Textile Engineering

Advance in Apparel Manufacturing Technology

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DECLARATION

We hereby attest that the thesis report on “Investigation on the pre-shipment inspection (PSI) reports of a denim garment industry” was created entirely by us, working under the supervision of **Md. Abdullah Al Mamun, Associate Professor**, Department of Textile Engineering, Daffodil International University.

We affirm that neither this project nor any component of it has ever been submitted somewhere else.

Submitted by:

Tasfia Jahan

ID: 201-23-900

Department of Textile Engineering

Daffodil International University

&

Md Tariqul Islam Illion

ID: 201-23-916

Department of Textile Engineering

Daffodil International University



Daffodil
International
University

LETTER OF APPROVAL

This is a certification that **Tasfia Jahan**, bearing **ID: 201-23-900**, and **Md. Tariqul Islam Illion**, bearing **ID: 201-23-916**, are students in the Department of Textile Engineering at Daffodil International University, have successfully completed the thesis report they were assigned under my supervision. Under the title "Investigation on the pre-shipment inspection (PSI) reports of a denim garment industry," they were handed a report name, which they fulfilled admirably.

The thesis report submitted by Tasfia Jahan and Md. Tariqul Islam Illion seems like authentic work and up to the mark.

I have gone through the final draft of the report and recommend its submission for the degree of Bachelor of Science in Textile Engineering.

Md. Abdullah Al Mamun

Associate Professor

Department of Textile Engineering

Faculty of Engineering

Daffodil International Engineering



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We are also grateful to **Palash Kumar Biswas (Planning Manager)**, Ultimate Fashions Limited, sir, as our organizational mentor. He assisted us with all the necessary final inspection reports for this project. Without his assistance, it would have been extremely difficult to prepare this report to this standard.

We deeply appreciate the guidance provided by the staff and operators at **Ultimate Fashions Limited**, who were a helping hand at every next step.

Finally, we are grateful to our parents, without them, we would not be here. Without the support of our parents, we would not be able to achieve our objectives and goals.



DEDICATION

Our beloved parents are the ones to whom we would like to dedicate this thesis paper.



ABSTRACT

The project titled “Analysis of denim industry final inspection reports to identify the common faults and their causes during production and to remedy them” is a comprehensive exploration aimed at evaluating and improving the quality control processes in the garment manufacturing industry. The project focuses on the systematic analysis of faulty reports generated during the final inspection of fully assembled garments. Through this analysis, the project aims to identify common faults, understand their root causes, assess their frequency and severity, and propose recommendations for process optimization. This report includes 14 final inspection reports from the Ultimate Fashions Limited garment industry. We evaluate the reports, highlight the findings in a chart, and identify the most common faults. Next, we provide the reasons behind these faults and then address remedies for them. After analysis, we found eight major faults in our project work in four different sections. The percentage rate of defects in every section is: fabric defect (3.62%), sewing defect (50.79%), finishing defect (39.27%), and miscellaneous defect (6.32%). This project is needed to improve product quality and prevent expenses for the industry. The buyer will be more satisfied, especially when this is done.

Table of Contents

CHAPTER 1: INTRODUCTION.....	1
1.1 Introduction	2
1.2 Objectives	2
1.3 Importance of this Project.....	2
1.4 Scope of the study.....	2
1.5 Limitations	3
CHAPTER 2: LITERATURE REVIEW	4
2.1 Process Flow of the Fabric Inspection.....	5
2.1.1 Clockwise Inspection	5
2.1.2 The 4- Point System.....	6
2.2 Final Self Inspection Procedure List	7
2.3 Final Inspection Procedure in UFL	8
2.3.1 Total Procedure of the Inspection as Per Below	9
2.3.2 How to Choose Cartons.....	9
2.3.3 Output Check System.....	9
2.4 Defect Classification.....	10
2.4.1 Appearance Zones of the garment	11
2.4.2 AQL Chart	11
2.5 Not Acceptable for Finishing Quality.....	12
2.6 Faults in Sewing Section	12
2.7 Quality Policy.....	13
2.7.1 Accessories Store Quality Flow Chart	13
2.7.2 Cutting Quality Control Flow Chart	14
2.7.3 Sewing Quality Control Flow Chart	14
2.7.4 Finishing Quality Control Process	15
CHAPTER 3: EXPERIMENTAL DATA.....	16
3.1 Methodology of the Study.....	17
3.1.1 Research Design.....	17
3.1.2 Data Sources.....	17
3.1.3 Target Population	17
3.1.4 Data Analysis.....	17
3.1.5 Documentation and Reporting	17



3.1.6 Data Collection.....	17
3.2 UFL's Final Inspection Reports.....	18
3.2.1 Final Inspection Report 1.....	18
3.2.2 Final Inspection Report 2.....	19
3.2.3 Final Inspection Report 3.....	20
3.2.4 Final Inspection Report 4.....	21
3.2.5 Final Inspection Report 5.....	22
3.2.6 Final Inspection Report 6.....	23
3.2.7 Final Inspection Report 7.....	24
3.2.8 Final Inspection Report 8.....	25
3.2.9 Final Inspection Report 9.....	26
3.2.10 Final Inspection Report 10.....	27
3.2.11 Final Inspection Report 11.....	28
3.2.12 Final Inspection Report 12.....	29
3.2.13 Final Inspection Report 13.....	30
3.2.14 Final Inspection Report 14.....	31
3.3 Summary of All Final Inspection Reports	32
CHAPTER 4: RESULT & DISCUSSION.....	34
4.1 All Section Defect Result in 100%	35
4.2 Fabric Section Defect (3.62%) Result.....	36
4.3 Sewing Section Defect (50.79%) Result.....	37
4.4 Finishing Section Defect (39.27%) Result	38
4.5 Miscellaneous Section Defect (6.32%) Result	39
4.6 One Major Fabric Defect.....	40
4.6.1 Rubbing mark (37.5%)	40
4.7 Three Major Sewing Defect.....	41
4.7.1 Broken stitch (30.66%).....	41
4.7.2 Skipped stitch (28%)	42
4.7.3 Raw edge out (6.67%)	43
4.8 Three Major Finishing Defect	44
4.8.1 Dirty spot (25.86%)	44
4.8.2 Poor iron (14.37%)	45
4.8.3 Uncut thread (12.64%).....	46
4.9 One Major Miscellaneous Defect	47
4.9.1 Cutting number mark (42.86%).....	47



4.10 Discussions	48
CHAPTER 5: CONCLUSION.....	49
5.1 Conclusions	50
REFERENCES	51

List of Figures

Figure No.	Description	Page No.
Figure 2.1	Clockwise Inspection	5
Figure 2.2	Final Self Inspection Procedure List	7
Figure 2.3	AQL Chart	11
Figure 2.4	Finishing Quality Faults	12
Figure 2.5	Faults in Sewing Section	12
Figure 2.6	Accessories Store Quality Flow Chart	13
Figure 2.7	Cutting Quality Control Flow Chart	14
Figure 2.8	Sewing Quality Control Flow Chart	14
Figure 2.9	Finishing Quality Control Process	15
Figure 3.1	Final Inspection Report 1	18
Figure 3.2	Final Inspection Report 2	19
Figure 3.3	Final Inspection Report 3	20
Figure 3.4	Final Inspection Report 4	21
Figure 3.5	Final Inspection Report 5	22
Figure 3.6	Final Inspection Report 6	23
Figure 3.7	Final Inspection Report 7	24
Figure 3.8	Final Inspection Report 8	25
Figure 3.9	Final Inspection Report 9	26
Figure 3.10	Final Inspection Report 10	27
Figure 3.11	Final Inspection Report 11	28
Figure 3.12	Final Inspection Report 12	29
Figure 3.13	Final Inspection Report 13	30
Figure 3.14	Final Inspection Report 14	31
Figure 4.1	Rubbing Mark	40
Figure 4.2	Broken Stitch	41
Figure 4.3	Skipped Stitch	42
Figure 4.4	Raw edge out	43
Figure 4.5	Dirty Spot	44
Figure 4.6	Poor Iron	45
Figure 4.7	Uncut Thread	46
Figure 4.8	Cutting Number Mark	47

List of Tables

Table No.	Description	Page No.
Table 2.1	4- Point System Defects	6
Table 3.1	All Final Inspection Reports Summary	32

List of Pie Charts

Pie Chart No.	Description	Page No.
Pie Chart 4.1	Fabric Section Defect Result	35
Pie Chart 4.2	Sewing Section Defect Result	36
Pie Chart 4.3	Finishing Section Defect Result	37
Pie Chart 4.4	Miscellaneous Section Defect Result	38
Pie Chart 4.5	All Section Defect Result	39



CHAPTER 1: INTRODUCTION



1.1 Introduction

Inspection is like checking or looking at something very closely to make sure it is good or working the way it should. It is a watchful investigation to dig up if there are any complications or defects. In routine life, we also have inspections, like whenever teachers check our homework to see if we did it correctly or when a chef overlooks the components in the kitchen to make sure they are spick and span. We can assure that the whole lot is in proper functioning order by running inspections.

This project is based on the final inspection reports of Ultimate Fashions Limited (UFL).

The primary aim is to gain comprehensive insights into the quality landscape of the end products, identify areas for enhancement, and ensure that manufacturing processes adhere to established quality standards.

1.2 Objectives

- ❖ To identify and categorize the most common faults
- ❖ To understand the underlying reasons behind these faults
- ❖ To generate and evaluate a list of corrective actions
- ❖ To improve the procedure of the final inspection
- ❖ To predict the future faults
- ❖ To quantify the financial impact of faults
- ❖ To compare the quality to accepted standards in the industry.
- ❖ To know the findings and recommendation

1.3 Importance of this Project

The analysis of faulty reports generated during the final inspection provides valuable insights into the quality of the produced garments and the effectiveness of the manufacturing processes. Here are key reasons highlighting the importance of such a project -

- For improving the quality of the product
- For cost reduction
- For process optimization
- For data-driven decision making
- For buyers satisfaction and compliance with standards

1.4 Scope of the study

The scope of the study includes identifying and categorizing common faults during the final inspection process of garments produced by Ultimate Fashions Limited (UFL), aiming to understand the underlying reasons behind these faults, generate and evaluate corrective actions, improve the final inspection procedure, predict future faults, quantify the financial impact of faults, and compare the quality to accepted industry standards.

1.5 Limitations

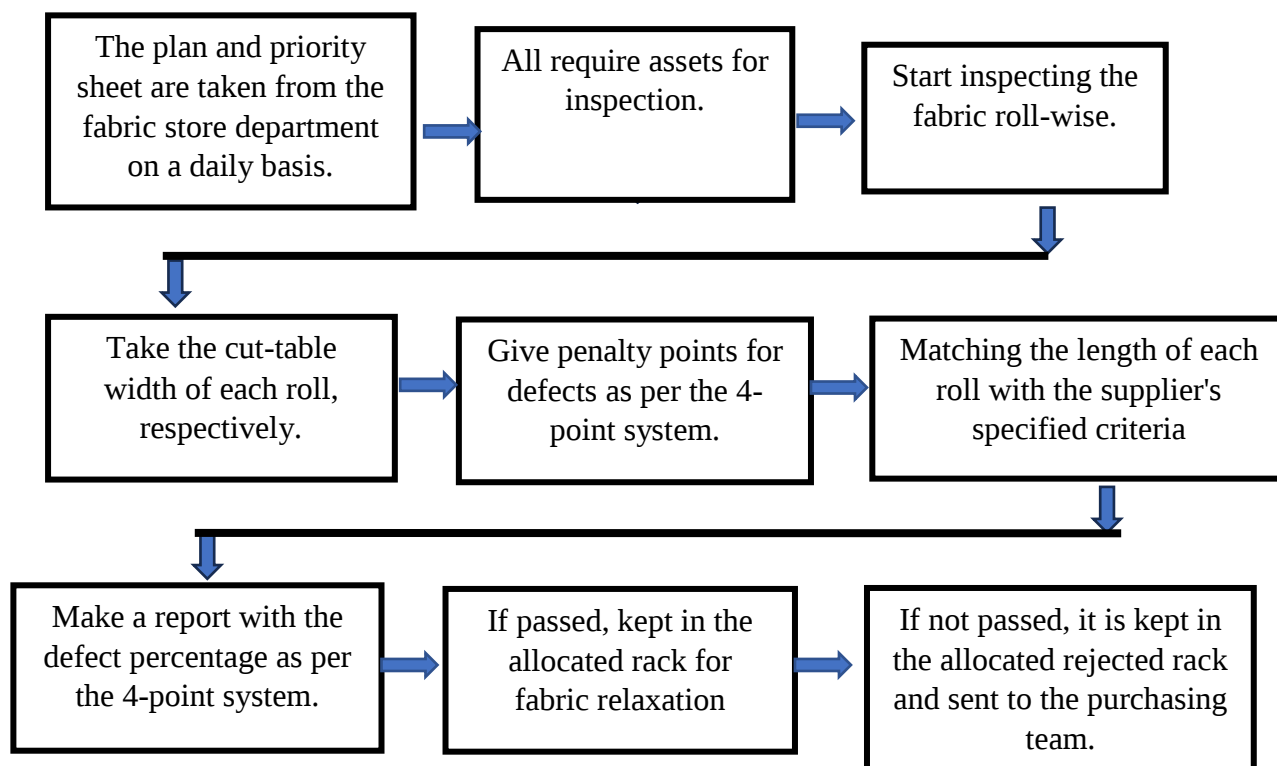
- 1) The study focuses solely on faults identified during UFL's final inspection, excluding potential issues in earlier production stages.
- 2) Findings may lack generalizability due to the limited sample size of faults analyzed.
- 3) Insights and recommendations may not extend beyond the denim manufacturing industry.
- 4) The study's findings are time-specific and may not reflect post-data collection changes in UFL's processes.
- 5) Reliability hinges on the completeness and accuracy of quality control data, subject to human error.
- 6) External factors like market trends or raw material prices may not be fully considered.
- 7) Resource limitations may affect the depth and thoroughness of the analysis.
- 8) The study might not fully grasp diverse buyer expectations, impacting corrective actions' effectiveness.



CHAPTER 2: LITERATURE REVIEW



2.1 Process Flow of the Fabric Inspection



2.1.1 Clockwise Inspection

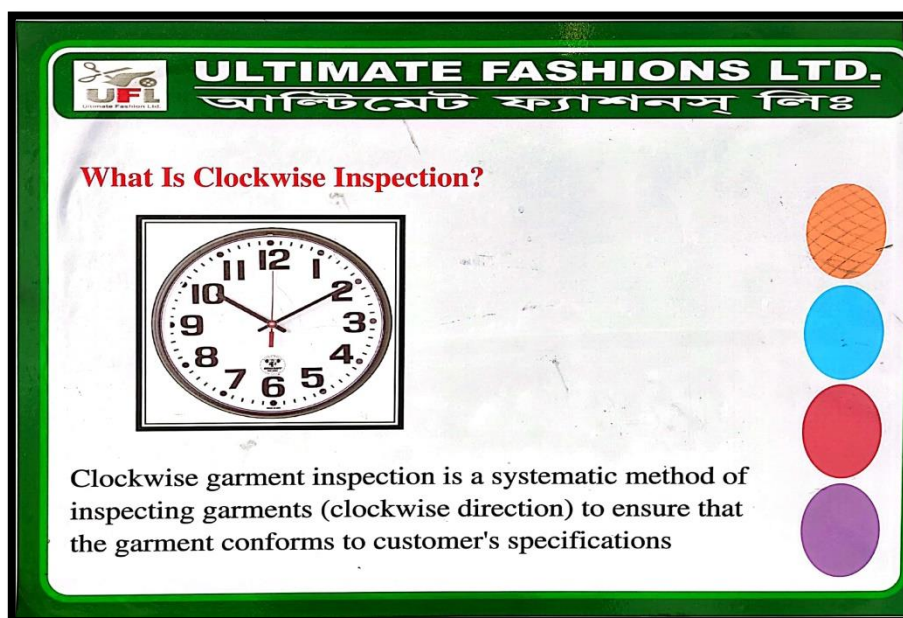


Figure 2.1: Clockwise Inspection

2.1.2 The 4- Point System

Table 2.1: 4- Point System Defects

Defect Length	Points
0" up to 3"	1
3" above to 6"	2
6" above to 9"	3
9" above	4
9" above	4
Hole Big knot	4

Equations for 4-point system inspection-

- Points per 100sq. yards: $(\text{Total points scored} \times 100 \times 3) / (\text{Width of the role (Inch)} \times \text{Total yards Inspected})$
- Points per 100s. meter: $(\text{Total points scored} \times 100 \times 100) / (\text{Width of the role (cm)} \times \text{Total yards Inspected})$.

2.2 Final Self Inspection Procedure List

SELF INSPECTION PROCEDURE	
SL.NO	CHECKING PROCEDURE
1	Collect Do letter, sample, trims card, Po sheet, measurment spec, others comments.
2	Need to actual pcs qty & carton Qty counting.
3	Check all shipping matk.(Size wise, pack ID wise)
4	check carton measurment.
5	Check total gross weight size wise & pack id wise.
6	Need picture carton all side with shipping mark.
7	Need carton opening image.
8	Need empty carton image.
9	Need bilester image and Pcs poly image.
10	Must be check styling with approved sample
11	Need accessories image all size together and Separately,compare with trims card.
12	Need to Specially check label construction with approved trims card
13	Need Approved sample and bulk production compare image.
14	Need folding image.
15	Check SKU.(Assort & Ratio)More important.
16	Need shade wise image with shade band compare image.
17	Check measurment size & inseam wise.
18	Check all Point to point again process wise ,if any confused
19	Any defect getting Above 10 pcs, must be use %, if Below 10 pcs use number Count.
20	Keep white paper for written comments any descriptions..
21	Need pull test report, Moistures report & measurment report
22	keep record monthly total inspection qty.
23	keep record all documents for future helf.
24	Must be ready inspection report within 3 hours.

Figure 2.2: Final Self Inspection Procedure List

2.3 Final Inspection Procedure in UFL

Ultimate Fashions Ltd.

South Gouripur, Ashulia, Dhaka

Final Inspection Procedure

It is done to the after pre-final inspection. After pre-final inspection if garment are passed. It will send to final inspection. After final inspection only, the decision of passing or rejecting is made.

- The QA File containing all the information regarding the Style (including all comments from Buyer) has to be kept ready before conducting the Final Inspection. This file has to be kept ready and updated by the Merchandiser.
- Final Inspection has to be conducted by Buying QC/In-house inspector/Account Responsible Person of the company.
- The criteria for Final inspection is mentioned below
 - Final inspections must be performed in a Inspection Room.
 - The Inspection Room must have a big table where the controls will take place.
 - The Inspection Room must be lit up by fluorescent tube Daylight = D65, and have TL 83 available. (nearby or over the table, based on different product groups needs according to information from PO.)
 - In this room only concerned people from factory should be present during inspection.
 - Smoking is totally prohibited in the Inspection room
 - The Final Inspection is conducted as per AQL 1.5/25/4.0 level-II, (also as per buyer requirements)
- Final inspection must take place when a minimum of 80% of the pieces are packed. (80% minimum only for our self-final inspection)
- The selected cartons are opened and the appearance of the open carton containing garments is observed (garments should not be tightly or loosely packed as it can change the presentation and appearance of the garment when the carton is opened).
- The carton is checked for ratio as per Contract/ PO Sheet. The garments are checked for Shade (as per the approved Shade Band) hand feel and moisture (as per the wash approved sample & moisture requirement), Quality, Presentation of the product.
- If the audit is passed, report is filed and preparations are taken for conducted the next Final Inspection.
- If the audit is failed, the Fail report is prepared and shown to the respective Head of quality, Concern People and The Head of production. The fail pcs are reviewed and necessary corrective action/ decision is taken immediately.
- The team prepares for next Final Inspection.
- When all the Final Inspections for a style is passed, then share to final packing list & send mail merchandiser for shipment approval purpose, after get approval then ship all inspected goods.

2.3.1 Total Procedure of the Inspection as Per Below

- 1) Start the inspection by checking the factory's Account Responsible Person Inline/Pre-final Inspection reports (to get an overview).
- 2) Compare the factory's QA inspection reports with the Accounts Responsible Person reports.
- 3) The account responsible person must, from a working packing list printed out, select the cartons to be inspected according to the supplier's internal markings.
- 4) Due to electronic packing lists, final carton marking will not be available until after the final packing list is submitted. Therefore, we (suppliers) are responsible for controlling the final carton marking, and what is inside the carton corresponds with the final packing list.
- 5) The cartons that need to be inspected must be chosen by the Independent QC.
- 6) Control that all packed cartons are stored order-by-order, country-by-country, fully positioned on pallets.
- 7) Check that the cartons have the correct size and quality (as per PO and ratio-wise).
- 8) Always check cartons containing SS/SC (solid size or solid color) and cartons containing ASST (assortments).
- 9) Control that all suggested improvements in earlier Nominated QC/Buying QC inspection reports have been accomplished.
- 10) Pick from each country a minimum of one carton.
- 11) Pick more cartons than required and check the specific fault if improvements have not been accomplished.
- 12) The nominated QC must always pick up the merchandise from the cartons themselves.
- 13) Check that the goods are packed according to the Bayer packing instructions. (Contact Buyer Packing responsible if necessary.)

2.3.2 How to Choose Cartons

Cartoons quantity are selected randomly us per square root of the total quantity of cartoons, But the issues is that selected cartoons should have all the color and size of the particular styles.

2.3.3 Output Check System

- First of all, the main label and care label should be checked.
- Label joint, loop joint, chain stitch, and top stitch reverse will not work.
- Skip stitch, broken stitch, single overlock, overstitch, and short stitch will not work.
- Uncut thread and join stitch garments cannot pass.
- Mouth close should be 100% straight.
- Waist belt loops that are slanted will not pass.
- Mouth lobe and width are uneven and will not work.
- Loop-up-down will not work.
- Displace bartack, overbartack, and short bartack will not work.
- The bartack position should be fixed.
- How many bartacks should be counted and checked?

- How many loops should be calculated and checked?
- Shadding, fabric defect, spot, or reject garments cannot be passed.
- Measurement of each piece, seeing the size of the label and passing garments
- Down stitch and pleat, puckking garments cannot pass.
- Process should be checked.
- Each garment's inseam and waist measurements should be taken.
- Styling should be matched with the PP sample before starting daily work. Styling should be coordinated.
- The daily width-out process, rejection, mistake, and spot should be recorded in the report form.
- There will be no number mistake.
- No kind of joint stitch will run.
- Every hour, it takes at least 10 minutes to check each country. The report should be updated every hour.
- Must update the bundle-wise report.
- If a new operator sits in any process, his work should be checked well.
- No problem can be hidden. Problems should be reported to everyone. The problem is first
- The chain of command must be obeyed. No action can be taken outside the chain of command.
- All the processes marked by the helper should be checked thoroughly every hour.
- A short bundle pass cannot be done.
- Everyone must comply with 55.

2.4 Defect Classification

Three types of defect -

1). Critical Defect - A defect that is likely to result in a hazardous or unsafe condition for an individual or anyone around him using the product or that contravenes mandatory regulations. Production is stopped when a critical defect shows itself.

2). Major Defect – A defect that is likely to result in failure; reducing the usability of the product and obvious appearance defects affecting the sale ability or shorten the life cycle of the product.

Stop producing after four major defects and one critical defect.

3). Minor Defect – A defect that does not reduce the usability of the product but is nevertheless a workmanship defect beyond the defined specifications or construction requirements.

4 Minor defects -> 1 Major Defect

2.4.1 Appearance Zones of the garment

The defects are rated by two areas of the garment, Zone A and Zone B.

- I. **ZONE A** = Areas of the garment that will draw attention: front, center of back, upper side of sleeve, upper side of collar.
- II. **ZONE B** = Areas of the garment that will not draw attention: sides under arm/sleeve, under sleeve, under collar, inner legs, inner collar and lining. To be defined more in detail later

2.4.2 AQL Chart

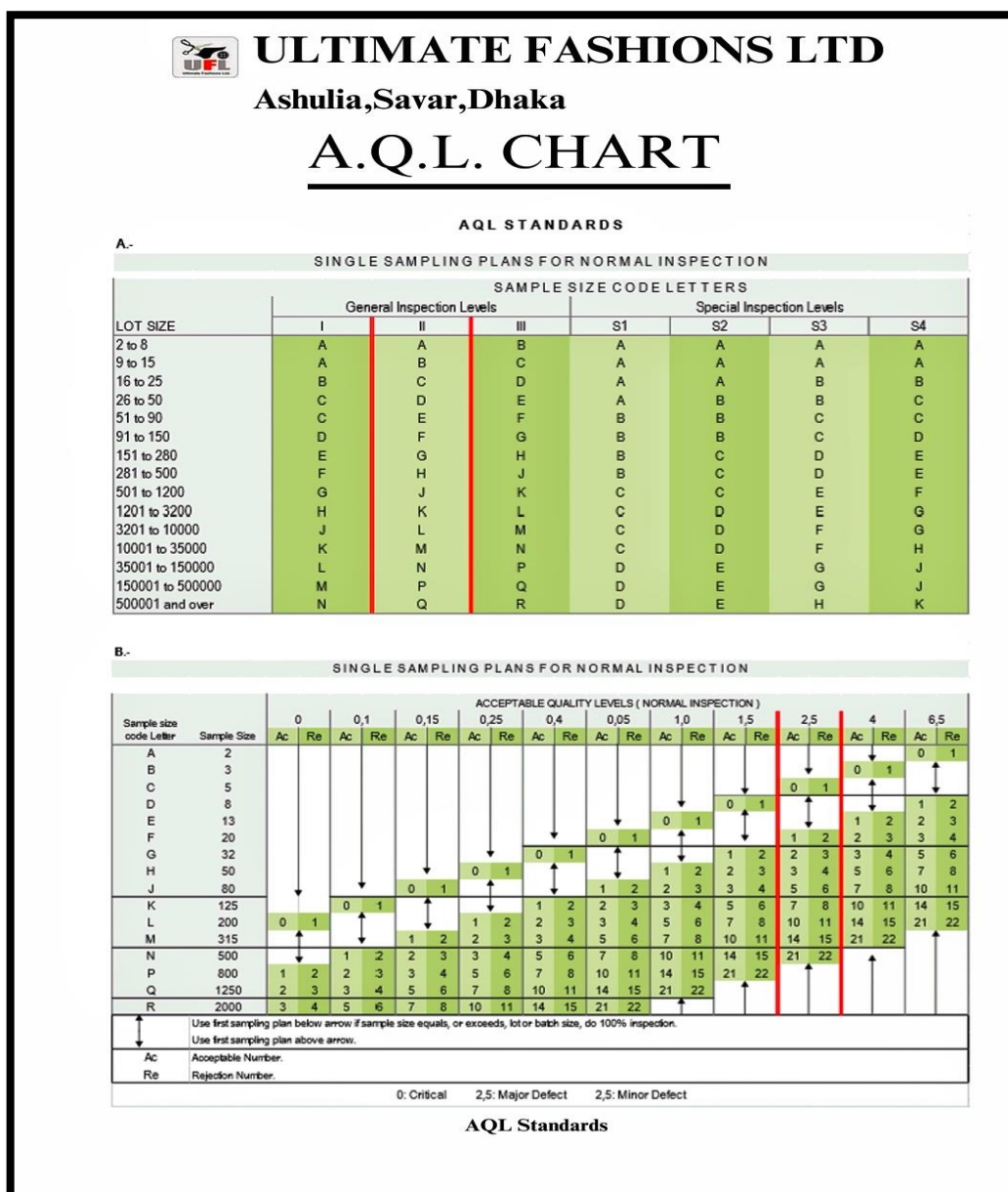


Figure 2.3: AQL Chart

2.5 Not Acceptable for Finishing Quality

ULTIMATE FASHION LTD.	
South gouripur, Ashulia, Savar, Dhaka.	
Not Acceptable for Finishing Quality	
❖	High-Low
❖	Puckering
❖	Shading
❖	Pleat
❖	Un-Cut Thread
❖	Model Out
❖	Fabric Fault
❖	Dirty Spot
❖	Poor Iron
❖	Damage
❖	Any Stitching Defect
❖	Washing Mark

Figure 2.4: Finishing Quality Faults

2.6 Faults in Sewing Section

ULTIMATE FASHIONS LTD		DEFECT CLASSIFICATION BORD (SEWING)			
	TYPE OF DEFECT	Critical	Major	Minor	
OPEN SEAM			X		
SKIP STITCH			X		
RUN OF STITCH			X		
UNEVEN STITCH					X
DOWN STITCH			X		
BROKEN STITCH			X		
STITCH OVERLAP			X		
JOINT STITCH			X		
UNEVEN STITCH TENSION			X		
LOOSE STITCH TENSION			X		
TIGHT STITCH TENSION			X		
STITCH MARGIN VARIATION			X		
SIZE MISTAKE		X			
NUMBER MISTAKE		X			
FRYING			X		
PLEATS			X		
GATHERING			X		
RAW EDGE OUT			X		
SHADEING			X		
OIL SPOT			X		
STRIP CHECK MISMATCH			X		
OVERLAPPING			X		
INSECURE BARTCK/BUTTON/LVL/B.HOLE/STITCH			X		
ZIPPER WAVV/BROKEN			X		
LOOP SLANTED			X		
UNEVEN LOOP LENGTH			X		
UNEVEN LOOP DISTANCE			X		
INCORRECT LOOP POSITION			X		
WAY MISTAKE		X			
TRIMS DEFECTS			X		
SHARP POINT			X		
HI LOW			X		
UNCUT THREAD			X		
POOR SHAPE			X		
TWISTED		X			
IRREGULAR SEAM ALLOWANCE			X		
SPOT			X		
UNEVEN WAIST BELT ALIGNMENT AT CENTER FRONT					X
UNEVEN BACK PKT ALIGNMEN			X		
UNEVEN BACK PKT DISTANCE FM B. RISE			X		
WRONG THREAD COUNT		X			
WRONG THREAD COLOR		X			
BIAS GRAIN LINE		X			
SLANTED			X		

Figure 2.5: Faults in Sewing Section

2.7 Quality Policy

They are committed to formulate measurable quality policy & objective based on their capabilities and customer's/buyer's expectations.

The quality policy of the company is as followed:

Customer/Buyer satisfactions with –

- Quality, safety & Legality
- Time and
- Consistency

2.7.1 Accessories Store Quality Flow Chart

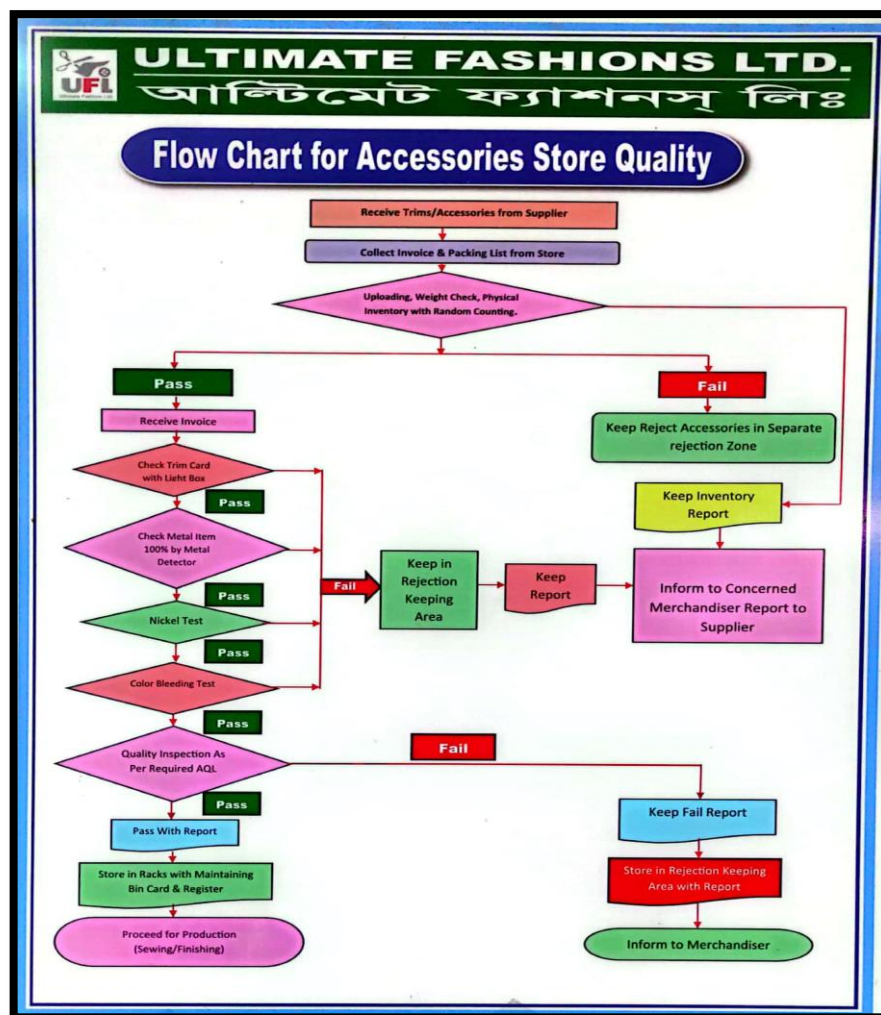


Figure 2.6: Accessories Store Quality Flow Chart

2.7.4 Finishing Quality Control Process



Figure 2.9: Finishing Quality Control Process

● — . — . — . — . — . — . — ●

CHAPTER 3: EXPERIMENTAL DATA

● — . — . — . — . — . — . — ●

3.1 Methodology of the Study

3.1.1 Research Design

The study adopts an exploratory research methodology to investigate and understand the common faults identified during the final inspection process of garments produced by Ultimate Fashions Limited (UFL).

3.1.2 Data Sources

To conduct this research, two sources are used:

1. Primary Source
2. Secondary Source

1). Primary Sources: Primary data collection includes acquiring information hand-in-hand from Ultimate Fashions Limited quality control records, final inspection reports, and holding a meeting with key personnel involved in the production and quality assurance processes.

2). Secondary Sources: Secondary data sources such as industry reports, academic journals, and related literature are evaluated to gather background information on common faults during garment production and quality control measures.

3.1.3 Target Population

The target population comprises all garments produced by UFL that undergo final inspection before distribution to customers.

3.1.4 Data Analysis

- a. Qualitative Analysis: Faults identified during the garment final inspection are categorized and analyzed qualitatively to comprehend their nature, predict future faults, and identify underlying causes.
- b. Quantitative Analysis: Quantitative techniques such as statistical investigation may be used to quantify the financial outcome of faults and determine their frequency over time.

3.1.5 Documentation and Reporting

All findings, analyses, summaries, and recommendations are recorded in a comprehensive report, describing the methodology, results, discussions, conclusions, and actionable recommendations for Ultimate Fashions Limited management to consider.

3.1.6 Data Collection

For data collection throughout the working days in the industry, we collected 14 final inspection reports.

3.2 UFL's Final Inspection Reports

3.2.1 Final Inspection Report 1


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE: 29-11-23
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: <u>MATALAD</u>				STYLE: <u>LBS245H003</u>				PO NO.: <u>F2406590</u>			
ITEM: <u>SHORT PANT</u>				COLOR: <u>BLACK</u>				CTN QTY:			
ORDER QTY:				SHIPMENT / PACK QTY:				INSPECTED QTY: <u>200 pcs 25/40 A.R.L</u>			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	☒		Pattern	☒		Pocket	☒		Retail packing / Solid packing	☒	
Knit/Rib	☒		Thread	☒		Hole	☒		Transport packing	☒	
Interfacing	☒		Stitches	☒		Shank button	☒		Transport marking, Incl. packing list in carton#1	☒	
Lining	☒		Seams	☒		Zipper	☒		Label/Pricetag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	☒	
Sequence	☒		Neck op./front	☒		W.band/B.loop	☒		Nickel test	☒	
Belt	☒		Shoulder/strape	☒		Bartack	☒		Needle detector	☒	
Print	☒		Sleeve/cuff	☒		Valore	☒		Broken needle record	☒	
Embroidry	☒		Hem <u>FOLD</u>	☒		Elastic	☒		Button & accessories test	☒	
									Output / Line	☒	

1. How many shade total / How many approved :

2. Does the production correspond to the approved C/S? YES NO COLOUR(S):

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501-1200	1201-3200	3201-10000	10001-35000	35001-150000	150001-500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :	Crit	Major	Minor
Final Inspection based on _____ pcs (____%) packed found with the following discrepancies :	-	-	-
* SKIP STC AT W/B & PKT BAG			111
* BROKEN STC AT BACK PKT & LOOP			11
* DOWN STC AT FLY			1
* DIRTY SPOT			1
* PLEAT AT W/B			1
* CRUCH MARK			111
* LABEL SLANTED			11
* BACK PKT ALLOW			1
* POOR TRON			1111
* FLY YARN & MOUTH CLOSE UP DOWN			111
Comments: * GOODS IS VISUAL PASS AS PER D.I.C.	FOUND DEFECTS	00	08
* MUST BE RE-CHECK 100% GOODS DUE TO UN-CUT & LOSS THREAD.	ALLOWED DEFECTS	00	10

Overall Inspection Result :

☒ Pass ☒ Re-Check ☐ Reject ☐ Hold up

Prepared By



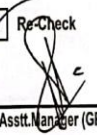
QC Incharge



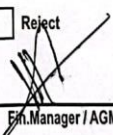
AQM



Asstt. Manager (GPQ & Audit)



Fin. Manager / AGM (Production)



QA Manager



Figure 3.1: Final Inspection Report 1

3.2.2 Final Inspection Report 2

UFL FQ -0112. V-02



ULTIMATE FASHIONS LTD.

FINAL INSPECTION REPORT

PRIMARK

Report No.:		Date: 23.10.23.10.23		Page 1 of 24	
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Brand Name:	PRIMARK	Vendor Name	NOIZE JEANS
Style & Kimball:	991087979&16029	Factory Name:	ULTIMATE FASHIONS LTD
P.O No:	1130499	Inspected By:	MD MOMIN UDDIN
Order Quantity:	1995PCS	Ship Quantity Packin :	1995PCS
Size:	6+8+10+12+14+16+18	Color Name:	g
Product Description:	2G TIE HEART DENIM SHORT	ETD	(AS PER PO SHEET)
POC No:	D11639222		

CHECK LIST	OK / NOT OK	CHECK LIST	OK / NOT OK
Styling:	OK	Lab test report No:	OK
P.P. Comments:	OK	Thread placement	OK
Trims & accessories	OK	Packaging Placement	OK
Shipping mark	OK	Poly / Hanger	OK
Size/ratio Qnty	OK	Belt Loop Pull Test:	OK
SBarcode Sticker (Gmnt / Carton)	OK	Carton weight:	5.100 Kgs
Fabric weight/GSM:	OK	CARTON MEASUREMENT	42X37X19 CM
Fabric composition:	100% COTTON.		
Moisture content:	FOUND MOISTURE RANGE- 30% TO 56%		
Shade (BATCH)	FOUND MIXED SHADE IN EXPORTED CARTON.		
Measurement:	OUT OF TOLERANCE SOME POINTS. PLEASE SEE THE ATTACHED MMS CHART.		
Inspected Carton Number:	NOT FOUND CARTON NUMBER WHEN INSPECTED THE GOODS.		

A. Workmanship:

Inspection Level -II,	A.Q.L – 1.5 For Major & 2.5 For Minor.	Sample size:125 PCS		
Defects / defects description		Critical	Major	Minor
01.RAWEDGE OUT AT BACK RISE		-	01	-
02.BROKEN STITCH AT W/B		-	01	-
03.SKIP STITCH AT INSEAM		-	01	-
04. WASHING MARK		-	-	-
05.RAW STITCH		-	-	01
06. UN CUT THREAD		-	-	01
07.POOR IRON		-	-	02
08.UNEVEN LOB AT MAIN LABEL		-	-	01
TOTAL DEFECTS		00	03	06
DEFECTS ALLOW		00	05	07

Visual Inspection Result:	PASS	Remarks: OVER ALL GOODS ARE FAIL. DUE TO FOUND BURN CARE LABEL.
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Figure 3.2: Final Inspection Report 2

3.2.3 Final Inspection Report 3


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE: 22-11-23
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: PRIMORR				STYLE: MOM SHORT				PO NO.: 1134176 POC-F11609189			
ITEM: SHORT PANTS				COLOR: BLUE				CTN QTY:			
ORDER QTY: 887 Pcs				SHIPMENT / PACK QTY:				INSPECTED QTY: 80 Pcs 25/4-0 AQL			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven			Pattern			Pocket			Trimming			Retail packing / Solid packing		
Knit/Rib			Thread			Hole			Pressing			Transport packing		
Interfacing			Stitches			Shank button			Washing			Transport marking, Incl packing list in carton#1		
Lining			Seams			Zipper			Stain etc			Label/Price tag/Waist tag/Leg sticker/ Hangtag/ Alarm tag		
Sequence			Neck op./front			W band/B loop			Chalk etc			Nickel test		
Belt			shoulder/strape			Bartack			Rivet			Needle detector		
Print			Sleeve/cuff			Velcro			Drawstring			Broken needle record		
Embroidry			Hem			Elastic			Stopper			Button & accessories test		
												Output / Line		

1. How many shade total / How many approved :

2. Does the production correspond to the approved C/S? YES NO COLOUR (S):

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501-1200	1201-3200	3201-10000	10001-35000	35001-150000	150001-500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :

Final Inspection based on _____ pcs (_____ %) packed found with the following discrepancies :

	Crit	Major	Minor
*SKIP STC AT W/B & FRONT RISE		02	
*BROKEN STC AT HEM & Side SEAM		02	
*RAWEDGE OUT AT ZIPER		01	
*DOWN STC AT MAIN LABEL		01	
*PLEAT AT PKT BAG		01	
*UNCLEAN POLY			11
*LOOP SLAATED			1
*SHORT STC & BACK PKT IN LOW			11
*RIVET DISPLACE			1
*POOR TRIM			11
Comments: * GOODS IS FAIL DUE TO BEYOND D.B.L.			
* 15% GOODS WERE FOUND UN-CUT THREAD.			
* FOUND MIX SHADE IN EXPORTED CTN.			
FOUND DEFECTS	07	09	
ALLOWED DEFECTS	05	07	

Overall Inspection Result : ☐ Pass ☒ Re-Check ☐ Reject ☐ Held-up

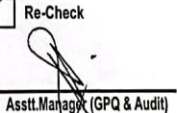
Prepared By:  QC Incharge:  AQM: _____ Asstt. Manager (GPQ & Audit):  Fin. Manager / AGM (Production):  QA Manager: 

Figure 3.3: Final Inspection Report 3

3.2.4 Final Inspection Report 4


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE: 18-11-2023
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: PRIMARK				STYLE: 79 STRIPE WIDE LEG				PO NO.: 1134372 POC-N/1607132			
ITEM: GIRLS LONG PANT				COLOR: LT BLUE				CTN QTY:			
ORDER QTY: - 20225 Pcs				SHIPMENT / PACK QTY:				INSPECTED QTY: 200 Pcs 25-40 A&L			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	✓		Pattern	✓		Pocket	✓		Trimming	✓		Retail packing / Solid packing	✓	
Knit/Rib	N/A		Thread	✓		Hole	✓		Pressing	✓		Transport packing	✓	
Interfacing	✓		Stitches	✓		Shank button	✓		Washing	✓		Transport marking, Incl packing list in carton#1	✓	
Lining	✓		Seams	✓		Zipper	✓		Stain etc	✓		Label/Price tag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	✓	
Sequence	✓		Neck op./front	N/A		W/band/B loop	✓		Chalk Bln	✓		Nickel test	✓	
Belt	N/A		shoulder/strape	N/A		Bartack	✓		Rivet	✓		Needle detector	✓	
Print	✓		Sleeve/cuff	N/A		Velcro	N/A		Drawstring	✓		Broken needle record	✓	
Embroidry	N/A		Hem	✓		Elastic	✓		Stopper	✓		Button & accessories test	✓	
												Output / Line	✓	

1. How many shade total / How many approved : _____

2. Does the production correspond to the approved C/S? YES NO COLOUR (S):

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501 - 1200	1201 - 3200	3201 - 10000	10001 - 35000	35001 - 150000	150001 - 500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :	Crit	Major	Minor
Final Inspection based on _____ pcs (_____ %) packed found with the following discrepancies :			
* MODEL OUT BROKEN STC AT CO/B & PKT		02	
* SKIP STC AT PKT		01	
* MISSING BARTACK AT LOOP		01	
* PLEAT AT W/B		01	
* HIT SEAL OPEN		01	
* DIRTY SPOT		02	
* WASHING MARK			03
* MOUTH PROSE UP down			02
* POOR IRON			04
** FOUND MIX SHADE 6 CARTON OUT RCTN. PLEASE RECHECK DUE TO MIX SHADE.			
Comments:- _____	FOUND DEFECTS	08	09
	ALLOWED DEFECTS	08	14

Overall Inspection Result : ☐ Pass ☒ Re-Check ☐ Reject ☐ Held-up

Prepared By:  QC Incharge: _____ AQM: _____ Asstt. Manager (GPQ & Audit): _____ Fin. Manager / AGM (Production): _____ QA Manager: _____

Figure 3.4: Final Inspection Report 4

3.2.5 Final Inspection Report 5


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE: 26-08-23
 TIME:

SEW-IN-LINE/FIN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: <u>Primark</u>		STYLE: <u>MDM JEAN-BW-23</u>		PO NO.: <u>125616 POE-N/1622292</u>	
ITEM: <u>LADIES LONG pant</u>		COLOR: <u>Black</u>		CTN QTY:	
ORDER QTY: <u>2001 Pcs</u>		SHIPMENT / PACK QTY:		INSPECTED QTY: <u>125 Pcs</u> <u>Q.L. 2.5</u>	

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	✓		Pattern	✓		Pocket	✓		Trimming	✓		Retail packing / Solid packing	✓	
Knit/Rib	N/A		Thread	✓		Hole	✓		Pressing	✓		Transport packing	✓	
Interfacing	✓		Stitches	✓		Shank button	✓		Washing	✓		Transport marking, Incl. packing list in carton#1	✓	
Lining	✓		Seams	✓		Zipper	✓		Stain etc	N/A		Label/Price tag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	✓	
Sequence	✓		Neck up / front	N/A		Wband/B loop	✓		Chalk Bin	✓		Nickel test	✓	
Belt	N/A		shoulder/strap	N/A		Bar tack	✓		Rivet	✓		Needle detector	✓	
Print	N/A		Sleeve/cuff	N/A		Velcro	N/A		Drawstring	N/A		Broken needle record	✓	
Embroidry	N/A		Hem	✓		Elastic	N/A		Stopper	N/A		Button & accessories test	✓	
												Output / Line	✓	

1. How many shade total / How many approved :

2. Does the production correspond to the approved C/S? YES NO COLOUR (S):

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501 - 1200	1201 - 3200	3201 - 10000	10001 - 35000	35001 - 150000	150001 - 500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :

Final Inspection based on 1650 pcs (82.9%) packed found with the following discrepancies :

	Crit	Major	Minor
* SKIP STE AT IN SEAM			
* BROKEN STE AT W/O S hem		01	
* INSECURED AT MAIN LABEL		02	
* DIRTY SPOT		01	
* POOR TRD		02	
* RIVET DIS PLACE			03
* LEG TWISTING			01
* FLY VARN			01
* UN CUT THREAD			02
			02

Comments: * VISUAL 1st INSPECTION RESULT IS PASS.
* DUE TO MIX SHADE (50%) INSPECTION FAIL.

	FOUND DEFECTS	06	09
ALLOWED DEFECTS		07	10

Overall Inspection Result :

☐ Pass

 Prepared By

☒ Re-Check

 QC Incharge

☐ Reject

 Asstt. Manager (GPQ & Audit)

☐ Held-up

 Fin. Manager / AGM (Production)

☐ QA Manager

 QA Manager

Figure 3.5: Final Inspection Report 5

3.2.6 Final Inspection Report 6

UFL FQ-0112. V-02

FINAL INSPECTION REPORT **MATALAN**

Report No.: _____ Date: 24.05.23 Page 1 of 11

Brand Name: MATALAN	Vendor Name: NOIZE JEANS
Style & Line code: LBW23DN005 & F459368	Factory Name: ULTIMATE FASHIONS LTD.
P.O No: F2364977	Inspected By: MD.MOMIN UDDIN
Order Quantity: 720-PCS	Ship Quantity / Packing: 580-PCS
Size: 8+10+12+14+16+18+20	Color Name: STONE
Product Description: SKINNY CARGO STONE	ETD: 15.MAY.2023 (AS PER PO SHEET)

Handwritten: Part due to mix shade + uncut thread

Handwritten: Need to Mark

CHECK LIST	OK / NOT OK	CHECK LIST	OK / NOT OK
Styling:	OK	Lab test report No:	OK
P.P. Comments:	OK	Thread placement	OK
Trims & accessories	OK	Packaging Placement	OK
Shipping mark	OK	Poly / Hanger	OK
Size/ratio Qty	OK	Belt Loop Pull Test:	15.400kg
SBarcode Sticker (Gmnt / Carton)	OK	Carton weight:	60X30X40
Fabric weight/GSM:	OK	Carton measurement	60X30X40
Fabric composition:	80% COTTON, 18% POLYESTER, 2% ELASTANE.		
Moisture content:	FOUND MOISTURE RANGE- 30% TO 57%.		
Shade (BATCH)	FOUND MIXED SHADE IN EXPORTED CARTON		
Measurement:	OUT OF TOLERANCE SOME POINTS. PLEASE SEE THE ATTACHED MMS CHART.		
Inspected Carton Number:	NOT FOUND CARTON NUMBER WHEN INSPECTED THE GOODS.		

A. Workmanship:		Sample size: 80 pcs		
Inspection Level -	A.Q.L - 2.5 For Major & 4.00 For Minor.	Critical	Major	Minor
Defects / defects description				
01. PLEAT AT PKT & W/B		-	01	-
02. CUT DAMAGE AT MAIN LABEL		-	01	-
03. DIRTY SPOT AT FRONT PART		-	01	-
04. RIVET DISPLACE		-	02	-
05. BACK PKT HI-LOW		-	-	01
06. FLY YARN		-	-	01
07. LOOP SLANTED		-	-	01
08. MOUTH CLOSE UP DOWN		-	-	01
09. MAIN LABEL SLANTED		-	-	-
TOTAL DEFECTS		00	04	05
DEFECTS ALLOW		00	05	07

Visual Inspection Result:	PASS	Remarks: GOODS WITHIN A.Q. L. BUT OVER ALL INSPECTION FAIL, DUE TO HUGE UNCUT THREAD AND MIX SHADE IN EXPORT CARTON.
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Figure 3.6: Final Inspection Report 6

3.2.7 Final Inspection Report 7


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE: 22-11-23
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: PRIMARK				STYLE: 2G TIE HEART DENTIM SHORT				PO NO.: 1130909 POE-B/1639228			
ITEM: SHORT PANT				COLOR: BLUE				CTN QTY:			
ORDER QTY: 4680 Pcs				SHIPMENT / PACK QTY:				INSPECTED QTY: 200 Pcs 259.0 AQL			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	✓		Pattern	✓		Pocket	✓		Trimming	✓		Retail packing / Solid packing	✓	
Knit/Rib	N/A		Thread	✓		Hole	✓		Pressing	✓		Transport packing	✓	
Interfacing	✓		Stitches	✓		Shank button	✓		Washing	✓		Transport marking, Incl. packing list in carton#1	✓	
Lining	✓		Seams	✓		Zipper	✓		Stain etc	✓		Label/Pricetag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	✓	
Sequence	✓		Neck op./front	N/A		W.band/B.loop	✓		Chalk Btm	✓		Nickel test	✓	
Belt	N/A		shoulder/strape	✓		Bartack	✓		Rivet	✓		Needle detector	✓	
Print	N/A		Sleeve/cuff	N/A		Velcro	✓		Drawstring	✓		Broken needle record	✓	
Embroidry	N/A		Hem	✓		Elastic	✓		Stopper	✓		Button & accessories test	✓	
												Output / Line	✓	

1. How many shade total / How many approved : _____

2. Does the production correspond to the approved C/S? YES NO COLOUR (S): _____

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501 - 1200	1201 - 3200	3201 - 10000	10001 - 35000	35001 - 150000	150001 - 500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :

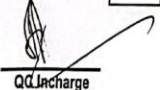
Final Inspection based on _____ pcs (_____ %) packed found with the following descriptions :	Crit	Major	Minor
* BROKEN STE AT W.B. & FRONT RISE		11	
* SKIP STE AT W. SEAM		1	
* FABBING MARK		1	
* DIRTY SPOT		111	
* INSECURED MAIN LABEL		1	
* WASHING MARK			111
* FLY YARN			11
* POOR TON			111
* LINE MARK			1

Comments:- * VISUAL INSPECTION IS POSS. BASED PER A.Q.L.
 * INSPECTION FAIL DUE TO BELT SHADING & YELLOW MARK.
 * 15% GOODS WERE FOUND UN-CUT THREAD.

FOUND DEFECTS	08	11
ALLOWED DEFECTS	10	19

Overall Inspection Result : ☐ Pass ☒ Re-Check ☐ Reject ☐ Held-up

Prepared By: 

QC Incharge: 

AQM: _____

Asstt. Manager (PQ & Audit): 

Fin. Manager / AGM (Production): 

QA Manager: 

Figure 3.7: Final Inspection Report 7

3.2.8 Final Inspection Report 8


ULTIMATE FASHIONS LTD.

ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL FQ-0042.V-02
 KIMBALL:
 DATE: 23-10-2023
 TIME:

SEW-IN-LINE/FIN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: PRIMARK		STYLE: CARGO DUNGAREE		PO NO.: A11873048	
ITEM: LOAG		COLOR: GREY		CTN QTY:	
ORDER QTY: 650 pcs.		SHIPMENT / PACK QTY:		INSPECTED QTY: 80 pcs.	

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	✓		Pattern	✓		Pocket	✓		Trimming	✓		Retail packing / Solid packing	✓	
Knit/Rib	N/A		Thread	✓		Hole	✓		Pressing	✓		Transport packing	✓	
Interfacing	N/A		Stitches	✓		Shank button	✓		Washing	✓		Transport marking, Ind. packing list in carton#1	✓	
Lining	✓		Seams	✓		Zipper	N/A		Stain etc.	N/A		Label/Price tag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	✓	
Sequence	✓		Neck cp./front	N/A		W band/B loop	✓		Chalk Btm	N/A		Nickel test	✓	
Belt	N/A		shoulder/straps	N/A		Bar tack	✓		Rivet	N/A		Needle detector	✓	
Print	N/A		Sleeve/cuff	N/A		Velcro	N/A		Drawstring	N/A		Broken needle record	✓	
Embroidry	N/A		Ham	✓		Elastic	N/A		Stopper	N/A		Button & accessories test	✓	
												Output / Line	✓	

1. How many shade total / How many approved :

2. Does the production correspond to the approved C/S? YES NO COLOUR (S):

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501 - 1200	1201 - 3200	3201 - 10000	10001 - 35000	35001 - 150000	150001 - 500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :

	Crit	Major	Minor
Final Inspection based on _____ pcs (_____ %) packed found with the following descriptions :			
* BROKEN STC FRONT BIB & PKT.		02	
* LINE MARK AT GMTS.		01	
* SPOT AT GMTS.		01	
* WASHING MARK.			01
* POOR IRON AT GMTS.			01
* LEG TWISTED			01
* FLY WEAR AT GMTS			01
* FOUND MIXED SHADE, UNCUT THREAD AT 50% GMT.			

Comments: ~~GOODS ARE PASS AS PER AQL. BUT UNAVAILABLE~~
UNCUT THREAD IN THIS REASON GOODS CHECK.

FOUND DEFECTS	04	09
ALLOWED DEFECTS	05	07

Overall Inspection Result :

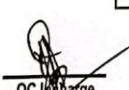
☐ Pass

☒ Re-Check

☐ Reject

☐ Held-up


 Prepared By


 QC Manager


 AQM


 Asstt. Manager (GPD & Audit)


 Fin. Manager / AGM (Production)


 QA Manager

Figure 3.8: Final Inspection Report 8

3.2.9 Final Inspection Report 9


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE:
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: <u>PRIMARK</u>				STYLE: <u>76 STRIKE WIDE LEG</u>				PO NO.: <u>1134372 POE - C1697133</u>			
ITEM: <u>GILLS LONG PANT</u>				COLOR: <u>LIGHT BLUE</u>				CTN QTY: <u>80</u>			
ORDER QTY: <u>80</u>				SHIPMENT / PACK QTY: <u>80</u>				INSPECTED QTY: <u>80</u>			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	☒		Pattern	☒		Pocket	☒		Trimming	☒		Retail packing / Solid packing	☒	
Knit/Rib	☒		Thread	☒		Hole	☒		Pressing	☒		Transport packing	☒	
Interfacing	☒		Stitches	☒		Shank button	☒		Washing	☒		Transport marking, Incl. packing list in carton#1	☒	
Lining	☒		Seams	☒		Zipper	☒		Stain etc	☒		Label/Price tag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	☒	
Sequance	☒		Neck up/ front	☒		W/ band/B. loop	☒		Chalk Bln	☒		Nickel test	☒	
Belt	☒		Shoulder/strape	☒		Bartack	☒		Rivet	☒		Needle detector	☒	
Print	☒		Sleeve/cuff	☒		Velcro	☒		Drawstring	☒		Broken needle record	☒	
Embroidry	☒		Hem	☒		Elastic	☒		Stopper	☒		Button & accessories test	☒	
1. How many shade total / How many approved :												Output / Line		

2. Does the production correspond to the approved C/S?										YES	NO	COLOUR (S):			
LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501 - 1200	1201 - 3200	3201 - 10000	10001 - 35000	35001 - 150000	150001 - 500000	500001 and over					
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21					
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21					
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21					

Workmanship / Others Appearance :										Crit	Major	Minor
Final Inspection based on _____ pcs (_____ %) packed found with the following descriptions :												
* BROKEN STE AT WLB											1	
* SHIP STE AT PKT											1	
* DIRTY SPOT											1	
* RAW EDGE OUT AT ZIPER											1	
* OPEN STE AT hem											1	
* HIT SEAL SLANTED												1
* WASHING MARK												1
* POOR TPO												1
* HIKING AT HEM												1
* FLOW STE FOUND W/ OUT THREAD 20% GIMS												1

Comments: ** FOUND MIX SHADES CARTON OUT OF 7 CTN PLEASE
RECHECK DUE TO MIX SHADE.

FOUND DEFECTS		05	06
ALLOWED DEFECTS		05	07

Overall Inspection Result : ☐ Pass ☒ Re-Check ☐ Reject ☐ Held-up

Prepared By: [Signature] QC Incharge: _____ AQM: _____ Asstt. Manager (GPQ & Audit): _____ Fin. Manager / AGM (Production): [Signature] QA Manager: [Signature]

Figure 3.9: Final Inspection Report 9

3.2.10 Final Inspection Report 10



ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL-FQ-0042.V-02
 KIMBALL:
 DATE: 18-11-23
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL /FINAL INSPECTION REPORT

BUYER: PRIMARK				STYLE: 76 STRIPE DUGGAKEE				PO NO.: 1134359			
ITEM:				COLOR: LIGHT BLUE				CTN QTY:			
ORDER QTY: 1310 Pcs				SHIPMENT/PACK QTY:				INSPECTED QTY: 80 Pcs 25/4-0 B&L			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	✓		Pattern	✓		Pocket	✓		Trimming	✓		Retail packing / Solid packing	✓	
Knit/Rib	N/A		Thread	✓		Hole	✓		Pressing	✓		Transport packing	✓	
Inter facing	✓		Stitches	✓		Shank button	✓		Washing	✓		Transport marking, Incl. packing list in carton#1	✓	
Lining/ Fusing	✓		Seams	✓		Zipper	N/A		Plastic Button	✓		Label/Pricetag/Waist tag/Leg sticker/ Hangtag/Alarm tag	✓	
Sequence	✓		Neck op./front	N/A		W.band/B.loop	N/A		Labelling	✓		Nickel test	✓	
Belt	N/A		Shoulder/strape	N/A		Bar tack	✓		Rivet	✓		Needle detector	✓	
Print	✓		Sleeve/cuff	N/A		Velcro	N/A		Drawstring	✓		Broken needle record	✓	
Embroidry	N/A		Hem	✓		Elastic	N/A		Stopper	✓		Button & accessories test	✓	

1. How many shade total / How many approved :
 2. Does the production correspond to the approved C/S? YES NO COLOUR (S):

LOTE SIZE	LESS THAN 281	281-500	501-1200	1201-3200	3201-10000	10001-35000	35001-150000	150001-500000	500001 and over
AQL-1.5	13 / 0 / 0	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 22
AQL-2.5	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	125 / 7 / 10	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :

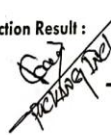
Final Inspection based on _____ pcs (_____ %) packed found with the following descriptions :	Crit	Major	Minor
* BROKEN STC AT PKT SW/B	-	02	
* SKIP STC AT W/B & PKT	-	02	
* PLEAT AT W/B		01	
* MODEL OUT AT B/B		01	
* SPOT		11	
* FLY YARN			1
* WASHING MARK			11
* POCK MARK			11
* UNWORN WASH			11

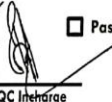
Comments: FOUND MIXED SHADE, UN CUT THREAD 20% GMT'S
 GOODS AREA FALL AS PER DUE TO ALL FOUND AREA RE-CHECK.

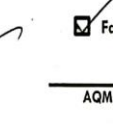
	FOUND DEFECTS	MAJOR	MINOR
FOUND DEFECTS	09	10	
ALLOWED DEFECTS	05	07	

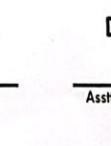
Overall Inspection Result :
☐ Pass
☒ Fail
☐ Re-Check
☐ Reject
☐ Held-up


 Prepared By


 QC Incharge


 AQM


 Assff. Manager (GPQ & Audit)


 Fin. Manager / AGM (Production)

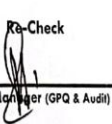

 QA Manager

Figure 3.10: Final Inspection Report 10

3.2.11 Final Inspection Report 11

UFL FQ-0112, V-02



UFL
ULTIMATE
FASHIONS LTD.

FINAL INSPECTION REPORT

PRIMARK®

Report No.:	Date: 15.06.2023	Page 1 of 16
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Brand Name:	PRIMARK	Vendor Name:	NOIZE JEANS
Style & Kimball:	991077333&57586	Factory Name:	ULTIMATE FASHIONS LTD
P.O No:	1117136	Inspected By:	MD.MOMIN UDDIN
Order Quantity:	1609PCS	Ship Quantity / Packing:	1300 PCS
Size:	6+8+10+12+14+16+18+20	Color Name:	DARK BLUE
Product Description:	PP GRUNGE STRAIGHT LEG JEAN	ETD	(AS PER PO SHEET)
POC No.	C11579466+N11579465		

CHECK LIST	OK / NOT OK	CHECK LIST	OK / NOT OK
Styling:	OK	Lab test report No:	OK
P.P. Comments:	OK	Thread placement	OK
Trims & accessories	OK	Packaging Placement	OK
Shipping mark	OK	Poly / Hanger	OK
Size/ratio Qnty	OK	Belt Loop Pull Test:	OK
SBarcode Sticker (Gmnt / Carton)	OK	Carton weight:	9.100 TO 11.600 KG
Fabric weight/GSM:	OK	CARTON MEASUREMENT	60X53X13 64X58X12 60X53X13 64X58X15
Fabric composition	100% COTTON.		
Moisture content:	FOUND MOISTURE RANGE = 28%-60%		
Shade (BATCH)	FOUND MIXED SHADE IN EXPORTED CARTON.		
Measurement:	OUT OF TOLERANCE SOME POINTS. PLEASE SEE THE ATTACHED MMS CHART.		
Inspected Carton Number:	NOT FOUND CARTON NUMBER WHEN INSPECTED THE GOODS.		

A. Workmanship:

Inspection Level -II,	A.Q.L – 2.5 For Major & 4.0 For Minor.	Sample size: 125PCS		
Defects / Defects description	Critical	Major	Minor	
01. BROKEN STITCH AT W/B&SIDE SEAM&PKT	-	03	-	
02. RABBING MARK	-	01	-	
03. RAWEDGE OUT AT SIDE SEAM & BACK RISE	-	01	-	
04. SKIP STITCH AT PKT BAG&BACK RISE	-	02	-	
05. DIRTY SPOT AT FRONT PART	-	01	-	
06. FABRIC DEFECT	-	01	-	
07. BACK PKT HI LOW	-	-	01	
08. LOOP SLANTED	-	-	01	
09. MOUTH CLOSE UP DOWN	-	-	02	
10. RIVET DISPLACE	-	-	01	
11. UN CLEAN DUST	-	-	01	
12. WASHING MARK	-	-	01	
13. HIKING AT HEM	-	-	01	
14. PUCKERING AT HEM	-	-	04	
TOTAL DEFECTS	00	09	12	
DEFECTS ALLOW	00	07	10	

Visual Inspection Result:	FAIL	Remarks: GOODS IS FAIL DUE ABOVE POINT
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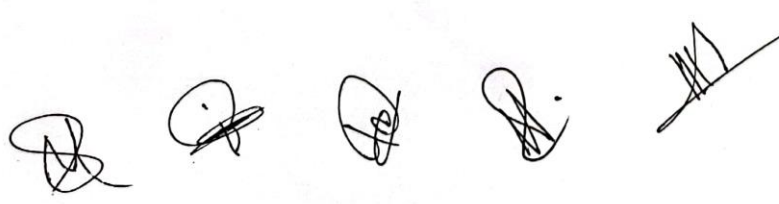


Figure 3.11: Final Inspection Report 11

3.2.12 Final Inspection Report 12

 ULTIMATE FASHIONS LTD.	FINAL INSPECTION REPORT	PRIMARK
Report No.:	Date: 19.01.23	Page 1 of 18

Brand Name:	PRIMARK	Vendor Name:	NOIZE JEANS
Style & Kimball:	991058297& 42424	Factory Name:	ULTIMATE FASHIONS LTD
P.O No:	1087569	Inspected By:	MD MOMIN UDDIN
Order Quantity:	320 PCS	Ship Quantity / Packing:	280PCS
Size:	XS+S+M+L+XL+2XL	Color Name:	GREY
Product Description:	DENIM BERMUDA	ETD	27.12.22- (ASPER PO SHEET)
POC No:	A11105926		

CHECK LIST	OK / NOT OK	CHECK LIST	OK / NOT OK
Styling:	OK	Lab test report No:	OK
P.P. Comments:	OK	Thread placement	OK
Trims & accessories	OK	Packaging Placement	OK
Shipping mark	OK	Poly / Hanger	OK
Size/ratio Qty	OK	Belt Loop Pull-Test:	OK
SBarcode Sticker (Gmnt / Carton)	OK	Carton weight:	8.400Kgs To 9.200 Kgs
Fabric weight/GSM:	OK		
Moisture content:	FOUND MOISTURE RANGE- 27% TO 53%.		
Shade (BATCH)	FOUND MIXED SHADE IN EXPORTED CARTON.		
Measurement:	OUT OF TOLERANCE SOME POINTS. PLEASE SEE THE ATTACHED MMS CHART.		
Inspected Carton Number:	NOT FOUND CARTON NUMBER.		

A. Workmanship:				
Inspection Level -II,	A.Q.L – 2.5 For Major & 4.00 For Minor.	Sample size: 32 PCS		
	Defects / defects description	Critical	Major	Minor
	01. UN CUT THREAD	-	04	-
	02. BROKEN STITCH	-	01	-
	03. FLY YARN	-	-	01
	04. WASHING MARK	-	-	02
	05. UN CUT THREAD	-	-	03
	06. RAW STITCH	-	-	01
		-	-	-
		-	-	-
	TOTAL DEFECTS	00	05	07
	DEFECTS ALLOW	00	02	03

Visual Inspection Result:	FAIL	Remarks: GOODS IS FAIL DUE TO ABOVE POIN
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Figure 3.12: Final Inspection Report 12

3.2.13 Final Inspection Report 13


ULTIMATE FASHIONS LTD.
 ASHULIA, SAVAR, DHAKA
 Quality Control Department

UFL FQ-0042.V-02
 KIMBALL:
 DATE: **29-10-23**
 TIME:

SEW-IN-LINE/FIN-IN-LINE/PRE-FINAL / FINAL INSPECTION REPORT

BUYER: PRIMARK				STYLE: 76-DENIM CARGO				PO NO.: 511649389			
ITEM: LONG PANT				COLOR: BLUE				CTN QTY:			
ORDER QTY: 4000 PCS.				SHIPMENT / PACK QTY:				INSPECTED QTY:			

FABRIC	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PRODUCTION	OK	NOT OK	PACKING	OK	NOT OK
Woven	✓		Pattern	✓		Pocket	✓		Trimming	✓		Retail packing / Solid packing	✓	
Knit/Rib	N/A		Thread	✓		Hole	✓		Pressing	✓		Transport packing	✓	
Interfacing	N/A		Stitches	✓		Shank button	✓		Washing	✓		Transport marking, incl packing list in carton#1	✓	
Lining	✓		Seams	✓		Zipper	✓		Stain etc	N/A		Label/Pricetag/Waist tag/Leg sticker/ Hangtag/ Alarm tag	✓	
Sequence	✓		Neck op./front	N/A		W.band/B loop	✓		Chalk Bin	N/A		Nickel test	✓	
Belt	N/A		shoulder/strape	N/A		Bartack	✓		Rivet	N/A		Needle detector	✓	
Print	N/A		Sleeve/cuff	N/A		Velcro	N/A		Drawstring	N/A		Broken needle record	✓	
Embroidry	N/A		Hem	✓		Elastic	✓		Stopper	N/A		Button & accessories test	✓	
												Output / Line		

1. How many shade total / How many approved :

2. Does the production correspond to the approved C/S? YES NO COLOUR (S):

LOTE SIZE	LESS THAN 150	150 - 280	281 - 500	501-1200	1201-3200	3201-10000	10001-35000	35001-150000	150001-500000	500001 and over
AQL-1.5	20 / 0 / 1	32 / 0 / 0	50 / 2 / 3	80 / 3 / 5	125 / 5 / 7	200 / 7 / 10	315 / 10 / 14	500 / 14 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-2.5	20 / 1 / 2	32 / 2 / 3	50 / 3 / 5	80 / 5 / 7	(125 / 7 / 10)	200 / 10 / 14	315 / 14 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21
AQL-4.0	20 / 2 / 3	32 / 3 / 5	50 / 5 / 7	80 / 7 / 10	125 / 10 / 14	200 / 14 / 21	315 / 21 / 21	500 / 21 / 21	800 / 21 / 21	1250 / 21 / 21

Workmanship / Others Appearance :	Crit	Major	Minor
Final Inspection based on _____ pcs (____%) packed found with the following descriptions :	—	—	—
SKIP STC AT WAIST, PANEL	—	05	—
BROKEN BTC AT PNT / HEM & WAIST	—	03	—
RAW EDGE OUT FRONT CORNER.	—	01	—
DIRTY SPOT	—	02	—
WASHING MARK AT GMTS.	—	01	01
OPEN STC AT ELASTIC	—	01	—
FLY YARN AT GMTS.	—	—	05
ELASTIC LOOSENESS.	—	—	03
ELASTIC TACK DIS-VISIBLE.	—	—	04
BK PK HIGH LOW, POOR	—	—	03
Comments: FOUND MIXED SHADE, POOR IRON, UNCUT THREAD 30% GMTS.	FOUND DEFECTS	00	13
GOODS ARE FAIL DUE TO BEYOND SS AQL.	ALLOWED DEFECTS	00	07

Overall Inspection Result :

☐ Pass

 Prepared By

☐ Re-Check

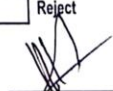
 QC Incharge

☒ Re-Check

 AQM

☐ Reject

 Asstt. Manager (PQ & Audit)

☐ Held-up

 Fin. Manager / AGM (Production)

☐ Held-up

 QA Manager

Figure 3.13: Final Inspection Report 13

3.2.14 Final Inspection Report 14

 UFI ULTIMATE FASHIONS LTD.	FINAL INSPECTION REPORT	PRIMARK®
Report No.:	Date: 19.01.23	Page 1 of 18

Brand Name:	PRIMARK	Vendor Name:	NOIZE JEANS
Style & Kimball:	991024694 & 64207	Factory Name:	ULTIMATE FASHIONS LTD
P.O No:	1066657	Inspected By:	MD MOMIN UDDIN
Order Quantity:	4224 PCS	Ship Quantity / Packing:	3500PCS
Size:	4+6+8+10+12+14+16+18+20	Color Name:	WHITE
Product Description:	BASIC DENIM JACKET	ETD	17.01.2023(ASPER PO SHEET)
POC No:	G11161958		

CHECK LIST	OK / NOT OK	CHECK LIST	OK / NOT OK
Styling:	OK	Lab test report No:	OK
P.P. Comments:	OK	Thread placement	OK
Trims & accessories	OK	Packaging Placement	OK
Shipping mark	OK	Poly / Hanger	OK
Size/ratio Qty	OK	Belt Loop Pull Test:	OK
SBarcode Sticker (Gmnt / Carton)	OK	Carton weight:	5.7 Kgs To 6.4 Kgs
Fabric weight/GSM:	OK		
Moisture content:	FOUND MOISTURE RANGE- 27% TO 58%.		
Shade (BATCH)	FOUND MIXED SHADE IN EXPORTED CARTON.		
Measurement:	OUT OF TOLERANCE SOME POINTS. PLEASE SEE THE ATTACHED MMS CHART.		
Inspected Carton Number:	NOT FOUND CARTON NUMBER.		

A. Workmanship:				
Inspection Level -II,	A.Q.L – 2.5 For Major & 4.00 For Minor.	Sample size: 200 PCS		
	Defects / defects description	Critical	Major	Minor
	01. DIRTY SPOT	-	02	-
	02. SKIP STITCH AT ARM HOLE	-	02	-
	03. POCKETING DAMAGE	-	01	-
	04. CARE LABEL WRONG POSITION		01	-
	05. CUTTING NUMBER MARK	-	04	-
	06. BUTTON DISPLACE	-	02	
	07. POOR IRON			02
	08. RAW STITCH			03
	09. GUMBLE UP DOWN			02
	10. LABEL SLANTED	-	-	01
	11. FLY YARN	-	-	05
	12. UN CUT THREAD			03
	TOTAL DEFECTS	00	12	16
	DEFECTS ALLOW	00	10	14

Visual Inspection Result:	FAIL	Remarks: GOODS IS FAIL DUE TO ABOVE POINT
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Figure 3.14: Final Inspection Report 14

3.3 Summary of All Final Inspection Reports

Table 3.1: All Final Inspection Reports Summary

Defect name	Major	Minor	Weight	Section wise %	Total %
Fabric defect					
1. Fabric defect	1×3=3		3	18.75%	3.62%
2. Hole	1×3=3		3	18.75%	
3. Line mark	1×3=3	1×1=1	3+1=4	25%	
4. Rubbing mark	2×3=6		6	37.5%	
Total			16	100%	

Sewing defect					
1. Broken stitch	23×3=69		69	30.66%	50.79%
2. Skipped stitch	21×3=63		63	28%	
3. Pleat	5×3=15		15	6.67%	
4. Button up-down	2×3=6		6	2.67%	
5. Pocket damage	1×3=3		3	1.33%	
6. Down stitch	1×3=3		3	1.33%	
7. Hi low		8×1=8	8	3.55%	
8. Mouth close up-down		8×1=8	8	3.55%	
9. Missing bar tack	1×3=3		3	1.33%	
10. Hit seal open	1×3=3	1×1=1	3+1=4	1.78%	
11. Raw edge out	5×3=15		15	6.67%	
12. Open stitch at hem	2×3=6		6	2.67%	
13. Hiking at hem		2×1=2	2	0.89%	
14. Raw stitch		6×1=6	6	2.67%	
15. Down stitch	1×3=3		3	1.33%	
16. Loop slanted		3×1=3	3	1.33%	
17. Short stitch		2×1=2	2	0.89%	
18. Puckering		4×1=4	4	1.78%	
19. Gumble up-down		2×1=2	2	0.89%	
Total			225	100%	

Finishing defect					
1. Dirty spot	15×3=45		45	25.86%	39.27%
2. Poor iron		25×1=25	25	14.37%	
3. Washing mark	1×3=3	18×1=18	3+18=21	12.07%	
4. Model out	1×3=3		3	1.72%	
5. Spot	4×3=12		12	6.9%	
6. Fly yarn		18×1=18	18	10.34%	
7. Rivet displace	2×3=6	3×1=3	6+3=9	5.17%	
8. Care label wrong position	1×3=3		3	1.72%	
9. Leg twisted		2×1=2	2	1.15%	
10. Insecure main label	3×3=9	1×1=1	9+1=10	5.75%	
11. Uncut thread	4×3=12	10×1=10	12+10=22	12.64%	
12. Crush mark		3×1=3	3	1.72%	
13. Unclean dust		1×1=1	1	0.57%	
Total			174	100%	

Miscellaneous defect					
1. Decoration label slanted		4×1=4	4	14.29%	6.32%
2. Uneven wash		3×1=3	3	10.71%	
3. Unclean poly		2×1=2	2	7.14%	
4. Elastic looseness		3×1=3	3	10.71%	
5. Elastic tuck visible		4×1=4	4	14.29%	
6. Cutting number mark	4×3=12		12	42.86%	
Total			28	100%	

All Total			443	100%
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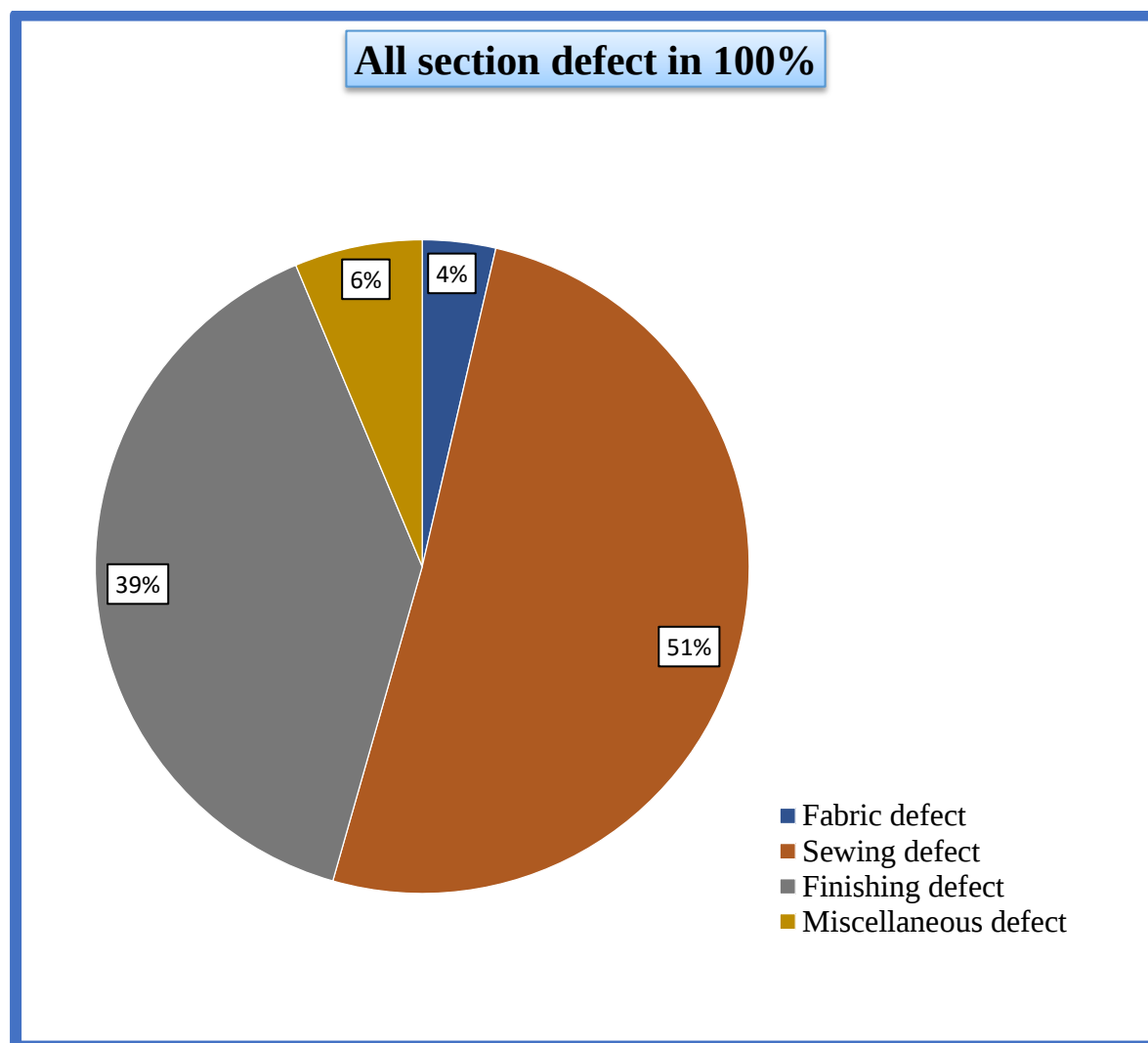
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CHAPTER 4: RESULT & DISCUSSION

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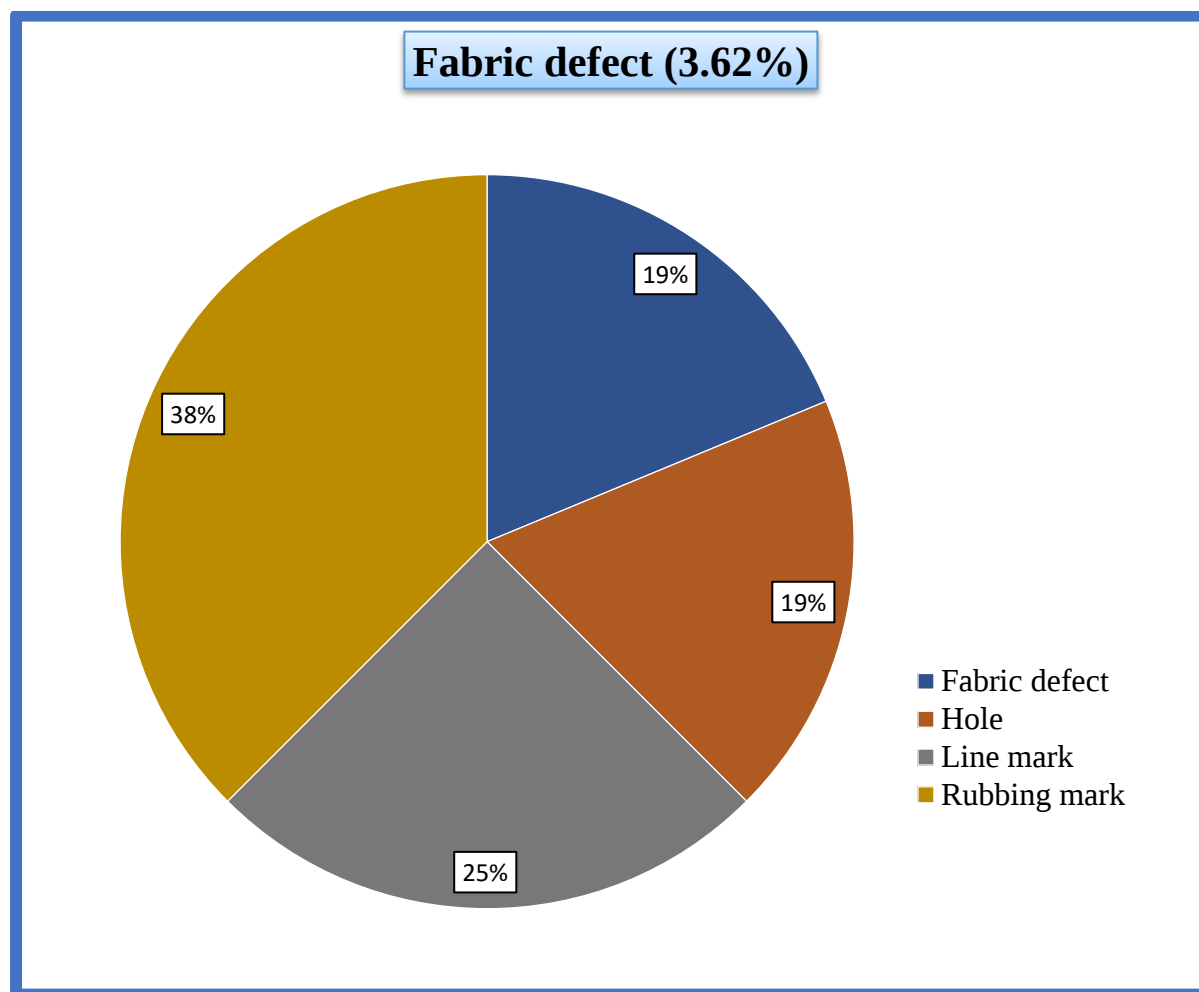
4.1 All Section Defect Result in 100%

Pie Chart 4.5: All Section Defect Result



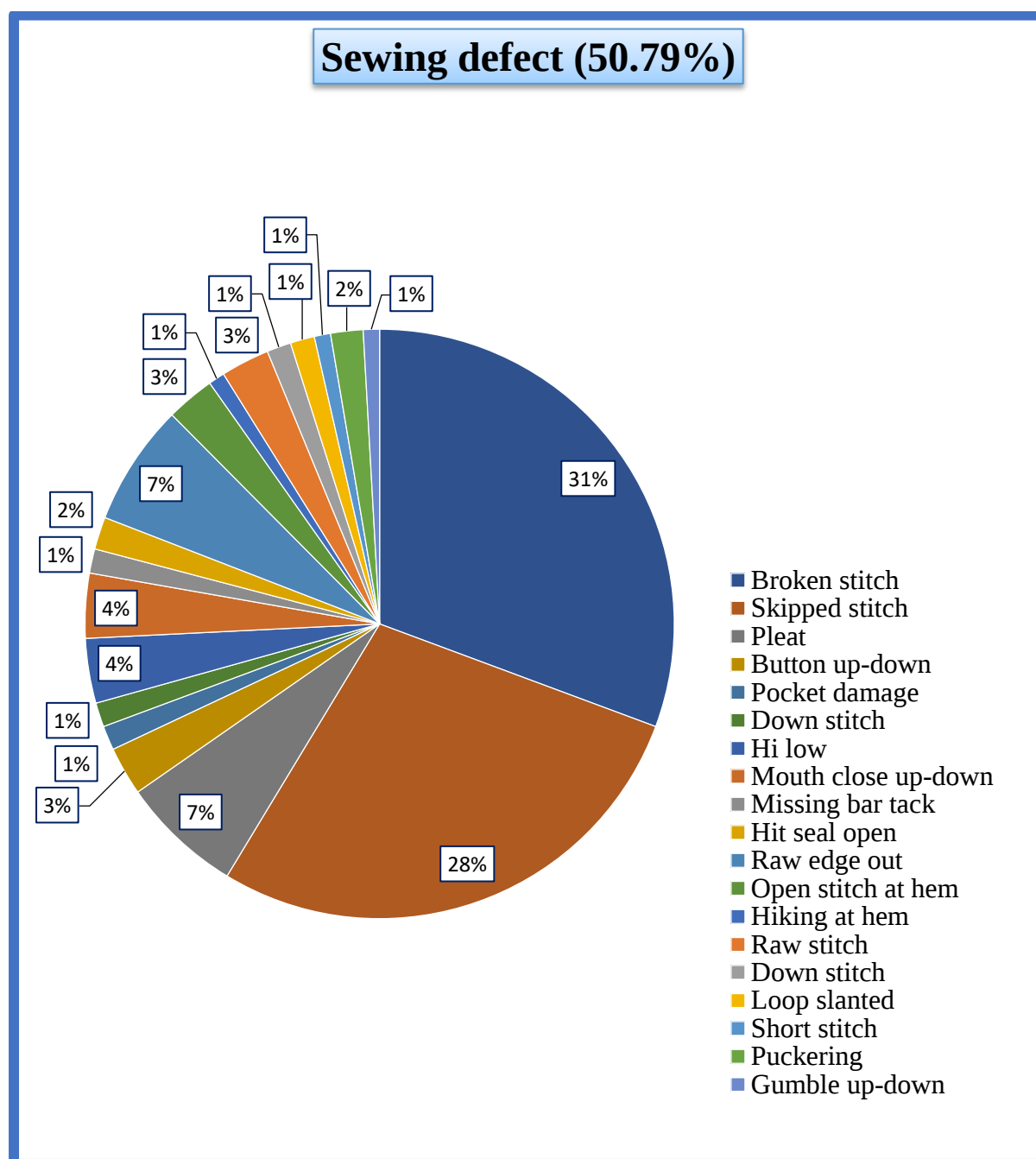
4.2 Fabric Section Defect (3.62%) Result

Pie Chart 4.1: Fabric Section Defect Result



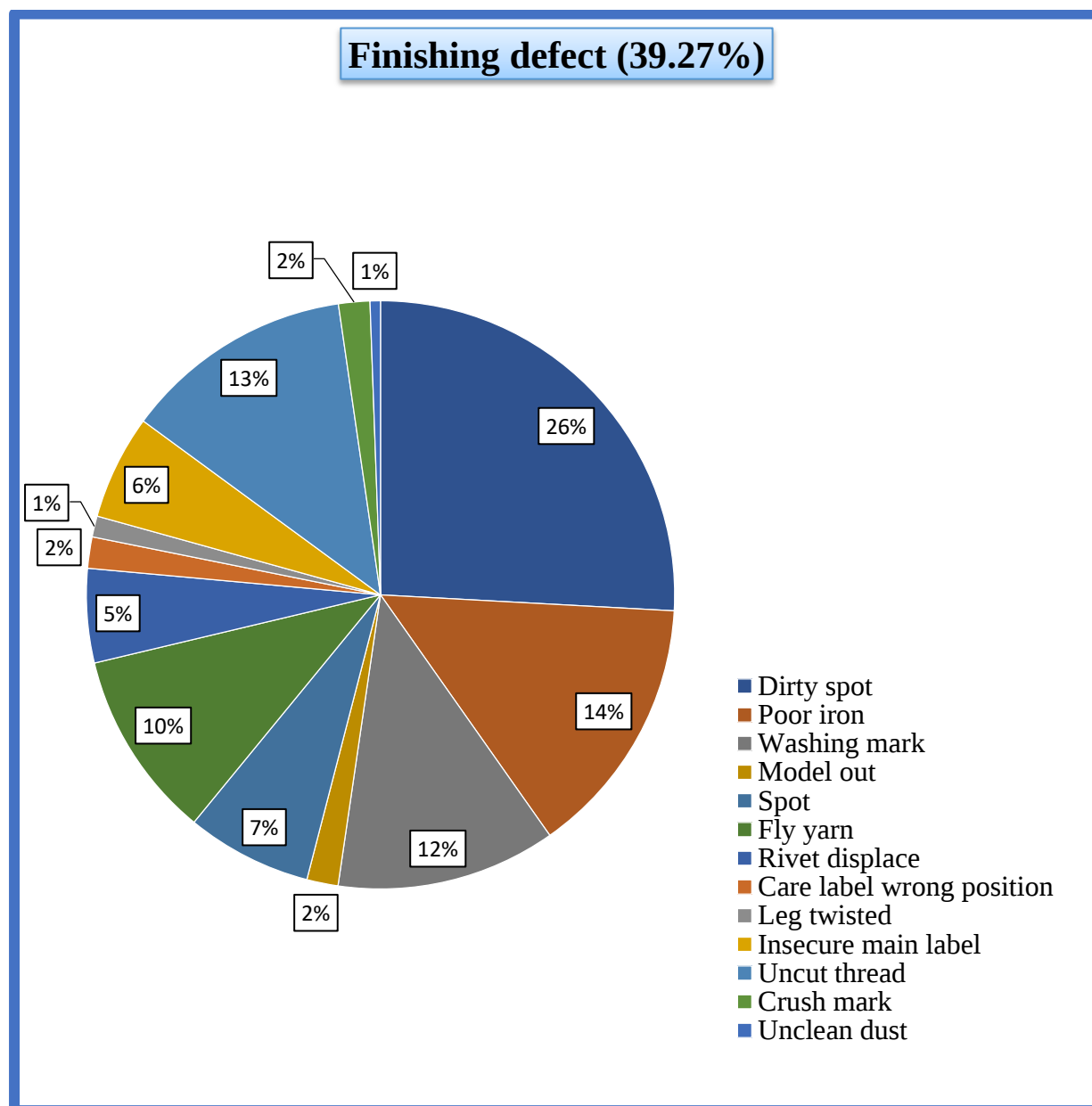
4.3 Sewing Section Defect (50.79%) Result

Pie Chart 4.2: Sewing Section Defect Result



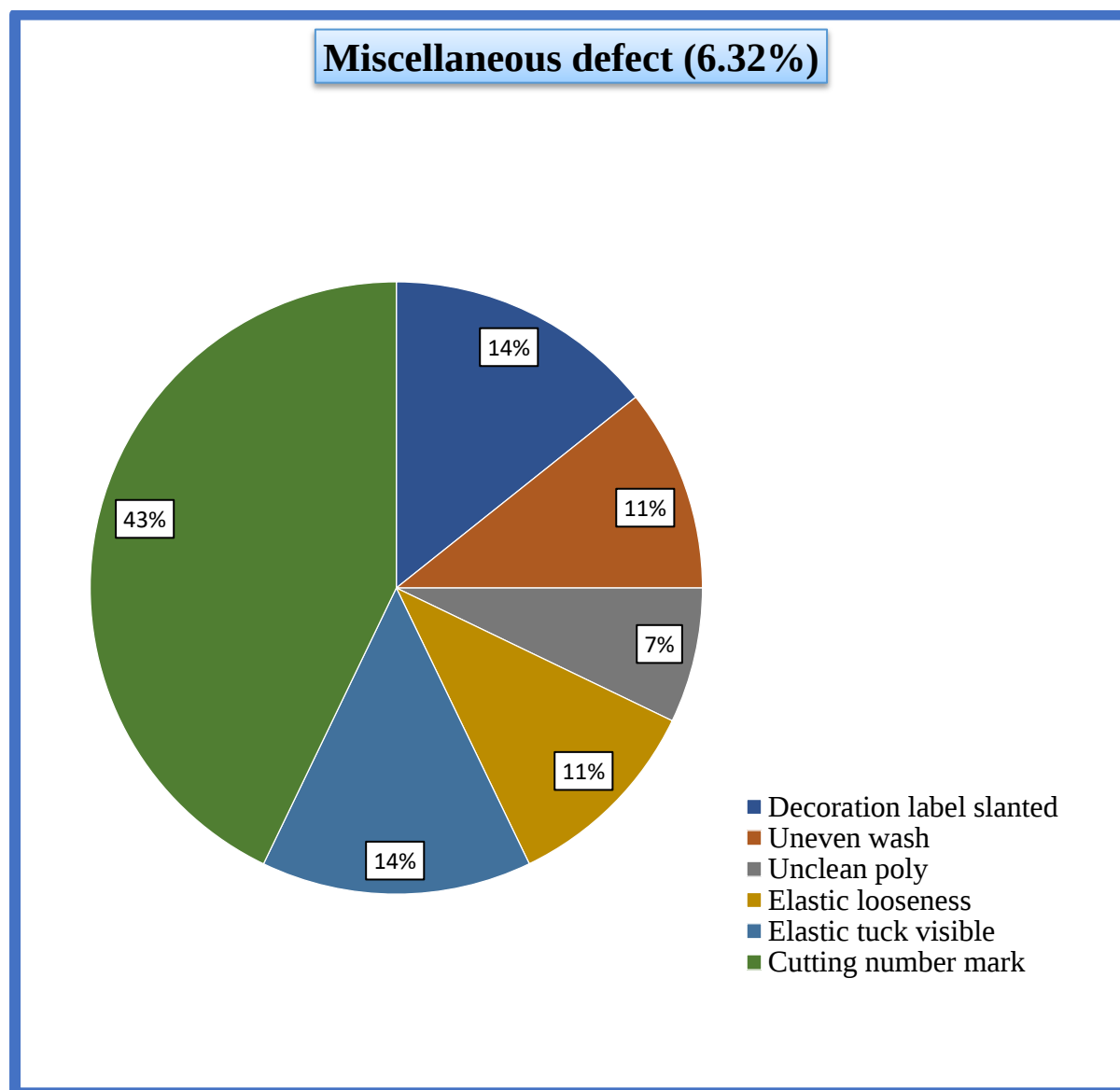
4.4 Finishing Section Defect (39.27%) Result

Pie Chart 4.3: Finishing Section Defect Result



4.5 Miscellaneous Section Defect (6.32%) Result

Pie Chart 4.4: Miscellaneous Section Defect Result



4.6 One Major Fabric Defect

1. Rubbing mark (37.5%)

4.6.1 Rubbing mark (37.5%)

An undesired noticeable marking or abrasion on the fabric surface caused on by friction or rubbing against another object during production, handling, or shipping is known to as a Rubbing Mark.

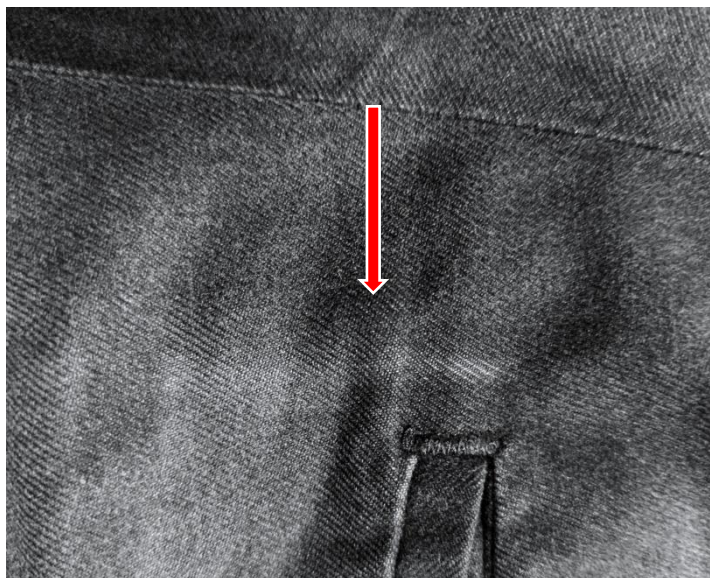


Figure 4.1: Rubbing Mark

Causes -

- Fabric poor packaging
- Handling during production
- Abrasive surfaces
- Inadequate lubrication in machinery
- Improper storage
- Transportation practices

Remedies -

- Better packaging
- Cautious handling in the production process
- Preventing abrasion on surfaces
- Conducting routine maintenance on machinery
- Appropriate storage circumstances
- Ensuring dye fastness quality

4.7 Three Major Sewing Defect

1. Broken stitch (30.66%)
2. Skipped stitch (28%)
3. Raw edge out (6.67%)

4.7.1 Broken stitch (30.66%)

A broken stitch is a sewing fault that shows as an interrupted or incomplete line of stitches when the thread continuity in a stitched seam or pattern is broken.



Figure 4.2: Broken Stitch

Causes -

- Incorrect tension on the thread
- The wrong stitch length
- Pulling or stretching of the fabric
- Mismatch between the needle and the thread
- Bobbin tension issues

Remedies -

- Modify the thread tension
- Regularly polish or replace needles
- Use appropriate pressure foot
- Adjusting the stitch length
- Assurance of thread quality

4.7.2 Skipped stitch (28%)

A skip stitch issue occurs when the sewing machine is unable to perform a complete stitch at regular intervals, leaving gaps or empty areas in the fabric that has been stitched.



Figure 4.3: Skipped Stitch

Causes -

- Incorrect sewing technique
- Issues regarding Bobbin and Bobbin case
- Length and speed of stitches
- A dull, broken or the wrong size needle
- Incorrect types of thread

Remedies -

- Always make use of the appropriate needle size.
- Choose the suitable thread.
- Lubricate all rotating parts of the machine.
- Re-sew the gap
- Replace needles regularly

4.7.3 Raw edge out (6.67%)

A raw edge out fault in sewing happens whenever a fabric's raw or unfinished edge shows through or extends over the intended stitching line or seam.



Figure 4.4: Raw edge out

Causes -

- Improper cutting of the pattern
- Design flaws
- Incorrect seam allowance
- Inadequate notching or clipping
- Misalignment during stitching

Remedies -

- Design review
- Accurate patterns and cutting
- Check and modify seam allowances
- Make sure everything is aligned correctly.
- Carefully select fabrics that are prone to fraying.

4.8 Three Major Finishing Defect

1. Dirty spot (25.86%)
2. Poor iron (14.37)%
3. Uncut thread (12.64%)

4.8.1 Dirty spot (25.86%)

Dirty spot fault in garments indicates any noticeable stains, marks, or discolorations on the surface of the fabric.

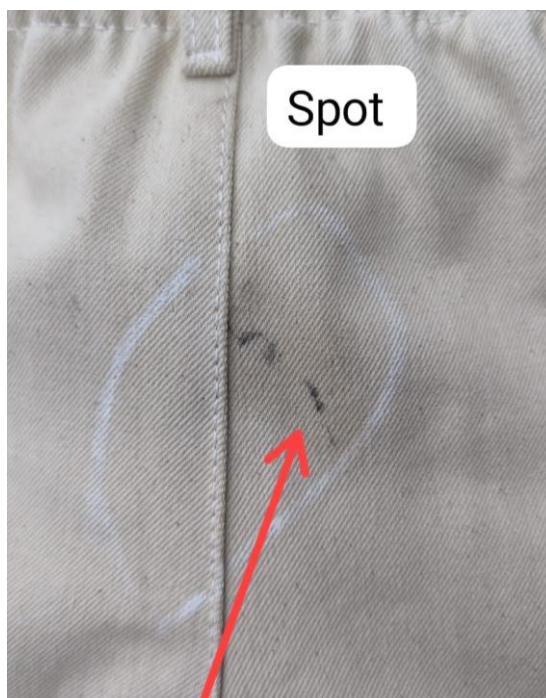


Figure 4.5: Dirty Spot

Causes -

- Unintentional stains or spills
- Improper dyeing or washing
- Stains from ink or markers
- Inadequate cleaning procedures
- Human handling during retail

Remedies -

- Verify and swap out the ink and markers.
- Educate workers about good hygiene
- Washing according to care instructions
- Implement quality control checks
- Ensure color fastness

4.8.2 Poor iron (14.37%)

When textiles or clothing are not properly ironed or pressed, it results in noticeable flaws in the fabric's appearance, which is known as a poor iron.



Figure 4.6: Poor Iron

Causes -

- Inaccurate temperature setting
- Low-quality ironing equipment
- Unsuitable surface for ironing
- Not enough moisture or steam
- Inadequate drying before pressing

Remedies -

- Always check the care label
- Start with low heat
- Make sure there is enough moisture or steam
- Keep the iron and the ironing surface clean.
- Adjust the ironing machine's parameters.

4.8.3 Uncut thread (12.64%)

When excess, loose threads remain after stitching and are not properly trimmed, it is referred to as an uncut thread fault in garments.

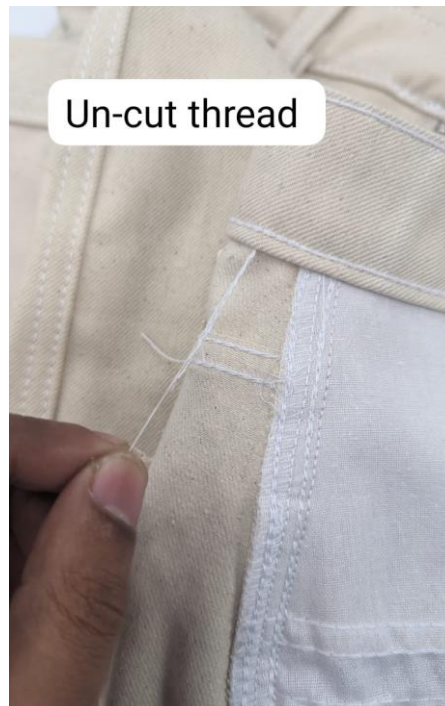


Figure 4.7: Uncut Thread

Causes -

- Rushing during production
- Complex construction
- Improper method of trimming
- Faulty wiper blade
- Excessive sewing speed

Remedies -

- Training and awareness
- Manual inspection and trimming
- Upgrade or repair trimming mechanisms
- Adjust sewing speed
- Address stitch formation issues

4.9 One Major Miscellaneous Defect

1. Cutting number mark (42.86%)

4.9.1 Cutting number mark (42.86%)

When the cutting identification numbers marked on the fabric pieces are visible on the completed garments, a problem known as a cutting number mark defect

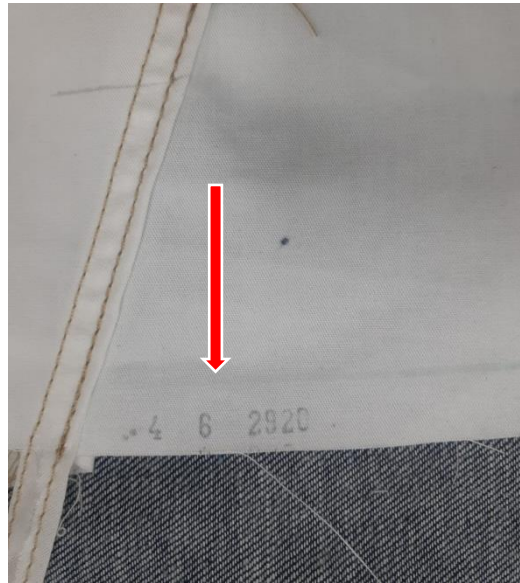


Figure 4.8: Cutting Number Mark

Causes -

- Incorrect choice of ink
- Wrong marking placement
- Not enough quality control checks
- Improper washing procedure
- Improper ironing or pressing

Remedies -

- Quality control checks
- Thorough washing procedures
- Utilize marking removal tools
- Choose concealable marking materials
- Effective pressing techniques

4.10 Discussions

Our summary table shows the percentage calculation for each section with every defect. Pie charts show the weight of each defect in a particular section.

The least fault found in this project was in the fabric section (3.62%). Rubbing mark defects are the most common among them.

If we talk about the section with the highest defect, then it is the sewing section. It has 50.79%. A total of 19 defects were found, which are categorized by sewing defect. During them, broken stitches, skipped stitches, pleats, and raw edges were the most common defects. What we have seen is that there are always have more sewing defects in an industry. There are many reasons for this, such as incorrect sewing technique, improper cutting of patterns, mismatch between the needle and the thread, etc.

The second-highest defect section is the finishing section (39.27%). Approximately 13 types of faults are found here. Most of the washing faults are seen here, and the faults that occur in the case of attaching tags and trimmings at the finishing line are also seen.

The second-least-numbered section is the miscellaneous section (6.32%). Six types of defects are found here. The causes of defects in this section are related to each section of an industry. Most of the minor defects are seen here.



CHAPTER 5: CONCLUSION



5.1 Conclusions

We achieved the goal of identifying common faults and their hidden causes through the analysis of final inspection reports taken from the denim industry, named Ultimate Fashions Limited. Denim's casual charm is what makes it so attractive, but poor manufacturing, dyeing, or finishing can ruin a brand's reputation and dissatisfy consumers.

Following analysis, from four separate sections, we were able to identify a total of 42 faults. We can now explain the reasons behind these faults. At this point, we have some understanding of how to minimize the chances that these mistakes are going to happen. Based on the findings from our study, we discover that the sewing and finishing section has the highest percentage of faults. 50.79% of the sewing section, and 39.27% of the finishing section. But the least fault was found in the fabric section (3.62%) and the miscellaneous section (6.32%).

From our project work, we can say that all the processing steps, from fabric receiving and cutting to finishing, are responsible for different kinds of fabric defects. We identified eight major faults in over four different garment sections. The following are the percentages of each: rubbing mark (37.5%), broken stitch (30.66%), skipped stitch (28%), raw edge out (6.67), dirty spot (25.86), poor iron (14.37%), uncut thread (12.64%), and cutting number mark (42.86%).

To make sure all the parts are operating properly, all industrial machinery must go through regular checkups. More appropriate instruction and training needs to be required for all industry workers.

In conclusion, we can say that this project will be highly beneficial to our careers.

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