



Faculty of Engineering

Department of Textile Engineering

**‘Investigation on the final inspection report to find out
the root causes of defects and their remedies’**

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LETTER OF APPROVAL

To

The Head

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Subject: Approval of project report of B.Sc. in TE Program

Dear sir,

I would be grateful if you could accept this project report and consider it for final evaluation. I'm just writing to let you know that the project report titled "Investigation on the final inspection report to find out the root causes of defects and their remedies" has been completed for final evaluation by the students "Md. Kausar Hossain bearing ID 201-23-777, Md. Yousuf Ali bearing ID 201-23-939." The entire report is made on the basis of appropriate investigation and interruption by critical examination empirical data with necessary belongings. The students were actively involved in their project activities and the creation of the report. It is critical to generate a lot of useful material for the readers. Therefore it will

Yours sincerely



Anik Kumar Das

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DECLARATION

We therefore declare that we completed this project with the assistance of Mr. Anik Kumar Das, Lecturer, Department of Textile Engineering, Daffodil International University. We further declare that neither this project nor any part of it has been presented elsewhere to the best of our knowledge.



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ABSTRACT

Our thesis topic is “Investigation on the final inspection report to find out the root causes of defects and their remedies” ‘The final stage of the garment inspection process is the final inspection before shipping. Final inspection is the process that occurs after the pre-final or lot pass inspection is finished and is often coordinated by the final inspector prior to shipment. The term "pre-shipment inspection" is also used. Knowing the entire process of making clothes is necessary for high-quality production. Quality in the clothing industry refers to garments that are free of stains, fabric flaws, sewing errors, button or buttonhole flaws, size or measurement errors, washing shrinkage, and handle flaws. A good or service's degree of acceptability can be used to determine its quality.. AQL (Acceptable Quality Level) and management systems are used for garment inspection in various textile manufacturers. We have accumulated a great deal of experience with this project. Our understanding of inspection procedures, issues, and methods for minimizing those issues has grown. We noticed a variety of defects in the apparel, for which the clothing passed and failed the inspection prior to shipment. We discover numerous methods to reduce flaws during bulk production and provide solutions for various sorts of defects. All faults are divided into four categories: fabric defects, sewing defects, finishing defects, and miscellaneous problems. According to the findings, there are 70% stitching defects, 12.06% finishing defects, 11.85% fabric defects, and 6.11% miscellaneous defects. After analysis, we find that the majority of sewing defects are caused by various garment failures during the final inspection. Fabric, Finishing, and Miscellaneous defect also responsible for some failures of garments. Finally, several recommendations are provided to improve the garment's quality.

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CHAPTER – 1

INTRODUCTION

1. Introduction

1.1 Background of the study: The textile industry produces ready-made clothing in large quantities. People were able to easily obtain the clothing they desired. People choose their clothes from a variety of fabric types with exquisite designs. Finding the ideal raw material is the first step in the creation of ready-to-wear clothing. There are various phases involved in the creation of a garment, from the acquisition of raw materials to shipping. The final shaping of the desired product occurs in the sewing section. The clothing undergoes some crucial scrutiny both during and after sewing. The final garments inspection section is one of the most crucial parts in the apparel industry. A significant problem for production and quality is garment defects. All varieties of faults are inspected by the garment inspection section. Both before and after sewing, printing, dying, and finishing, this portion will be examined. Therefore, we may find a wide range of defects and their fixes in the area dedicated to garment inspection.

1.2 The study's objective:

- i. To understand how the final garment inspection is conducted.
- ii. To be familiar with the 4-point inspection process.
- iii. To understand quality
- iv. To know about AQL.
- v. To know about garment defects and defect types.
- vi. To know the way of minimizing garment defects.

CHAPTER 02

LITERATURE REVIEW

2. Literature Review:

The thesis focuses on investigating the final inspection report of garments to identify root causes of defects and propose remedies. The final inspection stage, occurring before shipping, is crucial for ensuring product quality. Quality in the garment industry encompasses various aspects such as fabric flaws, sewing errors, and sizing inconsistencies. Acceptable Quality Level (AQL) and management systems are utilized for inspection in textile manufacturing. Through extensive experience, the researchers have identified common defects in apparel and categorized them into fabric, sewing, finishing, and miscellaneous issues. Analysis reveals that stitching defects constitute the majority, followed by finishing, fabric, and miscellaneous defects. Sewing defects are found to be the primary cause of garment failures during final inspection, with fabric, finishing, and miscellaneous issues also contributing. The thesis provides recommendations to mitigate these defects and enhance garment quality during bulk production. (Thesis Book 1)

Sharifuzzaman and Islam (2018) examined and also observe two knit garment industries few days for stitching faults, which are frequently occurring throughout production procedure process by employee. In our study we located some mistakes like damaged stitch 8.91%, skip stitch 16.80%, open joint 15.78% and other sewing faults at suprov composite weaved ltd. and also in a similar way when we observed at amantex ltd. we found damaged stitch 4.81%, sign up with stitch 4.39%, uncut thread 20.33%, up-down 17.31%, dust cloth side 7.28% as well as others. Lastly we discovered complete 6.38% garments are defective sources of stitching trouble for a solitary calculation for two sectors (Sharifuzzaman and Islam 2018).

Uddin and Rahman (2014) discovered that the use of DMAIC technique of six sigma minimized the defects rate in a picked garment manufacturing facility. This is a methodical method in the direction of deformities minimization through five stages of DMAIC methodology called define, measure, examine, boost as well as control. Different six sigma

tools were made use of in various phases. Pareto evaluation was done to recognize the significant types of defects. Origin of those defects were identified by cause and effect analysis. Lastly some possible remedies are recommended to overcome those causes. The outcome discovered after implementation of the options is extremely considerable. The fault percentage has been reduced from 12.61 to 7.7 and as a result the Sigma level has actually been boosted from 2.64 to 2.9255 (Uddin and Rahman 2014). Weseley and Poojitha (2010) aimed to simplify the skip stitch detection arrangement so that it could be utilized in the sector as an additional attachment in existing machines and provide operator-friendly job processes at a reduced price.

CHAPTER 03

METHODOLOGY

3. Methodology

3.1 Final Garment Inspection: The last stage of the garment inspection process is the final inspection. At this point, the buyer examines the finished garment. The primary fabric, trims, accessories, label, fabric issues, and other areas of the garment are all assessed at this point. There are numerous methods for final inspection in the apparel industry. Before an export order is shipped, a final inspection is essential.

Although there isn't a facility to perform total inspection before this, most garment inspections are completed during final inspections. The buying side is more concerned about this. In the final inspection, a garment's size, form fitting, and other flaws are mostly examined. The most crucial factor is the size of the item according to the label. The garment will be worthless or returned to the buyer if it is not made in the correct size and according to the specifications. Everybody has a standard body measurement, ladies and gentlemen alike. It is necessary to allow for the clothes' tolerance when they are manufactured in relation to this measurement. It is examined for clothing manufacturing in accordance with the permissible tolerance chart.

3.2 Final Inspection of Garments Quality:

Before submitting the lot to the manufacturer's QA Auditor, the supplier must conduct an internal quality inspection. Use the AQL sample plan table and the following steps to confirm product quality.-

- Determine the number of units in the shipment.
- Determine the number of units to be inspected using the AQL table.
- At random, choose a sample quantity from each size and color.
- Examine the sample lot quantity for all quality performance standards (for example, packing standards, function and testing standards, and visual standards).

3.3 Quality: To be of quality, a customer's needs must be met. Quality of goods is a critical factor for consumers and customers, specially for the last a few years its importance is increasing day by day. This is true that there is relation between the quality of goods and the profit of a business.

Generally, quality means a reasonable standard, which is accepted by customers. In garments industry, quality means "there will have no stains in garments, fabric faults, sewing defects, any defects of buttons or button holes, will have no faults of sizes or of measurements, and after washing colors will not fade or no shrinkage will happen, and during use it will not be easily torn or damaged." Achieve the highest level of conformance manufacturing items to customer requirements as described by the buyer its means quality.

The quality standard of fibre and yarn is used to gauge item quality in the clothing and material industries. Development of the textures, shading speed, structure, and the final item of apparel. Customers today are especially quality-conscious. The customers will be encouraged and better-quality products can be produced if it is possible to maintain a strong inspection approach. The idea of eligibility for usage might be related to a piece of clothing. A piece of clothing must have a suitable style for it to be appropriate for use.

1. Defects like stains, material flaws, open seams, loose hanging threads, incorrectly positioned buttons and buttonholes, broken zippers, etc. must not be present.
2. The item must suit the designated size adequately.
3. It must operate satisfactorily under usual use, which entails that a garment must be able to survive typical laundering, dry cleaning, pressing, and other processes without losing colour or shrinking, coming apart at the seams, tearing, or other problems.

However, maintaining a high level of excellence requires attempt. Through the preliminary research to determine genuine needs of the prospective client for a newly released item, to the design, details, and controlled production processes.

3.3.1 Objectives:

Ensuring that items are produced to the standards required by purchasers or customers is the basic objective of quality control.

- To increase product output while maintaining the required tolerances accurately the first time.
- To develop a fabric or garment design that is satisfactory in terms of the level of design, style, and color options, as well as the marketability of the product and the compatibility of its components.

3.3.2 The essential elements for producing high-quality clothing:

1. Quality Systems: Implementing quality systems helps to ensure that products are of the highest possible quality from the start. Maintaining quality standards during each step of the manufacturing process is necessary to deliver a high-quality product at the end. Checkpoints (checkers) can be placed throughout the process to assure the desired quality at the conclusion. Additionally, make sure that no department should transfer substandard products to the next procedure.

2. Raw material quality: One of the most important criteria for ensuring proper quality is the level of raw materials that will be utilized to make clothing. You can create high-quality clothing from a defective fabric lot, for example. The standard of the raw materials (fabric, trimmings, and accessories) must be met. Each entering raw material must, if necessary, be checked by trained checkers.

3. Human factor: People manage quality systems. And all tools, machinery, and labor are operated by people. A factory cannot manufacture high-quality clothing if the officers are unable to follow quality systems and the personnel are unable to operate equipment or carry out their assigned tasks. Operators and helpers need to be trained for their jobs, and managers need to be sufficiently certified.

4. Delay in Corrective Action: Garment manufacturing procedures have not yet been made error-free. As a result, there is a possibility of error wherever in the process flow. It is recommended that faults (defective components) or defective garments be discovered at an

early stage to lessen the severity of the quality issue. Delay in taking corrective action exacerbates the problem and may extend it.

5. Communication Gap: A complicated supply chain is in place to carry out the entire procedure. From order receipt until shipping dispatch. A lot of contact was place between departments and external parties such as suppliers and customers. Incorrect or insufficient information may aggravate the procedure. Especially when it comes to just following the buyer's instruction or request.

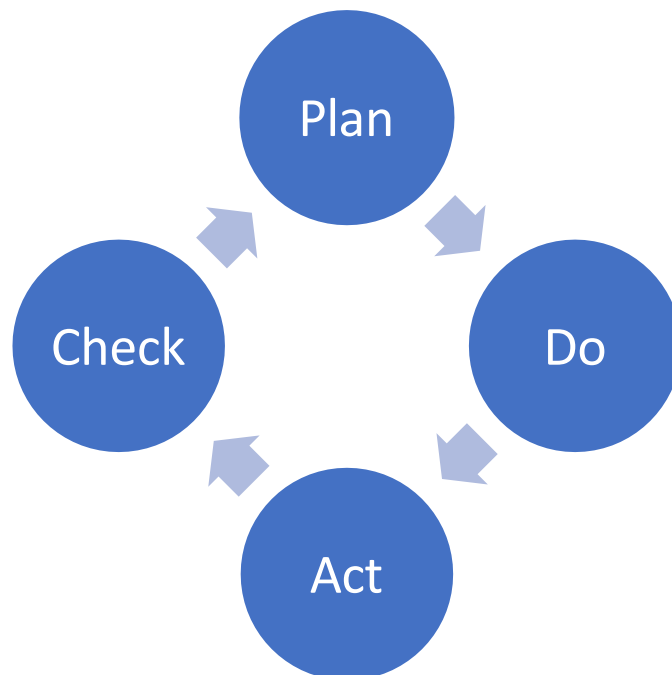
6. Material Handling: This component is also highly effective. Producing excellent clothing would be difficult if materials and garments were not managed correctly.

7. Housekeeping: Factory cleanliness and housekeeping improve product quality. This is comparable to material handling.

So you now understand what needs to be done to produce a high-quality product.

3.3.3 Requirements:

The requirements of the quality framework rely on PDCA cycles. Recognizing what customers anticipate in terms of quality.



- Setting up and instructing the department of quality control.
- Making sure the QC department receives quality demands in an efficient manner.
- Ensuring that the Production Department receives the proper flow of quality requirements.
- Developing sample methods, inspection systems, frequency, quality plans, parameters, and so on...
- Measurement, testing, and inspection in compliance with the plan.
- Monitor any deviations.
- Offer the production department input.
- Plan for upcoming improvements.

3.3.4 Determining the Standards of Quality:

Understanding, defining, and accepting the clients' quality requirements is the first step in the quality control process. The following steps are required.

1. Obtaining consumers' quality requirements
2. Referring to our prior performance
3. Speaking with the Quality Control Department
4. Speaking with the Production Department
5. Giving customers feedback
6. Getting the clients' updated quality needs
7. Accepting the standard of excellence

3.4 AQL (Acceptable Quality Level)

3.4.1 AQL: One of the most often used words when discussing clothes export quality is AQL. Since AQL-based sample plans form the foundation for the majority of acceptance decisions for garment shipments intended for the export market. Acceptable Quality Level is referred to as AQL. As is customary in commercial processes, the buyer inspects the goods prior to accepting the final goods from the manufacturer. This is especially important for the export clothes business because consumers in other countries are quite picky about the quality of their products. To the manufacturer, they provide an AQL level for the product. Buyers perform inspections of goods through a random sampling process. If the AQL criteria are met, it means the goods are at an acceptable quality level, and the buyer provides a certificate to allow the shipment of product. The level of AQL differs from procedure to procedure, item to item, and in fact customer to customer. This is an example of an inspection plan for the last shipment. The maximum number of defective products that could be considered acceptable following random sampling and inspection is known as the Acceptance Quality Level (AQL).

3.4.2 Classifying Defects :

Three categories comprise the flaws that were discovered during the inspection.:

- **Critical Defects:** (Must be precise to the letter. No suitable range exists.)are those that break necessary regulations or make the product dangerous or harmful for the final user.
 - Example: Presence of insects, broken needle in the garment, etc.
- **Major Defects:** (Must be precise to the letter. No suitable range exists.)are those that break necessary regulations or make the product dangerous or harmful for the final user.
- **Minor Defects:** (Normally up to 4% defects are allowed.) do not have an impact on a product's use or marketability, but they do indicate workmanship flaws that cause the product to fall short of established quality standards. For instance, a slight stain, small-scale puckering, etc.

3.4.3 How AQL Operates: By evaluating a sample of goods from a batch, the AQL system operates. The quantity of products to be inspected is determined on the AQL level, and the sample is chosen at random. The AQL approach is choosing a random sample of clothing from a batch and examining it for flaws or defects. The AQL level, which is agreed upon by the maker and the buyer, determines the quantity of clothes inspected and the allowed number of flaws.

3.4.4 Sampling Plan:

1. Single Sampling Plan - Normal Inspection:

Assure an AQL of 2.5%, a lot size of 1200 garments, and an 80-piece sample size. If there are 5 defective clothes identified, the whole lot is considered "Acceptable." If there are 6, the whole lot is considered "Reject/Re-Check."

2. Double Sampling Plan - Normal Inspection and Multiple Sampling Plan:

A lot size of 1200 items with an AQL of 4.0% and an 80-piece sample size are guaranteed. If there are 7 defective garments detected, the entire lot is "Acceptable" But if eight faulty items are discovered, the entire lot is marked as "Reject/Re-Check."

Similar strategies are used in multiple-sampling plans, which use up to 7 samples total. The sample sizes are relatively small, which is this method's main benefit.

3.4.4 Benefits of Using AQL:

1. Consistency: The AQL system makes sure that the apparel goods' quality complies with the goals. The brand's reputation and client happiness are maintained as a result.
2. Cost-effective: The AQL system assists in locating and rejecting defective items before they are delivered to customers, lowering the cost of rework, refunds, and potential liabilities.
3. Objective evaluation: The AQL system offers an objective evaluation of the products' quality, lowering the likelihood of prejudice or subjective evaluation.
4. Standardization: The AQL system offers a standardized approach to quality control that all stakeholders can understand and discuss.

5. Early identification: The AQL system assists in identifying and resolving quality problems as they arise early in the manufacturing cycle, lowering the likelihood of production delays or pricey product recalls.
6. Quality enhancement: By tracking and studying AQL data, the garment sector can find the underlying reasons of quality problems and take appropriate remedial action to raise the general caliber of the items.
7. Risk reduction: The AQL system assists in reducing the risk of legal actions relating to product quality, harm to one's reputation, and monetary losses as a result of subpar goods.

3.4.5 AQL Chart:

Acceptable Quality Limit Chart							
AQL Limit		AQL 1.5		AQL 2.5		AQL 4.0	
Lot Size	Sample Quantity	Major	Minor	Major	Minor	Major	Minor
51-90	13	0	1	1	2	1	2
91-150	20	1	2	1	2	2	3
151-280	32	1	2	2	3	3	5
281-500	50	2	3	3	5	5	7
501-1200	80	3	5	5	7	7	10
1201-3200	125	5	7	7	10	10	14
3201-10000	200	7	10	10	14	14	21
10001-35000	315	10	24	14	21	21	21
35001-150000	500	14	21	21	21	21	21

3.4.6 Requirements for AQL based on Products:

In most cases, the buyer gets to pick the AQL and sample strategy. The three different kinds of sample schemes are single, double, and multiple sampling plans. Three execution levels (regular, tightened, and lowered) are available for each sample plan, depending on the products' quality and the needs for the inspection. Single sampling strategies are typically used by the garment sector to make acceptance judgments. Still, some buyers also use the two-sample approach. A random sample of a preset number of clothes is chosen for a single sample from a vast number of garments based on the AQL table. The sample plan also specifies the maximum number of defective components that are allowed. If the number of defective pieces is less than the acceptable quantity, the lot is approved; if the number of defective pieces exceeds the allowed quantity, the lot is refused. It may be argued that results from the acceptance sample should be completely reliable because it is grounded on science. In simple terms, all lots with fault levels higher than the acceptable quality level (AQL) must be rejected, and all lots with defect levels lower than the AQL must be accepted. This isn't possible, though, because the acceptance choice is based only

on a small sample drawn from the entire lot, and there's a chance the judgment won't be correct.

3. 4.7 Quality Control

Excellence is crucial in every facet of the corporate world. Consumers expect and should receive value for their money. As clothing producers, we have an ongoing obligation to deliver excellent work.

The systems needed to plan and coordinate the activities of different groups inside an organization in order to preserve the necessary level of quality. Consequently, quality control is thought of as an embodiment of overall quality control or quality assurance.

In the apparel business, quality control is implemented at every stage, from acquiring raw materials to producing the final product. In the textile and apparel sectors, the standards and quality of the fibers, yarns, fabric composition, colorfastness, surface designs, and completed garments define the product quality. On the other hand, quality requirements for export are linked to retail locations and client segmentation.

One of the most crucial elements of any job's content is quality control and standards, making them a key component of training.

3.4.8 Principles of Quality Control

The fulfillment of the ensuing requirements is necessary to deliver a reliable product.:

- A designed effectively product that has undergone sufficient development testing to show that it is reliable under the circumstances in which it will be used. This is the ultimate product's crucial feature.
- A detailed description of the requirements for this quality, which must be understood by all parties involved in the manufacture of the finished product's constituent elements.
- Verification that the manufacturing procedures can meet these specifications.
- Complete acceptance of the responsibility for upholding the specifications' requirements by all parties involved in manufacturing.

- Monitors the product throughout the manufacturing process to look for any deviations from the specifications.
- Keep detailed records of the pertinent information gleaned from these checks to serve as actionable proof.
- The establishment of communication channels, such as feedback to output, to ensure that the required steps are made to modify people, processes, and materials in order to retain future output within the specification .
- Information on the product's uses, applications, and restrictions.
- An user experience analysis, departmental input, and swift remedial action.

3.4.9 Objectives:

To increase output of products while maintaining the required standards. a fabric's or garment's design must be satisfying in terms of the level of design, style, and color options, as well as the marketability of the product and the compatibility of its components. Only then can satisfactory quality be guaranteed:

- Recognizing needs of the buyer.
- Planning to accommodate buyer.
- Perfect development.
- Performance & safety certifications.
- Clearly written instructions
- Appropriate packing

3.4.10 Maintaining quality

From the perspective of the client, satisfaction quality can be guaranteed by offering:

1. The appropriate product.
2. Good quality.
3. The appropriate moment.
4. Undamaged state.

In order to guarantee the caliber of a garment, we must pay attention to some particular sectors: 1. Fabric without problems.

2. The clothing's color coordination.
3. Creating the pattern based on the needs of the buyer.
4. The garment should fit perfectly in all of its various parts.
5. Excellent stitching; the seams should form perfectly.
6. Extra accessories like the level, tag, zipper, and button are positioned correctly.
7. Container and wrapping.

3.4.11 Approach:

1. To provide a thorough specification, list all the variables that are present throughout the creation of fabrics and clothing.
2. To ensure that all members of the design and production teams are aware of the requirements, create a specification that is divided into multiple sections or pieces.
3. Specify appropriate working tolerances for each and every value on the specification.
4. Install systems for recording fault rates.
5. Gain more technical understanding of the product, such as
6. The geometry of the fabric and the interactions between yarn count, loop length, pick count, relaxation, and fabric qualities.
7. Issues with sewing.
8. The root causes and ways to avoid seam breakdown.

3.4.12 Quality control function:

1. Test Properties of Yarn

- Get an average delivery in terms of tex (count, denier) if routine yarn checks are performed.
- If the yarn is arriving uninspected, verify tex of the supply meant for sample, & used it only if it is within permitted limitations.

- Perform others pertinent yarn test, such the Crimp Nylon-Crimp Rigidity test. To make sure the dye is resistant to various factors including light, washing, and perspiration, knit a small sample.
- Take notes on details like yarn kind, source, tex (denier, count), and so on, then forward them to the knitting room.

2. Knitting Specification

- Make a note of all the details, including chain layout, stitch length, and any instrument measurements, that are required to create the fabric or garment blanks.
- Take notes on every step of creating the trimmings.
- Make a note of any problems you run into, like stitch patterns that occasionally cause drop stitches. Information should be passed to the makeup area.

3. Making-up Specification

- Keep a record of every aspect of the make-up, such as the kind and quantity of sewing thread used and the sequence in which the sections were seamed. b)
- Record any challenges you had, such as a challenging collar-attaching procedure.

4. Check the Garments' Physical Properties

- As soon as the garment is finished, note its dimensions.
- Determine the proper weight for a fiber with a significant moisture regain.
- Recheck the measurements after washing the clothing.
- Quality Control's communication with the Cost Department
- Provide all information to the cost department once completion.
- It is possible to directly price a sample for the appropriate yarn tex (count, denier). If the count is outside of an acceptable tolerance but above or below the average, adjust the weight and cost of the yarn accordingly.
- Allow for any additional challenges that may arise or a slower-than-usual rate of seconds.

5. Afterward Modification

- Make any changes that the company or the buyers request.
- Note modifications at every turn.

6. Quality control data generated

Each QC point generates data. Simple mechanisms must be used to capture this in order to offer ongoing visual verification. These documents give management the option to take prompt action based on timely input and employee accountability. –

Raw Materials:

- Shading : confirmed in a range of acceptance of the regular arrangement.
- Check delivery weight & report whatever discrepancies.

Yarns Check

- Staple Fibre Yarn Count Tests: Verify that count fluctuation inside cones and between deliveries is within the specified tolerance. If rough, yarn usage is compromised. Look up the running average.
- Continuous Filament Textured Yarn Bulking Tests: Verify filamentation and uniformity
- Condition Checks: Examine any improper conditions
- The wrapping of yarn;
- Yarn levelness (see user levelness).

Knitting Machine Settings

- Leveled and knitting-specific yarn tension.
- K.O. distribution; dial height and depth are set according to specifications.
- Length of loop/course: Run-in leveled and within specification; positive feed verified.
- Release tensions; make sure they're consistent.

Fabric Parameters, Fabric or Garment Blank Checks

- Accurate shade and look; accurate jacquard pattern; lack of barrenness.
- Normal width—the grey cloth here is merely a reference.
- Fabric weights per square meter, or ideally weights per specified rpm, verified to be within specification tolerances.
- The blank weight per dozen must fall within the specified tolerance.
- Examine the fabric for flaws and stains.
- Final loss: a continuous log of losses from scouring, etc.
- The responsibility of knitting

Sewing Checks

- The thread run-in ratio and stitches per centimeter were verified to be within the specified tolerance.
- Balance, evenness, and proper straightness; no stitches are omitted
- Correct security and extensibility (no laddering or cracking).
- No skip stitching is present.
- Machinist accountability.

Final Inspection

- Accurate shade that does not change from one area of the garment to another.
- The cut is accurate; the pockets, collar, and sleeves are all balanced, for example.
- Accurate weight and measurements within specification tolerance.
- Accurate appearance and consistent patterns.
- Accurately finished seams without laddering, cracking, or missing stitches.
- Correctly applied and functional accessories.
- The fabric is free of stains and flaws.
- Accurate labeling.
- Accountability for making-up (unsatisfactory work volume; breakdown by different types of faults).

Recovery Inspection

- Verify that the corrective actions are satisfactory.

- Verify the amount of work that was successfully recovered.
- Refusing to recycle work.

Product Tests

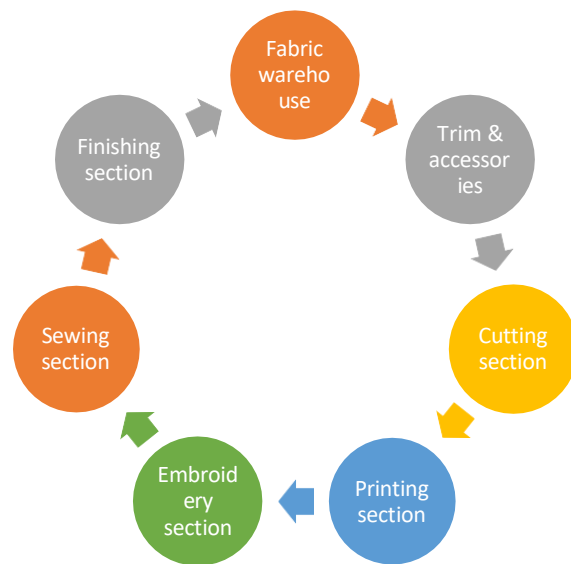
- Color fastness to agreed agencies: cards displaying ratings that are continuously generated and tested against specifications are generated for things like washing, rubbing, perspiration, and lighting.
- Stability: Tolerance within specification for shrinkage and extension recovery when necessary
- Endurance: evaluated for snagging, pilling, and abrasion where necessary. Rating compared to the requirements
- Luminosity

3.4.13 Quality Checkpoints

It should be noted that defective clothing increase inefficiency and cause the company to lose goodwill. What causes flaws to appear in final clothing? The process of making clothes involves numerous machinery and workers. It is inevitable that some defective products may be produced in any consignment during the chain process of garment production due to faulty equipment, inefficient processes, or human error. Though initially it is simple to repair or replace the damaged parts, it can often be expensive and time-consuming to find them in the final stages. A major issue will arise in the final stage if any defective items were allowed to pass through the initial stage without being identified and corrected, and the cost of repair or replacement will be far higher than that of initial identification.

The production process always begins whenever all the materials, such as fabrics and accessories, are received in the warehouse, and it ends when the boxed goods are delivered. Manufacturers typically establish quality checkpoints at the conclusion of each stage to ensure that only high-quality products advance to the next.

3.4.14 Flow of Quality Check Point



The following chart describes department-wise check criteria to assure product quality.

Fabric warehouse	AQL 2.5 calls for random inspection; if random inspection fails, 100% inspection is required.
Trim & accessories	AQL 2.5 calls for random inspection; if random inspection fails, 100% inspection is required.
Cutting Section	Verifying markers Verify the test report and fabric nature. Cutting tests to get QA approval. Spreading of the fabric > Relaxation if needed > Slicing. Bundling Examine the cut panel.
Print and Embroidery	Complete inspection of printing panel Complete inspection of the embroidered panel
Sewing Section	Checkpoint inline (at critical operation) Check at random end of line verification Examining the inspected parts
Finishing Section	first examination upon completion (after wash) Inspection of the final finishing (after pressing) Inspection of internal shipments

3.4.15 Quality Standards:

Quality control is one of the most crucial components of every project, hence the preparatory phase must include quality assurance rules. Through the use of a Quality Standard, we propose the point at which a deformity's severity becomes inappropriate, such as blame. It is comparable to resiliencies associated with measurable variables. Methodical making ready consists of the guidance of a person in: -

1. Fundamental instruction.
2. Adequate methods..
3. Quality measures.

It is impossible to prevent blemished advent without this last element. These standards are established based on the specifications, the purchase test, and other factors. The next level is consistency management, which includes supervising and evaluating each area of output. An item's quality can either be found or it cannot be found. This is where high-quality starts: it needs to be replicated into the item's development utilizing the agent. In this sense, educators are in charge level.

3.5 Garment defects & defects types

3.5.1. Garment defects

A defect occurs when a desired feature is missing from a product, an unpleasant feature is present but is being used incorrectly, or a feature is present but is distorted. Nobody never wants a defective product. Defective products lose value in the market. There are several possible defects in a product. The words "flaw" and "reject" are comparable. The majority of garment industry workers are used to facing rejection. A product is labeled a reject when it ceases to be marketable. Clothes manufacturers suffer when customers reject their products. If there is even one apparent defect in the most noticeable section of the garment, it may be rejected. Quality control is applied to both the finished product and the first stages of acquiring raw materials in the garment business. Within the textile and clothing industries, a product's quality is determined by its fiber composition, yarns, fabric structure, colorfastness, surface patterns, and finished garments. Conversely, the types of consumer segments and retail locations are linked to the export quality standards. A few of the elements that support the quality fitness of the apparel industry are the garment's perceived

quality, dependability, performance, and aesthetic appeal. It is imperative to define quality within a certain economic context.

3.5.2. Classification

Defects are also classified (as per extent of defect) into:

1. Critical defects
2. Major defects
3. Minor defects

1. Critical defects

- The most serious flaws (0%), known as critical defects, prevent a product from being exported.

2. Major defects

- Major defects are severe flaws that, based on the buyer's specifications, cannot be allowed to exceed a specific percentage (3%)

3. Minor defects

- Minor defects are significant flaws that, based on the buyer's specifications, cannot be accepted over a specific percentage (5%)

3.5.3. Apparel defects

primarily 2 kinds of flaws in clothing. They are listed in the follow order:

Non sewing defect

- Defect due to faulty materials, such as fabric, buttons, zippers, and so on.
- Defect due to incorrect design, incorrect marking.
- Defect due to incorrect spreading, incorrect cutting.
- Defect owing to improper ironing or folding;
- Defect due to improper packing, etc.

Sewing defect

- **Skipped stitch:** The primary source of these defects is a lack of loop creation and speed variation in the feed dog.
- **Staggered stitch:** Thin needles are susceptible to this kind of flaw. This flaw also manifests if the needle is moved and the thread count and size do not match.
- **Unbalanced stitch:** This kind of flaw results from uneven thread tension.
- **Variable stitch:** This kind of problem happens when the feed dog is not moving in the proper direction.
- **Open stitch:** Weak sewing thread and a dull needle are the causes of this kind of flaw.
- **Needle mark:** The essential tool for stitching is the needle. This imperfection appears

When incorrect sewing occurs. As a result, a defect may have one sort of cause or both. Anyhow, we can control the rejection of finished items if we can manage the origins of problems. It should receive special attention from the industry's quality control department. The quality of the product should be inspected at each stage of production. When any kind of flaw in the product is discovered, essential actions should be taken to determine the rate of the flaw.

3.5.4. Name of Garments Defect:

1. Missing button
2. snapped snap
3. faulty stitchings
4. faulty snap
5. Various hues inside the same outfit
6. droppe stitche
7. Notche that are exposed
8. rough edge exposed
9. Fabrics flaws
10. Hole

11. Zipper not working
12. Striking / loose sewing threads
13. Button and hole misalignment
14. Button omissions Needle bites/cuts
15. Open seam
16. Pull
17. Stains
18. Unfinish button hole
19. Zipper is too fast
20. Buttons is missing

3.6 Occurring defects in different stages

3.6.1. Defect throughout Garments Inspection

Defects were discovered often during the inspection. The significance of each defect varies and they are not all equal. Some of these flaws are serious, but others are quite minor.

We frequently get perplexed when trying to make a small decision. Please be aware that these categories are flexible and can change depending on the buyer's perspective.

Major defect: Something that so negatively impacts fit, look, performance, or customer pleasure that it justifies a return, a complaint, or non-purpose status for a discerning customer.

A minor flaw is any deviation from the standard that isn't significant enough to be considered a major one.

3.6.2 Major & Minor Defects in Garments

To determine if a garment fault is minor or major, consider the following list as a guide:

1. Seam & Stitch

Major Defect:

1. Stitching Requirement are:

- a. Inside 8 to 10 SPI
- b. Top stitch 8.9 SPI
- c. Others requirements as specify

- 2. granule of seaweed
- 3. Threads snags
- 4. Feeder deterioration
- 5. An excessive number of skips stitche
- 6. Pleats inside the seam (unless otherwise specified by the styles)
- 7. Inadequately mended seam
- 8. Broken stitche, 2 or more if visible.
- 9. Visible needle damaged holes.
- 10. Materials with open seams, raw edge, or fray edges
- 11. Stitch densities that is uneven, staggered stitches
- 12. Many stitche cause cloth bouncing and rupture, while too few cause bright and flimsy seam.
- 13. Incorrect stitches densities
- 14. Remove the run off sewing.
- 15. Omitte sewing, such as top stitching, buttonholes, snaps.
- 16. Severe, irregular seam edges, e.g. bottom of waistband, pocket mouth, etc.
- 17. Double stitching and shoddy repairs wreak havoc on the appearance and service.
- 18. Improperly formed stitch or slack tension of stitches, resulting in surface loops that are readily pulled out.
- 19. Normal stress causes stitch tension to break.
- 20. Incorrect color match thread

21. Fabric that was cut or sewn in the wrong way or intermingled in the garment, resulting in shading.
22. Incorrect seam or stitch type used
23. On the face side, there is visible blind stitching.
24. Reverse the garment components.
25. Extraneous piece caught in seam.
26. Incorrect seam.
27. Disparate checks or stripes
28. Any twisting, loosening, tightening, puckered, pleated, or overlapping seam.
29. Irregular or improper shape of sewing line "run-offs"
30. Improper or uneven width of inlay i.e. seams burst apart, raw edges exhibit slippage of weave threads.

2. Assembly Defect:

Major Defects:

1. The completed components are no longer symmetrical or appropriate in terms of measurement or structure.
2. Finished garments that are not measured.
3. Internal resistance to measurements is eliminated.
4. Parts, portions, ends, or highlights prohibited (e.g., waist band, snap, or catch).
5. Parts or components that are misplaced or misaligned.
6. Inadvertently twisted, overly full, overly tight, cockling interlining.
7. Parts of the garment that are cockling, crumpled, bent, and complete.
8. Textured shading or tinted garment components.

Small Errors: Missing Thread not removed

3. Major Defects in Little Parts.

- The rib knit set is slanted and has walks in the weave or gaps in the grain. Sleeves and collars asymmetrical.
- Incorrectly formed tabs

4. Zippers

Major Defects-

1. Closer than 3/8" from the bottom.
2. Poorly adjusted zipper leading to issues with closure.
3. The zipper twisting resulting from the front zipper's top stitching.
4. A poorly positioned zipper that makes the front wavy

Minor Defects-

1. The zipper front twists as a result of the top stitching..
2. Positioning front (or face) too near to the teeth, which prevents the slider from operating as intended.

5. Button/buttonholes

Major Defects-

1. The button and the button holes are not aligned or placed correctly.
2. Uncut buttonholes, absent buttons, buckles, zippers, snap closures, etc.
3. Not positioned correctly
4. Corrupt or corroded hardware
5. Hardware that is not the right size, color, or shape.
6. A snap off of the bartacks.
7. A missing, misplaced, or improperly lengthened rivet that does not serve its intended purpose.

Minor Defects-

1. The button hole has much too few stitches.
2. A buttonhole that is either too big or too little.
3. There is a loose button stitching.

3.6.3 Different Types of Fabric Defects

1. Barre: A circular stitch. This resulted from the yarn being blended as it was fed into the machine. There will seem to be level stripes in the texture.
2. Broken Color Pattern: Usually caused by yarn that is abnormally tinted on the wrapping.
3. 3. Wrinkle Mark: This is distinct from a wrinkle streak in that it is likely to be present across the entire roll.
4. 4. When the process is complete, the crease check indicates the areas where texture overlap causes creases. Last squeezing probably won't be able to restore texture or unique condition on snoozed texture. Oftentimes, staining is a problem.
5. Crease Streak: Ailments that are cylindrical in seam. results of the coloring process's use of crushed rollers on a wrinkly textureDrop Stitches: Caused by a broken jack or needle. We'll show any holes or weak joins..
6. 6. Finish: Happens in the warp stitch. arises from the sewing computer's intention to support walking with a loose end.
7. Hole: Resulting from a broken needle.
8. Knots: Resulted from combining yarn spools.
9. Missing Yarn: This occurs when stitching in twists. arises from twisting yarn of the incorrect size or fiber. If filaments have different color preferences, texture should be seen as a thick stop or a distinct shading.
10. Mixed End (yarn): This texture is created by using yarn of a different fiber blend on the twist outline.
11. Needle Line: Caused by a bent needle that frames erroneous lines. Usually, there is a line that is vertical.
12. 12. Press-Off: This happens when all or some of a curved sewing machine's needles stop working, which results in the texture either falling off the computer or having

- its arrangement completely disrupted or destroyed. Sewing needles break easily and need to be replaced when terrible press off occurs. Terrible press-offs for the most of the phase start a new texture move.
13. Runner: A broken needle was the cause. It will appear as a vertical line—the sprinter. When a needle breaks, most machines contain a halting device that turns off the computer.
 14. 14. Slab (Knit texture): Usually produced by ling sticking to yarn bolsters or by a thick or noticeable patch in the yarn.
 15. Thick Place: Frequently introduced due to the filled yarn breaking and the lingering intention to continue walking until the administrator notices the problem.
 16. Water Spots: Typically caused by a wet texture that is allowed to remain unduly pleasant before drying: shade changes that result in messes

3.6.4 Different type of Finishing Defects

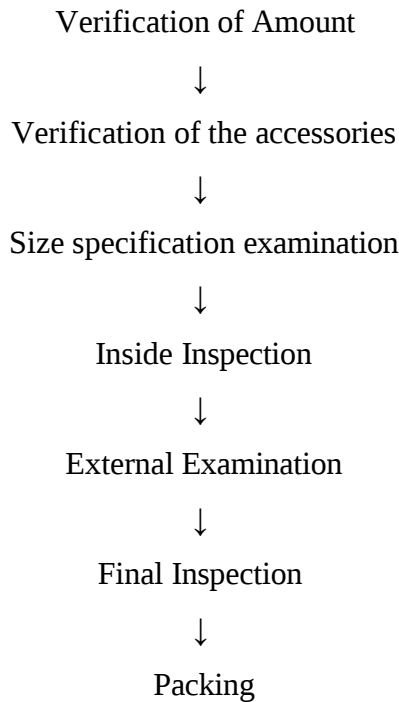
These are the flaws that are concealed throughout the finishing process:

1. Unwanted stains on the material.
2. A fabric patch that has lost color.
3. Hole punched out.
4. Make Pucker Sulfuric.
5. Bending.
6. Dosing.
7. Places of Water.
8. Nicks or Cuts.
9. A tear in the seam.
10. The ground.
11. Disparities.
12. Not Enough Pressing.
13. Pressing the Fabric to Produce Shine.
14. Fragile Elements.
15. Flaws in Folding.

3.7 Garment Inspection

By visually inspecting the products without using any devices, inspections are performed to control product quality. Inspection is the process of checking if the measures of the clothes, the stitching, the button, the thread, the zipper, and other components meet the required standards or requirements. There are several facilities for inspection in every sector of the apparel industry. By finding errors or defects at each stage of the garment-making process, inspection aims to save time and money.

3.7.1 Garment Inspection Process Flow Chart



3.7.2 Garment Inspection Procedure

1. Quantity Confirmation: To verify the quantity of each package of clothing against the vendor's packing document, the first step in the inspection process is to count all the pieces. The vendor is informed when the quantity is different from what is specified in the box and on the packing list.
2. Accessories Confirmation: Verifying the accessories is the second step. Here, we authorize price, demerit, brand, and other tags.; we may also approve woven labels, wash care label, accessory per buyer request.
3. Sizes Specification inspections: Next the accessory are confirmed, each item is checked to make sure it meets with the size requirements indicated on the instruction sheet that the customer provided. If there are any measurement problems, We immediately notify the customer after examining the original sample.
4. Inside Inspection: This stage involves looking at the garment from the inside out to check for any fabric faults, poor stitching, stains, or other problems.

5. Outside inspection: At this point, the outside of the clothing is checked to make sure there are no defects, such variations in color, problems in the fabric or printing, holes, shoddy stitching, smells, errors in dying, stains, etc.

6. Final Inspection: The phase of the inspection procedure that is most important is the final examination. The item is checked once more to ensure that testing and inspection were carried out properly without skipping any, and if any flaws are discovered, they are either rejected or returned for a refund.

7. Packaging: All "Grade-A" products are sent for needle inspection after being returned to their original poly bags.

Therefore, some clothing is sent for repair and others is rejected based on the severity of the defect.

3.7.3 Various Methods of Inspection Systems for Garments:

Procedure for Quality Control Bulk production is inspected to make sure it meets regulations before being delivered to the client. Consumers want to buy premium products at affordable costs. Customers must receive the products in the appropriate quality, depending on the pricing. Quality assurance encompasses all internal corporate processes that help produce high-quality products.

Which is done during the whole process (or) delivery? Present production representatives conduct the inspection, and the control chart records the findings. This procedure determines whether or not the product quality is acceptable. The process of visually inspecting a random selection of items from a delivery to ensure that they generally match the received instructions, descriptions, and/or sample and that they appear as claimed is known as garment inspection. There are different types of inspection following by inspectors as requirement of consumers.

1. Pre-Production Check (**PPC**)
2. Initial Production Check (**IPC**)
3. During Production Check (**DuPRO**)
4. Final Random Inspection (**FRI**)

1. Pre-Production Check(PPC):

This is completed prior to the start of manufacture. So where is the last inspection of the fabric used, the garment's design, cut, and craftsmanship to ensure that it meets the customer's specifications, or a pre-production sample?

2. Initial Productions Checks:

This is carried out at the beginning of manufacturing when a 1st batch of clothes are examined to find any potential difference or irregularities & to make it easier to make the necessary repairs before mass production begins. As a preliminary step, the inspection concentrates mostly on the overall design and appearance, craftsmanship, dimensions, fabric and component quality, weight, color, and/or printing.

3. During Production Check(DuPro):

In order to ensure that any early mistakes or variations have been corrected, this is done during production. This inspection is basically a follow-up to the production check that was done initially, and it is usually carried out a few days later, especially if there were any irregularities discovered.

4. Final Random Inspections:

When production of an order's entire amount or of a portion of a delivery is finished, this is done. A sample lot from the order will be chosen, and some of the clothing will be inspected; the buyer often specifies the percentage of the clothing that will be tested. Any inspection method created by the buyer may be used, not just the AQL sampling inspection.

CHAPTER - 04

5. DATA ANALYSIS/ EXPERIMENTALS DETAILS

5.1 Pass & Failed Final Inspections Report:

We've collected a few latest inspection reports. from Trust Knitwear Industries Ltd. of different buyer. We've collected 16 inspections reports of **ZXY**, **PEPCO**, **PRIMARK**. **NKD** and **LPP** buyers pass & fail reports. This reports are enlisted below:

Report-1: Buyer Name: ZXY Style No: AFW23W22 Style Quantity:1420 Pcs

ZXY APPAREL BUYING SOLUTIONS LTD.
89/1 Pragati Sarani, North Badda, Dhaka 1212, Bangladesh.

zxy

Inspection Reports

STYLE NO. / NAME	AFW23W22 / TROUSERS	DESCRIPTION	TROUSERS	ASSIGN DATE	17-05-2023
PO / ORDER NO.	23DF05648 / OS.04545	FACTORY	Trust Knitwear Industries Ltd	AUDIT DATE / INSPECTED DATE	28-08-2023
STYLE QTY. / ORDER QTY.	1380 Out of 1380 (Pcs)	CUSTOMER	Cheffo Sport S.P.A	INSPECTION START TIME	---
SHIP QTY.	1420 (Pcs)	TYPE OF INSPECTION (Final)	1st	INSPECTION FINISH TIME	---
INSPECTION RESULT	Pass	BUSINESS UNIT	Business Unit 2	INSPECTOR'S NAME	Md. Khabirul Islam
AQM NAME	---	ENTRY LOCATION	---		

FABRIC TEST	REACH	DEKO TEX	AZO	AATC	ZXY LAB
STATUS	☐	☐	☐	☐	☒

ACCESSORIES CHECK LIST

1 Main Label	2 Care/Content Label	3 Tags
4 Patching	5 Stickers	6 Hand Tags
7 Packing	8 Tissue Paper	9 Belt (if applicable)
10 Interlining or inside trim detail	11 Embellishments (of any kind)	12 Trimming's (Lace or Tape or Twill Etc.)

TEST PARAMETER		QUANTITY (PCS)		AQL 1.5		AQL 2.5	
Composition Order	FRENCH TERRY 80% COTTON, 20% POLYESTER 300 GSM	Lot Size	Sample Size	Major	Minor	Major	Minor
Composition Actual	80% ctn 20% polyester	Below 281	100%			Checked 100%	
Care Label Content	80% ctn 20% polyester	281-500	50	2	3	3	4
Required GSM or Weight	300	501-1200	80	3	4	5	6
Actual GSM or Weight	Wt	1201-3200	125	5	6	7	8
Required Shrinkage	5%	3201-10000	200	7	8	10	11
Actual Shrinkage	Wt	10001-35000	315	10	11	14	15
		35001-150000	500	14	15	21	22

SAMPLE SIZE	ACCEPT LEVEL		REJECT LEVEL		MAJOR FOUND	MINOR FOUND
	Major	Minor	Major	Minor		
125	7	8	9	5	5	2

ACCEPTED ☒ RE-INSPECTION ☐ HOLD ☐

FAULT CODE & DEFECTS FOUND	NO. OF DEFECTS		Remarks
	MAJ	MIN	
1. FABRIC DEFECTS			
101 Shading	1	0	---
2. CONSTRUCTION DEFECTS			
201 Open	1	0	---
202 Pkt misplace / close by sm	2	0	---
3. EMBELLISHMENTS DEFECTS			
301 Slanted Print	1	0	---
5. CLEANLINESS DEFECTS			
501 Oil	0	2	---

CARTON QTY ANALYSIS

Color	Carton Quantity	Selected Cartons
050 BLACK	50	15

Packing & Assortment	Yes	---
Shipping Mark	Yes	---
Labeling & Printed Materials & marking	Yes	---

FOLLOW UP ACTION ADDITIONAL COMMENTS

Figure- 3.1.1 Final Inspection Report

Result: Pass

Report-2: Buyer Name: ZXY

Style No: AFW816W23

Style Quantity:840 Pcs

ZXY APPAREL BUYING SOLUTIONS LTD.
89/1 Pragati Sarani, North Badda, Dhaka 1212, Bangladesh.

ZXY

Inspection Reports

STYLE NO. / NAME	AFW816W23 DRESS	DESCRIPTION	DRESS	ASSIGN DATE	17-05-2023
PO / ORDER NO.	23OF009505 CIS.04542	FACTORY	Trust Knitwear Industries Ltd	AUDIT DATE / INSPECTED DATE	20-08-2023
STYLE QTY. / ORDER QTY.	840 Out of 840 (Pcs)	CUSTOMER	Cisalpa Sport S.P.A	INSPECTION START TIME	—
READY QTY	840 (Pcs)	TYPE OF INSPECTION (Pre-Final)	1st	INSPECTION FINISH TIME	—
INSPECTION RESULT	Fail	BUSINESS UNIT	Business Unit 2	INSPECTOR'S NAME	Md. Khabirul Islam
AQM NAME	—	ENTRY LOCATION :			

FABRIC TEST	REACH	OEKO TEX	AZO	AATC	ZXY LAB
STATUS	☐	☐	☐	☐	☒

ACCESSORIES CHECK LIST

1 Main Label	2 Care/Content Label	3 Tags
4 Polybag	5 Stickers	6 Hand Tags
7 Packing	8 Tissue Paper	9 Zips (if applicable)
10 Embellishments (of any kind)	11 Trimmings (Lace or Tape or Ywill Etc.)	

TEST PARAMETER		QUANTITY (PCS)		AQL 1.5		AQL 2.5	
Composition Order	FLEECE LIGHT BRUSH 80% COTTON 20% POLY 300 GSM	LotSize	Sample Size	Major	Minor	Major	Minor
Composition Actual	56% ctn 44% polyester	Below 281	100%			Checked 100%	
Care Label Content	56% ctn 44% polyester	281-500	50	2	2	3	4
Required GSM or Weight	300	501-1200	80	3	4	5	6
Actual GSM or Weight	W/I	1201-3200	125	5	6	7	8
Required Shrinkage	5%	3201-10000	200	7	8	10	11
Actual Shrinkage	W/I	10001-35000	315	10	11	14	15
		35001-150000	500	14	15	21	22

SAMPLE SIZE	ACCEPT LEVEL		REJECT LEVEL		MAJOR FOUND	MINOR FOUND
	Major	Minor	Major	Minor		
80	5	6	6	7	20	0

ACCEPTED ☐ RE-INSPECTION ☒ HOLD ☐

FAULT CODE & DEFECTS FOUND	NO. OF DEFECTS		Remarks
	MAJ	MIN	
1. FABRIC DEFECTS			
101 Shading	7	0	Parts shading not allow. Pls sort-out defects qty.
2. CONSTRUCTION DEFECTS			
201 Improper Shape	9	0	Nk shape off Not acppt.pls rectify.
5. CLEANLINESS DEFECTS			
501 Spot	3	0	Not acppt
502 Wrong size gmts	1	0	Not accept.

CARTON QTY ANALYSIS

Color	Carton Quantity	Selected Cartons

FOLLOW UP ACTION ADDITIONAL COMMENTS

Attn-qm Today arrange p/final style-afw816 found quality discrepancy inside export ctn. This level quality defects gmts not allow for shipment. Pls open pack qty do 100% recheck sort-out mention defects gmts make rectify before next p/ final. Pls see the defects attachment.....

Figure- 3.1.2 Final Inspection report

Result: Fail



Figure- 3.1.3 Defects

ARENA		GRADING	AFW816 V.23											
SPORTWEAR LIFESTYLE			REV2 15/6/2023				PAPER PATTERN REFERENCE AFW814W22 REV1							
			XS		S		M		L		XL		XXL	
A	HALF CHEST	2	50	✓	52	✓	54	✓	56	✓	58		60	
B	FRONT LENGTH FROM HPS	2	83	✓	85	✓	87	✓	89	✓	91		93	
B1	BACK LENGHT FROM CENTRE BACK	2	81	✓	83	✓	85	✓	87	✓	89		91	
C	SLEEVE LENGTH FROM CENTRE BACK	2	60	✓	62	✓	64	✓	66	✓	68		90	
E	FRONT RAGLAN	1	29	✓	30	✓	31	✓	32	✓	33		34	0
E1	BACK RAGLAN	1	36	✓	37	✓	38	✓	39	✓	40		41	0.5
F	BACK NECK WIDTH	0.5	19.5	✓	20	✓	20.5	✓	21	✓	21.5		22	0
G	FRONT NECKDROP "V" COLLAR	0.5	16.5	✓	17	✓	17.5	✓	18	✓	18.5		19	0
H	COLLAR HEIGHT CENTER BACK	0	7	✓	7	✓	7	✓	7	✓	7		7	0
I	SLEEVE CUFF WIDTH	0.5	8	✓	8.5	✓	9	✓	9.5	✓	10		10.5	0
L	BOTTOM WIDTH	2	53	✓	55	✓	57	✓	59	✓	61		63	0.5
M	HEM HEIGHT	0	2	✓	2	✓	2	✓	2	✓	2		2	0
N	SLEEVE HEM HEIGHT	0	10	✓	10	✓	10	✓	10	✓	10		10	0
O	SLEEVE WIDHT AT 20 CM FROM ARMHOLE	0.7	15.8	✓	16.5	✓	17.2	✓	17.9	✓	18.6		19.3	0
P	SLEEVE WIDHT BEFORE CUFF	0.5	11.5	✓	12	✓	12.5	✓	13	✓	13.5		14	0
T	BICEP	1	21.5	✓	22.5	✓	23.5	✓	24.5	✓	25.5		26.5	0
X	FRONT ZIP LENGTH		20	✓	20	✓	21	✓	21	✓	22		22	0
Y	COLLAR UP		30	✓	40	✓	41	✓	42	✓				0.5
	PRINT POSITION FROM CENTRE HPS	0.5	18	✓	18.5	✓	19	✓	19.5	✓	20		20.5	0
BACK SLEEVE PRINT POSITION AT 3 CM ABOVE RIB														

16/11/23

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Figure- 3.1.4 Measurement

Report -3 Buyer Name: ZXY Style No: AFW826W29 Style Quantity:2880 Pcs

ZXY APPAREL BUYING SOLUTIONS LTD.
 89/1 Pragati Sarani, North Badda, Dhaka 1212, Bangladesh.



Inspection Reports

STYLE NO. / NAME	AFW826W29 LEGGINGS	DESCRIPTION	LEGGINGS	ASSIGN DATE	17-05-2023
PO / ORDER NO.	23OF005498 CIS.04541	FACTORY	Trust Knitwear Industries Ltd	AUDIT DATE / INSPECTED DATE	08-05-2023
STYLE QTY. / ORDER QTY.	2880 Out of 2880 (Pcs)	CUSTOMER	Cisalfa Sport S.P.A	INSPECTION START TIME	03:15 AM
SHIP QTY	2880 (Pcs)	TYPE OF INSPECTION (Final)	1st	INSPECTION FINISH TIME	04:20 AM
INSPECTION RESULT	Fail	BUSINESS UNIT	Business Unit 2	INSPECTOR'S NAME	Md. Khabirul Islam
AQM NAME	None	ENTRY LOCATION:			

FABRIC TEST	REACH	OEKO TEX	AZO	AATC	ZXY LAB
STATUS	☐	☐	☐	☐	☒

ACCESSORIES CHECK LIST

1 Main Label	2 Care/Content Label	3 Tags
4 Polybag	5 Stickers	6 Hand Tags
7 Packing	8 Tissue Paper	9 Linings (if applicable)
10 Embellishments (of any kind)	11 Trimmings (Lace or Tape or Twill Etc.)	

TEST PARAMETER		QUANTITY (PCS)		AQL 1.5		AQL 2.5	
Composition Order	JERSEY STRETCH 95% COTTON 5%EA 230 GSM	LotSize	Sample Size	Major	Minor	Major	Minor
Composition Actual	95% ctn 5% elasthane/60% ctn 35% polyester 5% elasthane	Below 281	100%			Checked 100%	
Care Label Content	95% ctn 5% elasthane/60% ctn 35% polyester 5% elasthane	281-500	50	2	2	3	4
Required GSM or Weight	230	501-1200	80	3	4	5	6
Actual GSM or Weight	W/t	1201-3200	125	5	6	7	8
Required Shrinkage	5%	3201-10000	200	7	8	10	11
Actual Shrinkage	W/t	10001-35000	315	10	11	14	15
		35001-150000	500	14	15	21	22

SAMPLE SIZE	ACCEPT LEVEL		REJECT LEVEL		MAJOR FOUND	MINOR FOUND
	Major	Minor	Major	Minor		
125	7	8	8	9	5	4

ACCEPTED ☐ RE-INSPECTION ☒ HOLD ☐

FAULT CODE & DEFECTS FOUND	NO. OF DEFECTS		Remarks
	MAJ	MIN	
1. FABRIC DEFECTS			
101 Yarn Contamination	1	2	---
2. CONSTRUCTION DEFECTS			
201 Wavy	1	1	---
202 Size wrong	1	0	---
3. EMBELLISHMENTS DEFECTS			
301 Poor Coverage	1	0	---
5. CLEANLINESS DEFECTS			
501 Spot	1	1	---

CARTON QTY ANALYSIS

Color	Carton Quantity	Selected Cartons
050 BLACK/GM22 NEW GREY MELANGE	10	46

Packing & Assortment	Yes	---
Shipping Mark	Yes	---
Labeling & Printed Materials & marking	Yes	---

FOLLOW UP ACTION ADDITIONAL COMMENTS

Figure- 3. 1.5 Inspections report

Result: Fail

Report -4 Buyer Name: PRIMARK Style No:991084608 Style Quantity:1450Pcs

Padma Textiles Limited
INSPECTION REPORT

Factory Name: TRUST KNITWEAR Buyer: PRIMARK Lot Qty: 1450 Sample Qty: 200 Date: 27-08-23

Name of Auditor: MD. RAHMAN ZAMAN Items: 25, 66, 96, 98 Ship Qty: 1450 + / - Qty: X S. Code:

Sty No: 991084608 PO: 1125316 Reqd GSM: 260 Fab Description: 60% COTTON 40% PC

Type of Inspection: ☐ 1st output ☐ Inline ☐ Pre-final ☐ Final ☒ Re-final AQL Major: 1.5 ☒ 4 ☐ AQL Minor: 1.5 ☐ 2.5 ☐ 4 ☒

Type of Audit	Accept	Reject	Comments	Labeling	Accept	Reject	Comments
PP Sample Audit:	☒	☐		Size Audit	☒	☐	
Color / Fabric Audit:	☒	☐		Main Label Audit	☒	☐	
Material Audit:	☒	☐		Care Label Audit	☒	☐	
Styling Audit:	☒	☐					
Special Country Audit:	☒	☐					
Product Safety Audit:	☒	☐		Print, Emb & Wash	☒	☐	
All Ticketing Audit:	☒	☐		Print Audit	☒	☐	
Carton Label Audit:	☒	☐		Emb Audit	☒	☐	
Pcs Per Carton Audit:	☒	☐		Wet / Dry Audit	☒	☐	
				GMT Wash Test Report	☒	☐	

Country of Origin: BANGLADESH
Size to Size: 15/2 - 3/8
Measurement: 15/2 - 3/8
Actual GSM: 255
Box Control: 58
Til No Of Ctn: 58
Completed Ctn: 58
Selected Ctn: 15

Inspection Ctn No: 2, 15, 47, 45, 55, 54, 27, 37, 13, 8, 7, 51, 3, 9, 2, 5

DEFECT	CRITICAL	MAJOR	MINOR
Fabric Defects			
Hole/ Snagging/ Skewed or Bowing			
Stain/ Dirty Spot			
Barrie/ Contamination			
Broken yarn/ Miss yarn/ Foreign yarn			
Knots/ Thick Place/ Thin Place			
Shading/ Line Mark/ Drooped Stitch			
Single Fly/ Missing a Yarn			
Missing Design			
Loose Linking/ Stitch			
Needle Drop/ Laddering			
Stitching Defects			
Oil Spok/ Inaccurate Stitch Count			
Joined stitching due to broken thread			
Broken stitches/ Insecure stitches			
Skipped stitches			
Uneven stitching/ Uneven stitching width			
Irregular stitching/ Wavy stitching			
Loose stitch tension/ Insecure back stitching			
Uneven stitch density/ Uneven stitch tension			
Unmatched join stitching/ Unmatched seam			
Needle hole (Depend on severity and position)			
Twisted seam/ Pleated seam or body			
Open seam/ broken seam/ Puckered seam			
Missed stitching/ Bartack			
Wrong bartack position			
Poor bartack workmanship			
Uneven pleats length/ Uneven darts width			
Misplaced bar tacks/ Insecure Tack			
Uncut thread			
Irregular gathering at cuff/ waist			
Raw edge outside			
wavy at zipper			
Seams & Closures			
Seam folded opposite to specify direction			
Unaligned seam			
Wrong Sleeve Setting			
Uneven seam length			
Linking seam not to STO for stretch			
Uneven sleeve length/ width			
Uneven sleeve placket width / length			
Notches exposed at sleeve slit			
Uneven cuff width / Cuff height			
Uneven position of pleats			
Poor Neck Shape			
Uneven front panel width			
Excess gathering at yoke seam			
Unmatched seams at armhole			
Improper gathering at sleeve cap			
Pocket & Pocket Flap			
Unaligned front /back pocket (Hi-Low pocket)			
Slanted pocket			
Excess tightness of pocket			
Excess fullness of pocket			
Twisted pocket cloth			
Misplaced pocket position			
Incorrect pocket position			

DEFECT	CRITICAL	MAJOR	MINOR
Insure Mending			
Missing Mending			
Tight Tension			
Collar			
Uneven collar points			
Mis-shaped collar/ collar points/ neckline			
Unbalanced collar			
Overlapping collar			
Bubble in collar fall			
Bubble in collar stand			
Uneven collar end			
Neck opening/ Collar shape not as approved			
Neck opening too small for wearing			
Crooked/Slant collar			
Uneven collar-points spreading			
Front Placket			
Uneven placket width / length			
Incorrect placket width			
Slanted placket / Bad shape			
Fullness at top center placket			
Button & Button Hole			
Missed button			
Broken button			
Unsecured button stitching			
Wrong button			
Incomplete bottom hole stitching/ Poor finishing			
Uncut button hole			
Unaligned button & button hole			
Misplaced button & button hole			
Button stitch not properly locked			
Letters on buttons upside down/not readable			
Button displace			
Broken Eyelet			
Labels & Hangtags			
Missed label / hangtag			
Wrong label / hangtag Wrong information on label			
Label Insecurely stitched			
Label folded by stitching			
Part of label sewn inside seam			
Label sewn inverted (Label up-side-down)			
Label sewn reversed (Label up-side-down)			
Label / Hangtag incorrectly placed			
Label sewn reversed (Label up-side-down)			
Label / Hangtag incorrectly placed			
Printing faults-(Off printing)			
Colour off shade or not as specified			
Wrong printing			
Print Cracking			
Print Bleeding			
Washing & Dyeing			
Missed washing			
Washing mark			
Wrong dyeing <u>UNEVEN DYEING</u>			
Dyeing spot			
Part Shading			
Product safety			
Draw Cord Safety Issue			

Incorrect position of pocket flap			
Hem			
Holes at rib			
Uneven hem*			
Twisted hem			
Wavy hem			
Lining/ Interlining			
Lining too short or too long			
Twisted lining			
Contrast interlining			
Waistband & Belt Loop			
Uneven waistband (H/Low waistband)			
Poor waistband finishing			
Uneven belt loop (Too long/too short)			
Missed belt loop			
Waistband stitching broken when stretched			
Little recovery or no elasticity at waistband			
Fly			
Uneven fly width			
Curved fly edge			
Exposed zipper tape when fly is closed			
Embroidery			
Missed embroidery			
Misplaced embroidery			
Broken embroidery stitches			
Incorrect embroidery stitch density			
Uneven embroidery stitching			
Wrong embroidery/ Embroidary Oil			
Printing Defects			
Missed printing			
Misplaced printing			
Printing faults(Printing stain)			

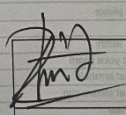
Snap Button Pull Tear Fail			
Metal Detector Fail			
Minimum Neck Strength Fail			
Others			
Mixed Shade			
Insecure tack at leg opening			
Visible contrast Thread *			
Miss Bartack			
Up- down at visible Draw cord			
Needle Mark			
Poor Iron			
Damage Tape			
Cutting sticker			
Looseness at Neck			
Both shoulder up-down			
Loose Thread			
Shiny Mark			
Pen Mark(Removal)			
Pen Mark(Not Removal)			
Chalk Mark			
Glue Mark			
Size Mistake			
Puckering			
BOTH LEG UP-DOWN	1	///	
MIX SHADE IN THE CARTON	11		
Total Defect	10	09	

Remarks: Do you find any defects more than 5%(Only if you have pre-approval lot will be consider pass)

Sl No	DEFECT	Percentage
1		
2		
3		
4		

Comments / Action Required: FOUND: MIX SHADE IN THE CARTON @ DIFFERENT SHADE COMPARE TO SAMPLE D PILLING ON THE GOODS

Result:	Pass	Fail	Repair	Hold
Workmanship Audit	☒	☐	☐	☐
Measurement Audit	☒	☐	☐	☐
Packing Audit	☒	☐	☐	☐
On Site Audit	☒	☐	☐	☐
Remarks	☒	☐	☐	☐
Overall Result	☒	☐	☐	☐

Approved and Signed By: _____

 Factory Signature: _____


We confirm the receipt of the report

Supplier is fully responsible to close the rest of the cartons which were selected for inspection. Please check with vendor's office to dispatch the goods.

Result: Pass

Report -5 Buyer Name: PRIMARK Style No:991051956 Style Quantity:15080Pcs

Padma Textiles Limited
INSPECTION REPORT

Factory Name: **TRUSTKNITWEAR** Buyer: **PRIMARK** Lot Qty: **15080** Sample Q.ty: **500** Date: **27-08-23**
 Name of Auditor: **MW. RAHMAN TALUKDER** Item: **CREW SWEAT** Qty: **15080** +/- Qty: **X** S. Code:
 Sty No: **991051956** PO: **1107602** Reqd GSM: **280** Fab Description: **50% COTTON 50% POLY**

Type of Inspection: ☐ 1st output ☐ Inline ☐ Pre-final ☐ Final ☒ Re-final AQL Major: 1.5 ☒ 3.5 ☐ 4 AQL Minor: 1.5 ☐ 2.5 ☐ 4 ☒

Type of Audit	Accept	Reject	Comments	Labeling	Accept	Reject	Comments
PP Sample Audit:	☒	☐		Size Audit	☒	☐	
Color / Fabric Audit:	☒	☐		Main Label Audit	☒	☐	
Material Audit:	☒	☐		Care Label Audit	☒	☐	
Styling Audit:	☒	☐					
Special Country Audit:	☒	☐		Print, Emb & Wash	☒	☐	
Product Safety Audit:	☒	☐		Print Audit	☒	☐	
All Tickling Audit:	☒	☐		Emb Audit	☒	☐	
Carton Label Audit:	☒	☐		Wet / Dry Audit	☒	☐	
Pcs Per Carton Audit:	☒	☐		GMT Wash Test Report	☒	☐	

Country of Origin: **BANGLADESH**
 Size to Size: **XS - 3XL**
 Measurement: **XS - 3XL**
 Actual GSM: **279**
 Box Control: **1508**
 Ttl No Of Ctn: **1508**
 Completed Ctn: **86**
 Selected Ctn: **86**

Inspection Ctn No: **ADDED PACKING LIST**

DEFECT	CRITICAL	MAJOR	MINOR
Fabric Defects			
Hole/ Snagging/ Skewed or Bowing			
Stain/ Dirty Spot			
Barrel/ Contamination			
Broken yarn/ Miss yarn/ Foreign yarn			
Knots/ Thick Place/ Thin Place			
Shading/ Line Mark/ Dropped Stitch			
Single Fly/ Missing a Yarn			
Missing Design			
Loose Linking/ Stitch			
Needle Drop/ Laddering			
Stitching Defects			
Oil Spot/ Inaccurate Stitch Count		///	///
Joined stitching due to broken thread			
Broken stitches/ Insecure stitches		///	
Skipped stitches			
Uneven stitching/ Uneven stitching width			
Irregular stitching/ Wavy stitching			
Loose stitch tension/ Insecure back stitching			
Uneven stitch density/ Uneven stitch tension			
Unmatched join stitching/ Unmatched seam			
Needle hole (Depend on severity and position)			
Twisted seam/ Pleated seam or body			
Open seam/ broken seam/ Puckered seam		///	
Missed stitching/ Bartack			
Wrong bartack position			
Poor bartack workmanship			
Uneven pleats length/ Uneven darts width			
Misplaced bar tacks/ Insecure Tack			
Uncut thread			///
Irregular gathering at cuff/ waist			
Raw edge outside			///
Washing & Dyeing			
Excess Stitch			
Seam folded opposite to specify direction			
Unaligned seam			
Wrong Sleeve Setting			
Uneven seam length			
Linking seam not to STO for stretch			
Uneven sleeve length/ width			
Uneven sleeve placket width / length			
Notches exposed at sleeve slit			
Uneven cuff width / Cuff height			
Uneven position of pleats			
Poor Neck Shape			
Uneven front panel width			
Excess gathering at yoke seam			
Unmatched seams at armhole			
Improper gathering at sleeve cap			
Pocket & Pocket Flap			
Unaligned front /back pocket (Hi-Low pocket)			
Slanted pocket			
Excess tightness of pocket			
Excess fullness of pocket			
Twisted pocket cloth			
Misplaced pocket position			
Incorrect pocket position			

DEFECT	CRITICAL	MAJOR	MINOR
Insure Mending			
Missing Mending			
Tight Tension			
Collar			
Uneven collar points			
Mis-shaped collar/ collar points/ neckline			
Unbalanced collar			
Overlapping collar			
Bubble in collar fall			
Bubble in collar stand			
Uneven collar end			
Neck opening/ Collar shape not as approved			
Neck opening too small for wearing			
Crooked/Slant collar			
Uneven collar-points spreading			
Front Placket			
Uneven placket width / length			
Incorrect placket width			
Slanted placket / Bad shape			
Fullness at top center placket			
Button & Button Hole			
Missed button			
Broken button			
Unsecured button stitching			
Wrong button			
Incomplete bottom hole stitching/ Poor finishing			
Uncut button hole			
Unaligned button & button hole			
Misplaced button & button hole			
Button stitch not properly locked			
Letters on buttons upside down/not readable			
Button displace			
Broken Eyelet			
Labels & Hangtags			
Missed label / hangtag			
Wrong label / hangtag Wrong information on label			
Label insecurely stitched			
Label folded by stitching			
Part of label sewn inside seam			
Label sewn inverted (Label up-side-down)			
Label sewn reversed (Label up-side-down)			
Label / Hangtag incorrectly placed			
Label sewn reversed (Label up-side-down)			
Label / Hangtag incorrectly placed			
Printing faults-(Off printing)			
Colour off shade or not as specified			
Wrong printing			
Print Cracking			
Print Bleeding			
Washing & Dyeing			
Missed washing			
Washing mark			
Wrong dyeing			
Dyeing spot			
Part Shading			
Product safety			
Draw Cord Safety Issue			

Incorrect position of pocket flap		Snap Button Pull Test Fail	
Hem		Metal Detector Fail	
Holes at rib		Minimum Neck Strength Fail	
Uneven hem		Others	
Twisted hem		Mixed Shade	
Wavy hem		Insecure tack at leg opening	
Lining/ Interlining		Visible contrast Thread	
Lining too short or too long		Miss Bartack	
Twisted lining		Up- down at visible Draw cord	
Contrast Interlining		Needle Mark	
Waistband & Belt Loop		Poor Iron	
Uneven waistband (Hi/Low waistband)		Damage Tape	
Poor waistband finishing		Cutting sticker	
Uneven belt loop (Too long/ too short)		Looseness at Neck	
Missed belt loop		Both shoulder up-down	
Waistband stitching broken when stretched		Loose Thread	
Little recovery or no elasticity at waistband		Shiny Mark	
Fly		Pen Mark(Removal)	
Uneven fly width		Pen Mark(Not Removal)	
Curved fly edge		Chalk Mark	111
Exposed zipper tape when fly is closed		Glue Mark	
Embroidery		Size Mistake	
Missed embroidery		NECK RIB SHADE	11
Misplaced embroidery		BOTTOM " "	11
Broken embroidery stitches		DIFFERENT SHADE IN THE	
Incorrect embroidery stitch density		CARTON	11
Uneven embroidery stitching		PART SHADE	11
Wrong embroidery/ Embroidary Oil		BOTH SLV UP-DOWN	11
Printing Defects			
Missed printing			
Misplaced printing			
Printing faults-(Printing stain)			
		Total Defect	18 11

Remarks: Do you find any defects more than 5%(Only if you have pre- approval lot will be considerd pass)		
SL No:	DEFECT	Percentage
1		
2		
3		
4		

Comments / Action Required:			

Result :	Pass	Fail	Repair	Hold
Workmanship Audit	☒	☐	☐	☐
Measurement Audit	☒	☐	☐	☐
Packing Audit	☒	☐	☐	☐
On Site Audit	☒	☐	☐	☐
Remarks	☒	☐	☐	☐
Overall Result	☒	☐	☐	☐

Approved and Signed By: _____

Factory Signatory: _____

We confirm the receipt of the report

Supplier is fully responsible to close the rest of the cartons which were selected for inspection. Please check with vendor's office to dispatch the goods.

Figure- 3. 1.7 Final Inspections report.

Result: Pass

Report -7 Buyer Name: PRIMARK Style No:991084532 Style Quantity:7200 Pcs

Daffodil International University																																																																																																																																																																																																																																																						
INSPECTION REPORT																																																																																																																																																																																																																																																						
Buyer Name	TRUST KNITWEAR		Buyer	PRIMARK		Lot Qty	7200 Pcs		Sample Qty	315 Pcs																																																																																																																																																																																																																																												
Date	02-09-2023																																																																																																																																																																																																																																																					
Inspector	A.K.H. RANZU		Items	24 HOOD		Ship Qty	7200 Pcs		+/- Qty	-																																																																																																																																																																																																																																												
No	991084532		PO	N11573376/B11573378		Reqd GSM	260		Fab Description	60% COTTON 40% POLYESTER																																																																																																																																																																																																																																												
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Country of Origin: BANGLADESH Size to Size: 157-2 - 318 Measurement: 157-2 - 318 Actual GSM: 263 Box Control: 360 CTN TV No Of Ctn: 360 Completed Ctn: 36 Selected Ctn: 36																																																																																																																																																																																																																																																						
Section Ctn No: 8, 17, 24, 33, 42, 53, 64, 76, 88, 97, 108, 116, 124, 137, 148, 156, 167, 178, 186, 197, 208, 216, 225, 237, 244, 53, 62, 73, 81, 96, 104, 116, 124, 135, 146																																																																																																																																																																																																																																																						
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Setting				Uneven seam length				Linking seam not to STO for stretch		01 Pcs	02 Pcs	Uneven sleeve length/ up 5 down				Uneven sleeve placket width / length				Uneven sleeve exposed at sleeve slit				Notches exposed at cuff height				Uneven cuff width / Cuff height				Uneven position of pleats				Poor Neck Shape				Uneven front panel width				Excess gathering at yoke seam				Unmatched seams at armhole				Improper gathering at sleeve cap				Pocket & Pocket Flap				Unaligned front /back pocket (Hi-Low pocket)				Slanted pocket				Excess lightness of pocket				Excess fullness of pocket				Twisted pocket cloth				Misplaced pocket position				Incorrect pocket position			
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Report -8 Buyer Name: PRIMARK Style No:991051956 Style Quantity:1390 Pcs

Padma Textiles Limited
INSPECTION REPORT

Factory Name: TRUST KNITWEAR Buyer: PRIMARK Lot Qty: 1390 Pcs Sample Qty: 200 Pcs Date: 24.07.2023

Name of Auditor: MR. ARIF Items: SWEATSHIRT Ship Qty: 1390 Pcs +/- Qty: — S. Code: 5325

Sty No: 991051956 PO: C11355142 Reqd GSM: 270 Fab Description: 50% COTTON, 50% POLYESTER

Type of Inspection: ☐ 1st output ☐ Inline ☐ Pre-final ☐ Final ☒ Re-final AQL Major: 1.5 ☐ 2.5 ☒ 4 AQL Minor: 1.5 ☐ 2.5 ☒ 4

Type of Audit	Accept	Reject	Comments	Labeling	Accept	Reject	Comments
PP Sample Audit:	☒	☐		Size Audit	☒	☐	
Color / Fabric Audit:	☒	☐		Main Label Audit	☒	☐	
Material Audit:	☒	☐		Care Label Audit	☒	☐	
Styling Audit:	☒	☐					
Special Country Audit:	☒	☐					
Product Safety Audit:	☒	☐		Print/Emb & Wash	☒	☐	
All Ticketing Audit:	☒	☐		Print Audit	☒	☐	
Carton Label Audit:	☒	☐		Emb Audit	☒	☐	
Pcs Per Carton Audit:	☒	☐		Wet / Dry Audit	☒	☐	

Country of Origin: BAHARUDESH
Size to Size: XS TO 3XL
Measurement: XS TO 3XL
Actual GSM: 275/282
Box Control: 139
Ttl No Of Ctn: 139
Completed Ctn: 139
Selected Ctn: 22

Inspection Ctn No: 24.18.13.03.09.55.31.40.49.84.71.66.79.95.105.110.113.125.121.132.137.99.

DEFECT	CRITICAL	MAJOR	MINOR
Fabric Defects			
Hole/ Missing/ Skewed or Bowing		01	—
Stain/ Dirty Spot			
Yarn/ Contamination			
Broken yarn/ Miss yarn/ Foreign yarn			
Knots/ Thick Place/ Thin Place			
Shading/ Line Mark/ Drooped Stitch			
Single Fly/ Missing a Yarn			
Missing Design			
Loose Linking/ Stitch			
Needle Drop/ Laddering			
Stitching Defects			
Oil Spot/ Unsewn Stitch Count		02	02
Joined stitching due to broken thread		01	02
Broken stitches/ Insecure stitches		02	—
Skipped stitches			
Uneven stitching/ Uneven stitching width			
Irregular stitching/ Wavy stitching			
Loose stitch tension/ Insecure back stitching			
Uneven stitch density/ Uneven stitch tension			
Unmatched join stitching/ Unmatched seam			
Needle hole (Depend on severity and position)			
Twisted seam/ Pleated seam or body			
Open seam/ broken seam/ Puckered seam			
Missed stitching/ Bartack			
Wrong bartack position			
Poor bartack workmanship			
Uneven pleats length/ Uneven darts width			
Misplaced bar tacks/ Insecure Tack			
Un-cut thread		—	02
Irregular gathering at cuff/ waist			
Raw edge outside			
wavy at zipper			
Excess Stitch			
Seam folded opposite to specify direction			
Unaligned seam			
Wrong Sleeve Setting			
Uneven seam length			
Linking seam not to STO for stretch			
Uneven sleeve length/ width			
Uneven sleeve placket width/ length			
Notches exposed at sleeve slit			
Uneven cuff width/ Cuff height			
Uneven position of pleats			
Poor Neck Shape		—	02
Uneven front panel width			
Excess gathering at yoke seam			
Unmatched seams at armhole			
Improper gathering at sleeve cap			
Pocket & Pocket Flap			
Unaligned front/ back pocket (Hi-Low pocket)			
Slanted pocket			
Excess tightness of pocket			
Excess fullness of pocket			
Twisted pocket cloth			
Misplaced pocket position			
Incorrect pocket position			

DEFECT	CRITICAL	MAJOR	MINOR
Collar			
Uneven collar points			
Mis-shaped collar/ collar points/ neckline			
Unbalanced collar			
Overlapping collar			
Bubble in collar fall			
Bubble in collar stand			
Uneven collar end			
Neck opening/ Collar shape not as approved			
Neck opening too small for wearing			
Crooked/Slant collar			
Uneven collar-points spreading			
Front Placket			
Uneven placket width/ length			
Incorrect placket width			
Slanted placket/ Bad shape			
Fullness at top center placket			
Button & Button Hole			
Missed button			
Broken button			
Unsecured button stitching			
Wrong button			
Incomplete bottom hole stitching/ Poor finishing			
Uncut button hole			
Unaligned button & button hole			
Misplaced button & button hole			
Button stitch not properly locked			
Letters on buttons upside down/ not readable			
Button displace			
Broken Eyelet			
Labels & Hangtags			
Missed label / hangtag			
Wrong label / hangtag Wrong information on label			
Label insecurely stitched			
Label folded by stitching			
Part of label sewn inside seam			
Label sewn inverted (Label up-side-down)			
Label sewn reversed (Label up-side-down)			
Label / Hangtag incorrectly placed			
Label sewn reversed (Label up-side-down)			
Label / Hangtag incorrectly placed			
Printing faults- (Off printing)			
Colour off shade or not as specified			
Wrong printing			
Print Cracking			
Print Bleeding			
Washing & Dyeing			
Missed washing			
Washing mark			
Wrong dyeing			
Dyeing spot			
Part Shading		02	02
Product safety			
Draw Cord Safety Issue			

Report -9 Buyer Name: LPP

Style No:1612F

Style Quantity:61034 Pcs

LPP INSPECTION REPORT							
inspection status: In Line: normal				% qty packed: 12		date: 30/08/2023	
PP sample: unavailable							
style no	1612F	item	L_t-shirts_slvless	depart	ladies' garment SI	brand	Sinsay
order no	10112047	ordered q-ty	61034	agent	Dhaka Office		
supplier	Trust Knitwear Industries (BD)			factory	Trust Knitwear Industries Limited (BD)		
PACKING							
packing	OK	desiccants	No desiccant				
comments:							
Carton sticker, number & weight not yet used							
INSPECTED CARTONS NUMBERS							
colsize	T01	T02	T03	T04	T05	T06	
00X		1 Carton	1 Carton	1 Carton	1 Carton	1 Carton	
99X	1 Carton	1 Carton	1 Carton	1 Carton	1 Carton	1 Carton	
ACCESSORIES							
main label	OK	hangtag	OK	washing instr	OK		
comments:							
INSPECTION DETAILS							
defect list	comments			critical	major	minor	
Shirring	Back part				7	1	
Uneven bottom shape	Bottom				1		
Joint stitch	Bottom					2	
Uneven side shape	Side				3	1	
Pleat	Front part				1		
Wavy	Back part				1		
Uncut thread	Different area					3	
total				0	13	7	
GSM CHECK							
Required		99X		00X			
160gsm		161 & 163		160 & 158			
RESUME OF INSPECTION							
status		status		status		status	
appearance	OK	workmanship	OK	cleanness	OK	moisture	OK
fabric quality	OK	measurement	B	trimmings	OK	packing	OK
color/dyeing	OK	fitting/function	N/A	decoration	N/A	others	OK
						mold	OK
S - SMALL, B - BIG, C - CRITICAL							
comments:							
Inspection Mark is 3.25.							
Mark is reduced due to measurement out of tolerance in shoulder, bottom & strap length.							
INSPECTION DECISION							
major defect	AQL: 6.5	mark(1-5)	3.25	inspection result			
inspected quantity	315			N/A			
number of major defects	13						
% of major defects	4						
% of minor defects	2						
NURUL AMIN KHAN							

Figure- 3.1.10 Final Inspection report.

Result: N/A

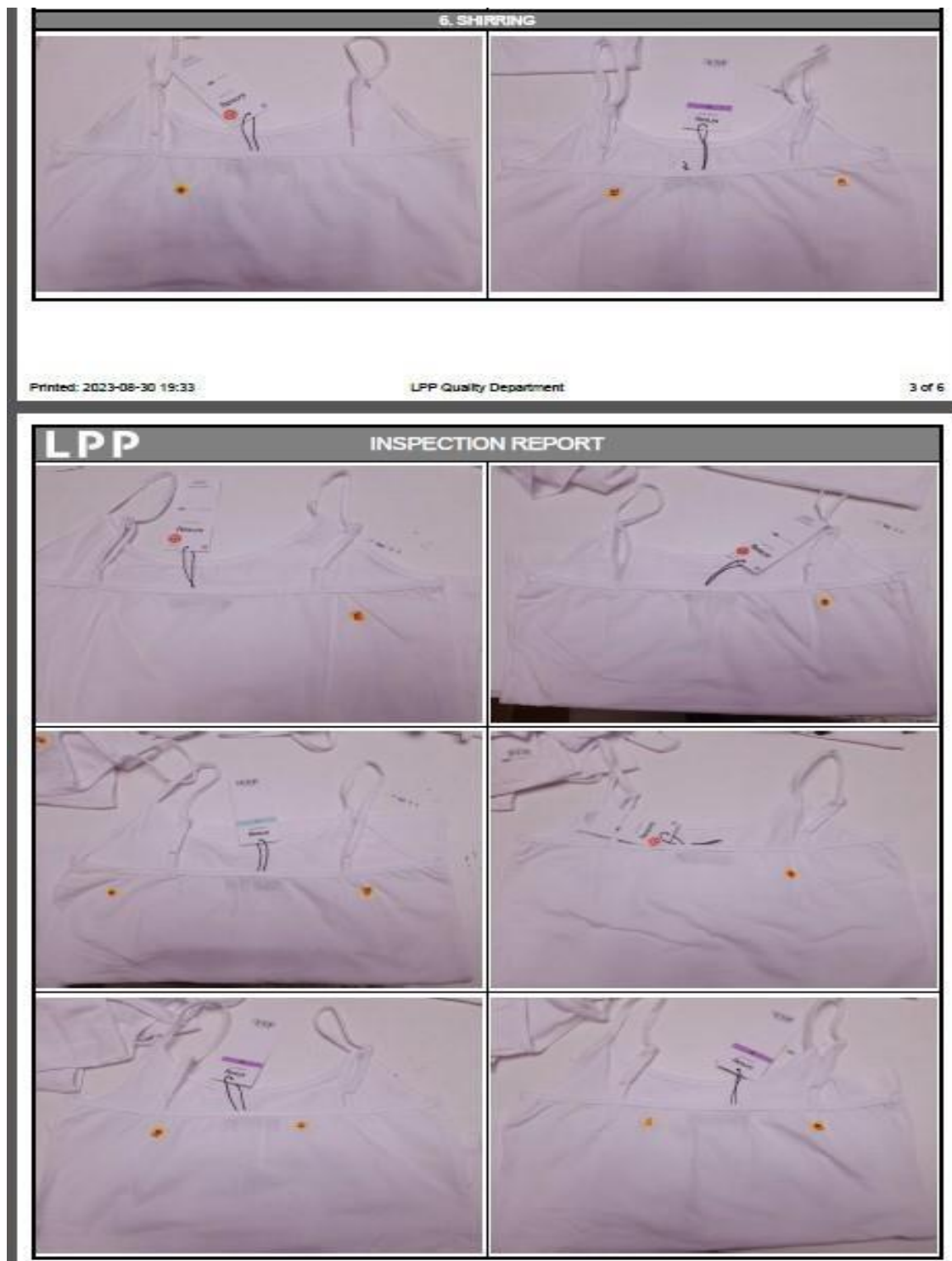


Figure- 3.1.11 Defects



Figure- 3.1.12 Defects & Measurement

Report -10: Buyer Name: LPP Style No:23810 Style Quantity:17024 Pcs

LPP INSPECTION REPORT							
inspection status: In Line: normal				% qty packed: 85		date: 21/08/2023	
PP sample: unavailable							
style no	23810	item	M_t-shirts_s_s	depart	men's garment SINSAY	brand	Sinsay
order no	10191746	ordered q-ty	17024	agent	Dhaka Office		
supplier	Trust Knitwear Industries (BD)			factory	Trust Knitwear Industries Limited (BD)		
PACKING							
packing	OK	desiccants	No desiccant				
comments:							
Used Non-standard carton 58*40*30 without approval from LPP Carton. Carton sticker, number & weight not yet used							
INSPECTED CARTONS NUMBERS							
collsize	P01	P02	T01	T02	T03	T04	T05
09M	5 Carton	2 Carton	1 Carton	1 Carton	1 Carton	1 Carton	1 Carton
collsize	T06						
09M	1 Carton						
ACCESSORIES							
main label	OK	hangtag	NOT OK	washing instr	OK		
comments:							
FSC logo missing in Hangtag "HG-SI446"							
INSPECTION DETAILS							
defect list	comments			critical	major	minor	
Hole	Front part				1		
Skip Stitch	Hem				4		
Rawedge	Different area				2	3	
Asymmetry both shoulder	Shoulder				2	2	
Spot	Front part				1		
Uncut thread	Different area					2	
total				0	10	7	
GSM CHECK							
Required				09M			
09m: 140 GSM, 00x: 160 GSM				137 & 140			
RESUME OF INSPECTION							
status	status	status	status	status	status	status	status
appearance	OK	workmanship	OK	cleanness	OK	moisture	OK
fabric quality	OK	measurement	OK	trimmings	B	packing	OK
color/dyeing	OK	fitting/function	N/A	decoration	N/A	others	OK
						mold	OK
S - SMALL, B - BIG, C - CRITICAL							
comments:							
Inspection Mark 3.25.							
Mark is reduced due to FSC logo missing in Hangtag "HG-SI446"							
INSPECTION DECISION							
major defect	AQL: 2.5	mark(1-5)	3.25	inspection result			
inspected quantity	200			N/A			
number of major defects	10						
% of major defects	5						
% of minor defects	4						
NIJRIJ AMIN KHAN							

Figure- 3.1.13 Final Inspection report.

Result: N/A

Report -13: Buyer Name: PEPCO
15960 Pcs

Style No: ss23ly351-SS23

Style Quantity:

WORKMANSHIP						
Total Defective Units: 14		Total Defects: 14		Total Defective Items: 5		
Occurrence		Critical	Major	Minor		
AQL		0	2.5	4.0		
Defects		0	5	9		
Max Allowed		0.0	7.0	10.0		
Defect Category	Defect Name	Critical	Major	Minor	Counted for AQL	
Workmanship & appearance	408b - Collar is not symmetrical (small)	0	0	1	On	
	401b - Uneven pockets (small)	0	0	2	On	
	411a - shiny marks from iron (significant)	0	1	0	On	
	401a - Uneven pockets (significant)	0	1	0	On	
	405b - Waistband twisted or with puckering (small)	0	0	1	On	
Seams/ Stitches	302 - Skipped stitch on seam	0	1	0	On	
	313a - Untrimmed threads, hanging threads (outside > 2cm)	0	1	0	On	
	312 - Unaesthetic joined stitches	0	0	1	On	
	313b - Untrimmed threads, hanging threads (outside < 2cm)	0	0	1	On	
Material	109b - colour shades within the garment small	0	0	1	On	
Page: 7 / 67						
Defect Category	Defect Name	Critical	Major	Minor	Counted for AQL	
	108b - Foreign fiber/yarn (size colour/contrast) small	0	0	1	On	
	109a - colour shades within the garment significant	0	1	0	On	
	111b - Dirty marks on bottom front and back	0	0	1	On	

Figure-3.1.16 Final Inspections report.

Result: Pass

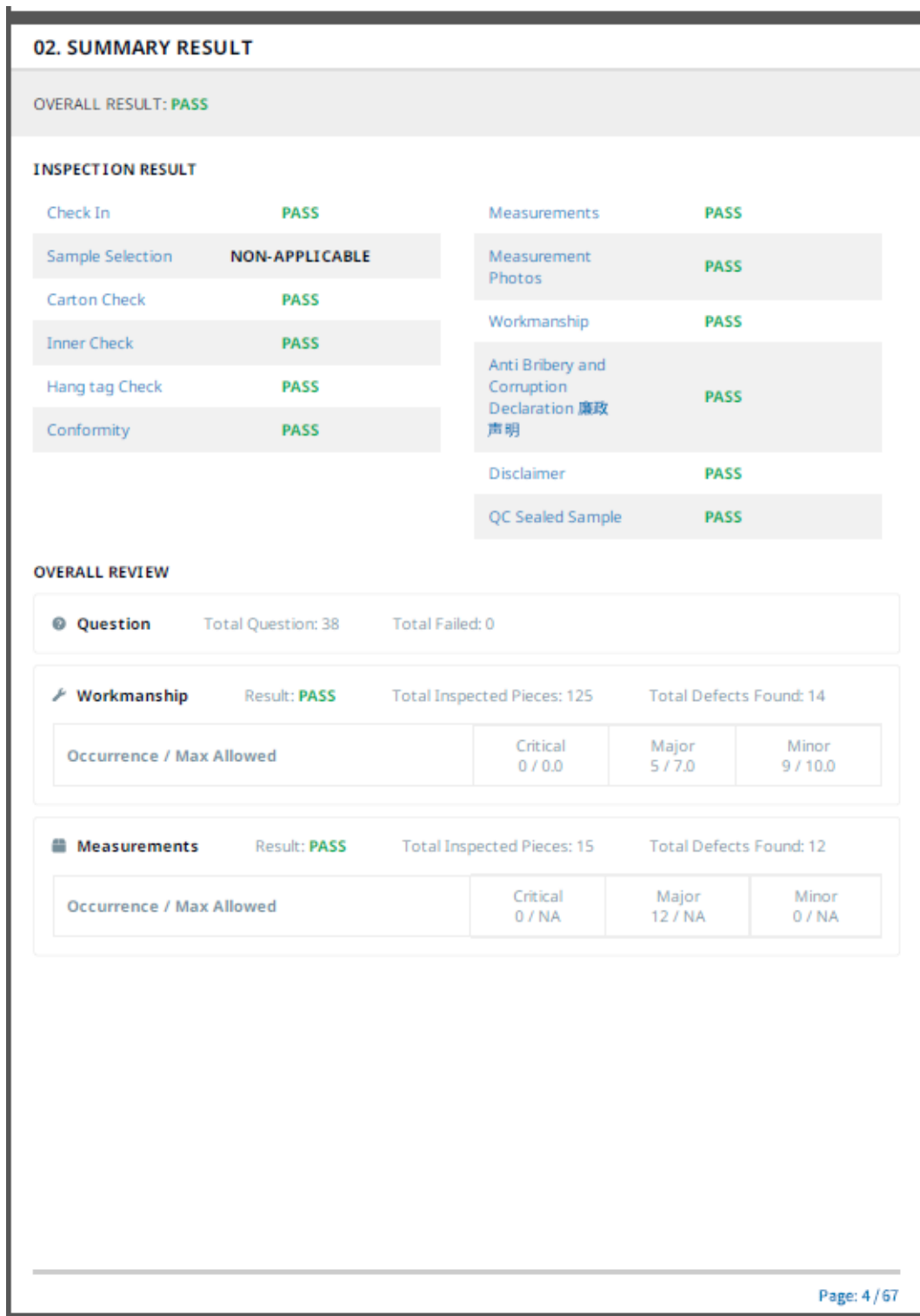


Figure- 3.1.17 Summary Result

WORKMANSHIP					
Total Defective Units: 27		Total Defects: 27		Total Defective Items: 8	
Occurrence		Critical	Major	Minor	
AQL		0	2.5	4.0	
Defects		0	21	6	
Max Allowed		0.0	5.0	7.0	
Defect Category	Defect Name	Critical	Major	Minor	Counted for AQL
Workmanship & appearance	408a - Collar is not symmetrical (significant)	0	3	0	On
	406a - Unsymmetrical shoulder/sleeve/sides/leg width/uneven length (significant)	0	5	0	On
	408b - Collar is not symmetrical (small)	0	0	1	On
	406b - Unsymmetrical shoulder/sleeve/sides/leg width/uneven length (small)	0	0	1	On
Material	111a - Dirty marks on top front and back	0	3	0	On
	109b - color shades within the garment small	0	0	1	On
Page: 7 / 56					
Defect Category	Defect Name	Critical	Major	Minor	Counted for AQL
	111b - Dirty marks on bottom front and back	0	0	2	On
	101 - Holes	0	1	0	On
Seams/ Stitches	310a - Twisting leg, sleeve, side seam (significant)	0	3	0	On
	301 - Broken seam	0	2	0	On
	313a - Untrimmed threads, hanging threads (outside > 2cm)	0	1	0	On
	305b - Seams or topstitching uneven (deviation of topstitching seam) small	0	0	1	On
Prints & embroideries	603a - Print stains (significant)	0	2	0	On
	602 - Defective or cracked print	0	1	0	On

Figure- 3. 1.18 Final Inspections report.

Result: Fail

02. SUMMARY RESULT

OVERALL RESULT: **FAIL**

INSPECTION RESULT

Check In	FAIL	Measurements	FAIL
Production Process and Status checking	PASS	Measurement Photos	PASS
Sample Selection	NON-APPLICABLE	Workmanship	FAIL
Carton Check	PASS	Anti Bribery and Corruption Declaration 廉政声明	PASS
Inner Check	PASS	Disclaimer	PASS
Hang tag Check	PASS	QC Sealed Sample	PASS
Conformity	FAIL		

OVERALL REVIEW

 **Question**

Total Question: 44

Total Failed: 2

 **Measurements**

Result: **FAIL**

Total Inspected Pieces: 24

Total Defects Found: 10

Occurrence / Max Allowed	Critical 0 / NA	Major 10 / NA	Minor 0 / NA
--------------------------	--------------------	------------------	-----------------

 **Workmanship**

Result: **FAIL**

Total Inspected Pieces: 80

Total Defects Found: 27

Occurrence / Max Allowed	Critical 0 / 0.0	Major 21 / 5.0	Minor 6 / 7.0
--------------------------	---------------------	-------------------	------------------

Figure- 3.1.19 Summary Result

Report -15: Buyer Name: PEPCO Style No: SS23PG273-SS23 Style Quantity: 40004 Pcs

WORKMANSHIP

Total Defective Units: 28

Total Defects: 28

Total Defective Items: 6

Occurrence

Critical

Major

Minor

Page: 10 / 66

Occurrence

Critical

Major

Minor

AQL

0

2.5

4.0

Defects

0

19

9

Max Allowed

0.0

10.0

14.0

Defect Category

Defect Name

Critical

Major

Minor

Counted for AQL

Material

111b - Dirty marks on bottom front and back

0

0

2

On

110a - Stains on top front and back

0

2

0

On

Workmanship & appearance

408a - Collar is not symmetrical (significant)

0

7

0

On

406b - Unsymmetrical shoulder/sleeve/sides/leg width/uneven length (small)

0

0

3

On

406a - Unsymmetrical shoulder/sleeve/sides/leg width/uneven length (significant)

0

8

0

On

411 - shiny marks from iron

0

0

2

On

408b - Collar is not symmetrical (small)

0

0

2

On

Seams/ Stitches

310a - Twisting leg, sleeve, side seam (significant)

0

2

0

On

Figure- 3.1.20 Final Inspections report.

Result: Fail

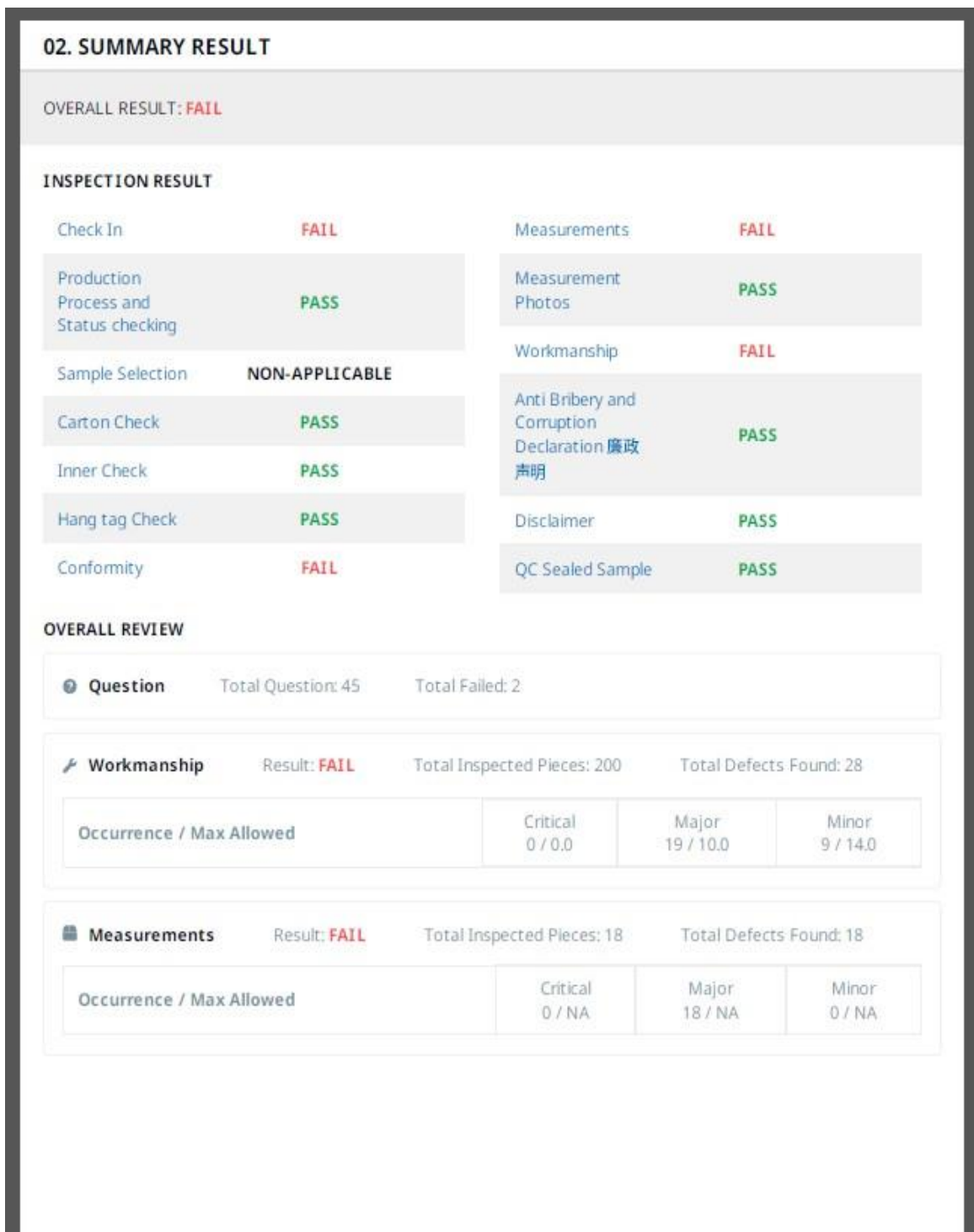


Figure- 3.1.21 Summary Result

Report -16: Buyer Name: PEPCO Style No: AW23MZ200R Style Quantity: 123576
Pcs

WORKMANSHIP					
Total Defective Units: 22		Total Defects: 22		Total Defective Items: 4	
Occurrence		Critical	Major	Minor	
AQL		0	2.5	4.0	
Defects		0	18	4	

Occurrence		Critical	Major	Minor	
Max Allowed		0.0	7.0	10.0	

Defect Category	Defect Name	Critical	Major	Minor	Counted for AQL
Workmanship & appearance	406a - Unsymmetrical shoulder/sleeve/sides/leg width/uneven length (significant)	0	7	0	On
	405a - Waistband twisted or with puckering (significant)	0	2	0	On
	406b - Unsymmetrical shoulder/sleeve/sides/leg width/uneven length (small)	0	0	2	On
	408a - Collar is not symmetrical (significant)	0	5	0	On
	405b - Waistband twisted or with puckering (small)	0	0	1	On
Material	109b - color shades within the garment small	0	0	1	On
	101 - Holes	0	1	0	On
	111a - Dirty marks on top front and back	0	1	0	On
Prints & embroideries	602 - Defective or cracked print	0	1	0	On
Seams/ Stitches	301 - Broken seam	0	1	0	On

Figure- 3.1.22 Final Inspection report.

Result: Fail

02. SUMMARY RESULT

OVERALL RESULT: **FAIL**

INSPECTION RESULT

Check In	PASS	Measurements	FAIL
Production Process and Status checking	PASS	Measurement Photos	PASS
Sample Selection	NON-APPLICABLE	Workmanship	FAIL
Carton Check	PASS	Anti Bribery and Corruption Declaration 廉政声明	PASS
Inner Check	PASS	Disclaimer	PASS
Hang tag Check	PASS	QC Sealed Sample	PASS
Conformity	PASS		

OVERALL REVIEW

🔍 Question	Total Question: 44	Total Failed: 0		
🔧 Workmanship	Result: FAIL	Total Inspected Pieces: 125	Total Defects Found: 22	
Occurrence / Max Allowed	Critical 0 / 0.0	Major 18 / 7.0	Minor 4 / 10.0	
📏 Measurements	Result: FAIL	Total Inspected Pieces: 12	Total Defects Found: 3	
Occurrence / Max Allowed	Critical 0 / NA	Major 3 / NA	Minor 0 / NA	

Figure- 3.1.23 Summary Result

5.2 Data Analysis

Defect name	Major	Minor	Weight	Section wise%	Total %
Fabric defect					
Shading	9×3=27	3×1=3	27+3=30	48.40%	11.85%
Hole	5×3=15		15	24.20%	
Yarn Contamination	1×3=3	3×1=3	3+3=6	9.67%	
Broken Thread	2×3=6		6	9.67%	
Others	1×3=3	2×1=2	3+2=5	8.06%	
Total			62	100%	

Sewing defect				
1. Non-sewing				
Neck shape poor	10×3=30	4×1=4	30+4=34	9.28%
Side seam shape	9×3=27	5×1=5	27+5=32	8.74%
Bottom shape	5×3=15	7×1=7	15+7=22	6.00%
Visible contrast thread	4×3=12	5×1=5	12+5=17	4.64%
Pocket shape	2×3=6	2×1=2	6+2=8	2.18%
Collar shape	3×3=9	1×1=1	9+1=10	2.73%
Both leg up-down	1×3=3	3×1=3	3+3=6	1.63%
2. Sewing				
Collar open	15×3=45	5×1=5	45+5=50	13.66%
Skipped stitch	13×3=39		39	10.65%
Shoulder up-down	1×3=30	5×1=5	30+5=35	9.56%
Broken stitch	8×3=24		24	6.56%
Twisting	7×3=21	3×1=3	21+3=24	6.55%
Uncut thread	2×3=6	13×1	6+13=19	5.19%
Slanted placket	3×3=9	4×1=4	9+4=13	3.55%
Bottom hiking	3×3=9	3×1=3	9+3=12	3.27%

Join stitch	1×3=3	7×1=7	3+7=10	2.73%	
Open seam	2×3=6		6	1.63%	
Pleat on neck	1×3=3		3	0.81%	
Uneven stitch		2×1=2	2	0.54%	
Total			366	100%	

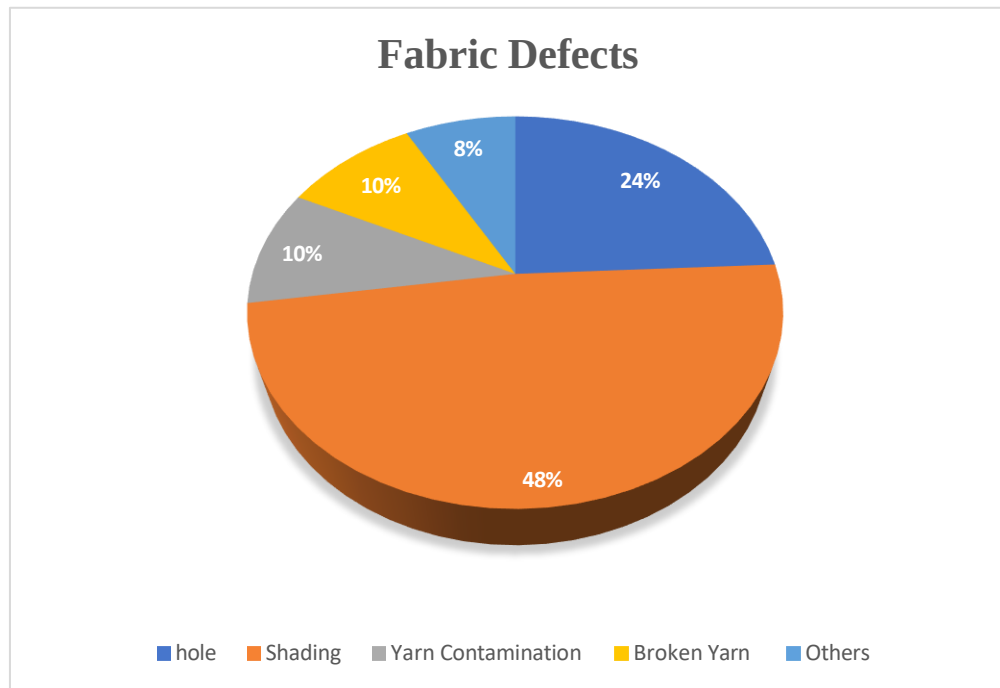
Finishing defect					
Dirty spot	5×3=15	6×1=6	15+6=21	32.82%	12.06%
Others	5×3=15	2×1=2	15+2=17	26.56%	
Oil spot	4×3=12	4×1=4	12+4=16	25%	
Stain	2×3=6		6	9.37%	
Shiny marks from iron	1×3=3	2×1=2	2+2=4	6.25%	
Total			64	100%	

Miscellaneous defect					
Print defect	7×3=21	2×1=2	21+2=23	71.87%	6.11%
Size mistake	2×3=6		6	18.75%	
Decoration label slanted		3×1=3	3	9.38%	
Total			32	100%	

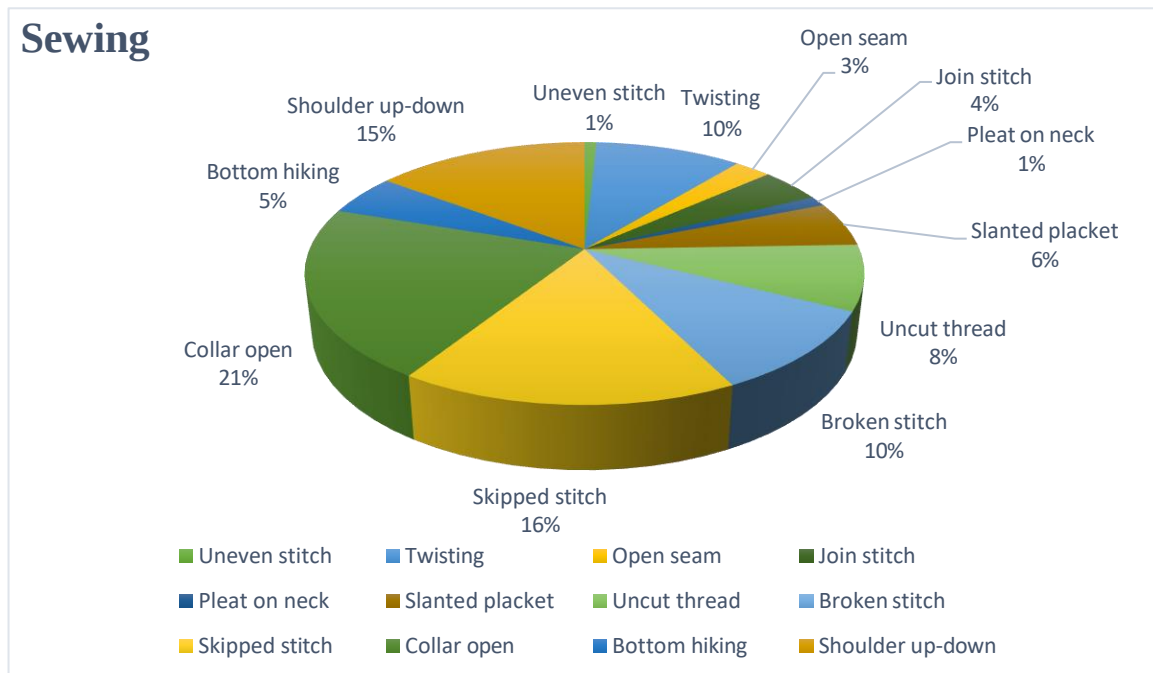
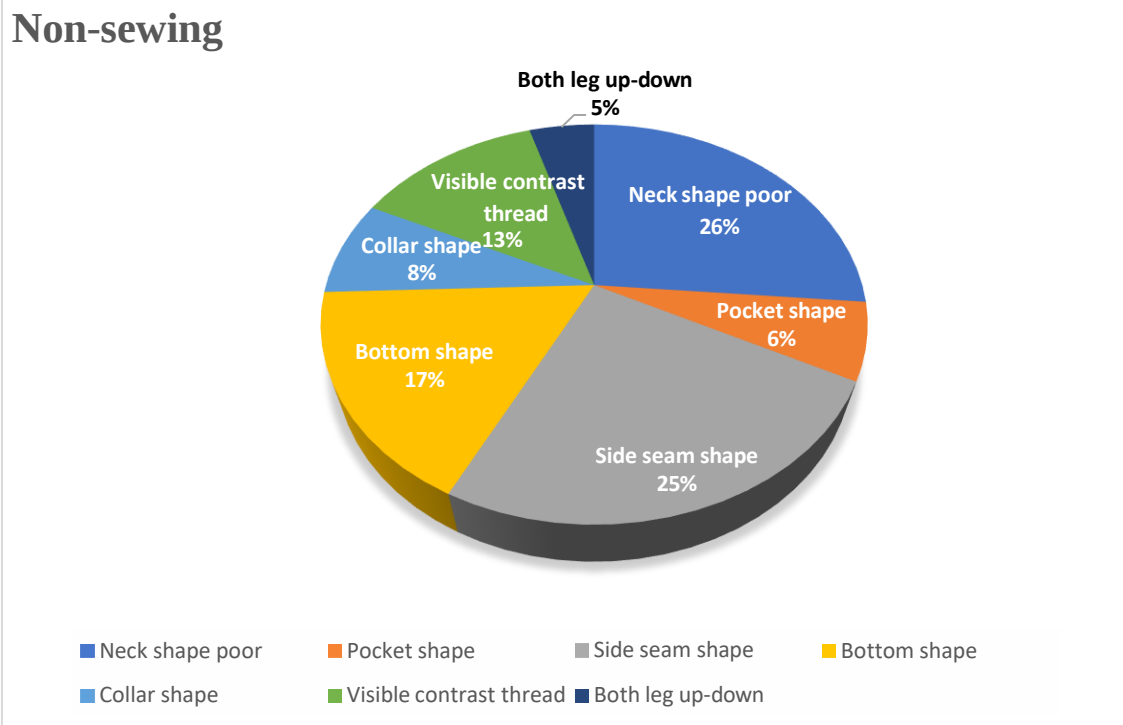
All Total			523	100%	
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5.3 Percentage of defect

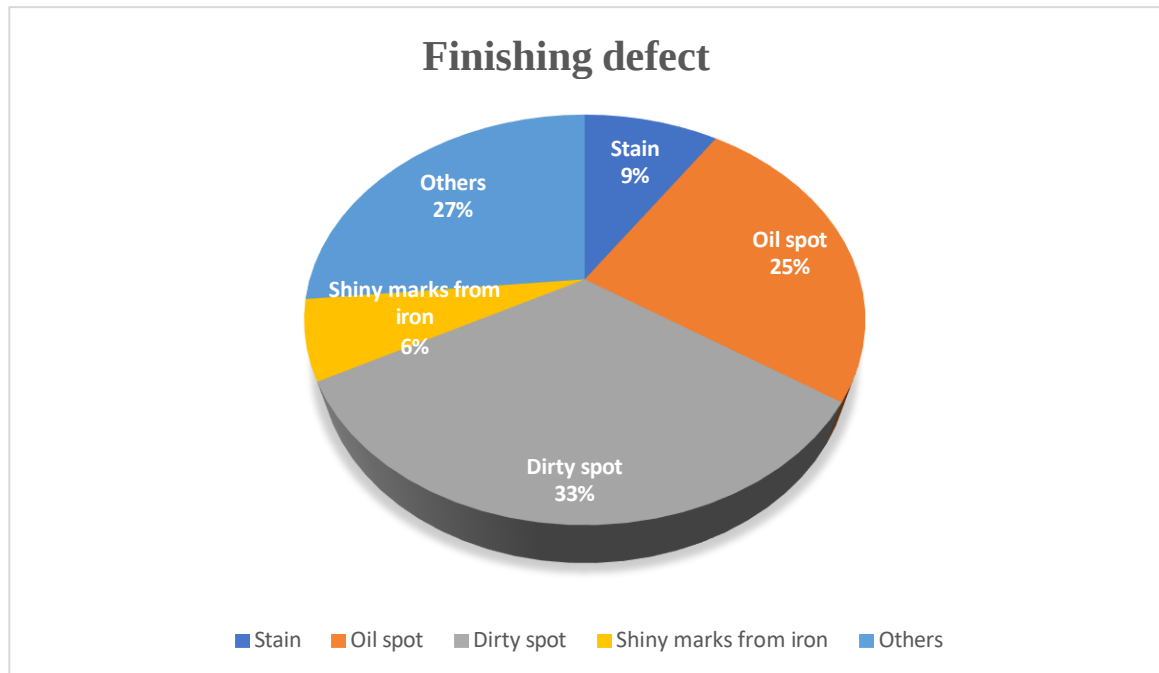
4.3.1 Percentage of Fabric defects



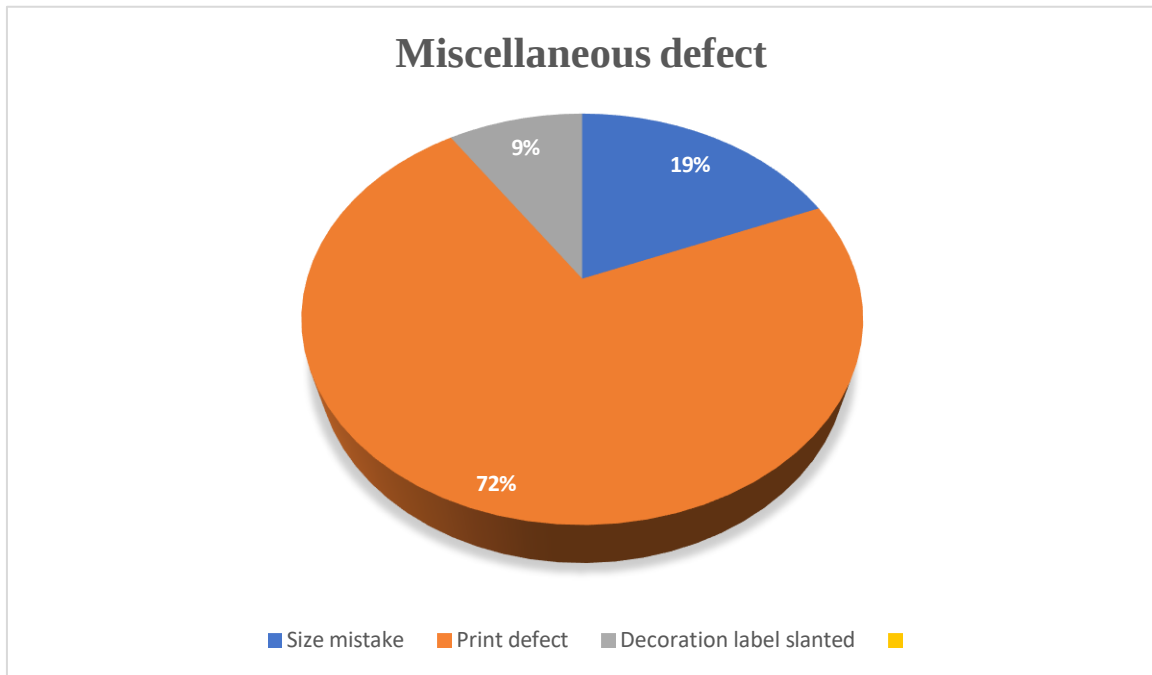
4.3.2 Percentage of Sewing defects



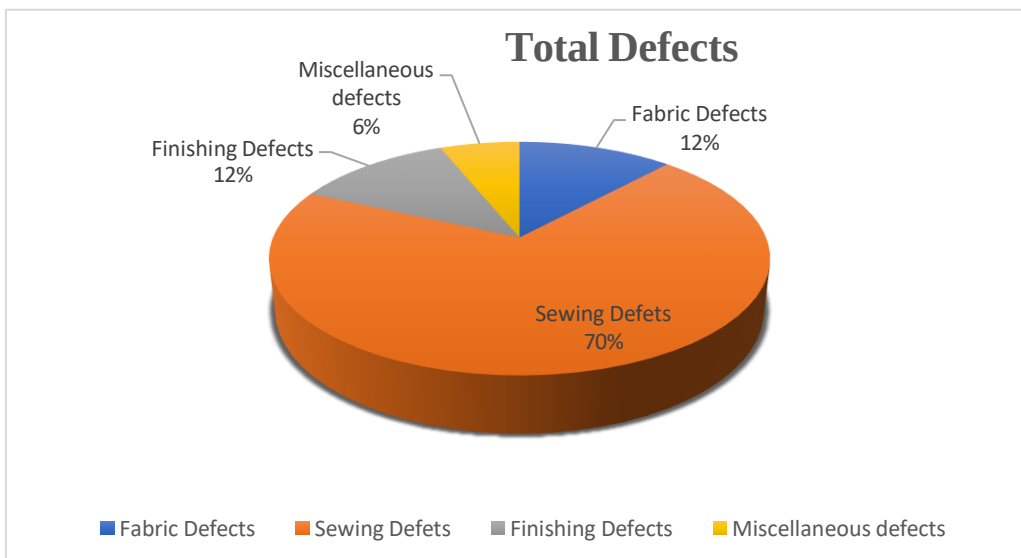
4.3.3 Percentage of finishing defect



4.3.3 Percentage of Miscellaneous defect



4.3.4 Percentage of total defects



CHAPTER-05

5.Result and Discussion

5.1 Result & Discussion

We have collected 16 final inspection reports from Trust Knitwear Industries Ltd. After then, we examined it and discovered numerous errors in various places. 11.85% of the faults were in the fabric part, 69.88% were in the sewing, 12.06% were in the finishing, and 6.06% were in other. Thus, we note that compared to other areas, the percentage of stitching errors is higher. Sewing faults and non-sewing faults are the two categories into which we separate sewing faults. Sewing errors make up a larger percentage of errors than non-sewing errors. Machine malfunctions result in sewing errors, whereas worker error or inexperienced operators cause non-sewing defects. It is a detachable finishing defect. Thus we can conclude that worker carelessness was the primary cause of the maximum defect discovered in the final random inspection.

The initial task for a new worker in Bangladesh's garment industry is to cut surplus sewing thread, regardless of gender. Subsequently, they run the machine. Worker training is not provided by the Garments Industries Administration. They consequently don't understand the cause of non-sewing errors.

We can ensure that new employees and operators know what to do by arranging for a minimum 15-day training period. An example of a non-sewing error is an improperly shaped neck. If a seamstress follows the neck measurement and sews from end to end of the neck part and body section, he will never make this mistake when sewing the neck to the body portion.

5.2 Causes and remedies of found defect

5.2.1. Causes and remedies of Fabric problem

1. Broken Yarn (9.67%)

Causes:

- Its occurred because of needle broken
- Sometimes needle can't catch the yarn, for this its occurred
- Poor yarn is also responsible for yarn miss

Remedies:

- Faulty needle should change as soon as possible
- Quality full yarn should use
- When this problem seen by operator, than machine must be off

2. Hole (24.20%)

Causes:

- The cause of holes is yarn breaking or cracking.
- The yarn splits near the needle hook during loop construction.
- In the event that the density, structure, gauge, or course of the yarn count is incorrect.
- Improperly tied spliced yarns feeder.

Remedies:

- Yarns strength needs to uniform and strong enough to resist stretching.
- Employ the correct yarn count.
- Proper yarn feeder setup.
- Knot needs to be applied correctly.

5.2.2. Cause and remedies of sewing problem

1. Uneven stitch (0.50%)

Causes:

This problem is occurred in sewing. When first time stitching is not finished then operator try to stitching again, then the problem occurred.

Remedies:

Stitching should be finished continuously.

Operator should be aware about this

2. Twisting (6.55%)

Causes:

- This problem is occurred in knitting section
- Mostly yarn is responsible for this problem
- It is happened because of high TPI (Twist per Inch)
- Operator problem

Remedies:

- Proper twisted yarn should used
- Operator in knitting department give proper command to the machine

3. Broken stitch (6.56%)

Causes:

- It is sewing section problem
- Poor machine efficiency
- Operator lack of concentration
- Feed dog is not smooth

Remedies:

- Feed dog should changed

- Skilled operator required

4. Skipped stitch (10.65%)

Causes:

- Improper threading
- Insufficient pressure
- The needle needs replacing
- Wrong size needle
- Needle size and thread weight are mismatched
- Wrong type of needle for the material

Remedies:

- Operator awareness is mostly required
- Changes the needle size
- Pressure foot and throat plate should be adjusted with needle
- Use a strobe to verify loop creation and reset to standard.

5. Neck shape poor (6.43%)

Causes:

- Poor marking;
- Wrong folding prior to neck stitching;
- Poor quality control

Remedies:

- The right marking,
- the proper folding before neck sewing,
- the use of a trained operator, and
- the proper quality check

5.2.3 Causes and remedies of Finishing problem

1. Oil spot (25%)

Causes:

- Hand dust from operators;
- lubricant oil in machine equipment;
- dirty parts used;
- natural dust

Remedies:

- Using lubricating oil appropriately
- Work floor should all times clean
- If once seen that, the oil mark is coming again and again then mechanics should required to checked the machine
- Operator should wear hand gloves during unload from knitting and many other process. Never allow the dust and impurities came into the floor

5.2.4 Causes and remedies of Miscellaneous

1. Print mistake (33%)

Causes:

- The screen paper that is used for printing should have issues.
- Issues with temperature;
- Variations in fabric kinds;
- Operator issues;
- Not applying the necessary pressure for printing

Remedies:

- • The necessary pressure must be supplied;
- the screen paper must be manufactured properly.

- Correct recipe applied
- Higher temperature does not applied in color or fabric
- Operator effectiveness needs to be raised.
- The printing method is modern or updated.

2. Size mistake (33%)

Causes :

- Attach the parts of the garment that are various sizes, such as the large body section and the small sleeve.
- Operator irresponsibility
- It may be cutting section problem when assembly the different parts, different size of body parts are kept on the table. For this operator should mistake by the mixing of size in one bundle

Remedies:

- Provide the appropriate size bundle for sewing;
- Number and bundle correctly based on actual size

CHAPTER-6

CONCLUSION

In the clothing sector, Quality control is the most crucial stages. The entire knit apparel industry quality control system is covered in this thesis. In actuality, what we are really attempting to accomplish is come up with a solution that helps Bangladeshi export clothing producers improve the quality of their export clothing and eliminate flaws that buyers find during Final Random Inspection. The final inspection stage is the end one in the clothes manufacturing process. The buyer may cancel the shipment or ask for a recheck if the final inspection report is negative. If the final inspection report is positive, the shipment will proceed. Consequently, the timely delivery of the goods and the client's pleasure depend heavily on the final inspection report.

From Trust Knitwear Industries Ltd., we gathered 16 final inspection reports. When we examined it further, we discovered numerous errors in various places. We discovered 69.88% stitching faults, 12.06% finishing faults, 6.06% miscellaneous faults, and 11.85% faults in the fabric part. Thus, compared to other areas, we notice that the percentage of stitching errors is higher. The sewing defect is separated into two categories: sewing faults and non-sewing faults. Sewing defects account for a larger percentage of errors than non-sewing issues. Machine issues give rise to sewing faults, while worker errors or inexperienced operators give rise to non-sewing faults. The flaw in finishing is detachable. Thus, the greatest fault discovered during the last random inspection took place.

This thesis report is essential reading for anyone involved in the clothing industry or studying textiles since it explains why certain garment attributes fail and how to fix them. I believe that this thesis paper might assist everyone in the apparel sector in resolving the issue of carrying this flaw in the thesis paper.

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