



Daffodil
International
University

Faculty of Engineering
Department of Textile Engineering

Thesis Report on
Investigation of Defects in Different Types of Samples

TE-4214: Project (Thesis)

Submitted By

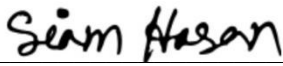
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This report presented in partial fulfillment of the requirements for the Degree of
Bachelor of Science in Textile Engineering
Advance in Apparel Manufacturing Technology

DECLARATION

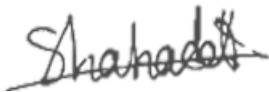
We certify that the project/thesis report presented is entirely our original work. We confirm that this report is only intended for academic purposes and not for any other use. Unless otherwise stated or acknowledged, all presented work is our own.



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LETTER OF APPROVAL

This research is titled "Investigation of Defects in Different Types of Samples" in the Garments Industry. The Thesis report was authored by Md.Siam Hasan (201-23-942) and Md.Shahadot Jaman (201-23-945). It was approved as a partial fulfillment of the requirements for the Bachelor of Science in Textile Engineering degree. It has been reviewed and is now recommended for approval and acceptance.



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ABSTRACT

This project aims to investigate defects in various types of samples in the garment industry. A factory must demonstrate its work through sampling to receive an order for mass production. If an industry delivers samples on time and to a satisfactory standard, it can generate orders and positively impact profits.

From the project's findings Measurement problems, Wrong Accessories or Accessories missing, Stitching issues, Color Shade or Print Color, Pattern problems, Parts missing problems, Puckering issues, and Button issue problems, in many different types of samples. In this report, you should identify problems, their impacts and consequences, and provide possible solutions. The project works to identify the Sample Section problem and develop workable and relevant answers.

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CHAPTER-1 Introduction

1.1 Background of the Study

The process of creating garment samples is given a lot of importance in the apparel manufacturing or export industry. This is because the approval of these samples decides if a customer will place future orders, which in turn brings in revenue for the company. In the clothing industry, sampling plays a crucial role in the pre-production process. Manufacturers create samples of various styles to get them approved, which helps in expediting the production of clothing in large quantities.

Sampling is a process that can benefit not only consumers but also manufacturers. By providing a sample, manufacturers can estimate the amount of yarn required for fabric creation, as well as the costs of dyeing, printing, and stitching are done to meet a buyer's specific design requirements. Businesses can decide to have a merchandiser work with the sample department to procure raw materials and processes for producing high-quality products at competitive prices. Another option is to have a separate sampling department that closely collaborates with the merchandiser.

During the sampling process, numerous details are considered. These include the product or style code, reference number, color requirements, fabric type, composition, description, quantity, and information about any used buttons, zippers, or other accessories. It can be said that clothing samples play a crucial role in connecting manufacturers and consumers.

The clothing sample production involves a team of professionals, including buyers, designers, manufacturing staff, quality control experts, and pricing personnel.

The export of garments requires manufacturers to develop various types of samples based on the needs of buyers. Here are the different types of samples used:

1.2 Objectives of the study:

The current investigation aims to achieve the following objectives:

- To gain knowledge about various types of sample-making systems.
- To identify the reasons behind sample failure.
- To explore the most effective ways to prevent such issues.
- To comprehend the root cause of the garment sample failure.
- To understand the type of sample that buyers demand.

1.3. Limitations of the Study

Officers and staff at various levels assisted us in various circumstances. However, depending on the research, I should explain a few issues we have encountered.

We have a few issues that we need to address:

- Our knowledge on the matter is limited and we need to work together to gather more information.
- It is impossible to learn about sample creation and identify the cause of their failure within 60 days.
- No further or out-of-date documents are accessible.

CHAPTER-2 Literature Review

2.1. History of the garments industry in Bangladesh

The garment industry in Bangladesh started its journey in the 60th decade of the 19th century and has reached its present position. In 1965–1966, the industry shipped shirts made in Karachi, known as Mercury shirts, for the first time to the European market. In 1977-78 only 9 exporting industries were available. At that time, Paris Garments, Jewel Garments, and Riaz Garments were the three biggest industries. Of all of these, Riaz Garments was the most well-known and established industry at that time.

Riaz Garments, which was owned by Mohammad Riaz Uddin, started as a tailor shop under the name Riaz Store. In 1973, the name was changed to Riaz Garments. The business started exporting goods overseas in 1978, and one million shirts were sent in 1979. Desh Garments from Bangladesh collaborated with a South Korean company named Daiyuu to innovate in the RMG sector.

Some other quiet and industrious entrepreneurs in the nation started their RMG enterprises by imitating the RMG sector's beginners. After that, Bangladesh's RMG industry continued to grow without stopping. Despite having crossed some important milestones along the way. During that period, we became aware of child labor in 1994 and effectively eliminated it from our clothing sector in 1995.

2.2. Overview of Bangladesh RMG Industry

The ready-made garments (RMG) sector has a greater potential sector than any other sector in terms of employment and foreign exchange earnings to reduce poverty and contribute to the national economy. Based on secondary data, the study is intended to draw the scenario of the RMG industry in Bangladesh, especially the growth, contribution, and challenges. This industry has an undeniable track record of success, but it also faces some significant obstacles to further expansion. The current study has investigated the many facets of the RMG industry's contribution and challenges in Bangladesh. To finish the process, descriptive study is conducted using an examination of the records that are already available. According to the study, the ready-made garment (RMG) industry has made significant contributions to the development of human capital and physical infrastructure, particularly in the last 30 years since its inception. The sector has employed around 4 million people directly and has established 4222 RMG units. Bangladesh's Ready-Made Garment (RMG) sector has played a significant role in empowering women, as it has the highest percentage of female labor force participation in Southeast Asia. Nearly 90% of the country's workforce is comprised of women. RMG also contributes significantly to the country's economy, accounting for 81% of its total export revenue and around 14.07% of the GDP.

However, there are some obstacles that need to be addressed to ensure the country's continued growth. These include low-skilled labor, inadequate infrastructure, the energy crisis, high-interest rates on bank loans, high tax rates, complex social compliance, political unrest, a lack of market and product diversification, compliance pressure from alliances and accord, and a lack of integration.

The RMG (Ready-Made Garment) industry in Bangladesh is known to employ impoverished women from rural areas with little or no education. Unfortunately, this industry has been notorious for using cheap labor and producing low-quality clothing. As a result, manufacturing high-value products remains a significant challenge. Additionally, the sector heavily relies on imported raw materials, especially for woven clothing, which leads to longer production lead times. It seems that this industry was established to provide affordable clothing products, compromising quality. Unfortunately, there is a lack of eagerness in the industry to improve technical expertise, provide training, innovate, and conduct research and development to produce high-paying and high-value products. Over time, the competitiveness of this sector decreases due to various reasons such as low motivation at work and the monotony of repeating

tasks. The RMG sector is also frequently disturbed by periodic political violence, natural disasters, or other unforeseen events. For instance, the 1998 flood damaged over 300,000 workers and caused a delay in fulfilling a \$15 million export order as scheduled (Kuddus & Rashid, 1999).

In addition to government initiatives, international brands and retailers have made significant contributions by forming the Alliance for Bangladesh Worker Safety and the Bangladesh Accord on Fire and Building Safety. In addition to internal difficulties, the global political and economic system presents difficulties for the RMG industry. For example, the RMG industry is having trouble due to the recent devaluation of the EURO compared to the USD. Bangladesh's primary export market, the EU, finds its RMG product pricey as a result. Bangladesh's exports to the United States decreased by 13.04 percent as a result of political crises such as the terrorist attack in the United States in 2001 and the slump that followed in 2004 (Abdin, 2008).

Due to its significant contributions to employment and revenue generation, this industry faces various challenges from both internal and external factors.

2.3. Development and progression of Bangladesh RMG Industry

Total export earnings from Readymade Garments (RMG) stood at USD 11739.17 million in April-June of FY23 (Woven USD 5138.45 million and Knitwear USD 6600.72 million) which was 4.22 percent lower than that of the previous quarter but 4.96 percent higher than that of the same quarter of the last year.

RMG's total export earnings in April-June of FY23 were 7.55 percent lower than the quarterly target of USD 12697.32 million.

The United States, Germany, the United Kingdom, Spain, France, Italy, the Netherlands, Canada, and Belgium were the top destinations for Bangladesh's RMG exports during April-June of FY23. From these nine countries, Bangladesh earned USD 8329.16 million from RMG, accounting for 70.95 percent of total RMG exports.

In this quarter, RMGs' net export (determined by subtracting RMG raw material import value from RMG export value) was USD 8390.70 million or 71.48 percent of gross RMG exports.

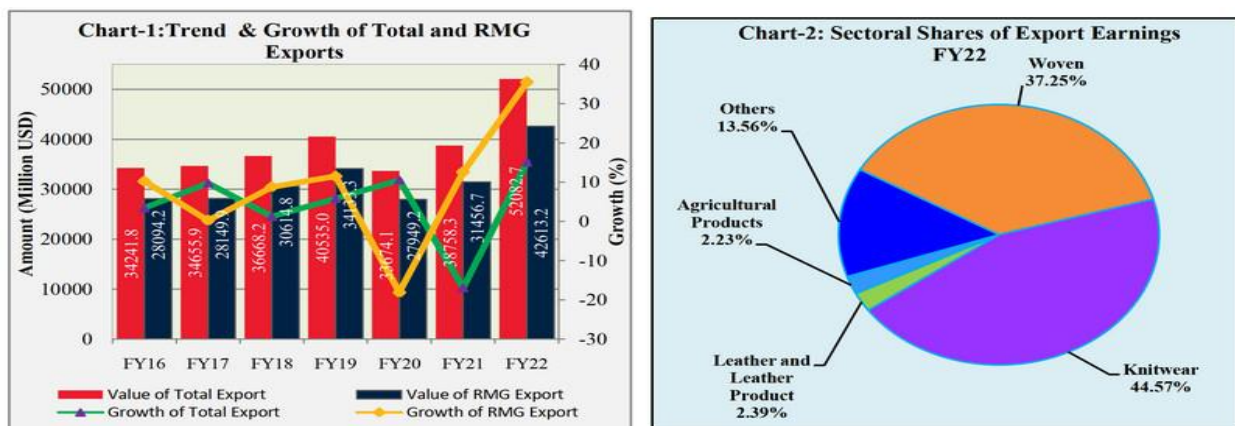


Figure 1: Development and progression of Bangladesh RMG Industry

2.4. Definition of sample

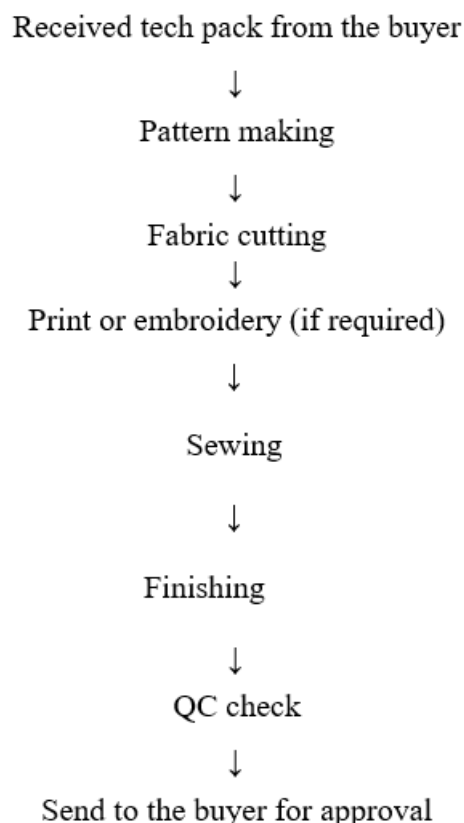
The buyer can choose how and if to confirm the order based on the sample, which is the prototype or model of the garment. The garment sample procedure is a critical step in clothing production as it helps to attract customers and confirm export orders. A corporation might have a separate section dedicated to sampling. The sampling department will be under the control of the merchandiser who deals with customers' requests and samples.

2.5. Purpose of Sample

- Gathering more information from the merchandiser about the style details.
- Checking if the pattern is feasible.
- Developing various samples and requesting the buyer's permission.
- When preparing the sample, it is important to report any quality issues to the quality control staff.
- looking for methods to reduce usage and procedures.

2.6. Process Flow Chart of Garments Sample Making

To receive an order for garment exports, it is essential to provide garment samples. The sample division of a clothing factory completes this task. Therefore, the sample department receives the highest priority among all other parts such as cutting, sewing, and finishing. To facilitate the process of an export order for a garment, A garment merchandiser should have a comprehensive understanding of the process flow chart for creating samples.



2.7. Types of sample & Uses:

Serial no.	Sample	Use
01	Proto/ Development Sample	To convert the pattern into actual garment.
02	Size set/ Grade/ Fitting Sample	To fit the styling of the garment.
03	Additional Sample (White Only) Magazine. Photo shot) garment on the rack.	All these Samples are made to show the garment of the rack
04	Contract Seal/ Seal Sample	To gain approval before the bulk Production.
05	Pre-Production (PP) sample	To gain approval before the bulk Production.
06	Production Sample	To gain approval for shipping the garment.
07	Sales Man Sample (SMS)	To gain approval for bulk production

Figure 2: Types of sample & Uses

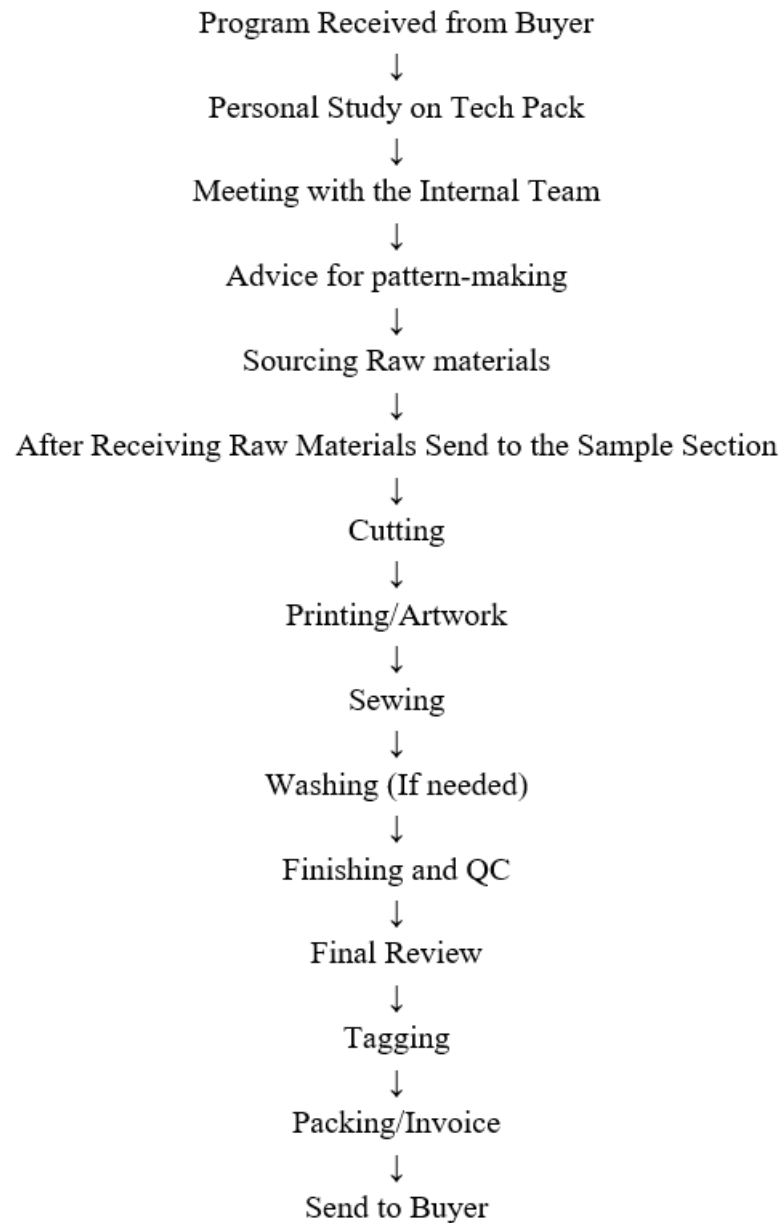
2.8. Types of Samples Required for Completing a Garments Order

To complete a garment order, eight primary types of samples are required. Those Ares-Proto sample

- Fit sample
- Size set sample
- Salesman sample
- Development sample
- Pre-Production sample
- Counter sample
- Shipment sample
- Showroom sample
- Gold seal sample
- Sealed sample

2.9. Sample Development in the Garment Industry

Process Flow Chart of Proto Sample Development in the Garment Industry



CHAPTER-3 Methodology

3.1. The buyers whose sample garments order report we had

Studied:

1. Knits only



2. 3U Intimo



3. MATALAN



4. MOUNTAIN WAREHOUSE



3.2 DATA COLLECTION:

		Customer:	Scapino
		Label:	0
Date:		Description style:	0
WL number:	0	Quality & Weight:	0
Stylenumber:	3B538	PATTERN MADE BY:	

Technical Sheet




Figure 3: Data Collection

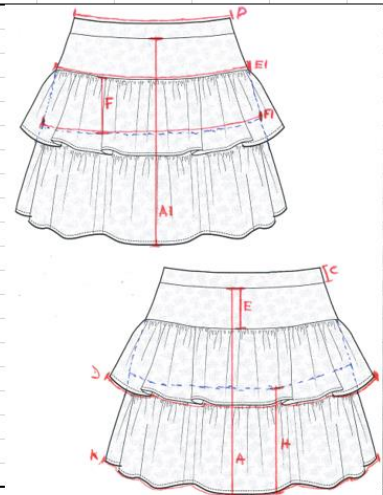
		M	M	M	
A1	Length from HSP back excl neckheight totaal	57	+0,5	62	(FIT) comments: (3-10) Fit: Top is too short, so we increased length, see ammended sizes highlighted in yellow Bottomwidth relaxed and stretched are too small, see ammended sizes highlighted in yellow. Sleeveopening relaxed we would increase into 14 cm for size M Workmanship: NECKBINDING INSIDE BACKNECK IS MISSING, PLEASE ADD IN PPS AND PRODUCTION, but please tace care we won't face problems with minimum neckstretch Trimmings: MAIN + SIZE LABEL = OK WCL = AVAILABLE, POSITION IS OK HANGERLOOPS = MISSING PRICETICKET = MISSING Fabric: AVAILABLE next step: PPS 2x size M + 1 x size XL
A3	0	0		0	
B	1/2 Chestwidth under armhole	50	v	50	
C1	Crossfront at 15cm from HSP	33	+0,75	33	
C2	Crossback at 15cm from HSP	35	v	35	
D1	Waistheight from HSP	0		0	
D2	1/2 Waistwidth	0		0	
E2	1/2 Bottomwidth straight relaxed	37	-0.5	41	
F	1/2 Bottomwidth straight stretched	49	v	55	
G	Shoulder to shoulder	38	+0,5	38	
H	Armhole depth straight	21	-0.5	21	
I	Sleevelength from shoulder	35	-0.5	35	
O	Sleevelength from CB along the shoulder	0		0	
O	Underarm lenght	0		0	
J	1/2 Bicep below armpit	22	+0,5	22	
K	1/2 Elbow 20cm below armpit	0		0	
L	1/2 Sleeve opening relaxed	13	-1	14	
L	1/2 Sleeve opening stretched	20	v	20	
M	Neckwidth straight seam till seam	21.5	-0.5	21.5	
N	Front neckdrop from HSP till seam	11	v	11	
O	Back neckdrop from HSP till seam	2.5	v	2.5	
P	Neckheight	1.2	v	1.2	
O	Cuffheight	0		0	
O	Bottomheight	0		0	
O	Forwarded shoulder	1.5	v	1.5	
O	Ruffle height at sleevehem and bottomhem	2.5	v	2.5	
O	Total ready gathering at sleeve head	12	v	12	
O	MINIMUM NECKSTRETCH?	58		58	
O	0	0			

A		B	C	D	E	F	G
KNITS ONLY 			Customer:		Scapino		
Date:			Label:		0		
WL number: 0			Description style:		0		
Stylenumber: 38538			Quality & Weight:		0		
PATTERN MADE BY:							
Technical Sheet							
							

		M	M	XL	XL	M	
A1	Length from HSP back excl neckheight totaal	62	-1	65	-1	62	(PPS) comments: (24-11)
A3	0	0		3		0	Fit:
B	1/2 Chestwidth under armhole	50	+0,5	56	+0,5	50	A few sizes marked in red are out of tolerance, please keep SPEC
C1	Crossfront at 15cm from HSP	33	-1	36	1,5	33	A few sizes changed slightly see highlighted in yellow
C2	Crossback at 15cm from HSP	35	+0,5	38	+0,5	35	
D1	Waistheight from HSP						
D2	1/2 Waistwidth						
E2	1/2 Bottomwidth straight relaxed	41	+1	47	+0,5	41	
F	1/2 Bottomwidth straight stretched	55	+0,5	61	v	55	Workmanship: OK
G	Shoulder to shoulder	38	v	41	+0,5	37	
H	Armhole depth straight	21	v	23	v	21	
I	Sleevelength from shoulder	35	+0,5	36,2	+0,8	35	Trimmings:
0	Sleevelength from CB along the shoulder						Mainlabel + Sizelabel = OK
0	Underarm lenght						WCL = OK
J	1/2 Bicep below armpit	22	-0,5	24	-0,5	22	Hangerloops are too short, please make them 16 cm
K	1/2 Elbow 20cm below armpit	0		1,5		0	
L	1/2 Sleeve opening relaxed	14	+0,5	15,5	+0,5	14	Fabric:
L	1/2 Sleeve opening stretched	20	+0,5	21,5	v	20	BULK= OK
M	Neckwidth straight seam till seam	21,5	-0,5	22,5	+0,5	20,5	
N	Front neckdrop from HSP till seam	11	-0,2	11,6	v	11	next step:
O	Back neckdrop from HSP till seam	2,5	-0,1	2,5	v	2,5	START WITH PRODUCTION AFTER ABOVE IMPROVEMENTS
P	Neckheight	1,2	v	1,2	v	1,2	SHS 4x size S
0	Cuffheight	0		0		0	Final inspection NAFISA
0	Bottomheight	0		0		0	
0	Forwarded shoulder	1,5	v	1,5	v	1,5	
0	Ruffle height at sleevehem and bottomhem	2,5	v	2,5	v	2,5	
0	Total ready gathering at sleeve head	12	v	12	v	12	
0	MINIMUM NECKSTRETCH?	58	v	58	v	58	
0	0	0		0			
0	0	0		0			
0	0	0		0			

KNITS ONLY 		Customer:	SCAPINO
Date:		Label:	0
WL number:	0	Description style:	DROP 4
Stylenumber:	35094	Quality & Weight:	JERSEY BRODERIE ANGLAISE
		Pattern made by:	

Technical Sheet



		M	M	M	
A	Length from CB excl waistband	42.5	v	42.5	(FIT) comments: (3-10)
A1	Length from CF excl waistband	42.5	v	41.5	
A3	Length from sideseam from top	0		0	
B	Waistdrop	0		0	
C	Waistband height = also elastic height inside	2.5	v	2.5	Fit: OK
D	1/2 Waistwidth relaxed	37	-1	37	
D	1/2 Waistwidth stretched	49	v	49	
E	Hipheight from CB under waistband = partitionseam	14	v	14	
E1	1/2 Hipwidth (= partitionseam)	52	v	52	Workmanship: PLEASE USE BLACK ELASTIC IN BLACK COMBO AND WHITE ELASTIC IN WHITE COMBO
F	Hip partitionseam to 2nd partitionseam = under topuffle	12	v	12	
F1	Width of 2nd partitionseam	56	+1	56	
G	Top ruffle height	18	v	18	
H	Lowest ruffle height	16.5	v	16.5	Trimmings: MAIN + SIZE LABEL = AVAILABLE WCL = AVAILABLE, POSITION IS OK HANGERLOOPS = MISSING PRICETICKET = MISSING
J	1/2 Bottom width top ruffle	82	-2	82	
K	1/2 Bottom width lowest ruffle	95	-3	95	
0	Bottom hem height	0		0	
0	Difference CB hem to Lining hem	6	v	6	Fabric: AVAILABLE
0	1/2 Bottom hem width lining	57	v	57	
0	0	0			
0	0	0			
0	0	0			next step: PPS 2x size M + 1 x size XL
0	0	0			
0	0	0			
0	0	0			

KNITS ONLY 		Customer:	SCAPINO
		Label:	0
Date:		Description style:	DROP 4
WL number:	0	Quality & Weight:	JERSEY BRODERIE ANGLAISE
Stylenumber:	3S094	Pattern made by:	

Technical Sheet



		M	M	M	XL	XL	XL	M	
A	Length from CB excl waistband	42.5	+1	+0,5	45.5	+2	v	42.5	(PPS) comments: (24-11) Fit: Ok as per samples Workmanship: OK Trimmings: Mainlable + Sizelabel = OK WCL = OK Hangerloops missing Fabric: Bulk = OK next step: START WITH PRODUCTION SHS 4x size S FINAL INSPECTION NAFISA
A1	Length from CF excl waistband	41.5	+1	-0.5	44.5	+0,5	-0.5	41.5	
A3	Length from sideseam from top	0			3			0	
B	Waistdrop	0			0			0	
C	Waistband height = also elastic height inside	2.5	v	v	2.5	v	v	2.5	
D	1/2 Waistwidth relaxed	37	+0,5	+1	43	+0,5	+1	37	
D	1/2 Waistwidth stretched	49	v	+1	55	v	+1	49	
E	Hipheight from CB under waistband = partitionseam	14	v	+0,5	15	-0.5	v	14	
E1	1/2 Hipwidth (= partitionseam)	52	v	+1	58	v	+2	52	
F	Hip partitionseam to 2nd partitionseam =under topuffle	12	v	v	13	v	-0.5	12	
F1	Width of 2nd partitionseam	56	v	v	62	v	+4	56	
G	Top ruffle height	18	+0,5	v	19	+1	+0,5	18	
H	Lowest ruffle height	16.5	v	v	17.5	+0,5	+0,5	16.5	
J	1/2 Bottom width top ruffle	82	+3	v	88	v	+1	82	
K	1/2 Bottom width lowest ruffle	95	+2	+1	101	1.5	+1	95	
0	Bottom hem height	0			0			0	
0	Difference CB hem to Lining hem	6	v	-0.5	6	v	v	6	
0	1/2 Bottom hem width lining	57	-1	-0.5	63	+1	-1	57	
0	0	0			0				

STYLE NO.: NA244003

DATE:09-10-2023

SIZE:3/4 5/6 7/8 9/10 11/12 13/14

1:1:1:1:1:1



NA244002 GIRLS 3-14y 女中童短袖短裤	3/4	5/6	7/8	10.09	1ST	9/10	11/12	13/14
胸围 1/2 chest	34	36	38	-0.5	-1	40	42	44
下摆围 1/2 bottom	37	39	41	-1	-	43	45	47
衣长 length	42	46	50	-1	-	54	58	62
袖长不含领条 sleeve length exclusive the collar tape	16.5	18.25	20	-0.5	-	21.75	23.5	25.25
袖口 sleeve opening	12.5	13	13.5	-	-	14	14.5	15
袖肥 arm width	13.5	14	14.5	-0.5	-	15	15.5	16
领宽 inner neck width	14	14	change to 15	-	-1.5	15	16	16
前领深 neck depth at front	8	8.5	change to 8.5	-	-	9	9	9.5
后领深 neck depth at back	1.5	1.5	1.5	-	-	1.5	1.5	1.5
裤长 length of shorts	25	26	27.5	-0.5	-	29	30.5	32
横裆 1/2 thigh width	21.5	23	24.5	-	-	26	27.5	29
臀围 1/2 hip	39	41	43	-	-	45	47	49
前立裆 front rise	20.5	22	23.5	-	-0.5	25	26.5	28
后立裆 back rise	27	28.5	29.5	-0.5	-	31	32.5	34
紧腰围 loose waist	24	25	26	-	-	27	28	29
裤口 leg bottom	20	21.5	23	-	-	24.5	26	27.5
腰绳中童 waist tapes	105	110	115	-	-	120	125	130
橡根宽度 Elastic	3	3	3	-	-	3	3	3



橡根宽度 Elastic	3	3	3	-	-	3	3	3
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The first samples are 7/8Y, fabrics are correct.

Cancel the placket and buttons for all sizes, only raglan shoulder.
and increase inner neck width & depth as list.

tapes are too tight on shoulders, improve the effcts.

Please resubmit T-shirt PP samples for both combos.

Embroider on chest colors and measurements are OK for each combo.

For 3/4-5/6Y ,Pocket from shoulder 13CM ,from front-center 4CM .

For 7/8-9/10Y,pocket from shoulder 14CM,from front-center 4.5CM.

sample effect is OK



add soft ironing lining at embroider back.

Printed tapes on shoulder and waistband are OK for bulks production.

shorts are OK for bulks production.

change all shorts carelabel to back rise , bellow waistband 6CM.

not at sideseams.

STYLE NO.: NA244007

SIZE:9/10 11/12 13/14 15/16

1:1:1:1



DATE:10-11-2023

NA244007女大童短袖袖短裤 GIRLS 10-16Y T-SHIRT AND SHORTS	9/10	11/12	13/14	15/16	1ST 8. 12	11.09
肩宽shoulder	32	34	36	38	-	-
胸围 1/2chest	40	42	44	46	-	-
下摆围 1/2bottom	42	44	46	48	-	-
衣长 length of T-Shirt (shorter)	50	54	58	62	-0.5	-
袖长 sleeve length	12	13	14	15	-	-
袖肥 arm width	14	15	16	17	-0.5	-
袖口 1/2 sleeve opening	12	13	14	16RE1 5	-0.5	-
领宽 neck width	15.5	16	16.5	17	-	-
前领深 neck depth at fr	8.5	9	9.5	10	-	-
后领深 neck depth at back	2	2	2	2	-	-
裤length of shorts	27	28.5	30	31.5	-	-
length at sideseam INC Waistband	25.5	27	28.5	30	+1.5	+0.5
横裆 1/2 thigh width	27	28	29	30	-0.5	-
臀围 1/2hip	47	49	51	53	-	+0.5
前立档 front rise	24	25.5	27	28.5	-0.5	-
后立档 back rise	30	31.5	33	34.5	-	-
紧腰围 loose waist	27	28	29	30	-	-



裤口 leg opening	28	29	30	31	-1	-
橡根宽度 elastic	2.5	2.5	2.5	2.5	-	-

The PP samples are 15/16Y, Farbics are correct,
Fabrics are OK, but Melange LT.grey should be improved,
it looks Weft twisted effect .
sleeves opening should be smaller 1CM.
 revised shorts are OK.



Terry Artworks widthX height 18x2.7 cm is OK for all sizes.
 9/10-11/12Y artwork from collar seam 6CM at center.
 13/14-15/16Y artwork from collare seam 7cm at center.

18-1763 should be improved
 15-3917 should be improved
 12-1708 should be improved
 11-0618 OK
 16-1459 OK

but Overall effects are OK, so accepte all colors for bulks production.

STYLE NO.: NO245009

DATE:10-11-2023

SIZE:9/10 11/12 13/14 15/16

1:1:1:1



NO245009 男大童 boys 10-16Y	9/10	11/12	13/14	15/16	firs 8.12	pp
胸围 1/2chest	41	43.5	45.5	48	-0.5	-0.5
下摆围 1/2 bottom	41	43.5	45.5	48	-1	-0.5
衣长 length T-Shirt	54	58	62	66	-	-
袖长 rangla sleeve	25	27	29	31	-1	-
袖肥 arm width	15	16	17	18	-1	-
袖口 sleeve opening	13	14	15	16	-	-
领宽 neck width (INner)	15.5	16	16.5	17	-3	-
领深 neck depth	8.5	9	9.5	10	-1	-
裤长 length shorts	33	35	37	37.5	-	-
臀围 1/2hip	45	48	51	54	-	-
前立档 front rise	26	27.5	29	30.5	-	-
后立档 back rise	32	33.5	35	36.5	-	-
横档 1/2 thigh width	27	28	29	30	-	-
裤口 1/2 leg opening	25.5	26.5	27.5	28.5	-	-
紧腰围 loose waist	27	28	29	30	-	-
裤子贴袋 宽X高 cargo pocket width X height	12x14	12x14	13.5x16	13.5x16	-/-	-

紧腰围 loose waist	27	28	29	30	-	-
裤子贴袋 宽X高 cargo pocket width X height	12x14	12x14	13.5x16	13.5x16	-/-	-
口袋盖宽X高pocket flap width	12.5X4.5	12.5X4.5	14X5	14X5	-/-	-/-

The PP samples are 15/16Y,

Fabrics are OK, but Melange LT.grey should be improved,
it looks Weft twisted effect .

Artwork widthX height 16X15.4cm is OK for all sizes.

9/10-11/12Y artwork from collar seam 6CM at center.

13/14-15/16Y artwork from collare seam 7.5cm at center.

colors are OK for each combo.

Cargo pocket is OK ,from shorts bottom 3CM.

Overlock stithings effects are OK

Cord on waistband was canceled during quotation,acceptable.

Style NO.: PH246035

SIZE:M/L/XL/XXL 2:2:1:1

STYLE: PH246035
FABRIC: 100% COTTON SINGLE JERSEY
SIZE: 16-18A
SEASON: SPRING SUMMER 2024
DESIGNER: L
DESIGNER SPEC SHEET: L

DATE:09-11-2023



PH246035	M	1st	L	PP	XL	XXL
肩宽 shoulder	53	-1	54.5	-1	56	57.5
胸围 1/2chest	54	-1	56	-	58	60
下摆围 1/2 bottom	54	-1	56	-	58	60
衣长 length T-shirt	69	-	70	-	71	72
后衣长 back length	69	-	70	-	71	72
袖长 1/2sleeve length	19	-	20	-	21	22
袖口 1/2 sleeve opening	18	-	19	-	19	20
挂肩 armhole straight	24	-	25	-	26	27
内领宽 Inner neck width	19	-3	19	-2	20	20
领深内领 neck depth	11	-	11	-	12	12
裤长 shorts length	44	-	46	-0.5	48	50
横档 1/2 thigh width	34	-1	35	-	36	37
前立档 front rise	33	-	34	-	35	36
后立档 back rise	41	-	42	-	43	44
紧腰围松量 loose waist	34	-	36	-	38	40
裤口 bottom leg	30	-	31	-	32	33
臀围 1/2hip	56	-1	58	-	60	62
橡根宽 elastic	3.5	-	3.5	-	3.5	3.5
腰头绳 waist tapes	146	-	150	-	154	158

紧腰围松量 loose waist	34	-	36	-	38	40
裤口 bottom leg	30	-	31	-	32	33
臀围 1/2hip	56	-1	58	-	60	62
橡根宽 elastic	3.5	-	3.5	-	3.5	3.5
腰头绳 waist tapes	146	-	150	-	154	158

The PP samples are L #, Fabrics are substituted.

Revise t-shirt front and back length to same.

inner neck width should be same as list.

Others are OK for bulks production.

Artwork width X height 19X8.5cm is OK for all sizes.

Artwork from collar seam 9CM at front-center is OK.

Artwork colors are OK for each combo.

6CM contrast color piece jointed on sleeves are OK.

Side opening 6cm at front hem is OK.

Drawstrings on waistband are OK for each combo.
on both side of shorts, 6.5CM melange lt. grey pieces are OK for all sizes.

STYLE NO.: NA244009

DATE:17-10-2023

SIZE: 9/10 11/12 13/14 15/16 1:1:1:1



NA244008 GIRLS 10-16Y T-SHIRT AND	9/10	11/12	13/14	15/16	10. 17	1st 8. 14
落肩宽 Dropped shoulder	39	41	43	45	-1	-
胸围 1/2chest	42	44	46	48	-0.5	-
下摆围 1/2bottom	42	44	46	48	-	+0.5
衣长 length of T-Shirt (shorter)	46	49	52	55	-1	-
袖长 sleeve length	12	13	14	15	-0.5	-
袖肥 arm width	15.5	16.5	17.5	18.5	-0.5	-
袖口 1/2 sleeve opening	14	15	16	17	-	-
领宽 inner-neck width	16	16.5	17	17.5	-1.5	-1
前领深 neck depth at fr	9	9	10	10	-0.5	-
后领深 neck depth at back	2	2	2	2	-	-
裤长length of shorts	31	32.5	34	35.5	-	-
横裆 1/2 thigh width	26	27	28	29	-1	-1
臀围 1/2hip	47	49	51	53	-1	-1
前立裆 front rise	25	26.5	28	29.5	-	+0.5
后立裆 back rise	31	32.5	34	35.5	-	-
紧腰围 loose waist	27	28	29	30	-	-
裤口 leg opening	24.5	25.5	26.5	27.5	-1	-0.5
橡根宽度 elastic	2.5	2.5	2.5	2.5	-	-

前立裆 front rise	25	26.5	28	29.5	-	-
紧腰围 loose waist	27	28	29	30	-	-
裤口 leg opening	24.5	25.5	26.5	27.5	-1	-0.5
橡根宽度 elastic	2.5	2.5	2.5	2.5	-	-

PP samples are 15/16Y,

Fabrics are correct.

collar to 1.5CM joint pattern is OK,

But inner-neck width should be correct as list, sample is too small.

shorts fabrics covered seam is OK.

Dropped shoulders and sleeves effects are OK.

Shorts thigh width ,1/2 hip are smaller , should be improve at bulks

Artwork widthX height 20x14.3 cm is OK for all sizes.

9/10-11/12Y artwork from collar seam 6CM at center.

13/14-15/16Y artwork from collare seam 7cm at center.

Artworks on samples are OK for each combo.

Style No.: NO245001

Date:16-10-2023

SIZE:3/4 5/6 7/8 9/10 11/12 13/14

1:1:1:1:1:1



NO245001	3/4	5/6	7/8	10 1/6	1st	9/10	11/12	13/14
肩宽 shoulder	28	30	32	-0.5	-0.5	34	36	38
胸围 1/2chest	35	37	39	-	-1	41	43	45
下摆围 1/2 bottom	35	37	39	-	-	41	43	45
衣长 length of T-shirt	42	46	50	-1	-0.5	54	58	62
上拼片高 yoke height	14	15.3	16.6	-0.5	-	18	19.3	20.5
袖长 length sleeves	10.5	11.5	12.5	-	-	13.5	14.5	15.5
袖口 sleeve opening	12	12.75	13.5	+0.5	-	14.5	15.25	16
挂肩 arm hole straight	15	16	17	-0.5	-	18	19	20
领宽 inne neck width	13.5	14	14.5	-1	-3	15	15.5	16
领深 neck depth	7.5	7.5	8	-	-	8	8.5	9
裤长 length shorts	26	27.5	29	-1.5	-0.5	30.5	32	33.5
横档 1/2 thigh width	22	23.5	25	-	-	26	27.5	29
前立档 front rise	21	22	23.5	-	+0.5	25	26.5	28
后立档 back rise	27	28	29.5	-	+0.5	31	32.5	34
臀围 1/2 hip	38	40	42	-	-	44	47	50
紧腰围 loose waist	24	25	26	-	+1	27	28	29
裤口 leg opening	20	21.5	23	-	-	24.5	26	27.5
art work height	3.6	3.6	3.6	-	-	4.5	4.5	4.5
腰头橡根 elastic	3	3	3	-	-	3	3	3

臀围 1/2 hip	38	40	42	-	-	44	47	50
紧腰围 loose waist	24	25	26	-	+1	27	28	29
裤口 leg opening	20	21.5	23	-	-	24.5	26	27.5
art work height	3.6	3.6	3.6	-	-	4.5	4.5	4.5
腰头橡根 elastic	3	3	3	-	-	3	3	3

PP samples are 7/8Y, fabrics are correct.

Patterns are OK for bulks production.

Front and back yoke pieces effect is Ok

T-shirt and shorts length should be same as list, samples are shorter.

Artworks colors are OK for each combo.

width 10.56cm height 3.6CM for 3/4-7/8Y as sample , effects are OK.

width 13.29cm height 4.53cm for 9/10-13/14Y.

shorts are OK.

Elastic waistbands on samples are OK for each combo.



STYLE NO.: NO245002

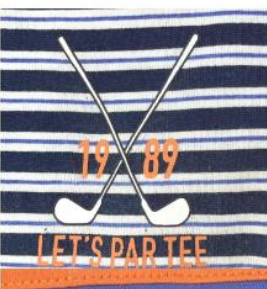
SIZE:3/4 5/6 7/8 9/10 11/12 13/

1:1:1:1:1:1



DATE:16-10-2023

NO245002 男中童	3/4	5/6	7/8	10.1	B	9/10	####	13/1
肩宽 shoulder	28	30	32	-	-0.5	34	36	38
胸围 1/2chest	35	37	39	-	-	41	43	45
下摆围 1/2 bottom	35	37	39	-	-0.5	41	43	45
衣长 length T-Shirt	42	46	50	-0.5	-	54	58	62
B组上拼片高	9.5	9.5	11	-	-	12	13	14
Combo B Uper yoke								
中间拼片高 white	6.5	6.5	6.5	-	-	7	7	7
joint piece								
袖长 sleeve length	10.5	11.5	12.5	-	-	13.5	14.5	15.5
袖口 sleeve opening	12	12.7	13.5	-	-	14.5	15.3	16
		5						
挂肩 arm hole straight	15	16	17	-	-	18	19	20
领宽inner neck width	13.5	14	14.5	-	-0.5	15	15.5	16
领深 neck depth	7.5	7.5	8	-	-	8	8.5	9
裤长 length shorts	26	27.5	29	-1	-1	30.5	32	33.5
横档 1/2 thigh width	22	23.5	25	-0.5	-0.5	26	27.5	29
前立档 front rise	21	22	23.5	-	-	25	26.5	28
后立档 back rise	27	28	29.5	-	-	31	32.5	34
臀围 1/2hip	38	40	42	-	-	44	47	50
紧腰围 loose waist	24	25	26	-	-	27	28	29
裤口 1/2 leg opening	20	21.5	23	-	-	24.5	26	27.5
局印高 artwork1 heigh	4.2CM	5cm	-	-	-	5cm		
腰头橡根 elastic	3	3	3	-	-	3	3	3
腰头绳 waist tapes	104	108	112	-	-	113	120	124



COMBO A PP samples are 7/8Y, fabrics are correct.
Patterns are OK for bulks production.

Artwork from shoulder 14cm ,from front -center 4.5CM for 3/4-5/6Y

for 7/8-9/10Y from shoulder 15CM ,from front -center 5cm ,
as sample is OK.

for 11/12-13/14Y from shoulder 16CM,from front-center 5CM.
Shorts are OK with pockets.

COMBO B pp samples are 7/8Y, fabrics are correct
Artwork1# at chest piece center ,
from front -center 4.5CM for 3/4-5/6Y
for 7/8-9/10Y,from front -center 5cm ,as sample is OK.
for 11/12-13/14Y ,from front-center 5CM.

Shorts are OK with pockets.

Artwork 2# at right leg are OK

From hem 2CM, from side seam 3CM for all sizes.

Drawstring on waistband are approved for both combos.

STYLE NO.: NO245010

SIZE:9/10 11/12 13/14 15/16

1:1:1:1

STYLE NO: NO245010
T-SHIRT (10-16Y) (10-16Y)
SHORTS (10-16Y) (10-16Y)
COLOR: 10-16Y (10-16Y)
10-16Y (10-16Y)
10-16Y (10-16Y)
10-16Y (10-16Y)

DATE:17-10-2023



NO245010 男大童 boys 10-16Y	9/10	11/12	13/14	15/16	10.17	1st
肩宽 Regular shoulder	33	35	37	39	-	-
胸围 1/2chest	41	43.5	45.5	48	-1	-0.5
下摆围 1/2 bottom	41	43.5	45.5	48	-	-
衣长 length T-Shirt	53	57	61	65	-0.5	-
袖长 sleeve length	13.5	14.75	16	17.5	-	-0.5
袖口 sleeve opening	14.5	15.5	16.5	17.5	-	-
领宽 neck width	15.5	16	16.5	17	-	-3
挂肩 arm hole straight	18	19	20	21	-	-
领深 neck depth	8.5	9	9.5	10	-	-
裤长 length shorts	32	34	36	38	-0.5	-
横档 1/2 thigh width	27	28.5	30	31.5	-0.5	-
前立档 front rise	26	27.5	29	30.5	-	-
后立档 back rise	32	33.5	35	36.5	-	-
裤口 1/2 leg opening	25	26.5	28	29.5	-	-
紧腰围 loose waist	27	28	29	30	-	-
臀围 1/2hip	44	47	50	53	-	-
腰头绳 waist tapes	120CM		130cm			

PP samples are 15/16Y,



腰头绳 waist tapes	120CM	130cm
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PP samples are 15/16Y,

Fabrics are correct.

Patterns are OK for bulks production.

Artwork height 12.75 cm is OK for all sizes.

9/10-11/12Y artwork from collar seam 5CM at center.

13/14-15/16Y artwork from collare seam 6cm at center.

colors of artwork on samples are OK for each combo.

Cord on waistband are OK ,for both combos.

Style No.PH246023

SIZE:M/L/XL/XXL 2:2:1:1

STYLE: PH246023
FABRIC: 100 GSM TC DRINKS JERSEY
SIZE: M, XL
MEASUREMENTS: 100/100/100
DESIGNER: J. J. J. J. J.
DESIGNER: J. J. J. J. J.

MAN

DATE:17-10-2023



PH246023	M	1ST	L	10.17	XL	XXL
肩宽 shoulder	53	-	54.5	-	56	57.5
胸围 1/2chest	56	-0.5	58	-1	6	62
下摆围 1/2 bottom	56	-	58	-1	60	62
衣长 length T-shirt	70	-	71	-1	72	73
袖长 sleeve length	19	-	20	-	21	22
袖口 sleeve opening	18.5	-	19.5	-	20.5	21.5
挂肩 armhole straight	24	-	25	-	26	27
内领宽 inner-neck	19	-3	19	-1	20	20
领深内领 neck depth	11	-	11	-0.5	12	12
裤长 shorts length	44	-	46	-0.5	48	50
横档 1/2 thigh width	34	-0.5	35	-1	36	37
前立档 front rise	33	-	34	-	35	36
后立档 back rise	41	-	42	-	43	44
紧腰围松量 loose waist	34	-	36	-	38	40
裤口 bottom leg	30	-	31	-	32	33
臀围 1/2hip	58	-	60	-	62	64
折边 edgefold	2.5	-	2.5	-	2.5	2.5
橡根宽 elastic	3.5	-	3.5	-	3.5	3.5
腰绳长 tape on waist	148	-	148	-	156	156

PH246023 PP samples



PH246023	M	1ST	L	10.17	XL	XXL
臀围 1/2hip	58	-	60	-	62	64
折边 edgefold	2.5	-	2.5	-	2.5	2.5
橡根宽 elastic	3.5	-	3.5	-	3.5	3.5
腰绳长 tape on waist	148	-	148	-	156	156

PP samples are L#,

Fabrics are correct, patterns are OK.

Patterns are OK for bulks production.

Correct all measurements same as list in bulks,
especially inner-neck width, sample is smaller 1CM .

Artwork at front-center under collar seam 9CM is OK for all sizes.

Colors of artworks are OK for each combo.

Tapes on waistband are green a bit,

but we approved it for both combos.

Shorts pockets and 3CM decorate are OK .

STYLE NO.:PH246027

SIZE;M/L/XL/XXL

2:2:1:1



DATE:25-10-2023

PH246027	M	1ST	L	10.3	XL	XXL
肩宽 shoulder	45	-	46.5	-0.5	48	49.5
胸围 1/2chest	54	-	56	-	58	60
前片拼接高 White York height	7	-	7	-	7	7
white chest piece from shoulder	19	-	19	-	20	20
york height at back	17	-	17	-	18	18
下摆围 1/2 bottom	54	-	56	-0.5	58	60
衣长 length T-shirt	70	-	72	-1	74	76
袖长 sleeve length	23	-	24	-	25	26
袖口 sleeve opening	18	-	19	-0.5	19	20
挂肩 armhole straight	25	-	26	-0.5	27	28
内领宽 neck width	18	-3	18	-	19	19
领深内领 neck depth	10	-	10	-	11	11
裤长 shorts length	44	-	46	-1	48	50
横档 1/2 thigh width	34	-	35	-	36	37
前立档 front rise	33	-	34	-	35	36
后立档 back rise	41	-	42	-	43	44



臀围 1/2hip	58	-	60	-0.5	62	64
折边 edgefold	2.5	-	2.5	-	2.5	2.5
橡根宽 elastic	3.5	-	3.5	-	3.5	3.5
tape on waistband	150	-	150	-	155	155

PP samples are M#,Fabrics are correct.

Patterns are OK

M-L# white piece from shoulder 19CM.

XL-XXL# white picce form shoulder 20CM.

Back york heigth effect is OK .

artwork 1# at chest position is OK.

colors are OK for each combo.

At left leg „Move down artwork 2# 1CM ,

M from top of waistband 20CM, OK on the 1st.

L from top of waistband 21CM,

XL from top of waistband 22CM.

XXL from top of waistband 23CM.

1.5CM cotton herringbone on waistband tape ,

in color 17-5513 is OK for both combos.

shorts are OK with pockets.

TWINS ASIA LTD
PRE – PRODUCTION SAMPLE COMMENT

	RESULT		Status of Sample Reviewing									
✓	APPROVED		Receiving Date: 17 Dec 2023									
	REJECTED		Comments Date: 18 Dec 2023									
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Buyer: MATALAN</td> <td style="width: 33%;">Department: Ladies</td> <td style="width: 33%;">Factory : Cotton Field</td> </tr> <tr> <td>Style : RFS24TP901</td> <td>Fabrication: 100% Cotton, S/J GSM 120.</td> <td>Product Item: SS print floral Gypsy top</td> </tr> <tr> <td>Sizes: 12</td> <td>Qty: 2115 Unit</td> <td>Ship Date: 10 Jan 2024</td> </tr> </table>				Buyer: MATALAN	Department: Ladies	Factory : Cotton Field	Style : RFS24TP901	Fabrication: 100% Cotton, S/J GSM 120.	Product Item: SS print floral Gypsy top	Sizes: 12	Qty: 2115 Unit	Ship Date: 10 Jan 2024
Buyer: MATALAN	Department: Ladies	Factory : Cotton Field										
Style : RFS24TP901	Fabrication: 100% Cotton, S/J GSM 120.	Product Item: SS print floral Gypsy top										
Sizes: 12	Qty: 2115 Unit	Ship Date: 10 Jan 2024										
<u>Line code: multi aop F466581</u> <u>Further color, checked with gold seal comments.</u> Comments after Dummy Checked : OK Comments after Overall Review : # Chest +1.5cm, BNW +2cm please follow spec correctly. # Bad smell on fabric, please take care during print and check before cutting. # Hem frill depth keep even all around at 2cm correctly. # Ensure having lock stitch on smoking thread edge where closing at side PP sample ok. # Armhole shape as V close to armpit please make shape as U for G/S and bulk. # Ensure hanger loop is attaching correctly at side neck point not to front or back as pp. # During smoking panel join, ensure depth is even all around on pp sample found uneven. # Grain line keep straight during cutting. # Fabric must keep relax minimum 24 hours prior the bulk cutting. All trims and fabric s/b follow as per approve by twins Asia concern merchant before bulk. Packing is 3s <u>Ensure packing properly and ensure no any crease mark issue from buyer end.</u>												
<u>Technician: Ashraf Mukul</u>		<u>Merchandiser: Mr. Sudepta</u>										

TWINS ASIA LTD

PRE – PRODUCTION SAMPLE COMMENT

	RESULT		Status of Sample Reviewing
✓	APPROVED		Receiving Date: 11 Dec. 2023
	REJECTED		Release Result Date: 11 Dec. 2023

Buyer: MATALAN	Department: Essential	Style: KWS24OGN - 07
Vendor: Mondol	Factory: Cotton field	Item: Tee and Shorts set
Size: 7y and 10y	Qty: 7098 Sets.	Ship Date: 06 Dec. 2023

Fabric type- 95%cotton / 5%elastane and 180 gsm.

pp sample checked based on red seal comments

Revised P.P sample approved with below comments: - Dummy Check--- ☐

Tee -

- The neck rib color still not match with body base color on pp sample should be properly match on bulk.
- Back neck tape stitch is cracked on pp sample should be properly adjust machine tension on sewing time.
- Puckered at the neck seam area on pp sample should be puckering free.
- The neck shape is uneven and hi low at side neck point on pp. sample should be keep rounded and to avoid hi low on bulk.

Shorts -

- Uneven shirring at waistband and frill attached seam area on pp sample, which is not accepted should be even shirring all around on bulk.
- Ensure the frill not pressed flat and is of even depth on bulk.
- Too over pressed at the out seam on pp sample should be to avoid during iron on bulk.
- All trims and fabrics should be approval from TWINS ASIA concern merchandiser before start production.

TWINS ASIA LTD

PRE – PRODUCTION SAMPLE COMMENT

	RESULT		Status of Sample Reviewing
✓	APPROVED		Receiving Date: 13 Dec 2023
	REJECTED		Comments Date: 14 Dec 2023
Buyer: MATALAN		Department: Ladies	Factory : Cotton Field
Style : RFS24TP907		Fabrication: 100% Cotton, S/J GSM 120.	Product Item: SS solid Gypsy top
Sizes: 12, 18		Qty: 19720	Ship Date: 10 Jan 2024

Line code: Blue F466388 White F466389

Further color, checked with gold seal comments.

Comments after Dummy Checked : OK

Comments after Overall Review :

Neck opening along edge -1.5 on white, please follow spec correctly.

Hem smoking slack, not as previous G/S sample please follow existing G/S in bulk.

Hem frill depth keep even all around at 2cm correctly.

Ensure having lock stitch on smoking thread edge where closing at side PP sample ok.

Armhole shape as V close to armpit please make shape as U for G/S and bulk.

Ensure hanger loop is attaching correctly at side neck point not to front or back as pp.

During smoking panel join, ensure depth is even all around on pp sample found uneven.

Grain line keep straight during cutting.

Fabric must keep relax minimum 24 hours prior the bulk cutting.

All trims and fabric s/b follow as per approve by twins Asia concern merchant before bulk.

Ensure packing properly and ensure no any crease mark issue from buyer end.

TWINS ASIA LTD

PRE – PRODUCTION SAMPLE COMMENT

	RESULT		Status of Sample Reviewing
✓	APPROVED		Receiving Date: 13 Dec 2023
	REJECTED		Comments Date: 14 Dec 2023
Buyer: MATALAN		Department: Ladies	Factory : Cotton Field
Style : RFS24TP901		Fabrication: 100% Cotton, S/J GSM 120.	Product Item: SS print floral Gypsy top
Sizes: 12, 18		Qty: 33960	Ship Date: 10 Jan 2024
<u>Line code multi aop F466290 Yellow aop F466291</u> <u>Further color, checked with gold seal comments.</u> Comments after Dummy Checked : OK Comments after Overall Review : # Chest +2cm, Back neck drop -1cm and hanger loop +2cm please follow spec correctly. # Hem smoking slack, not as previous G/S sample please follow existing G/S in bulk. # Bad smell on multi aop, please take care during dying and check before cutting. * Hem frill depth keep even all around at 2cm correctly. * Ensure having lock stitch on smoking thread edge where closing at side PP sample ok. * Armhole shape as V close to armpit please make shape as U for G/S and bulk. * Ensure hanger loop is attaching correctly at side neck point not to front or back as pp. * During smoking panel join, ensure depth is even all around on pp sample found uneven. * Grain line keep straight during cutting. * Fabric must keep relax minimum 24 hours prior the bulk cutting. All trims and fabric s/b follow as per approve by twins Asia concern merchant before bulk. <u>Ensure packing properly and ensure no any crease mark issue from buyer end.</u>			
<u>Technician: Ashraf Mukul</u>		<u>Merchandiser: Mr. Sudeepa</u>	

TWINS ASIA LTD

PRE – PRODUCTION SAMPLE COMMENT

	RESULT		Status of Sample Reviewing
✓	APPROVED		Receiving Date: 23 Jan 2024
	REJECTED		Comments Date: 23 Jan 2024
Buyer: MATALAN		Department: Ladies	Factory : Cotton Field
Style : RFS24TP901		Fabrication: 100% Cotton, S/J GSM 120.	Product Item: SS print floral Gypsy top
Sizes: 12		Qty: 9240	Ship Date: 24 Jan 2024

Line code multi aop F466606

Further color, checked with gold seal comments.

Comments after Dummy Checked : OK

Comments after Overall Review :

Chest +2cm, Back neck width -4cm and hem frill depth -0.5cm please

Follow spec correctly. Hem frill depth keep even all around at 2cm correctly.

* Ensure having lock stitch on smoking thread edge where closing at side PP sample ok.

* Ensure hanger loop is attaching correctly at side neck point not to front or back as pp.

* During smoking panel join, ensure depth is even all around on pp sample found uneven.

* Grain line keep straight during cutting.

*Fabric must keep relax minimum 24 hours prior the bulk cutting.

All trims and fabric s/b follow as per approve by twins Asia concern merchant before bulk.

Ensure packing properly and ensure no any crease mark issue from buyer end.



PROTO FIT COMMENTS : 17.08.23

SAMPLE DATED :

FIT

1. Hem is not level and is distorted below pocket / at CF zip
2. Length is short, increase 3cm to bring back to spec
3. Kangaroo pocket at front is small, bring all pocket measurement back to spec
4. Raglan shape to be more of an S shape, see photo of pink fleece to refer to
5. Front raglan is short, increase 1.5cm to bring back to spec
6. Bicep is tight, increase 1cm to bring back to spec
7. Hood is small, bring hood height and width back to spec
8. Hood arc is small, increase 6cm to bring back to spec
9. Reduce hood stand depth 0.5 to stop catching at chin

MAKE

1. Hood to be without borg lining
2. Add back neck compass branding as per buying stylebook
3. Zip insertion to be improved currently curving at hem

Please submit 5/6yrs 1st fit following all above comments

Please ensure risk assessment is completed and sent before new sample arrives in office

Please confirm what zips you are using for bulk



2ND FIT 09.11.2023:

SAMPLE DATED: 02.11.2023

FIT

1. Hood opening wide, control stitching to ensure you are not stretching
2. Back neck drop is low, raise 1.5cm to bring back to spec
3. Hood arc is long, reduce 1.5cm to measure 41.5cm

CONSTRUCTION/MAKE

1. Improve zip insertion, currently wavy on sample

Please submit 5/6, 9/10 and 11/12 PP following above comments

Please ensure all testing is sent at PP stage and ensure workbook is completed



PP FIT - SIZE SET : 05.12.2023

SAMPLES DATED : 26.11.23

FIT

1. I have remeasured your samples as the measurements given by you are not accurate. Please take care when measuring to ensure all measurements are recorded correctly so that necessary corrections can be made.
2. Across chest and hem are not to specs on all sizes. Please correct in production.
3. Raglan length to be brought back to specs as these plus to specs, and issue is worse on the larger sizes. Please check your patterns and grading are correct.
4. Biceps are looking wide, please check these are brought back to specs once raglan armholes are corrected
5. Sleeve length looks long on age 5-6 due to neck width being +1cm, please bring both back to specs in production.
6. Sleeve length looks too short on 11-12y and is -0.9cm, neck width is +0.6cm, please bring both back to specs in production.
7. Pocket positioning ok on 5-6y, but is looking high on the 9-10y and 11-12y. Please lower pockets on larger sizes to bring back to specs.

CONSTRUCTION

1. Ensure pocket opening are not stretched-off in stitching to avoid them gaping. Pocket opening on 9-10y is gaping and this needs controlling
2. Hems are very uneven and this is being made worse by poor zip insertion. Please improve 100%
3. Ensure hem is level either side of CF zip Samples are all longer on RHS as worn.
4. Check zip length are not too short to avoid distortion occurring at CF.
5. Please ensure pocket corners are secure and cannot come away / unstitched in use.
6. Gros-grain tape zip puller is too narrow. It is only 0.5cm wide, please check with buying as to correct width required in bulk

OUTSTANDING

1. GARMENT APPEARANCE AFTER WASH - PASSED REPORT NEEDED
2. CF TESTS FOR TURQUOISE
3. COMPLETED US CPC
4. ADDITIONAL TESTS FOR KIDS

PP APPROVED WITH COMMENTS

SUBMIT SHS IN AGE 5-6Y ONCE ALL TESTING HAS BEEN RECEIVED AND APPROVED.





PROTO FIT 13.07.2023:

Sample dated 08.06.2023

FIT

Sleeve length long, reduce 1.5cm to be 48cm

Back raglan too long, reduce 1cm to bring back to spec

Distance between back raglans at neck seam is too narrow increase 3cm to be 10cm

Distance between front raglans at neck seam is narrow increase 1cm to bring back to spec

Bicep tight increase 1cm to be 14cm

Front neck drop is high, lower 1cm to bring back to spec

Back neck width correct as per sample, spec has been updated

Collar depth is small, increase 1cm to bring back to spec at 6cm

Pocket opening is too high on sample, lower by 2cm to be 27 from SNP

Pocket opening is small, increase to be 13cm

Pocket welt is too narrow, width needs to be 2cm

Zip pull length to measure 4cm

MAKE

Collar wavy and messy improve make

Add bartack to zip pull as per photo

Zip insertion to be improved, seeing more tape on LSAW

Please submit 1st fit following the above in 5/6yrs

Please submit Risk assessment

Please confirm what zip supplier you will be using





1ST FIT:07.09.23

Sample dated : 28.08.23

FIT

1. Collar depth looks too deep. Reduce 1cm to measure 5cm
2. Neck wide, bring back neck width back to spec by increase 0.5cm
3. Glazing at seams on pocket, correct and control

MAKE

1. Fabric zip pull long, reduce 0.5cm to measure 4.5cm
2. Chest branding position to match branding guidelines
3. Embroidery backing paper to be fully removed
4. Improve zip insertion at CF, currently dragging on sample

Please submit PP sample following above comments in 5/6, 9/10 and 11/12Y

Please fill out Risk Assessment and send before new sample arrives in office

Please submit all testing at PP stage, we cannot approve PP without all testing approved





PP FIT 09.11.2023:

SAMPLE DATED: 02.11.2023

FIT

1. Dragging occurring at CF, improve zip insertion on all sizes
2. Sleeve length long on 5/6 and 9/10, increase 1cm on 5/6 and 1.2cm on 9/10
3. Front neck drop high, lower 1cm on 5/6

CONSTRUCTION/MAKE

1. Ensure branding at chest is level on all sizes currently dropping on 11/12
2. Ensure you do not over press samples as there is impression at the pockets
3. Improve neck shaping on all sizes ensure stitch tension is the same throughout

Please submit 5/6 SHS following all above comments

Please ensure you have filled out all of the workbook before SHS as we cannot approve SHS without all testing and everything completed

Ensure you have actioned a V-Trust on the 1st production line



1ST FIT:07.09.23

Sample dated : 28.08.23

FIT

1. Collar depth looks too deep. Reduce 1cm to measure 5cm
2. Neck wide, bring back neck width back to spec by increase 0.5cm
3. Glazing at seams on pocket, correct and control

MAKE

1. Fabric zip pull long, reduce 0.5cm to measure 4.5cm
2. Chest branding position to match branding guidelines
3. Embroidery backing paper to be fully removed
4. Improve zip insertion at CF, currently dragging on sample

Please submit PP sample following above comments in 5/6, 9/10 and 11/12Y

Please fill out Risk Assessment and send before new sample arrives in office

Please submit all testing at PP stage, we cannot approve PP without all testing approved

Figure 4: Data Collection

3.3. The number of the report analysis

Buyer name	S.no	Style no.	Garments Type	Type of Sample								
					A	B	C	D	E	F	G	H
Knits only	1	3B538	Top & Skirt	FIT	x					x	x	
Knits only	2	3B538	Top & Skirt	PP	x						x	
Knits only	3	3S094	Top & Skirt	FIT	x							
3U Intimo	4	NA244003	Kids T-shirt & shorts	pp	x		x				x	
3U Intimo	5	NA244007	Kids T-shirt & shorts	pp				x			x	
3U Intimo	6	NO245009	Kids T-shirt & shorts	pp				x				
3U Intimo	7	PH246035	Kids T-shirt & shorts	PP							x	
3U Intimo	8	NA244009	Kids T-shirt & shorts	PP							x	
3U Intimo	9	NO245001	Kids T-shirt & shorts	pp					x		x	
3U Intimo	10	NO245002	Kids T-shirt & shorts	pp					x		x	
3U Intimo	11	NO245010	Kids T-shirt & shorts	pp					x		x	
3U Intimo	12	PH246023	Kids T-shirt & shorts	pp							x	
3U Intimo	13	PH246027	Kids T-shirt & shorts	pp							x	
MATALAN	14	KWS240G N-07	Tee and Shorts set	PP		x		x				x
MATALAN	15	RFS24TP9 01	Gypsy Top	Gold Seal				x			x	
MATALAN	16	RFS24TP9 01	Gypsy Top	Gold Seal							x	x
MATALAN	17	RFS24TP9 07	Tee and Shorts set	Gold Seal							x	x
MOUNTAIN WAREHOUSE	18	MWF-67537	KIDS JACKET	FIT							x	
MOUNTAIN WAREHOUSE	19	MWF-67537	KIDS JACKET	PP							x	x
MOUNTAIN WAREHOUSE	20	MWF-67546	KIDS HOODIE	FIT						x	x	
Total					4	1	1	4	3	2	17	4

CHAPTER-4 Result and Discussion

4.1 Result and Discussion

The provided section contains details on how to create a sample, as well as comments from buyers. We seen a range of remarks regarding the sample and the number of issues that occurred during sampling. Sampling presents some challenges, including issues with measurement, Wrong Accessories or Accessories missing, Stitching issues, Color Shade or Print Color, Pattern problems, Parts missing, Puckering issues, Button issues, and many more. Based on our research, we have found that the main problem is related to the measurement issue. This leads to numerous unsuccessful samples. Therefore, the pattern department and QC should work more to solve these problems meticulously.

4.2 Calculation of Fault Percentage

Fault Percentage = (No. of Particular Fault $\times$ 100) $\div$ Total Fault

Example: Measurement

$$= (17 \times 100) \div 36$$

$$= 46.2\%$$

4.3 Reason for the Sample Failure:

S.no	Name of the categories of faults:	No. of samples failed
01	Measurement	17
02	Wrong Accessories or Accessories missing	4
03	Stitching issue	4
04	Color Shade or Print Color	4
05	Pattern problem	3
06	Parts missing	2
07	Puckering issue	1
08	Button issue	1
	Total	36

4.4 Report of the percentage of fault

Fault	%
Measurement	46.2%
Wrong Accessories or Accessories missing	11.1%
Sewing problem	11.1%
Colour Shade or Print Colour	11.1%
Pattern problem	8.3%
Parts missing	5.6%
Puckering issue	2.8%
Button issue	2.8%

4.5 Graphical view of sample failure data

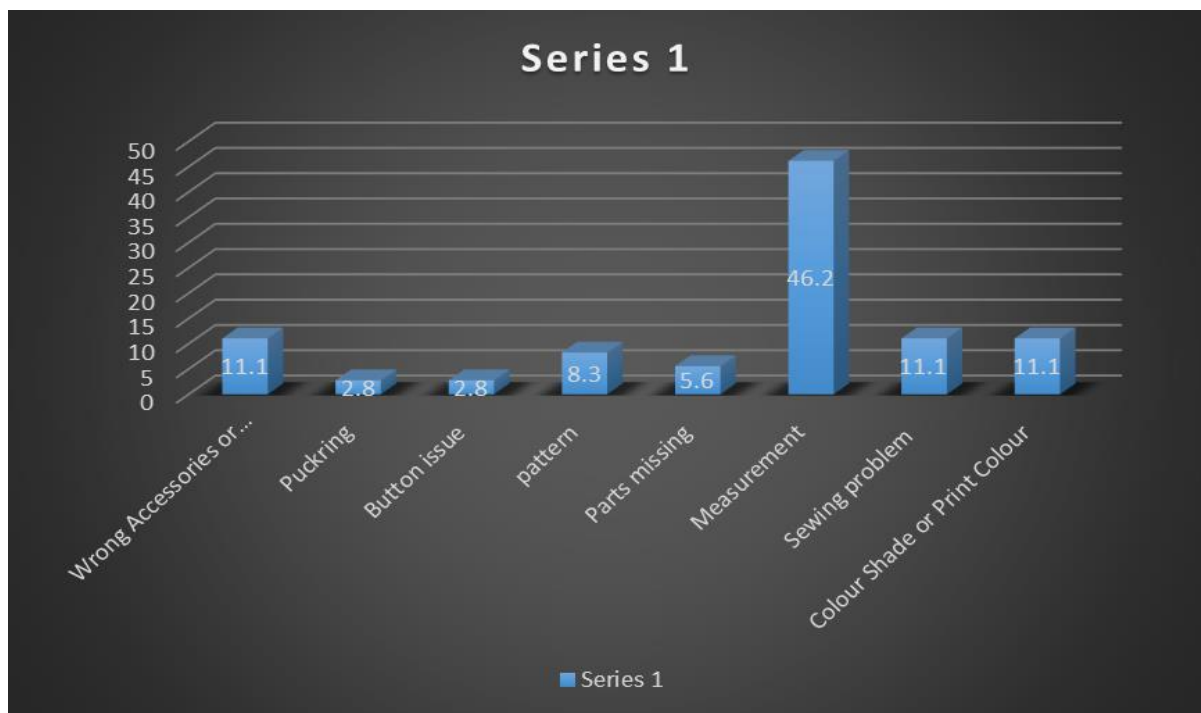
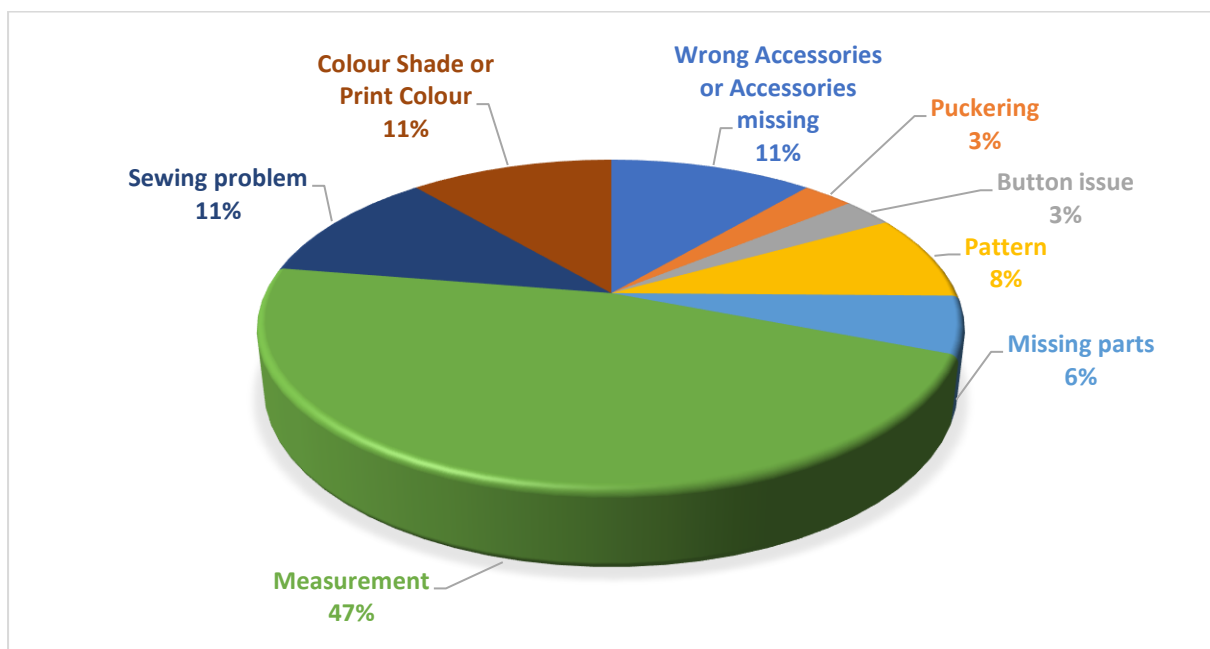


Figure 5: Graphical view of sample failure data



4.6 Major problems with their Remedies

From the project, we identify the number of faults and their percentage of the sample. Here we discuss about the major faults and also discuss about their remedies.

4.6.1 Measurement problem (46.2%):

After analyzing the report, we have identified that most of the problems are due to measurement errors. When workers are unable to match the buyer's measurement, it is called a measuring difficulty.



Figure 6: Measurement problem

4.6.1.1 Causes of measurement problem:

- Wrong pattern making
- For fabrics shrinkage
- Not proper fabric relaxation
- Not proper fabric cutting
- Cause of washing
- Sewing thread shrinkage
- Cause of ironing

4.6.1.2 Remedies of the Measurement Problem

- Make pattern properly
- Properly calculate the shrinkage percentage
- Proper fabric relaxation
- Proper fabric spreading with proper tension

- Cutting quality control
- Match Sewing thread and fabric shrinkage percentage
- Ensure proper pulling while sewing
- Before wash shrinkage checking
- Remove Puckering issue
- Proper washing
- Proper ironing

4.6.2 Sewing problem (11.1%):

A sewing problem can occur when stitches are placed incorrectly along the seam line.

The sewing department is the most essential in the factory that makes clothing. Here are the most common mistakes that hamper the overall quality of the clothing.



Figure 7: Sewing problem

4.6.2.1 Causes of Sewing Problem

- Skipped stitches
- Unbalance stitch
- Staggered stitch
- Seam puckering
- Thread breakage
- Needle thread and bobbin/looper thread tension are not the same
- Stitch density is not perfect
- Cause of the needle size
- Depending on the needle guide
- Unskilled operator

4.6.2.2 Remedies of Sewing Problem

- Accurate thread tension
- Ensure that the needle size and thread match the fabric requirements
- pressure foot adjusts properly
- Feed dog motion should be adjusted
- Proper movement of fabric while sewing by the operator
- Adjusts Stitch density
- Use the proper needle guide
- Ensure skillful operator

4.6.3 Color Shade or Print problem (10.90%):

A common issue in printed or dyed garments is shade fluctuation, which is considered a defect. The shade variation that occurs in clothing is a result of variations in the fabric shade from one sequence to another.



Figure 8: Color Shade or Print problem

4.6.3.1 Causes of Color Shade or Print Problem

- The recipe does not mix properly
- Cause of temperature
- Scorching and bleaching are not proper
- Not selecting a good leveling agent
- Lack of proper pretreatment
- Dyeing recipes vary between different batches
- Not Maintain PH
- Not proper mixing of printing paste
- Color Staining while sewing
- Mis fitting of the design
- Mis fitting of the fabric
- Low viscosity of print paste

4.6.3.2 Remedies of Color Shade or Print Problem

- Make dyeing and print recipe properly
- Maintain time and temperature
- Good Scorching and bleaching in fabric
- Maintain PH
- Ensure good water quality
- It is important to use a good-quality leveling agent
- Make recipe depend on fabric types
- Fitting design/fabric in the correct position
- Do pretreatment properly
- Make print paste in proper density
- Ensure accurate pressure on the printing rollers

4.6.4 Pattern problem

Pattern-making is a critical step in the RMG industry and plays a vital role. If the patterns are incorrect cutting panel of the garments must be rejected. Patterns are different demo parts of a garments.



Figure 9: Pattern problem

4.6.4.1 Causes of Pattern Problem

- Measurement mistake
- Carelessness in Cutting
- Unskilled operator
- Incorrect Grading of Pattern
- Bad-quality pattern paper

4.6.4.2 Remedies of Pattern Problem

- Correctly take the measurement
- Carefully cutting
- Avoid bad-quality pattern accessories
- Use skilled operator
- Use automatic pattern machine

4.6.5 Parts missing Problem

In garment industries, huge quantities of fabrics are cut together. That's why sometimes garment parts are missing. It's also missing in sewing line for negligancy of sewing operator.



Figure 10: Parts missing Problem

4.6.5.1 Causes of Parts Missing Problem

- Wrong numbering after cutting
- It can be caused by the absence of a pattern.
- Neglancy of Operator
- When different shades of fabric are cut together then it can happen

4.6.5.2 Remedies of Parts Missing Problem

- Numbering the cut panel accurately
- Check pattern accurately
- Try to remove neglancy
- Different shades of fabric cut carefully

CHAPTER-5 Conclusion

5.1 Conclusion

In the apparel industry, samples serve as the basis for large orders. Therefore, it is crucial to create accurate samples. To achieve this, we require high-quality artwork, fabric, accessories, and dedicated merchandisers who can carefully manage everything involved in producing a top-quality sample. We take customer feedback seriously and identify issues with the sample, seeking solutions to any challenges and rectifying any problems. After careful analysis, we have determined that the main issue lies in the measurements, which were caused by a pattern problem. We are working hard to address this issue by updating the measurement table and ensuring that it remains up-to-date. With these measures in place, we are confident that we can produce error-free and high-quality samples.

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