



Faculty of Engineering
Department of textile engineering
Daffodil International University

Project Title
Comparative study on the final inspection of buying QC.

Course Title: Project (Thesis)»

Course Code: TE-4214

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A report submitted in partial fulfilment of the requirements for the degree of
Bachelor of Science in Textile Engineering

Advance Apparel Manufacturing Technology

Spring 2023

Letter of Approval

12th March 2024

To

The Head

Department of Textile Engineering

Daffodil International University

Daffodil Smart City, Ashulia, Savar, Dhaka.

Subject: Approval of Project (Thesis) Report of B.Sc. in TE Program.

Dear Sir,

I'm writing to inform you that the student with IDs 201-23-850 and 201-23-917 has finished the project report titled "**Comparative study on the final inspection of buying QC**" in preparation for its final assessment. The entire report is written using appropriate research methods and interruptions by thorough examination of empirical facts and necessary accessories. Since the students actively participated in their projects, the report played a crucial role in providing readers with a wealth of insightful information.

As a result, I would greatly appreciate it if you would accept my project report and give it some thought before deciding to evaluate it.

Your Sincerely,



.....

Abdullah Al Mamun

Assistant professor

Department of Textile Engineering

Faculty of Engineering

Daffodil International University



Daffodil
International
University

Faculty of Engineering
Department of Textile Engineering

DECLARATION

We hereby declare that the work included in this report, "**Comparative study on the final inspection of buying QC,**" is entirely original, hasn't been submitted for credit toward a degree from any other university, and has been properly acknowledged in all the sources used to gather the data for it.

Submitted By:



.....
Md. Ahasan Habib

ID: 201-23-850



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Acknowledgment

"In the name of Allah, the Almighty, Almighty and Almighty"

I want to start by thanking Allah for giving us life. This is the reason I'm here. With Allah's blessing, we finished our project report. We owe a debt of gratitude to numerous individuals who assisted us in the preparation of this project report. Additionally, we are appreciative of our supervisor, **Mr. Abdullah Al Mamun, an assistant professor** in the textile engineering department of Daffodil International University's faculty of engineering. It has been made possible to complete this project report by his unending patience, scholarly direction, constant encouragement, energetic supervision, constructive criticism, insightful counsel, reviewing numerous subpar drafts, and rectifying these at every stage. I want to express my gratitude to the management, supervisors, technicians, operators, and all other employees who helped us out so well with the project report.

We express our gratitude to all the instructors, lab assistants, coordinators, registrar, sir, and Daffodil International University staff. With great pleasure, we offer our greetings and appreciation to our former head, Mr. Md. Mominur Rahman, for his outstanding assistance.

Finally, we would like to thank our parents for their unwavering support and mental fortitude during the project report's completion.

ABSTRACT

"Comparative study on the final inspection of buying QC" is the title of the paper. In the whole RMG industry, this project is the most significant. Using efficient quality control (QC) procedures is essential to guaranteeing the dependability and integrity of the products you buy. Before products are approved for use or distribution, final inspection—a critical step in the procurement process—verifies that they comply with established criteria.

One way to define quality would be the extent to which goods or services are acknowledged. Item quality is assessed based on the material and vesture assiduity, considering the quality and standard of the fibers, yarns, texture development, shadowing speed, plans, and the final pieces.

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1. CHAPTER 1

INTRODUCTION

1.1. Background of the Study:

The project aims to compare final inspection methods across industries to understand their role in ensuring product quality. It seeks to determine standard procedures, difficulties, and the potency of various review techniques. The study is motivated by the importance of final inspections in industries where product defects can have critical results. It includes collecting data inspection reports to provide insights into inspection criteria and the impact of inspection outcomes on quality control. The study explores the application of technology in final inspections, including automated systems with a focus on employee awareness and training programs that will increase workers' abilities and elevate quality standards.

1.2. Objective of this Project:

The intention of this report is distinctive, we are working on a certain target. They are,

1. Increase garment productivity.
2. Simplify processes.
3. Identify and eliminate problems.
4. Balance workloads on the sewing floor.
5. Improve worker capacity.
6. Sustainability within the garment production process.

1.3. Importance of this Project:

1. Ensures commitment to quality requirements and standards.
2. Reduces the possibility that buyers may receive faulty products.
3. Improves client happiness and brand reputation.
4. Minimizes the need for rework and encourages timely delivery.
5. Emphasizes transparency and accountability throughout the production process.

1.4. Aim of the Project:

The final inspection of Buying Quality Control (QC) aims to enhance product quality, customer satisfaction, and operational efficiency by providing insights into the final inspection process and recommending strategies to make improvements.

1.5. Opportunity of the Project:

1. The final examination of purchasing QC in the apparel industry offers a plethora of creative opportunity.
2. The RMG industry is aware of how crucial purchasing QC inspections are to increased production.
3. Currently, purchasing quality control inspection is focused on finding the most economical way to consistently raise production.
4. Inspection Documentation and Reporting assess the effects of these procedures on the inspection process's transparency and traceability.
5. The final inspection procedure affects how consumers view the quality of the product and the reputation of the brand.

1.6. Limitation of the study:

1. A shortage of skilled operators can impact the quality of the final inspection process.
2. Deficiency of advising with Operators and Helpers.
3. Shortage of Proper Training.
4. Confidentiality Concerns.

2. CHAPTER 2

LITERATURE RIVEW

2.1. Inspection of buying QC

Quality Control (QC) inspections are crucial for ensuring the quality of purchased products. These inspections are systematic checks conducted at various stages of the production process to ensure that products meet specified quality standards. They help identify defects early, saving time and money by avoiding costly rework or returns. Additionally, QC inspections ensure that products meet regulatory requirements and safety standards, reducing the risk of liability for the buyer.

Setting precise acceptance criteria and quality standards is essential for a successful QC inspection. With thorough records of the inspection findings and any remedial measures implemented, the inspection procedure should be well documented. In general, QC inspections play a crucial role in the purchasing process by assisting in ensuring that goods fulfill the necessary requirements for quality standards and specifications. Buyers can reduce the possibility of acquiring subpar products and guarantee client satisfaction by doing comprehensive inspections.

2.2. Important of Buying (QC)

Quality Control (QC) is crucial in purchasing due to several reasons. Firstly, it ensures that products or services meet predefined standards, enhancing customer satisfaction. Secondly, it helps in identifying defects early on, reducing costs associated with rework or recalls. Thirdly, it plays a significant role in maintaining brand reputation, which can lead to increased sales and customer loyalty. Additionally, QC ensures compliance with regulatory requirements and industry standards, avoiding legal issues and fines. Lastly, it fosters continuous improvement by identifying areas for enhancement in the production process, leading to increased efficiency and productivity. In summary, QC is vital for ensuring quality, reducing costs, and maintaining brand reputation.

2.3. Buying (QC)

A comparative study comparing visual inspection, statistical sampling, and technological aids for final inspection in purchasing quality control notes evaluates their effectiveness in ensuring

product compliance with standards, offering insights for optimizing inspection processes and enhancing procurement quality assurance.

2.4. Objective of Buying QC

Buying Quality Control (QC) aims to ensure products meet predefined standards and specifications by verifying the quality, consistency, and conformity of goods procured from suppliers. Key objectives include compliance, risk reduction, cost optimization, supplier performance evaluation, customer satisfaction, and continuous improvement. It also focuses on preventing defects, preventing rework, assessing supplier performance, and enhancing procurement effectiveness.

2.5. Factors Affecting Quality

Quality in Production Process –

- Raw materials' quality directly impacts final product's integrity and performance.
- Production processes must adhere to strict standards for consistency and reliability.
- Workforce competence is critical for maintaining quality standards and identifying potential issues.
- Stringent quality control measures, inspections, and testing are necessary to detect and rectify defects.
- Supplier quality is crucial as components and materials from external vendors must meet specified standards.
- Environmental factors, equipment maintenance, design considerations, regulatory compliance, and customer feedback also contribute to overall quality.

2.6. Classification of Buying Quality Control

2.6.1. Inspection Methods:

- **Visual Inspection** : Assess product quality based on visual appearance.
- **Functional Testing** : Evaluates product performance and functionality.
- **Sampling Inspection** : Select a representative sample for inspection.

2.6.2. Scope of Control:

- **Incoming Inspection** : Checks quality of raw materials, components, or products upon receipt.
- **In-process Inspection**: Monitors and controls quality during production.
- **Outgoing Inspection** : Verifies quality of finished products before shipment.

2.6.3. Criticality of Products:

- **Critical Items** : Essential for product functionality, safety, or regulatory compliance.
- **Non-Critical Items** : Less impact on overall product performance or safety.

2.6.4. Frequency of Control:

- **Regular QC** : Routine quality control activities.
- **Spot Checks** : Random or occasional inspections.
- **Batch Inspection** : Inspects entire batches or lots.

2.6.5. Technology Utilization:

- **Manual Inspection** : Manual inspection is performed manually by human operators.
- **Automated Inspection**: Conducted using automated systems, sensors, or equipment.

2.7. Step of Buying Quality Control

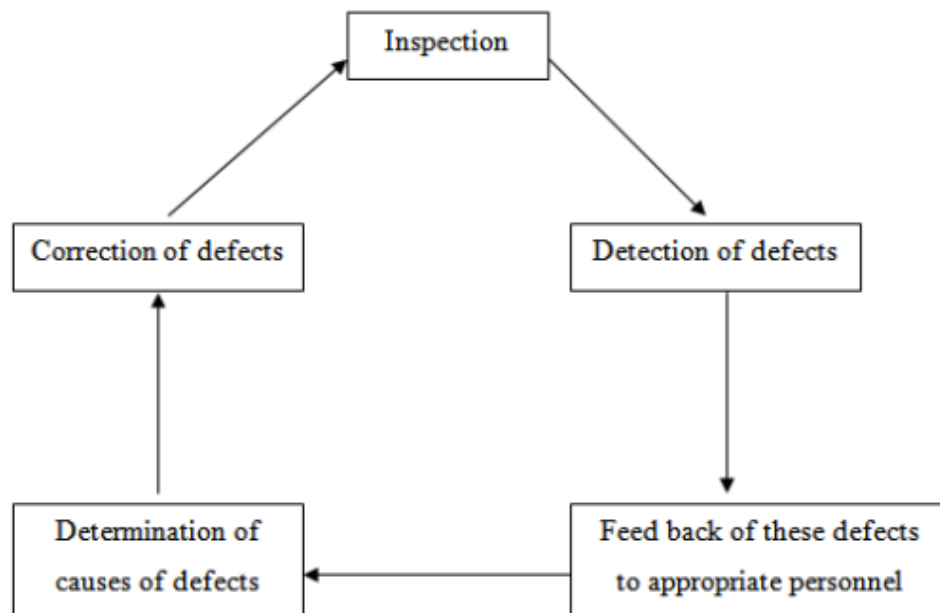


Figure 1: Garments inspection circle

2.8. Acceptable Buying Quality Control

Acceptable buying quality control is an essential process that ensures goods meet predetermined standards and specifications. This meticulous procedure includes pre-production inspections, in-process assessments, and final product examinations. By conducting rigorous quality checks, organizations can minimize the risk of receiving defective or substandard items, safeguard their reputation, and ensure customer satisfaction. Effective quality control measures maintain competitiveness in the market.

Sampling Plan for shipment inspection and acceptance level at AQL 2.5, AQL 4 and AQL 6.5

Lot or Batch size	Sample size Code Letter	Sample Size (Level-I)	Acceptable Quality level (AQL)					
			2.5		4		6.5	
			Ac	Re	Ac	Re	Ac	Re
2 – 8	A	2	0	1	0	1	0	1
9 – 15	B	3	0	1	0	1	0	1
15 – 25	C	5	0	1	0	1	0	1
26 – 50	D	8	0	1	1	2	1	2
51-90	E	13	1	2	1	2	2	3
91-150	F	20	1	2	2	3	3	4
151-280	G	32	2	3	3	4	5	6
251-500	H	50	3	4	5	6	7	8
501-1200	J	80	5	6	7	8	10	11
1201-3200	K	125	7	8	10	11	14	15
3201-10000	L	200	10	11	14	15	21	22
10001-35000	M	315	14	15	21	22	21	22

Source : ANSI/ASQ Z 1.4 The Sampling procedures and table for inspection by attributes

Table 1: AQL Chart

2.9. Working sequence of buying quality control

The buying quality control process involves defining quality criteria, selecting suppliers, conducting pre-production inspections, implementing in-process quality control measures during production, and conducting final product inspections before shipment. Documentation and record-keeping are crucial throughout the process to track quality control activities and provide evidence of compliance. Continuous improvement efforts identify areas for enhancement and ensure ongoing compliance with evolving quality requirements. By following this working sequence, organizations can mitigate risks, uphold quality standards, and ensure customer satisfaction with their purchased goods.

2.10. Defects on Garments:

1. Open seam
2. Stripe up and down
3. Raw edge
4. Join stitch
5. Glue mark
6. Un-cut thread
7. Insect
8. Button missing
9. Zipper sharp edge
10. Needle Mark
11. Size mistake
12. Broken button
13. Needle cut
14. Logo missing

2.11. Quality control in garments production:

The project focuses on two sections:

Sewing Section and Finishing Section both-

2.11.1. Sewing Section:

1. Examining the source material
2. Check the cut panel and accessories
3. Examining the sewing thread
4. Check the sewing needle
5. Panel checking printing
6. Check for stitches
7. Check for seam faults
8. Checking measurements
9. Examining the differences in darkness between various sections
10. Interline, verify, and trim
11. Examine your entire body shape

2.11.2. Finishing Section

1. The cut thread, dust, and grime are checked
2. Check seams and stitches
3. First measurement verification
4. Barcode check for hangtag and care labels
5. Examine the metal
6. Checking folding measurements
7. Verify the size when cartooning

3. CHAPTER 3

METHODOLOGY

We have worked at Aman Graphics & Designs Ltd. We worked with GPQ auditor of this garments industry and particularly, we worked with Sainsbury's Argos GPQ auditor.

We analyze certain quality sheets as part of our study to find issues that frequently arise in the GPQ auditor. We then make every effort to address the issues raised in our methodology section. Twenty Inspection Reports were used in our study.

3.1. Data Collection:

We have some reports to share from our project, which came from the factory where I work. Every employee in the factory and other individuals are overly nice. We obtained this completely certified data from the GPQ auditor.

3.2. Final Inspection Report:

Sainsbury's Argos				Inspection No.:		B109224022201					
Supplier Self-Inspection Report				Report Date:		Feb 22, 2024			Page 2 of 14		
D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity <u>Units</u>	Shipment Quantity <u>Units</u> <u>Cartons</u>		Presented Quantity for Inspection	Units Packed in Cartons <u>QTY</u> %		Units Finished Not Packed <u>QTY</u> %		Units Not Finished <u>QTY</u> %	
2613988	144011201	2650	2687	86	2687	2687	100	0	0	0	0
Total:		2650	2687	86	2687	2687	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 02, 09, 12, 18, 30, 39, 54, 66, 76, 79. Total <u>10</u> Cartons were opened for sampling.									
E. WORKMANSHIP (Basic Function & Appearance)											
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)								
Inspection Level - Workmanship / Visual:			II	Acceptance Quality Limit (AQL) - Critical Defectives:						Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal	AQL - Major Defectives:						2.5	
				AQL - Minor Defectives:						4.0	
Sample Size - Workmanship / Visual:			Critical:	125	Major:	125	Minor:		125		
	Defect Code	Defective Description					Critical	Major	Minor		
1.	294	Broken stitch at hem & back pocket (1cm to 1.2cm)					0	2	0		
2.	334	Dirty stain at front part (0.5cm)					0	2	0		
3.	266	Puckering at back rise (5cm)					0	1	0		
4.	267	Poor pressing at hem (Non-Obvious)					0	0	2		
5.	44	Untrimmed thread at waist band (0.5cm)					0	0	1		
Total Defectives Found:							0	5	3		
Defectives Accepted:							0	7	10		
Result:							PASS				
Remarks - Other defects observed but not counted in the AQL Result: N/A											

Figure 2: Final Inspection Report 1

Sainsbury's Argos Supplier Self-Inspection Report				Inspection No.: B109224022004	
				Report Date: Feb 20, 2024	Page 2 of 14

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2616739	143777790	4610	4613	165	4613	4613	100	0	0	0	0
Total:		4610	4613	165	4613	4613	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 09, 33, 41, 56, 80, 90, 101, 112, 122, 140, 150, 157, 164. Total <u>13</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)												
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)									
Inspection Level - Workmanship / Visual:			II		Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed			
Sampling Plan - Workmanship / Visual:			Single / Normal		AQL - Major Defectives:				2.5			
					AQL - Minor Defectives:				4.0			
Sample Size - Workmanship / Visual:			Critical:		200		Major:		200		Minor:	
	Defect Code	Defective Description					Critical	Major	Minor			
1.	44	Untrimmed thread at waist inside, inside side seam, back pocket & front pocket (1cm to 9cm)					0	3	2			
2.	294	Broken stitch at back pocket (0.8cm)					0	1	0			
3.	334	Pen mark & dirty stain at back part (0.3cm to 1.2cm)					0	2	0			
4.	267	Poor pressing at front pocket & hem					0	0	2			
5.	46	High-low at back pocket (0.5cm)					0	0	2			
Total Defectives Found:							0	6	6			
Defectives Accepted:							0	10	14			
Result:							PASS					
Remarks - Other defects observed but not counted in the AQL Result: N/A												

Figure 3: Final Inspection Report 2

Sainsbury's Argos				Inspection No.: B109224022003	
Supplier Self-Inspection Report				Report Date: Feb 20, 2024	
				Page 2 of 14	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2616294	143937861	3920	4157	80	4157	4157	100	0	0	0	0
Total:		3920	4157	80	4157	4157	100	0	0	0	0

List of Export Carton Numbers Opened	Carton No.: 05, 12, 26, 33, 49, 57, 65, 75, 77, 80. Total <u>10</u> Cartons were opened for sampling.
--------------------------------------	--

E. WORKMANSHIP (Basic Function & Appearance)							
Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)					
Inspection Level - Workmanship / Visual:		II	Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed
Sampling Plan - Workmanship / Visual:		Single / Normal	AQL - Major Defectives:				2.5
			AQL - Minor Defectives:				4.0
Sample Size - Workmanship / Visual:		Critical:	200	Major:	200	Minor:	200

Defect Code	Defective Description	Critical	Major	Minor
1. 44	Untrimmed thread at armhole & front pocket (1.5cm to 2.5cm)	0	3	0
2. 334	Dirty stain at front part (0.5cm)	0	1	0
3. 331	Foreign yarn at front part (3cm)	0	1	0
4. 294	Broken stitch at inside placket (0.5cm)	0	1	0
5. 281	Slanted at front pocket	0	0	2
6. 267	Poor pressing at collar	0	0	3
Total Defectives Found:		0	6	5
Defectives Accepted:		0	10	14
Result:		PASS		

Remarks - Other defects observed but not counted in the AQL Result: N/A
--

Figure 4: Final Inspection Report 3

Sainsbury's Argos				Inspection No.: B109224022002	
Supplier Self-Inspection Report				Report Date: Feb 20, 2024	
				Page 2 of 13	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2593260	142675450	610	611	28	611	611	100	0	0	0	0
Total:		610	611	28	611	611	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 02, 06, 10, 19, 25, 27, 28.									
		Total 07 Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)								
Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)						
Inspection Level - Workmanship / Visual:		II	Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed	
Sampling Plan - Workmanship / Visual:		Single / Normal	AQL - Major Defectives:				2.5	
			AQL - Minor Defectives:				4.0	
Sample Size - Workmanship / Visual:		Critical:	80	Major:	80	Minor:	80	
	Defect Code	Defective Description				Critical	Major	Minor
1.	334	Dirty stain at front part (1cm to 1.2cm)				0	2	0
2.	294	Broken stitch at inside side seam (1.2cm)				0	1	0
3.	44	Untrimmed thread at hem & front dirt area (1cm to 2cm)				0	1	3
4.	267	Poor pressing at leg (Non-Obvious)				0	0	2
Total Defectives Found:						0	4	5
Defectives Accepted:						0	5	7
Result:						PASS		
Remarks - Other defects observed but not counted in the AQL Result: N/A								

Figure 5: Final Inspection Report 4

Sainsbury's Argos Supplier Self-Inspection Report	Inspection No.: B109224022001		
	Report Date: Feb 20, 2024	Page 2 of 12	

D. QUANTITY(QTY)

P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2614959	144039721	1610	1620	25	1620	1620	100	0	0	0	0
Total:		1610	1620	25	1620	1620	100	0	0	0	0
List of Export Carton Numbers Opened			Carton No.: 03, 08, 14, 18, 21, 24. Total 06 Cartons were opened for sampling.								

E. WORKMANSHIP (Basic Function & Appearance)

Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)												
Inspection Level - Workmanship / Visual:		II	Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed							
Sampling Plan - Workmanship / Visual:		Single / Normal	AQL - Major Defectives:				2.5							
			AQL - Minor Defectives:				4.0							
Sample Size - Workmanship / Visual:		Critical:	125	Major:	125	Minor:	125							
	Defect Code	Defective Description				Critical	Major	Minor						
1.	334	Dirty stain at front part (1.2cm to 2.5cm)				0	2	0						
2.	46	High-low at front placket (1cm)				0	1	0						
3.	44	Untrimmed thread at inside side seam area & sleeve rolling area (1cm to 4cm)				0	1	2						
4.	294	Broken stitch at collar (0.8cm)				0	1	0						
5.	281	Slanted at front pocket (Non-Obvious)				0	0	1						
6.	267	Poor pressing at collar (Non-Obvious)				0	0	1						
Total Defectives Found:						0	5	4						
						Defectives Accepted:						0	7	10
						Result:						PASS		
Remarks - Other defects observed but not counted in the AQL Result: N/A														

Figure 6: Final Inspection Report 5

Sainsbury's Argos Supplier Self-Inspection Report	Inspection No.: B109224021401	Page 2 of 13
	Report Date: Feb 14, 2024	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2614963	144040001	1530	1545	45	1545	1545	100	0	0	0	0
Total:		1530	1545	45	1545	1545	100	0	0	0	0
List of Export Carton Numbers Opened			Carton No.: 02, 09, 16, 30, 36, 40, 44. Total <u>07</u> Cartons were opened for sampling.								

E. WORKMANSHIP (Basic Function & Appearance)										
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)							
Inspection Level - Workmanship / Visual:			II		Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal		AQL - Major Defectives:				2.5	
					AQL - Minor Defectives:				4.0	
Sample Size - Workmanship / Visual:			Critical:		125		Major:		125	
Defect Code		Defective Description					Critical	Major	Minor	
1.	44	Untrimmed thread at inside back pocket & hem (1cm to 3cm)					0	2	2	
2.	334	Dirty stain at front part & waist band area (1cm to 2cm)					0	2	0	
3.	294	Broken stitch at hem (1.2cm)					0	1	0	
4.	267	Poor pressing at leg					0	0	2	
Total Defectives Found:							0	5	4	
Defectives Accepted:							0	7	10	
Result:							PASS			
Remarks - Other defects observed but not counted in the AQL Result: N/A										

Figure 7: Final Inspection Report 6

Sainsbury's Argos Supplier Self-Inspection Report				Inspection No.: B109224020601		Page 2 of 15	
				Report Date: Feb 06, 2024			

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity <u>Units</u>	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			<u>Units</u>	<u>Cartons</u>		<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>
2604004	140475745	1500	1537	58	1537	1537	100	0	0	0	0
Total:		1500	1537	58	1537	1537	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 01, 02, 04, 06, 10, 15, 23, 30, 36, 41, 47, 52, 55, 68.									
		Total <u>14</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)											
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)								
Inspection Level - Workmanship / Visual:			II	Acceptance Quality Limit (AQL) - Critical Defectives:						Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal	AQL - Major Defectives:						2.5	
				AQL - Minor Defectives:						4.0	
Sample Size - Workmanship / Visual:			Critical:	125	Major:	125	Minor:		125		
	Defect Code	Defective Description					Critical	Major	Minor		
1.	266	Pleat at side seam (Obvious)					0	1	0		
2.	294	Broken stitch at front pocket rolling (1.2cm)					0	1	0		
3.	334	Dirty stain at front part (2cm)					0	1	0		
4.	44	Untrimmed thread at side seam, Hem & cargo pocket (1cm to 5.5cm)					0	1	3		
5.	18	Raw edge at cargo pocket flap area (Obvious)					0	1	0		
6.	46	High-low at back pocket (0.5cm)					0	0	2		
7.	281	Back show at cargo pocket (Non-Obvious)					0	0	1		
Total Defectives Found:							0	5	6		
Defectives Accepted:							0	7	10		
Result:							PASS				
Remarks - Other defects observed but not counted in the AQL Result: N/A											

Figure 8: Final Inspection Report 7

Sainsbury's Argos				Inspection No.: B109224020301	
Supplier Self-Inspection Report				Report Date: Feb 3, 2024	
				Page 2 of 13	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2608463	143864324	1210	1239	42	1239	1239	100	0	0	0	0
Total:		1210	1239	42	1239	1239	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 05, 08, 14, 23, 30, 34, 42. Total <u>07</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)											
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)								
Inspection Level - Workmanship / Visual:			II	Acceptance Quality Limit (AQL) - Critical Defectives:						Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal	AQL - Major Defectives:						2.5	
				AQL - Minor Defectives:						4.0	
Sample Size - Workmanship / Visual:			Critical:	125	Major:	125	Minor:		125		
	Defect Code	Defective Description					Critical	Major	Minor		
1.	44	Untrimmed thread at hem, inside & front rise area (1cm to 3cm)					0	2	1		
2.	334	Dirty stain at front part (0.3cm)					0	1	0		
3.	42	Shading at back part (Obvious)					0	1	0		
4.	267	Poor pressing at hem (Obvious & Non-Obvious)					0	1	3		
Total Defectives Found:							0	5	4		
Defectives Accepted:							0	7	10		
Result:							PASS				
Remarks - Other defects observed but not counted in the AQL Result: N/A											

Figure 9: Final Inspection Report 8

Sainsbury's Argos Supplier Self-Inspection Report				Inspection No.: B109224012401			
				Report Date: Jan 24, 2024		Page 2 of 13	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2606408	143747591	470	470	10	470	470	100	0	0	0	0
Total:		470	470	10	470	470	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 01, 02, 03, 04, 05, 06, 07, 08, 09, 10. Total <u>10</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)												
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)									
Inspection Level - Workmanship / Visual:			II		Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed			
Sampling Plan - Workmanship / Visual:			Single / Normal		AQL - Major Defectives:				2.5			
					AQL - Minor Defectives:				4.0			
Sample Size - Workmanship / Visual:			Critical:		50		Major:		50		Minor:	
	Defect Code	Defective Description					Critical	Major	Minor			
1.	334	Dirty & washing stain at hem & front part area (2cm to 2.5cm)					0	2	0			
2.	47	Fabric fault at front pocket (9cm)					0	1	0			
3.	281	Slanted at front pocket (Non-Obvious)					0	0	2			
4.	267	Poor pressing at hem & sleeve (Non-Obvious)					0	0	2			
Total Defectives Found:							0	3	4			
Defectives Accepted:							0	3	5			
Result:							PASS					
Remarks - Other defects observed but not counted in the AQL Result: N/A												

Figure 10: Final Inspection Report 9

Sainsbury's Argos				Inspection No.: B109224012302	
Supplier Self-Inspection Report				Report Date: Jan 23, 2024	
				Page 2 of 12	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity <u>Units</u>	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			<u>Units</u>	<u>Cartons</u>		<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>
2605738	143815741	899	902	18	902	902	100	0	0	0	0
Total:		899	902	18	902	902	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 04, 07, 12, 15, 16, 18.									
		Total <u>06</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)											
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)								
Inspection Level - Workmanship / Visual:			II	Acceptance Quality Limit (AQL) - Critical Defectives:						Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal	AQL - Major Defectives:						2.5	
				AQL - Minor Defectives:						4.0	
Sample Size - Workmanship / Visual:			Critical:	80	Major:	80	Minor:		80		
	Defect Code	Defective Description					Critical	Major	Minor		
1.	44	Untrimmed thread at collar (3.5cm)					0	2	0		
2.	294	Broken stitch at shoulder stitch (0.7cm)					0	1	0		
3.	334	Dirty stain at collar (2cm)					0	1	0		
4.	41	Uneven sleeve hem					0	0	2		
5.	267	Poor pressing at sleeve hem					0	0	2		
6.	281	Slanted at front pocket					0	0	1		
Total Defectives Found:							0	4	5		
Defectives Accepted:							0	5	7		
Result:							PASS				
Remarks - Other defects observed but not counted in the AQL Result: N/A											

Figure 11: Final Inspection Report 10

Sainsbury's Argos				Inspection No.: B109224012301	
Supplier Self-Inspection Report				Report Date: Jan 23, 2024	
				Page 2 of 12	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity <u>Units</u>	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			<u>Units</u>	<u>Cartons</u>		<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>
2594656	143457585	979	1031	24	1031	1031	100	0	0	0	0
Total:		979	1031	24	1031	1031	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 01, 03, 10, 14, 20, 23, 24.									
		Total <u>07</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)											
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)								
Inspection Level - Workmanship / Visual:			II	Acceptance Quality Limit (AQL) - Critical Defectives:						Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal	AQL - Major Defectives:						2.5	
				AQL - Minor Defectives:						4.0	
Sample Size - Workmanship / Visual:			Critical:	80	Major:	80	Minor:	80			
	Defect Code	Defective Description					Critical	Major	Minor		
1.	46	High-low at front drawcord (1.5cm to 3.5cm)					0	2	0		
2.	44	Untrimmed thread at hem, back pocket & front pocket (1cm to 2cm)					0	2	2		
3.	267	Poor pressing at lag (Non-Obvious)					0	0	2		
Total Defectives Found:							0	4	4		
Defectives Accepted:							0	5	7		
Result:							PASS				
Remarks - Other defects observed but not counted in the AQL Result: N/A											

Figure 12: Final Inspection Report 11

Sainsbury's Argos				Inspection No.: B109224012201			
Supplier Self-Inspection Report				Report Date: Jan 22, 2024		Page 2 of 14	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2604472	143777790	1020	1020	38	1020	1020	100	0	0	0	0
Total:		1020	1020	38	1020	1020	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 03, 08, 14, 21, 25, 31, 33, 34, 36, 37. Total <u>10</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)												
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)									
Inspection Level - Workmanship / Visual:			II		Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed			
Sampling Plan - Workmanship / Visual:			Single / Normal		AQL - Major Defectives:				2.5			
					AQL - Minor Defectives:				4.0			
Sample Size - Workmanship / Visual:			Critical:		80		Major:		80		Minor:	
	Defect Code	Defective Description					Critical	Major	Minor			
1.	294	Broken stitch at back pocket (0.9cm)					0	1	0			
2.	38	Skipped stitch at pocket rolling (1cm)					0	1	0			
3.	42	Shading at front part (Obvious)					0	1	0			
4.	18	Raw edge at back pocket (Obvious)					0	1	0			
5.	267	Poor pressing at front pocket (Non-Obvious)					0	0	2			
6.	44	Untrimmed thread at front pocket & back pocket (1cm)					0	0	3			
Total Defectives Found:							0	4	5			
Defectives Accepted:							0	5	7			
Result:							PASS					
Remarks - Other defects observed but not counted in the AQL Result: N/A												

Figure 13: Final Inspection Report 12

Sainsbury's Argos				Inspection No.: B109224010301			
Supplier Self-Inspection Report				Report Date: Jan 3, 2023		Page 2 of 13	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2605735	143815741	1460	1465	24	1465	1465	100	0	0	0	0
Total:		1460	1465	24	1465	1465	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 03, 11, 16, 19, 22, 24.									
		Total <u>06</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)												
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)									
Inspection Level - Workmanship / Visual:			II		Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed			
Sampling Plan - Workmanship / Visual:			Single / Normal		AQL - Major Defectives:				2.5			
					AQL - Minor Defectives:				4.0			
Sample Size - Workmanship / Visual:			Critical:		125		Major:		125		Minor:	
	Defect Code	Defective Description					Critical	Major	Minor			
1.	294	Broken stitch at inside vent & side hem area (0.5cm)					0	2	0			
2.	46	Hi-low at front placket (0.5cm)					0	1	0			
3.	334	Dirty stain at front part (2cm)					0	1	0			
4.	281	Slanted & back show at front pocket & back collar (Non-Obvious)					0	0	3			
5.	267	Poor pressing at sleeve hem & back yoke (Non-Obvious)					0	0	2			
6.	41	Looseness at collar & hem vent area (Non-Obvious)					0	0	2			
7.	44	Untrimmed thread at sleeve hem (1cm)					0	0	1			
Total Defectives Found:							0	4	8			
Defectives Accepted:							0	7	10			
Result:							PASS					
Remarks - Other defects observed but not counted in the AQL Result: N/A												

Figure 14: Final Inspection Report 13

Sainsbury's Argos				Inspection No.: B109224010302			
Supplier Self-Inspection Report				Report Date: Jan 3, 2023		Page 2 of 14	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2611535	143937861	3820	3852	77	3852	3852	100	0	0	0	0
Total:		3820	3852	77	3852	3852	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 05, 13, 21, 35, 44, 59, 60, 71, 75, 77.									
		Total <u>10</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)								
Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)						
Inspection Level - Workmanship / Visual:		II	Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed	
Sampling Plan - Workmanship / Visual:		Single / Normal	AQL - Major Defectives:				2.5	
			AQL - Minor Defectives:				4.0	
Sample Size - Workmanship / Visual:		Critical:	200	Major:	200	Minor:	200	
	Defect Code	Defective Description				Critical	Major	Minor
1.	294	Broken stitch at hem & front pocket (0.3cm to 1cm)				0	3	0
2.	47	Fabric fault at shoulder & front part (6cm to 7cm)				0	2	0
3.	44	Untrimmed thread at front pocket, hem & sleeve hem (1cm to 3cm)				0	2	2
4.	334	Dirty stain at front part (0.7cm)				0	1	0
5.	281	Slanted & back show at front pocket & back collar (Non-Obvious)				0	0	4
6.	267	Poor pressing at collar (Non-Obvious)				0	0	1
7.	331	Foreign yarn at front part (1cm)				0	0	1
Total Defectives Found:						0	8	8
Defectives Accepted:						0	10	14
Result:						PASS		
Remarks - Other defects observed but not counted in the AQL Result: N/A								

Figure 15: Final Inspection Report 14

Sainsbury's Argos				Inspection No.: B109224010303			
Supplier Self-Inspection Report				Report Date: Jan 3, 2023		Page 2 of 14	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2606406	143747591	2300	2319	40	2319	2319	100	0	0	0	0
Total:		2300	2319	40	2319	2319	100	0	0	0	0
List of Export Carton Numbers Opened			Carton No.: 03, 07, 10, 16, 22, 28, 31, 36, 39, 40.								
			Total <u>10</u> Cartons were opened for sampling.								

E. WORKMANSHIP (Basic Function & Appearance)								
Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)						
Inspection Level - Workmanship / Visual:		II		Acceptance Quality Limit (AQL) - Critical Defectives:			Not Allowed	
Sampling Plan - Workmanship / Visual:		Single / Normal		AQL - Major Defectives:			2.5	
				AQL - Minor Defectives:			4.0	
Sample Size - Workmanship / Visual:		Critical:		125	Major:		125	
				Minor:		125		
Defect Code	Defective Description				Critical	Major	Minor	
1.	334	Washing stain at front part (0.4cm)				0	2	0
2.	294	Broken stitch at hem & collar (0.6cm)				0	2	0
3.	44	Untrimmed thread at sleeve hem, inside pocket & back collar (1cm to 4cm)				0	1	2
4.	267	Poor pressing at back part (Non-Obvious)				0	0	2
5.	331	Foreign yarn at front part (1cm)				0	0	1
Total Defectives Found:						0	5	5
Defectives Accepted:						0	7	10
Result:						PASS		
Remarks - Other defects observed but not counted in the AQL Result: N/A								

Figure 16: Final Inspection Report 15

Sainsbury's Argos				Inspection No.: B109224010304			
Supplier Self-Inspection Report				Report Date: Jan 3, 2023		Page 2 of 14	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2611155	143940905	2630	2669	48	2669	2669	100	0	0	0	0
Total:		2630	2669	48	2669	2669	100	0	0	0	0

List of Export Carton Numbers Opened	Carton No.: 02, 07, 13, 19, 25, 32, 38, 43, 46, 48. Total <u>10</u> Cartons were opened for sampling.
--------------------------------------	--

E. WORKMANSHIP (Basic Function & Appearance)							
Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)					
Inspection Level - Workmanship / Visual:		II	Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed
Sampling Plan - Workmanship / Visual:		Single / Normal	AQL - Major Defectives:				2.5
			AQL - Minor Defectives:				4.0
Sample Size - Workmanship / Visual:		Critical:	125	Major:	125	Minor:	125

	Defect Code	Defective Description	Critical	Major	Minor
1.	46	High-low at placket & front placket (0.5cm)	0	2	2
2.	38	Skipped stitch at shoulder stitch (0.4cm)	0	1	0
3.	294	Broken stitch at placket (0.3cm)	0	1	0
4.	47	Fabric fault at sleeve (0.3cm)	0	1	0
5.	281	Back show at back collar & front pocket (Non-Obvious)	0	0	3
6.	267	Poor pressing at collar point area (Non-Obvious)	0	0	1
Total Defectives Found:			0	5	6
Defectives Accepted:			0	7	10
Result:			PASS		

Remarks - Other defects observed but not counted in the AQL Result: N/A
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Figure 17: Final Inspection Report 16

Sainsbury's Argos Supplier Self-Inspection Report	Inspection No.: B109224010801	Page 2 of 14
	Report Date: Jan 8, 2023	

D. QUANTITY(QTY)

P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2604685	143747363	2475	2522	47	2522	2522	100	0	0	0	0
Total:		2475	2522	47	2522	2522	100	0	0	0	0
List of Export Carton Numbers Opened		Carton No.: 02, 06, 10, 15, 20, 26, 30, 34, 38, 40. Total <u>10</u> Cartons were opened for sampling.									

E. WORKMANSHIP (Basic Function & Appearance)

Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)						
Inspection Level - Workmanship / Visual:		II		Acceptance Quality Limit (AQL) - Critical Defectives:		Not Allowed		
Sampling Plan - Workmanship / Visual:		Single / Normal		AQL - Major Defectives:		2.5		
				AQL - Minor Defectives:		4.0		
Sample Size - Workmanship / Visual:		Critical:	125	Major:	125	Minor:	125	
	Defect Code	Defective Description				Critical	Major	Minor
1.	334	Dirty stain & pen mark at front part (0.5cm to 1.8cm)				0	3	0
2.	294	Broken stitch at back yoke & hem (0.5cm to 1cm)				0	2	0
3.	44	Untrimmed thread at collar (2cm)				0	1	0
4.	41	Uneven hem turnup				0	0	2
5.	267	Poor pressing at collar				0	0	1
6.	281	Slanted & back show at sleeve hem & front pocket				0	0	2
Total Defectives Found:						0	6	5
						Defectives Accepted:		
Result:						PASS		
Remarks - Other defects observed but not counted in the AQL Result: N/A								

Figure 18: Final Inspection Report 17

Sainsbury's Argos				Inspection No.: B109224011001	
Supplier Self-Inspection Report				Report Date: Jan 10, 2023	
				Page 2 of 14	

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity <u>Units</u>	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			<u>Units</u>	<u>Cartons</u>		<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>	<u>QTY</u>	<u>%</u>
2611538	143941991	500	527	14	527	527	100	0	0	0	0
Total:		500	527	14	527	527	100	0	0	0	0
List of Export Carton Numbers Opened			Carton No.: 01, 02, 03, 04, 05, 06, 07, 08, 09, 10, 11, 12, 13, 14.								
			Total <u>14</u> Cartons were opened for sampling.								

E. WORKMANSHIP (Basic Function & Appearance)											
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)								
Inspection Level - Workmanship / Visual:			II	Acceptance Quality Limit (AQL) - Critical Defectives:						Not Allowed	
Sampling Plan - Workmanship / Visual:			Single / Normal	AQL - Major Defectives:						2.5	
				AQL - Minor Defectives:						4.0	
Sample Size - Workmanship / Visual:			Critical:	80	Major:	80	Minor:	80			
	Defect Code	Defective Description					Critical	Major	Minor		
1.	44	Untrimmed thread at sleeve cuff, front placket & armhole area (1cm to 3.2cm)					0	3	2		
2.	266	Pleat at vent area (Obvious)					0	1	0		
3.	281	Slanted at front pocket (Obvious)					0	1	0		
4.	267	Poor pressing at sleeve cuff & hem (Non-Obvious)					0	0	2		
5.	333	Knot at sleeve (0.2cm)					0	0	1		
Total Defectives Found:							0	5	5		
Defectives Accepted:							0	5	7		
Result:							PASS				
Remarks - Other defects observed but not counted in the AQL Result: N/A											

Figure 19: Final Inspection Report 18

Sainsbury's Argos Supplier Self-Inspection Report					Inspection No.: B109223112201		Page 2 of 13					
					Report Date: Nov 22, 2023							
D. QUANTITY(QTY)												
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished		
			Units	Cartons		QTY	%	QTY	%	QTY	%	
2593134	142675450	2911	2924	143	2924	2924	100	0	0	0	0	
Total:		2911	2924	143	2924	2924	100	0	0	0	0	
List of Export Carton Numbers Opened			Carton No.: 06, 16, 26, 34, 62, 75, 94, 108, 116, 125, 133, 140. Total 12 Cartons were opened for sampling.									
E. WORKMANSHIP (Basic Function & Appearance)												
Inspection Standard:			ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)									
Inspection Level - Workmanship / Visual:			II		Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed			
Sampling Plan - Workmanship / Visual:			Single / Normal		AQL - Major Defectives:				2.5			
					AQL - Minor Defectives:				4.0			
Sample Size - Workmanship / Visual:			Critical:		125		Major:		125		Minor:	
	Defect Code	Defective Description					Critical	Major	Minor			
1.	294	Broken stitch at waist band (1cm)					0	2	0			
2.	334	Dirty stain at front part (0.7cm to 4cm)					0	2	0			
3.	42	Shading at front & back part (Obvious)					0	1	0			
4.	44	Untrimmed thread at front part, crotch point & waist band (1cm to 2.5cm)					0	1	3			
5.	46	High/low at back pocket (0.5cm)					0	0	1			
Total Defectives Found:							0	6	4			
Defectives Accepted:							0	7	10			
Result:							PASS					
Remarks - Other defects observed but not counted in the AQL Result: N/A												

Figure 20: Final Inspection Report 19

Sainsbury's Argos					Inspection No.: B109223112901	
Supplier Self-Inspection Report					Report Date: Nov 29, 2023	
Page 2 of 12						

D. QUANTITY(QTY)											
P.O. No.	Product Item/Style No.	Order Quantity Units	Shipment Quantity		Presented Quantity for Inspection	Units Packed in Cartons		Units Finished Not Packed		Units Not Finished	
			Units	Cartons		QTY	%	QTY	%	QTY	%
2594650	143457585	800	802	19	802	802	100	0	0	0	0
Total:		800	802	19	802	802	100	0	0	0	0

List of Export Carton Numbers Opened	Carton No.: 01, 03, 06, 12, 15, 17, 19. Total <u>07</u> Cartons were opened for sampling.
--------------------------------------	--

E. WORKMANSHIP (Basic Function & Appearance)							
Inspection Standard:		ANSI/ASQ Z1.4 (formerly known as MIL-STD-105E)					
Inspection Level - Workmanship / Visual:		II	Acceptance Quality Limit (AQL) - Critical Defectives:				Not Allowed
Sampling Plan - Workmanship / Visual:		Single / Normal	AQL - Major Defectives:				2.5
Sample Size - Workmanship / Visual:		Critical:	80	Major:	80	Minor:	80

Defect Code	Defective Description	Critical	Major	Minor
1. 334	Pen mark & dirty stain at pocket area (2.5cm)	0	2	0
2. 44	Untrimmed thread at back pocket, crotch point & inside area (0.8cm to 5cm)	0	1	2
3. 381	Needle cut at front pocket (Obvious)	0	1	0
4. 267	Poor pressing at hem (Non-Obvious)	0	0	1
5. 331	Foreign yarn at front part (0.5cm)	0	0	1
Total Defectives Found:		0	4	4
Defectives Accepted:		0	5	7
Result:		PASS		

Remarks - Other defects observed but not counted in the AQL Result: N/A
--

Figure 21: Final Inspection Report 20

3.3. Summary

Date	Style Name	Check Piece. (cartons)	Fabric Fault	Shading	Foreign Yarn	Needle Cut	Broken Stitch	Skip Stitch	Uneven Stitch, Hem	Hi-low	Dirty Stain	Pleat	Slanted & Back Show	Poor Pressing	Looseness	Uncut Thread	Raw Edge	Defect		Total
																		Major	Minor	
Feb 22, 2024	14401 1201	10/86					2				2			2		1		4	3	7
Feb 20, 2024	14377 7790	13/165					1			2	2			2		5		6	6	12
Feb 20, 2024	14393 7861	10/80			1		1				1		2	3		3		6	5	11
Feb 20, 2024	14267 5450	07/28					1				2			2		4		4	5	9
Feb 20, 2024	14403 9721	06/25					1			1	2		1	1		3		5	4	9
Feb 14, 2024	14404 0001	07/45					1				2			2		4		5	4	9
Feb 06, 2024	14047 5745	14/58					1			2	1	1	1			4	1	5	6	11
Feb 3, 2024	14386 4324	07/42		1							1			4		3		5	4	9
Jan 24, 2024	14374 7591	10/10	1								2		2	2				3	4	7
Jan 23, 2024	14381 5741	06/18					1		2		1		1	2		2		4	5	9
Jan 23, 2024	14345 7585	07/24								2				2		4		4	4	8
Jan 22, 2024	14377 7790	10/38		1			1	1						2		3	1	4	5	9
Jan 3, 2023	14381 5741	6/24					2			1	1		3	2	2	1		4	8	12
Jan 3, 2023	14393 7861	10/77	2		1		3				1		4	1		4		8	8	16
Jan 3, 2023	14374 7591	10/40			1		2				2			2		3		5	5	10
Jan 3, 2023	14394 0905	10/48	1				1	1		4			3	1				5	6	11
Jan 8, 2023	14374 7363	10/47					2		2		3		2	1		1		6	5	11
Jan 10, 2023	14394 1991	14/14	1									1	1	2		5		5	5	10
Nov 22, 2023	14267 5450	12/143		1			2			1	2					4		6	4	10
Nov 29, 2023	14345 7585	07/19			1	1					2			1		3		4	4	8
Total		186	5	3	4	1	22	2	4	13	27	2	20	34	2	57	2	98	100	198
			(2.53%)	(1.52%)	(2.02%)	(0.51%)	(11.11%)	(1.01%)	(2.02%)	(6.57%)	(13.64%)	(1.01%)	(10.10%)	(17.17%)	(1.01%)	(28.79%)	(1.01%)			

Table 2: Final Inspection Report Summary

3.4. Intensity wise defect:

Uncut Thread	- 28.79 %
Poor Pressing	- 17.17 %
Dirty Stain	- 13.64 %
Broken Stitch	- 11.11 %
Slanted & Back Show	- 10.10 %
Hi-low	- 6.57 %
Foreign Yarn	- 2.02 %
Uneven Stitch	- 2.02 %
Shading	- 1.52 %
Skip Stitch	- 1.01 %
Pleat	- 1.01 %
Looseness	- 1.01 %
Raw Edge	- 1.01 %
Needle Cut	- 0.51 %
.....	
Total:	100%

4. CHAPTER 4

Result and Discussion

4.1. Analysis Data Collection:

According to the Table of total summary report displays the discrete defect issue in each final inspection. After analysis the table I ensure that, there are total 186 cartons garment are inspected and total 198 defects are identified.

4.2. Chart is given below based on [chapter 3.3](#)

4.2.1. Final Inspection faults are shown in the chart (20 Reports Summary)

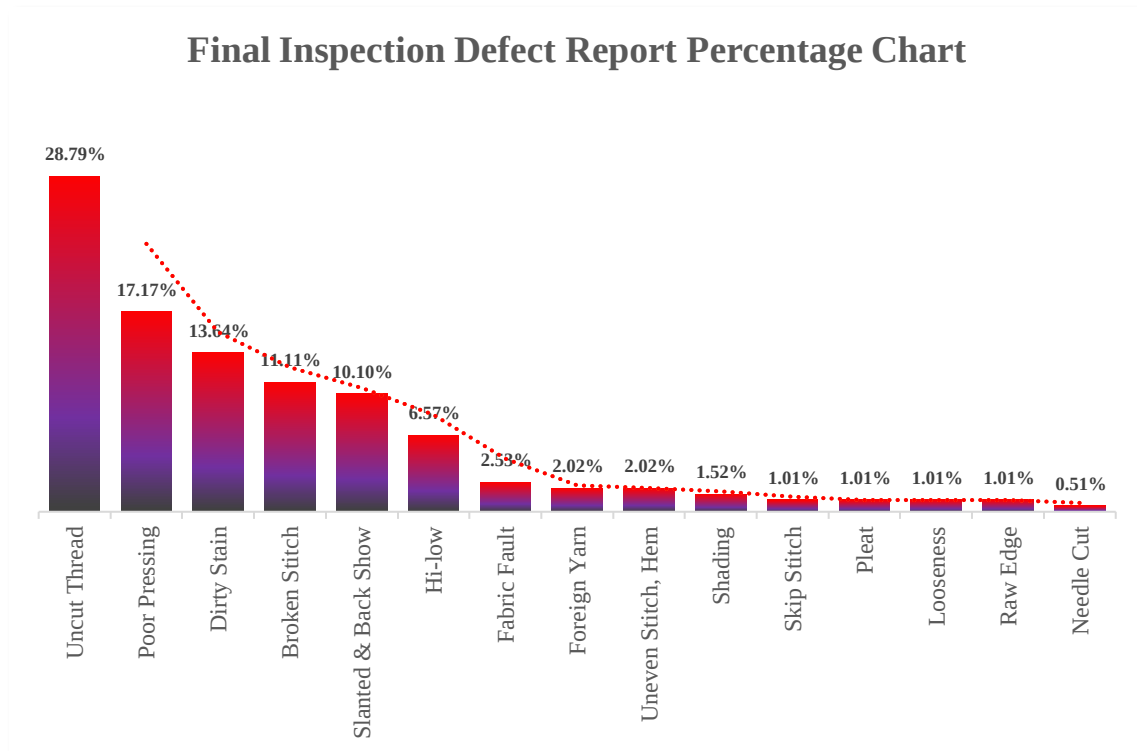
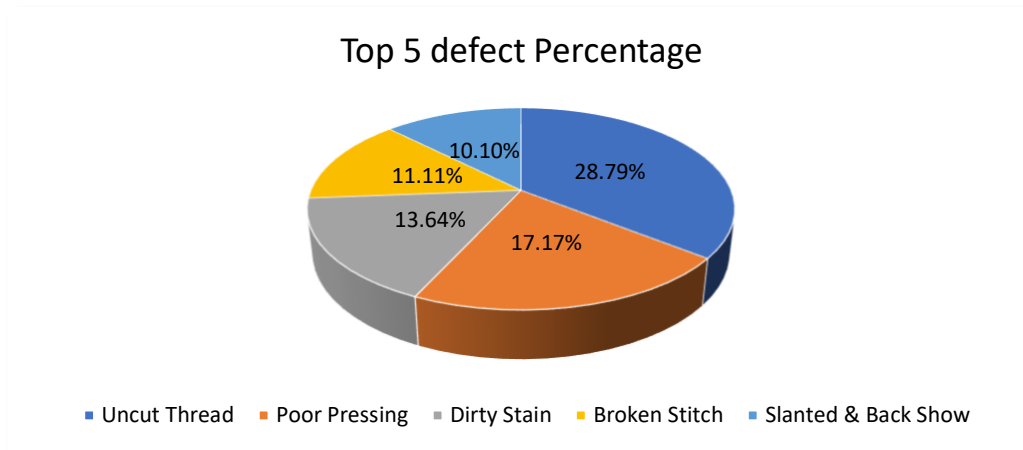


Figure 22: Final Inspection Defect % Chart

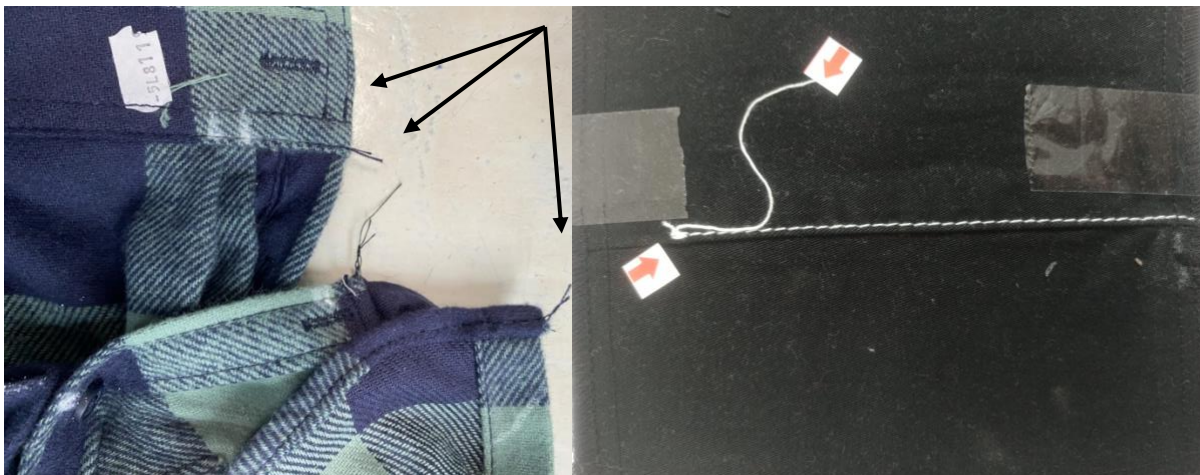
Here we can see in the above chart the percentage of Final Inspection Defect. From that chart I can tell that throughout my (20 report) analysis on finished garment. I have found some defects found. Those defects are Uncut Thread - 28.79 %, Poor Pressing - 17.17%, Dirty Stain - 13.64 %, Broken Stitch - 11.11 %, Slanted & Back Show - 10.10 %, Hi-low - 6.57%, Foreign Yarn - 2.02 %, Uneven Stitch - 2.02 %, Shading- 1.52 %, Skip Stitch - 1.01 %, Pleat- 1.01 %, Looseness - 1.01 %, Raw Edge- 1.01 % & Needle Cut- 0.51 %.

4.3. Discuss about top 5 defects with remedies:



4.3.1. Uncut Thread (28.79%):

- If some extra unnecessary thread remains, then it's called uncut thread.



Causes:

1. Incorrect cutting machine settings.
2. Sewing machine wiper not used properly.
3. Operator and helper do not cut their extra thread in their own operation.

Remedies:

1. Need to use a sewing machine wiper.
2. Need to use thread trimmer after every operation.
3. Must train every operator and need to inspire to cut extra thread in their own operation.
4. Properly Garments finishing should be checked.

4.3.2. Poor pressing (17.17%):

- Poor pressing in garments is a defect related to the finishing process where the ironing or pressing of the garment is not done properly. This is noticeable problems that detract from the garment's overall quality and look.



Causes:

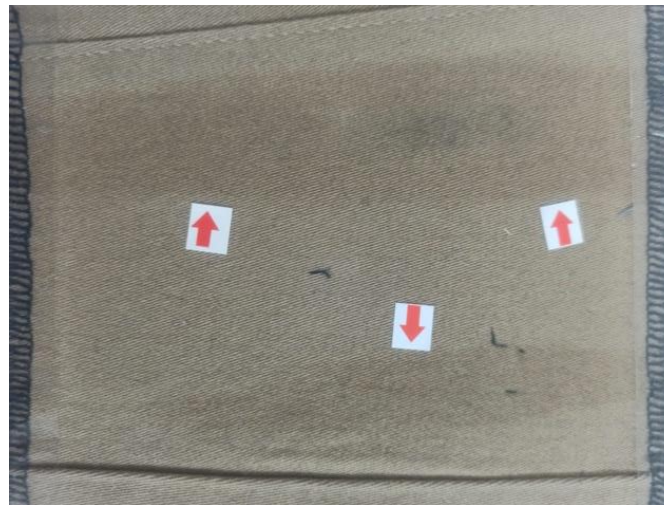
1. Insufficient heat or pressure during pressing.
2. Insufficient steam or moisture.
3. Lack of skill or training in the pressing process.
4. Poor-quality pressing equipment.
5. Incorrect pressing techniques for specific fabrics.
6. Rushed or Insufficient time allocated for pressing.
7. Inconsistent pressing across different parts of the garment.

Remedies:

1. Ensure proper training for press operators.
2. Use high-quality pressing equipment.
3. Set appropriate heat and pressure levels for different fabrics.
4. Implement thorough quality control checks after pressing.
5. Allow sufficient time for each garment to be pressed correctly.
6. Use steam or moisture as needed for specific fabrics.
7. Address and rectify any issues with pressing machinery properly.

4.3.3. Dirty Stain (13.64%):

- A "dirty stain" is a visible mark on a fabric or garment caused by dirt, grease or foreign matter during handling, transport, or storage.



Causes:

1. Improper handling during manufacturing or transportation.
2. Lacking storage conditions exposing the fabric to dirt.
3. Accidental spills of liquids or substances during production.
4. Contaminated work surfaces and equipment.
5. Poor hygiene during garment assembly.

Remedies:

1. Implement strict hygiene practices in the manufacturing environment.
2. Improve and enforce proper storage conditions for fabrics and finished garments.
3. Train personnel on careful handling techniques during production.
4. Regularly clean work surfaces and equipment to prevent contamination.
5. Implement quality control measures to identify and address stains before the final product reaches consumers.

4.3.4. Broken Stitch (11.11%):

- When a thread fails to create a strong, continuous connection, leaving gaps or breaks in the stitched line, it is broken stitch. This may weaken the stitching in fabrics.



Causes:

1. Incorrect Thread Tension.
2. Dull or Bent Needle.
3. Thread Quality Issues.
4. Machine Malfunctions.
5. Machine Speed.
6. Inadequate Lubrication.

Remedies:

1. Adjust Thread Tension.
2. Replace or Sharpen Needles.
3. Use High-Quality Thread.
4. Machine Maintenance.
5. Control Machine Speed.
6. Proper Lubrication.

4.3.5. Slanted & Back Show (10.10%):

- When a seam, stitch, or other component of a garment is not properly aligned, that is slanted. And when two pieces of a garment are attached, the lower portion that is supposed to be covered is left uncovered or visible, that is back show.



Slanted-

Causes:

1. Misalignment during the cutting process.
2. Uneven tension on the sewing machine.
3. Incorrect feeding or guiding of the fabric during sewing.
4. Operator Skill problem

Remedies:

1. Ensure accurate alignment during the cutting phase.
2. Regularly check and adjust the tension settings on the sewing machine.
3. Properly guide and feed the fabric to maintain even stitching.
4. Must train every operator.

Back show-

Causes:

1. Misalignment during sewing.
2. Uneven tension on the sewing machine.
3. Incorrect stitching technique.
4. Insufficient seam allowance.
5. Faulty cutting.
6. Use of inappropriate thread.
7. Operator skill level.
8. Pattern irregularities.

Remedies:

1. Align components perfectly.
2. Regular tension checks.
3. Training on stitching techniques.
4. Ensure enough seam allowance.
5. Improve cutting procedures.
6. Enhance quality control measures.
7. Select appropriate thread.
8. Ensure operator training.
9. Review and improve patterns.

5. CHAPTER 5

5.1. CONCLUSION

The thesis has been a rewarding journey through extensive discussions and inspections, providing valuable insights into final buying quality control. It has enriched our understanding of navigating complexities and the importance of attention to detail and effective communication. This knowledge will serve as a solid foundation for future growth and success in quality control, allowing us to contribute meaningfully to our respective fields.

We can work in a clothing industry thanks to the thesis project. It was a hands-on learning opportunity outside of the typical classroom setting. We learned real facts about people, equipment, supplies, techniques, and the industry from this course. I now have firsthand, practical understanding of the raw materials, the state in which machines operate, the job of technicians, and administration. We toured the store, cutting, sewing, and administrative section during our training. We encountered kind treatment from every employee around. We regard this relationship as a means of bridging the knowledge gap between theory and practice. Without a doubt, this attachment helped us learn more about industrial procedures, industrial management, textile technology, and the production process.

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