



Faculty Of Engineering
Daffodil International University

**‘Study On Sample Development Procedure For
Woven Items’**

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LETTER OF APPROVAL

To,

The Head

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

Dear sir,

I would be grateful if you could accept this project report and consider it for final evaluation. I'm just writing to let you know that the project report titled "Study On Sample Development Procedure For Woven Items" has been completed for final evaluation by the students "Navid Alam bearing ID 212- 23-5798, Arup Sarkar bearing ID 212-23-5800." The entire report is made on the basis of appropriate investigation and interruption by critical examination of empirical data with necessary belongings. The students were actively involved in their project activities and the creation of the report. It is critical to generate a lot of useful material for the readers.

Therefore it will

Yours sincerely,



Abdullah Al Mamun

Associate Professor

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DECLARATION

We therefore declare that we completed this project with the assistance of Mr. Abdullah Al Mamun, Assistant Professor, Department of Textile Engineering, Daffodil International University. We further declare that neither this project nor any part of it has been presented elsewhere to the best of our knowledge.



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ABSTRACT

Our thesis topic is “Sample development procedure of woven items”. A sample development process begins with the buyer's order confirmation. It is difficult for the manufacturer to make ideal sample garments. A sample order serves as the buyer's means of identifying and evaluating the manufacturer's capabilities. After receiving the garment sample, they will decide whether to place the order with the manufacturer. The apparel industry works only when orders are received. Merchandisers help with orders. They contact the customer and get an order from them. However, after the sample arrives, the customer verifies the order. After making sure everything is in order, they check everything they need for the clothes before placing the order. Because of this, both manufacturers and consumers place the biggest value on sample clothing. By the completion of this thesis, we hope to have an understanding of the sample development process from start to finish. What kind of documents need to be approved for the buyer and what are the necessary things to be taken into consideration are discussed here. While working on this thesis, we have had direct or indirect contact with every industry, and we have been able to gain amazing knowledge about the complete sample development. After completing it, we got the final sample. We learned how to develop a product step by step.

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Chapter-01

Introduction

1.1: Background Of The Study

The textile industry in Bangladesh is a critical component of the country's economy, significantly contributing to its growth. Bangladesh has become a global champion in the textile and garment sector over the past few decades as a result of a combination of favorable government policies, a large and skilled workforce, and competitive labor costs. The textile industry in Bangladesh began to develop in the early 1980s and continued to expand throughout the 1990s and early 2000s. Initially, it concentrated on the production of low-cost, mass-market garments for export. However, it has since expanded its operations and advanced in the value chain. The textile and garment industry is a fundamental component of the Bangladeshi economy, accounting for approximately 11% of the nation's GDP. It provides essential livelihood opportunities and promotes gender equality by employing more than four million individuals, the majority of whom are women. The European Union, the United States, and Canada are among the main markets for Bangladesh's textiles and garments, which account for over 80% of the country's total exports. International apparel labels and merchants are drawn to Bangladesh due to its low labor costs, which rank among the lowest in the world. The industry capitalizes on a substantial population of skilled and semi-skilled laborers who possess expertise in a variety of garment production processes. Various incentives, such as tax rebates, duty-free import of apparatus, and back-to-back letters of credit, are provided by the government to promote the industry's expansion.

In this industry, there are many departments to support and grow the industry very smoothly. As like Merchandising, Industrial Engineering, Knitting, Dying, Planning, CAD, R&D, Printing, Washing, etc.

The Merchandising department in the apparel industry is essential for bridging the gap between design, production, and sales. It is responsible for creating samples and obtaining approvals, as well as negotiating with the customer, creating cost and expense sheets, and ensuring that the appropriate products are available at the appropriate time, place, and price to meet consumer demand.

The merchandising section does thorough research to comprehend market trends, customer preferences, and the competitive environment. This entails scrutinizing

data from several sources such as fashion exhibitions, trade fairs, and retail reports. Engage in collaboration with designers and trend analysts to anticipate and integrate forthcoming fashion trends into the product range. Source and acquire raw materials and textiles from dependable vendors that adhere to quality criteria and financial limitations. Engage in pricing negotiations, establish delivery schedules, and determine payment conditions with suppliers in order to achieve cost-efficient procurement. Develop and uphold quality benchmarks for both raw materials and final products, doing routine inspections and audits. The merchandising department organizes production meetings, oversees mass manufacturing, conducts final product quality inspections, and manages transportation. Merchandisers must possess a comprehensive comprehension of firm legal paperwork in order to carry out retailing activities effectively. The paperwork consists of bills of lading, packing lists, dispatch documents, negotiable checks, pro forma checks, and credit letters.

Merchandising department's goals are to align product offerings with market demand, optimize inventory levels, and maximize profitability while maintaining brand integrity and sustainability.

In this department Sample developing procedure is one of the most important for receiving orders. They need to approve samples to do work to the next step. The sample development procedure in the apparel industry is of critical importance for several reasons. This stage serves as the foundation for the entire production process, ensuring that the final products meet the desired quality, fit, and aesthetic standards.

1.2 Objectives of the study

In this project, a merchandiser creates many excellent samples in accordance with the demands of various customers.

Objectives are given below :

- ❖ To know about sample development.
- ❖ To know about the procedure of sample development.
- ❖ To know about Tech pack in detail.
- To know about the pricing of a sample.
- ❖ To study sewing machine operation, stitch types, and seam comparisons between Various clothing.
- ❖ To learn about the kinds of samples that the buyer requires.
- ❖ To be knowledgeable about technological fixes for various types of errors.

1.3 Significance of The Study

In the thesis report, we have discussed the steps to be taken to create a merchandiser's sample development. So that a common student can learn some things from the report and understand the challenges taken by the merchandiser, Samples are very important to inform the buyer about the exporter's potential and allow the buyer to judge the exporter's production. First, we discussed how merchandisers collect the tech pack provided by the buyer and go through sample development step by step. Analyzing the tech pack is the first task of the merchandiser. Then get an estimate of the cost of making a complete sample, including fabric, measurements, sewing, accessories, and the cost of a complete order. By looking at all the topics, a student can gain good knowledge about sample development.

1.4 Limitations of the study

- ❖ Can't learn about the full process of merchandising
- ❖ Only known about woven items
- ❖ Restriction of mobility around the element.

CHAPTER -02

LITERATURE REVIEW

2.1 Definition of garments sample

A garment sample is a piece of clothing that is used to judge a group or a lot of other items based on size, style, quality, or some other factor. Based on clothing examples, the buyer confirms or gives comments on any changes in the quality of the product. Samples of clothing can be made either before or after the final product is made. Extra care should be taken when getting clothes models ready. In order to make it easy to get orders from buyers, different models are made for each order or design. There are different steps of prototyping that are used to get the exact result of an improved spirit.

An excellent sample gives buyers and exporters or manufacturers a positive first impression.

2.2 Sample Development

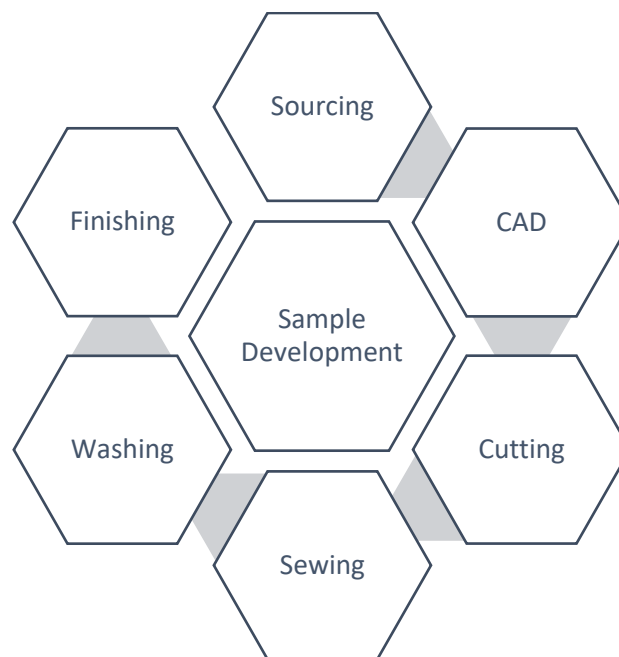
Sample development refers to the process of creating fabric and cloth samples for the purpose of obtaining the buyer's approval. It represents the product's aesthetic. It assists in identifying the style number, cloth structure, zipper and button type, consumption, rate, and other accessories. In this particular segment, it is vital to have operators of superior caliber. Furthermore, every product necessitates the utmost level of quality in order to achieve high-quality results.

Once the chosen sample has been accepted, it is locked in for mass production. For the style, size, color, and other details, they make a lot of them based on the approved model. In the clothing business, sampling is a big part of the pre-production step.

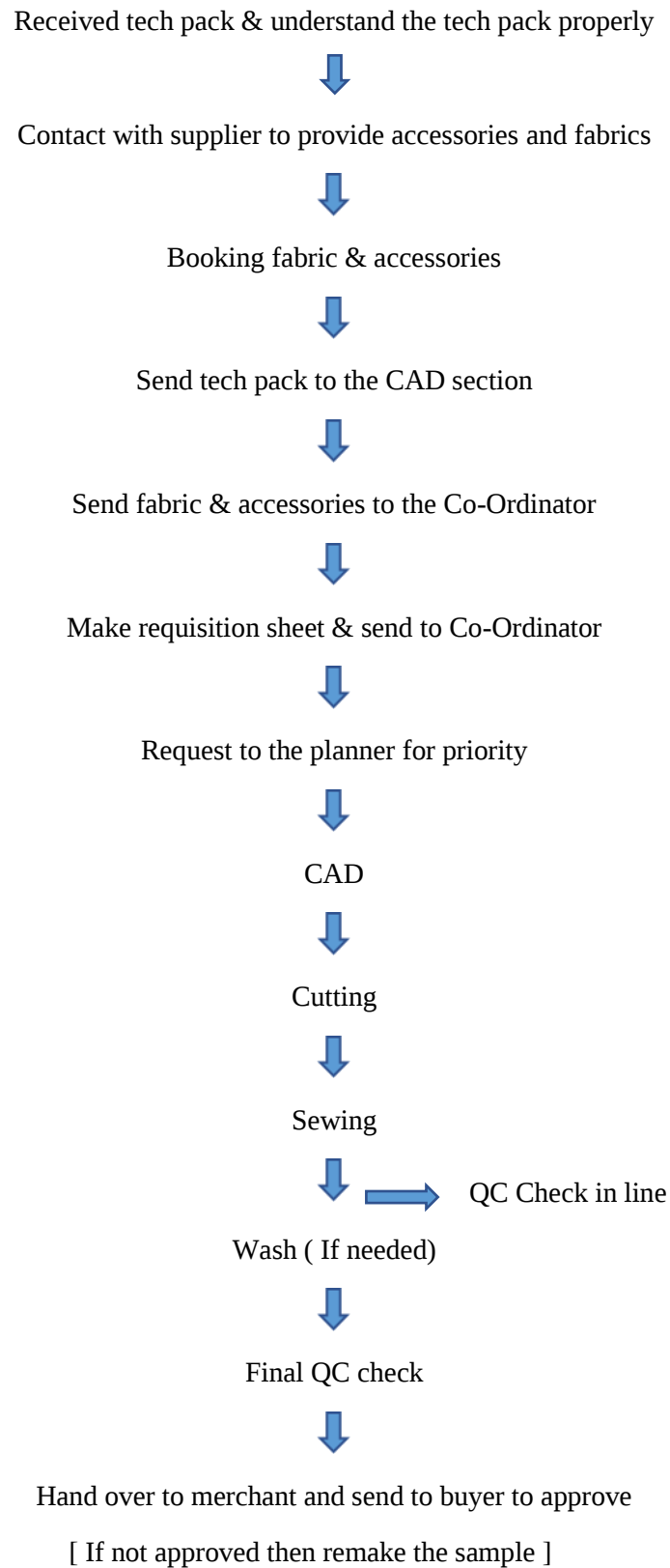
The high-quality sample helps a company that manufactures or exports apparel win business by determining whether the buyer will approve their future purchases.

2.3 Garment Sample Development Process

A development merchandiser depends on many sections for developing the sample, These are Sourcing, CAD, Cutting, Sewing, Washing, and Quality section & many people are included here. Development merchandisers always connect with those sections to develop samples properly.



2.3.1 Flow Chart Of Sample Development



2.3.2 Tech Pack

The technical package is a long document that is used in the clothing business to give makers and sellers detailed information about a garment. It is used as a guide for making clothes and has all the details that are needed to make sure the finished item meets the designer's vision and quality standards. A tech pack includes a model picture or structure, a measuring chart, a label tag, and directions for packing, as well as information about the fabric type or construction.

After receiving the tech pack read it properly to understand the style and buyer requirements.

2.3.3 Sourcing Materials

After understanding the tech pack and buyer requirements, then contact with supplier to provide fabric, trims, and accessories. Sometimes buyer fix the supplier & and sometimes, merchandisers need to source materials.

2.3.4 CAD Section

Tech pack must be sent to the CAD section for pattern making of the sample, here the CAD master makes the pattern to follow the measurement and style of the sample. For perfect measurement of the pattern have to shrinkage test.

2.3.5 Planning Section

Planning section of the sample, make the planning of making the sample. Development merchandiser must need priority from planning section to making sample. Development merchandiser requests for priority on the previous day of the operation of making samples. The next day, the planner puts the sample at the priority chart & distributes the work in sample section, like which operator conducts the operation, which in charge follow up on the operation & which quality controller checks the finishing sample.

2.3.6 Co-Ordinator

A Co-Ordinator is a person who helps to making the sampling procedure. Development merchandiser provides all of fabric, accessories & trims to Co-Ordinator. And also send requisition form for sample. Co-Ordinator provides fabric, accessories & trims to sample section to make the sample. If Development merchandiser missed to provide anything to Co-Ordinator, Co-Ordinator must stop making the sample.

2.3.7 Cutting

Cutting section of the sample follows the pattern of the CAD section to cut the fabric for a specific style.

2.3.8 Sewing

Sewing section sewing the sample in a specific style. here, skilled operators do the work.

QC checks the sewing fault of the sample and corrects the sewing.

2.3.9 Measurement & Finishing

Final QC check the measurement and finishes the sample. here are some chart for measurement check. Uncut threads are cut for the smooth finishing of the product.

2.4 Types of Samples & Their Uses

Serial no	Sample	Use
01	Proto Sample	To convert the pattern into actual garment
02	Fit Sample	To check the fit and construction of the garment.
03	Size Set Sample	To fit the styling of the garment.
04	Counter Sample	The first sample a factory makes for a production order
05	Top Sample	To assure buyer that the same quality is maintained as shown in the sample
06	Counter Sample	To see the Workmanship and test the Factory's skill
07	Salesman Sample (SMS),	To showcase in various showrooms to get the order.
08	Pre-production Sample (PPS)	To gain approval before the bulk Production.
09	Production Sample	To gain approval for shipping the garment.
10	Shipment Sample	To assure buyers that quality is maintained throughout the end of production.

Fig: 2.4 Type of samples & their uses

2.5 Types of Samples Required for Completing an Order

To complete an order for the garments, these eight primary types of samples are required. These are-

- a) Proto Sample
- b) Fit Sample
- c) Size Set Sample
- d) Pre-Production Sample (PPS)
- e) Counter Sample
- f) Salesman Sample (SMS)
- g) Production Sample
- h) Shipment Sample

All of the aforementioned garment examples are covered in the following:

2.5.1 Proto sample

Proto is derived from the Greek word meaning "first" or "original". The first sample is obtained at the beginning of the sampling process. The objective of this sample is to authenticate the style and design. If the original fabric and trimmings are unavailable, alternate fabric and trims might be utilized to produce the sample.

If the customer rejects the initial prototype, the producer is required to provide a further prototype sample for approval.

2.5.2 Fit Sample

Once the proto sample has been approved, the developer should proceed to create the fit sample using the measuring sheet given. It may be created by utilizing fabric that is comparable in texture, has a higher GSM (grams per square meter), and can be dyed in any color. For the Fit sample, it is imperative that the stitching and measurement be absolutely precise. While the fabrication and color options are flexible, there is no chance of compromise when it comes to stitching and measurement. The fit sample typically consists of 2-3 garments, with one piece retained by the maker and the remaining pieces supplied to the customer.

2.5.3 Size Set Sample

Size set samples are groups of clothing pieces made in different sizes so that the fit and style can be tested on different body types before the clothes are made in large quantities. A size set sample might include t-shirts in small, medium, large, and extra-large sizes if a new t-shirt design is being made. Designers and makers can be sure that the clothes will fit well and look good on all sizes this way.

2.5.4 Counter Sample

A factory will create two to three extra samples for internal use when it produces samples for various sample approvals from the buyer. We refer to these samples as the counter sample. Counter samples are the copy of original sample.

2.5.5 Salesman Sample (SMS)

In the clothes business, a salesman sample is a prototype of a piece of clothing that is made before the full production run. The salespeople use these samples to show the new collection to people who might buy it, like stores or sellers, in order to get orders.

2.5.6 Pre-Production Sample (PPS)

In the clothing business, a pre-production sample is a final version that is made before the big production starts. It is used to make sure that the clothing meets all the requirements for style, quality, and production. The makers and quality control team look over this model carefully and give their approval to make sure everything is perfect before the whole batch is made.

2.5.7 Production Sample

Factory starts bulk production after the PP sample approval. After the bulk production start, few garments are picked randomly from the production output of the first production run for quality checking by the buyer's QA. These samples are known as Top of Production sample.

2.5.8 Shipment Sample

When the items are prepared for shipment, the final inspection must be completed and a shipment sample is required. For packing information, please refer to this sample; all information is linked to the final garment. Three shipment samples are kept by the factory: one for the customer, one for the factory, and one for the buying house merchant.

2.6 Advantages & Disadvantages of Product Development By Buying Specification

2.6.1 Advantages of Product Development by Buying Specification

- ❖ The market is better understood by the buyer due to market forecasting.
- ❖ The buyer determines the latest designs and trends that are on offer.
- ❖ Buyers typically develop colors, prints, and patterns to establish new markets and a prosperous business environment.
- ❖ The buyer bears full responsibility for the produced style's success.

2.6.2 Disadvantages of Product Development by Buying Specification

- ❖ If the buyer does not have the capability for in-house production, the process of product development becomes lengthy.
- ❖ The buyer has to depend on the buying house or the clothing/textile producer to develop the lab-dip, strike-off, and samples.
- ❖ At this time product development becomes expensive.
- ❖ Buyers' styles often lead the market in new directions.

CHAPTER – 03

METHODOLOGY

For sample development, we took a deep analysis of the tech packs offered by various buyers from the merchandisers. Our focus on CELIO & OKAIDI buyers.

Here we studied about half sleeve shirt from CELIO buyer and boys Skinny Long Pant from OKAIDI buyer.

Tech Pack with Specification

Different types of tech packs carry different types of data. There are different types of tech packs that we worked on during the internship, but in this thesis, we have presented one tech pack along with specifications which we present here nicely.

Buyer : CELIO

Celeio is a famous French retailer for men's clothes that is known for selling modern and stylish clothes. Celio is a big name in the fashion industry around the world, and it does a lot of business through its many shops and online sites. Celio has gone from being a small French company to a global clothing store, and its shoppers have been very important to this growth. Celio's past and how the buyer job has changed over time show how the brand has grown from a small French store to a global fashion giant. Buyers have been very important to Celio's success. They have helped the company adapt to changes in the market and adopt new technologies, and they have made sure that Celio continues to meet the needs of its diverse and changing customer base.

Here are some details of Celio buyer :

Industry & Type	Retail & Private limited liability company
Company Size	4,000 Employes
Founder	Maurice Grosman
Founded	1978
Sourcing Office	China, India, Bangladesh, and Vietnam
Head Office	Saint-Ouen, Paris, France
Annual Revenue	1B Euros Per Year

3.1 Short Sleeves Shirt Of CELIO Buyer

Style Name : BAGAZ

celio*	Buying file
WINDY APPARELS LTD	BAGAZ 24H
Collection : 24H	Created by : 2023-10-13 -
Universe : ESSENTIAL	Last update : 2024-02-28
Fashion scale : 3- KEY ITEMS	File download : 2024-04-02
Department : 03 10 SHIRT	Color Proto :
Family : SHORT SLEEVES SHIRT	ok sous conditions
Sub family : Short sleeves Shirt	
Active sizes : XS S M L XL XXL	
Fit : Regular	
Folding type : SHIRT - folding B - SS - Flat collar	

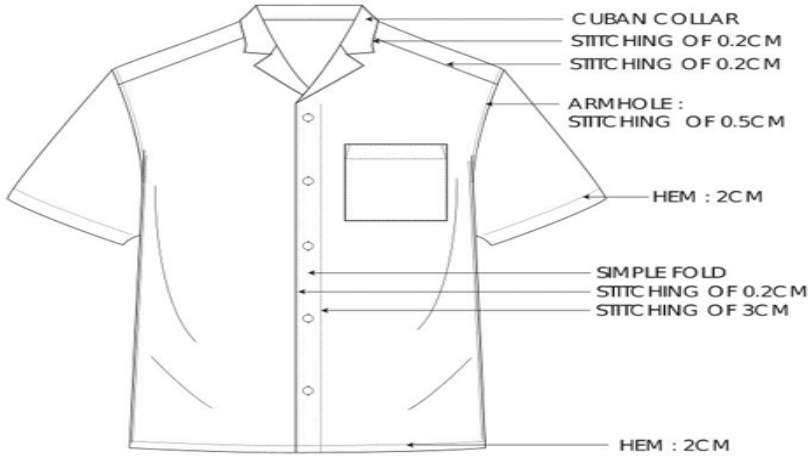
celio*	Tech sketches
WINDY APPARELS LTD	BAGAZ 24H
HIGH SUMMER 24 - BAGAZ	
	
PATTERN / SHIRT REGULAR PLUS SS V2 FABRIC / SAME AS BAGAZ SS23 COLLAR / CUBAN COLLAR FRONT / SIMPLE FOLD + STITCHING 0.5CM + STITCHING 3CM BACK / YOKE : 9CM HEM / SIMPLE HEM : 2CM BUTTON / HO FAT / REF : BS2-023 SEMI-MAT - DTM FOR ALL COMBO BUTTON SIZE / 11.5MM FOR FRONT PLACKET BUTTON THREAD / DTM WITH BUTTON BUTTONHOLE / DTM WITH SHELL FABRIC THREAD / 5 POINTS/CM - DTM TO SHELL FABRIC INTERLINING / 50 FT TREATMENT / GARMENT WASH (SAME HANDFEEL AS BAGAZ SS23)	

Fig 3.1 : Short Sleeves Shirt of CELIO Buyer

BAGAZ is a short-sleeved shirt. It's an order from CELIO buyer for Summer 2024. Windy Group developed the sample for BAGAZ & approved the sample for receiving the order.

In our discussion, we will present all of the details & steps for the development of the style (BAGAZ) of CELIO buyer.

3.1.1 Details of the specific style (BAGAZ)

We Collect the information and specific details for the style from the tech pack.

In below the details :

- ❖ Fabric Specification: 100% cotton double cloth, 40x40/1000x84,
- ❖ Weight : 115 GSM (+/-5%), Shrinkage (ISO 6330): warp-23%, weft 18%
- ❖ Interlining: Tricot
- ❖ Wash: Garment Reactive Dye
- ❖ Button: 11.5 mm, 4H Plastic Button
- ❖ Sewing Thread: 40/2

3.1.1.a Items & Supplier Names

Sl No	Items	Supplier
1.	Shell Fabric	NZ
2.	Button	Dekko
3.	Main Label	Adzi
4.	Size Label	Adzi
5.	Info Tag	Adzi
6.	Loop	Adzi
7.	MRS Sticker	Adzi
8.	PriceTicket,PolySticker, Carton Sticker	PAXAR
9.	Barcode,Warning,Care Label	S25
10.	Clips	Babylon
11.	Gum, Scootch Tape	Apparel Mart
12.	Sewing Thread	Apparel Mart
13.	Single, Dark Polybag	Label edge
14.	Carton	A.H Packaging

Fig 3.1.1 a: Supplier names for BAGAZ

3.1.1.b Specific Sketches for BAGAZ

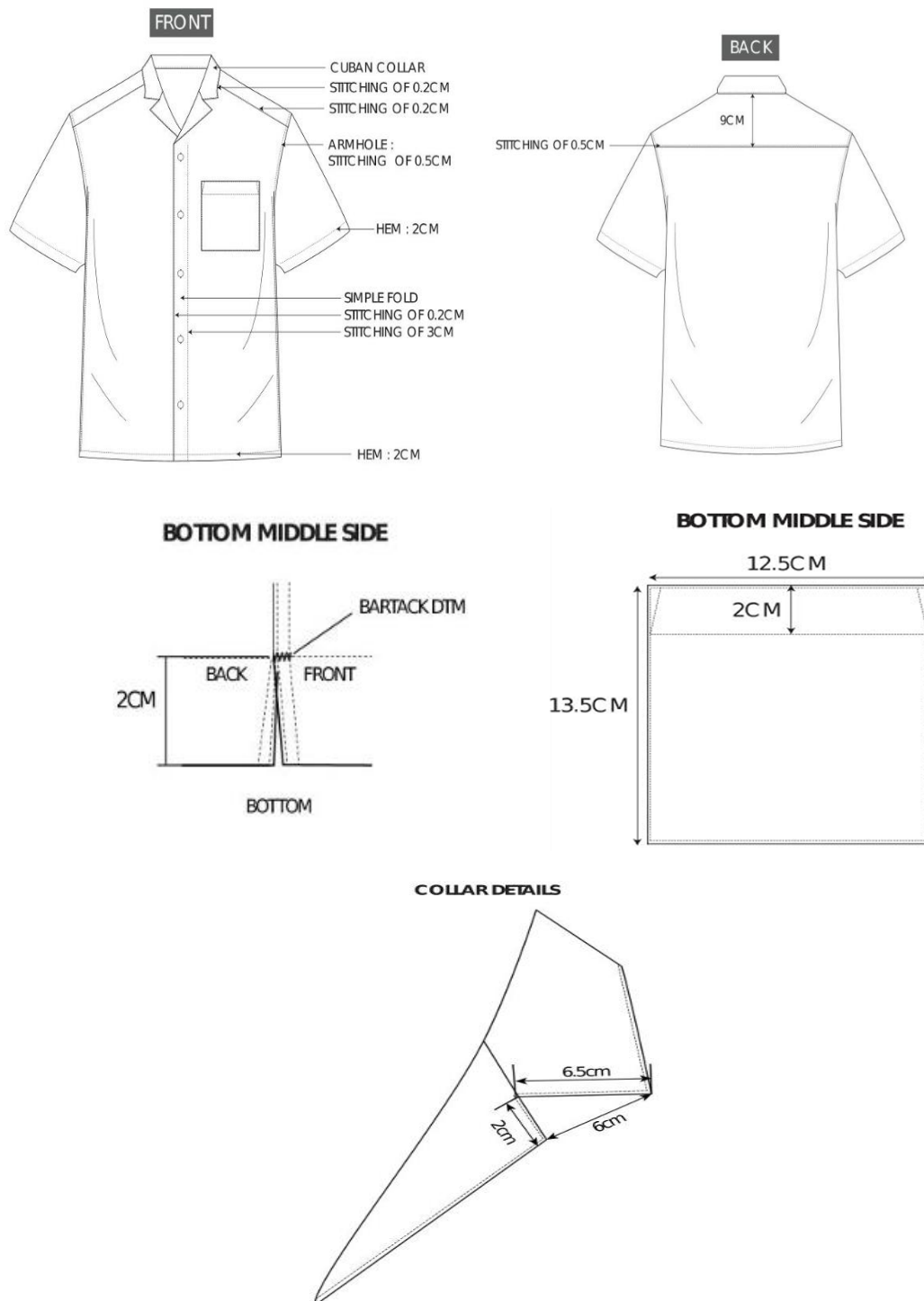


Fig 3.1.1.b: Specific sketches for BAGAZ

3.1.1.c Care Labels & Trims For BAGAZ

celio* **Fabrics**
WINDY APPARELS LTD **BAGAZ** 24H

Fabrics :

Type	Composition	Colors	Comments
SHELL FABRIC 1	100% Cotton	All colors	

Care symbols :

1171      TM

Care 19/C

Laver à l'envers avec couleurs similaires
Wash inside out with similar colours
Lavar del revès con colores similares
Lavare al contrario con colori simili
Prát na lewej stronie z podobnymi kolorami
Spalati pe interior alaturi de culori similare
Lavar do avesso com cores similares
СТИРАТЬ НАИЗНАНКУ С ВЕЩАМИ ПОДОБНОГО ЦВЕТА
Met soortgelijke kleuren binnenstebuiten wassen
Prát naruby a s výrobky podobné barvy
Perte obrátené na rubovú stranu s podobnými farbami
يغسل مقلوباً مع نفس الألوان
Skalbt išvertus su panašios spalvos gaminiais
Да се пере от вътрешната страна заедно с подобни цветове
Теріс айналырып өзімен түстес заттармен жуу керек
Spalati pe interior alaturi de culori similare
გარეცხეთ უკუღმა პირზე იმავე ფერის ნივთებთან ერთად

Fig 3.1.1.c: Care Symbols For BAGAZ

Description :

Care labels on clothing offer vital instructions to assist clients in effectively maintaining their apparel, so guaranteeing durability and excellence. The labels are commonly stitched into the clothing's seam and consist of standardized symbols accompanied by written instructions. Comprehending these symbols and instructions is essential for ensuring appropriate maintenance of garments.

Here are the symbols meaning :

- 1) Machine wash can be applied at 40°C.
- 2) Do not bleach wash.
- 3) Tumble dry do not apply.
- 4) Ironing in warm state 150°C.
- 5) Do not dry clean.

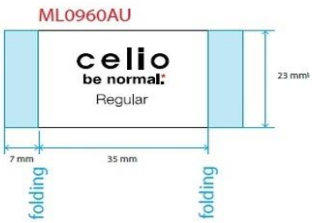
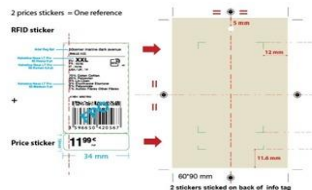
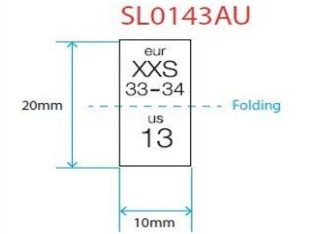
ML0960AU MAIN LABEL (23mmx35mm) REGULAR 	IT1928AU MAIN HANGTAG optical white 	CL0385AU Pack Care label SHIRT size / CL + 																
ET0340AU Folding B - Flat collar - plastic <table border="1" data-bbox="303 842 616 954"><thead><tr><th colspan="2">Plastic extra trims B flat collar</th></tr></thead><tbody><tr><td>.4 pcs Plastic clip, weight = 0.002 gm</td><td></td></tr><tr><td></td><td></td></tr><tr><td></td><td>0,002</td></tr></tbody></table>	Plastic extra trims B flat collar		.4 pcs Plastic clip, weight = 0.002 gm					0,002	WL0081AU WARNING label / cold Dye 	ET0341AU Folding B - Flat collar - paper <table border="1" data-bbox="967 842 1273 954"><thead><tr><th colspan="2">Paper Extra trims B flat collar</th></tr></thead><tbody><tr><td>Tissue paper, weight = 0.004 gm</td><td></td></tr><tr><td></td><td></td></tr><tr><td></td><td>0,004</td></tr></tbody></table>	Paper Extra trims B flat collar		Tissue paper, weight = 0.004 gm					0,004
Plastic extra trims B flat collar																		
.4 pcs Plastic clip, weight = 0.002 gm																		
	0,002																	
Paper Extra trims B flat collar																		
Tissue paper, weight = 0.004 gm																		
	0,004																	
PS0054AU Price sticker / tag shirt 	SL0143AU W20 SIZE LABEL (10x10mm in loop) SHIRT 	LP0051AU LOOP ALL UNIVERSE WHITE 																

Fig 3.1.1.c(a) : Trims Of BAGAZ

Description:

In the production of clothing, trimmings have a variety of effects on fit, appearance, durability, and brand identity. To create items that satisfy both market and design requirements, they must be carefully chosen and applied to sample outfits.

3.1.1.d Measurement Chart Of BAGAZ

celio*		Size specs									
WINDY APPARELS LTD		BAGAZ									
Paper pattern :		SHIRT REGULAR PLUS SS V2									
Code	Description (unit: cm)	Tol +/-	Proto	XS	S	M	L	XL	XXL	XXXL	
A01	Neck width from HSP to HSP	0.5		13.0	14.0	15.0	16.0	17.0	18.0		
B01a	Shoulder slope in cm	0.0		5.5	5.5	5.5	5.5	5.5	5.5		
B05	Shoulder seam length	0.5		15.0	15.5	16.0	16.5	17.0	17.5		
B10	Across shoulder	1.0		43.0	45.0	47.0	49.0	51.0	53.0		
C01	Armhole depth straight measured	0.5		22.0	23.0	24.0	25.0	26.0	27.0		
D01	Front shoulder breadth	1.0		37.2	39.6	42.0	44.4	46.8	49.2		
D07	Back yoke bottom seam length	1.0		42.2	44.6	47.0	49.4	51.8	54.2		
D08	shoulder breath position from HSP	0.0		16.5	17.0	17.5	18.0	18.5	19.0		
E02	Chest width at armhole bottom line, back pleat closed if any	1.0		50.0	54.0	58.0	62.0	66.0	70.0		
E03	Waist width at the tightest level	1.0		46.0	50.0	54.0	58.0	62.0	66.0		
E05	Bottom width straight measured	1.0		47.0	51.0	55.0	59.0	63.0	67.0		
E08	Bottom finish height (rib / hem / binding / ...)	0.0		2.0	2.0	2.0	2.0	2.0	2.0		
E13	Waist width position from HSP	0.0		43.8	44.9	46.0	47.1	48.2	49.3		
F04	Center front height from neck seam to bottom edge	1.0		59.5	61.5	63.5	65.5	67.5	69.5		
F06	Center back height from neck seam to bottom edge	1.0		66.0	68.5	71.0	73.5	76.0	78.5		
F09	Side seam height	0.8		40.5	42.0	43.5	45.0	46.5	48.0		
F11	Back yoke height at center back	0.5		9.0	9.0	9.0	9.0	9.0	9.0		
G06	Short sleeve length (to sleeve edge)	1.0		21.0	22.0	23.0	24.0	25.0	26.0		
G10	Underarm short sleeve length (to sleeve edge)	0.8		6.1	6.7	7.3	7.9	8.5	9.1		
G11	Biceps width (from armhole seam)	0.5		18.4	19.2	20.0	20.8	21.6	22.4		
G16	Short sleeve bottom width (relaxed)	0.5		17.9	18.7	19.5	20.3	21.1	21.9		
H03	Collar height at center back excluding collar band if any	0.5		7.0	7.0	7.0	7.0	7.0	7.0		
H07	Collar point length	0.2		6.0	6.0	6.0	6.0	6.0	6.0		
I06	Distance between buttons	0.3		9.8	9.8	10.3	10.3	9.8	9.8		
J01	Chest patched pocket(s) top width	0.3		11.7	12.1	12.5	12.9	13.3	13.7		
J02	Chest patched pocket(s) height at highest point (excluded flap)	0.3		12.7	13.1	13.5	13.9	14.3	14.7		
J09	Chest pocket(s) position from LSP to pocket top	0.5		18.5	19.5	20.5	21.5	22.5	23.5		
J10	Chest pocket(s) upper position from center front line (included flap)	0.5		4.2	4.6	5.0	5.4	5.8	6.2		

Fig 3.1.1.d: Measurement chart of BAGAZ

Description :

A measurement chart makes sure that all clothes are made to the same standard, so the fit is the same on all of them. Taking accurate measurements can help to avoid mistakes and issues that can happen when cutting and sewing. A measurement chart is a standard point of reference for everyone who works in manufacturing, from designers to pattern makers to cutters to sewers. It ensures that everyone is on the same page and knows the exact sizes each outfit needs. In the end, using a measuring chart is meant to meet customer needs.

3.1.2 Working Procedure Of CELIO Buyer

Sample Development for CELIO Buyer is very challenging & different. Because their style is very unique & modern. CELIO buyer always follow good workmanship & it's a major requirement to do work with them. Step by step we will discuss about the working procedure of Celio buyer.

3.1.2.a Sample Required For CELIO Buyer

C.P sample: Color proto sample, It's a development stage of sample. Here, no need actual trims & accessories.

E.P sample: Extra proto sample, It's make for fitting / measurement test. Here, no need actual trims & accessories.

P.P sample: Pre-production sample, Measurement, color, trims & accessories all need actual based on buyer's requirement.

At Development stage CELIO buyer needs these three types of samples—very few times they require for size set sample.

After complete bulk production CELIO buyer requires Merchandising sample & Sales man sample.

3.1.2.b Swatch Card Approval

Fabric, Trims & accessories are the major goods of sample development. It must be approved by buyer & must be matched to buyer's requirements.

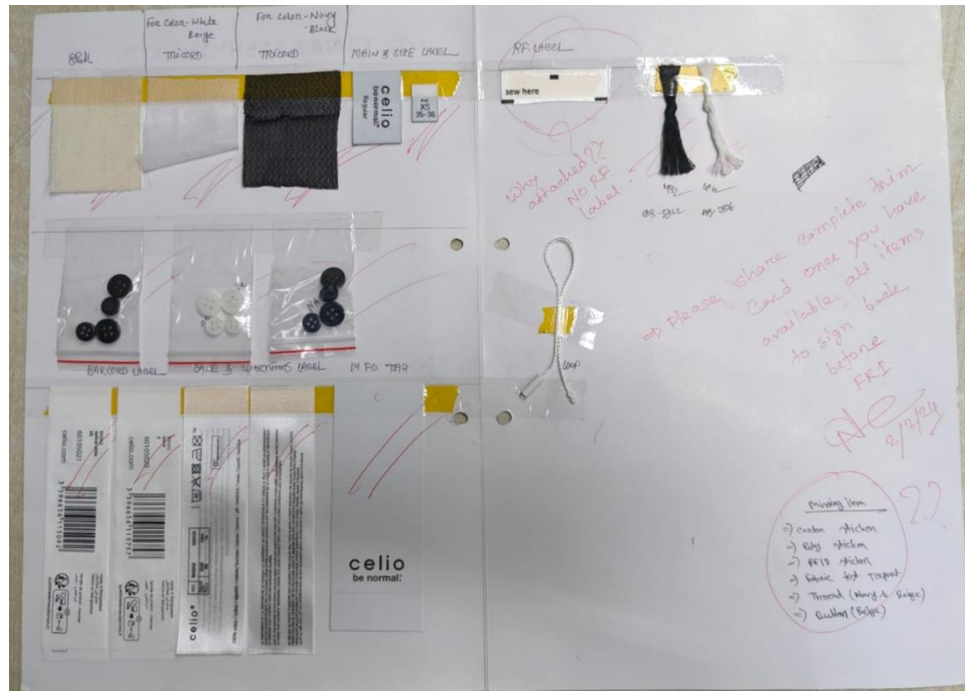


Fig 3.1.2.b: Swatch card approval for BAGAZ

The style of BAGAZ made by shell fabric, It was 100% cotton double cloth fabric. And for BAGAZ they used tricod interlining. Button used there 11.5 mm, 4H Plastic Button. 40/2 count of thread used here. These are approved by buyer and also Barcode, Care label, and warning label are approved by buyer. After approving all Construction/operations start step by step smoothly.

3.1.2.c Fabric Consumption & Pattern

WINDY GROUP TECHNICAL DEPARTMENT- CENTRAL CAD									
CONSUMPTION FOR BOOKING									
MERCHANDISER :		BUYER : CELIO		STYLE : BAGAZ		OR :			
ITEM DESCRIPTION : SHIRT		SIZE : S TO XL SAMPLE SIZE= M		TYPE OF WASH : YES		DATE: 25-02-2024			
SL NO	ITEM DESCRIPTION	C/ WIDTH	MARKER/YDS	INCH	QTY	ACTUAL CONS:	YDS DOZ	REMARKS	
1	????	60"	1	23	1	19.74	YDS DOZ		
	SAMPLE SHRINKAGE= L=19% W=19%								
	SIZE=M/1= 1 PCS								
NOTE:-----									
***Size Ratio : - - -		ACTUAL SIZE RATIO & DEVELOPMENT SAMPLE SHRINKAGE							
***Fabric C/W : - - -		ACTUAL							
***Measurement Spec : - - -		As Per Tech-Pack							
***Styling Sketch : - - -		As Per Tech-Pack							
PREPARED BY: MR. BEKASH / MD. ATAUR		CHECKED BY				RECEIVED			

Fig 3.1.2.c(a): Fabric Consumption For Bagaz

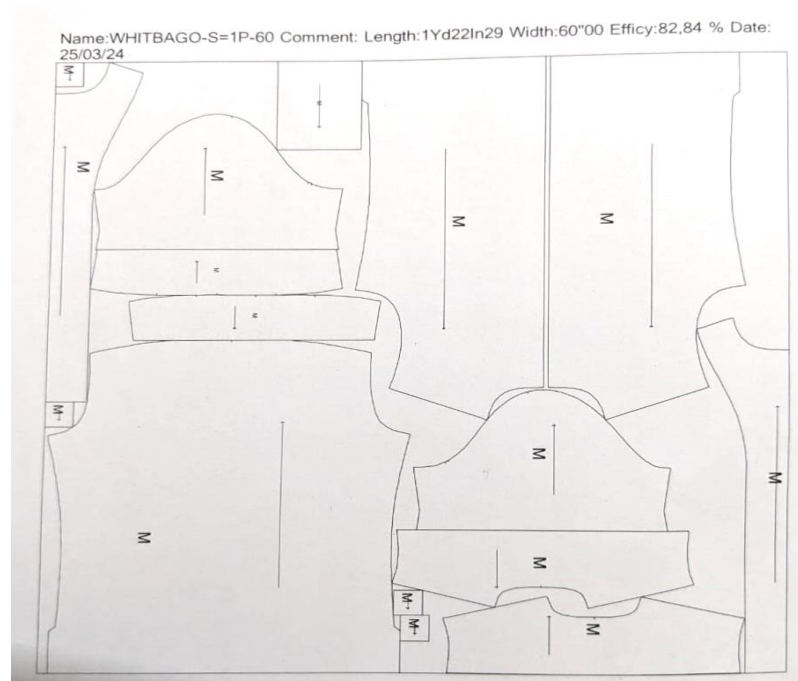


Fig 3.1.2.c(b) : Pattern Of Bagaz

Description :

CAD section prepares the Consumption & Pattern based on Tech pack. CAD/ Pattern master follows the details & measurements of Tech pack to make the specific style of sample. Pattern master make the pattern very carefully because a simple mistake can harm the sample structure and affect the measurement.

Basically, sample makes in M size. For one one-piece M-size sample of Bagaz, we need 1.23 yds of fabric. Fabric width was 60 inches.

3.1.2.d Thread Consumption Operation wise Count Details

		Windy Group	
Thread consumption operation wise count details (as per sample)			
Buyer	CELIO	Date :	14/01/2024
Style	BAGAZ		
Order Qty		Sample date:	20/12/2023
Type of sample	EP		
Operation	Count	Remarks	
Top stitch	40/2	SHOULDER & BACK YOKE SEAM S/B PINTUCK, THEN SNTS.	
Bobbin	40/2		
Side Seam	40/2	3-THREAD O/L SEPERATLY, THEN DNTS.	
Join stitch/Attach	40/2		
FOA+Kansai Chain stitch	40/2		
Over lock	40/2	COLLAR JOINT S/B 5-THREAD O/L.	
Over lock chain stitch	40/2		
Pocket Over Lock	40/2		
Pocket bag lock Stitch	N/A		
Bartack	40/2		
Button Hole	40/2		
Button Attach	40/2		
FL	Needle	N/A	
	Looper (In)	N/A	
Eyelet Hole	N/A		
Eyelet Cord	N/A		
WAIST PATCH JOINT			
LABEL ATTACH	40/2		
Prepared By-	MD.AL-MAMUN	QC Incharge	
Approved By-	H.M Nazmul Huda	Quality Manager	

Fig 3.1.2.d: Thread consumption operation wise count details

When we make a sample of garments, they need basically 20/2,20/3,40/2 count of thread. But BAGAZ made by only 40/2 count of thread.

3.1.2.e Cutting & Sewing Study

Initially, the pattern papers are sent to the cutting machine for sample cutting once the pattern is created based on the dimensions of the tech pack that the client has supplied. After laying up the pattern sheets on the fabric sample, the fabric is cut.

Since only a little bit of cloth is initially used to create the sample, cutting must be done with extreme precision. If a fabric cutting error is discovered, money and time are lost, which could prevent the buyer's order from being delivered on schedule. The cutting department is crucial in minimizing fabric waste and conserving a significant amount of fabric during bulk production.

However, this isn't the case in the sample department because there, cloth cutting is done in order to create some samples. For this reason, there are no significant alterations or particular data to omit from the sample portion.

Sewing comes next in importance after cutting the fabric. For Bagaz there are no mention sewing details on tech pack, we collect from sewing line operation QC .

Sewing process for BAGAZ :

- 1) Collar & Placket -Fusing (Steam)
- 2) Collar two-part made by plain machine
- 3) After joining collar- outside (Top stitch sewing), Inside (Plain machine)
- 4) Placket making & joining by plain machine
- 5) Back yoke -Pin tag (Double Part) After pin tag double lair top sewing
- 6) Shoulder – Pin tag & join before top sewing
- 7) Sleeve join – Over lock (5 thread)+ top sewing
- 8) Pocket ruling after pocket joint
- 9) Side seam – Over lock (3 thread 2 needle),After over lock then top sewing by feed of the machine.

There are too many differences between sample section & bulk production sewing line. Because 1-3 operators make the sample, & bulk production sewing line, there are too many operators make the product.

OPERATION	M/C
BACK PART	
COLLAR MARK & CREASE	SNL
COLLAR MAKE	SNL
TRIM & TURN COLLAR	TURNING
COLLAR BASTING & CREASE	IRN
COLLAR HALA MARK & GROUP CUT	H
COLLAR MARK STITCH	SNL
BACK PART	
BACK SIDE EDGE SERGING WITH SLIT	3 OL
BACK PART UPPER EDGE ROLLING	SNL
LABEL ATTACH AT YOKE	SNL
BACK SIDE SLIT RULLING WITH MARK & GROUP CUT	DNL
BACK YOKE JOIN	SNL
BACK YOKE TOP STITCH	SNL
BACK PART FITTINGS WITH IRON	H
FRONT PART	
FRONT PART EDGE SERGING WITH SLIT	3 OL
FRONT PART SLIT RULLING	DNL
FRONT PART PIN TACK	SNL
MARK FRT PKT ATT. POSITION	H
FRONT POCKET EDGE OL	3 OL
FRONT POCKET HEM	DNL
CREASE FRONT POCKET	IRN
ATTACH FRONT POCKET WITH REINFORCEMENT+ DI	SNL
FRONT INNER FACING EDGE SERGING	3 OL
FRONT INNER FACING HEM WITH LABEL	SNL
FRONT FACING JOIN	3 OL
FRONT INNER FACING SAFETY STITCH WITH NOSE MA	SNL
ASSEMBLY	
FRONT & BACK MATCH & BACK NECK CENTER M	H
SHOULDER JOIN	SNL
SHOULDER TOP STITCH	SNL
COLLAR MATCH	SNL
COLLAR ATTACH	SNL
NECK SERGING	3 OL
SIZE & PATTERN LABEL ATTACH WITH POLY	H
FRONT FACING NOSE TURN	H
FRONT FACING TACK AT NECK	SNL
COLLAR CLOSE STITCH	SNL
FACING EDGE TACK AT SHOULDER POSITION	SNL
SLEEVE MATCH	H
ATTACH SLEEVE	5 OL
ARM HOLE TOPSTITCH	CHAIN
ARM HOLE EDGE SERGING	3 OL
SIDE SEAM JOIN (FOLDER) & TRIMMINGS	FOA
CARE LABEL MAKE & ATTACH WITH POLY	SNL
FRONT PLACKET CREASE WITH SLEEVE TURN	IRN
PLACKET EDGE STITCH WITH COLLAR	SNL
FRONT PLACKET TOP STITCH	SNL
HEM POSITION MARK & STICKER REMOVE	H
BOTTOM HEM*3 PART	SNL
SLEEVE OPENING HEM	SNL
NORMAL HOLE *5 NOS WITH MARK	BH
SIDE SLIT & BOTTOM HEM OPENING TACK	SNL
BARTACK*4	BT
WASH TUCK	SNL

Fig 3.1.2.e: Sewing line operation for BAGAZ

3.1.2.f QC Check List

WINDY GROUP SAMPLE SECTION

Sample Check List

Buyer: _____ Date: _____

Style No: _____

Item: _____

Type of Sample: _____

Sample color: _____

Sample size: _____

Sample Qty: _____

	Actual	Avallavle
Main Body Fabric		
contrast Fabric		
Pocketing		
Fusing		
Jenssy		
Main Body thread top		
Main Body thread bob		
Main Body thread o/L		
Contast thread		
Bartack thread		
Pocketing thread		
Embroidary thread		
Front Fly Zipper		
Side Zipper		
Leg Zipper		
Pocket Zipper		
Waist Elastic		
Adjustable hole Elastic		
Main Label		
Size Label		
Care Label		
Shank Button		
Sanap Button		
Ring Sanap Button		
Rivet		
Lather Patch		
Print / embo		
Piping/ Binding		
Key hole/ btn hole		
Draw cord		
Twili Tape		

Wash Comments

Construction comments

Sample Submit Date

WINDY GROUP SAMPLE SECTION

Sample Check List

Buyer: CELTO Date: 20-02-23

Style No: BAGAZ

Item: SHIRT

Type of Sample: PREP/SAMPLE

Sample color: WHITE + KHAKE + NAVY

Sample size: M

Sample Qty: 02 PCS

	Actual	Avallavle
Main Body Fabric	✓	
contrast Fabric	✓	
Pocketing	✓	
Fusing	✓	
Jenssy	✓	
Main Body thread top	40/2	
Main Body thread bob	40/2	
Main Body thread o/L	40/2	
Contast thread	✓	
Bartack thread	✓	
Pocketing thread	✓	
Embroidary thread	✓	
Front Fly Zipper	✓	
Side Zipper	✓	
Leg Zipper	✓	
Pocket Zipper	✓	
Waist Elastic	✓	
Adjustable hole Elastic	✓	
Main Label	✓	
Size Label	✓	
Care Label	✓	
Shank Button	✓	
Sanap Button	✓	
Ring Sanap Button	✓	
Rivet	✓	
Lather Patch	✓	
Print / embo	✓	
Piping/ Binding	✓	
Key hole/ btn hole	✓	
Draw cord	✓	
Twili Tape	✓	

Wash Comments: WASH A2 PER BUYER STANDARD

Construction comments: SAMPLE MAKE BASE ON PREVIOUS
SAMPLE WITH UPDATE COMMENT

Sample Submit Date

SAMPLE QC QC INCHARGE HEAD OF SAMPLE

Fig 3.1.2.f : QC check list for BAGAZ

Description :

After completing sewing & washing, quality controller checks the sample very carefully. Mainly check measurement, color shade, uncut thread, trims & accessories.

3.1.2.g Sample Submission to Buyer for Approval

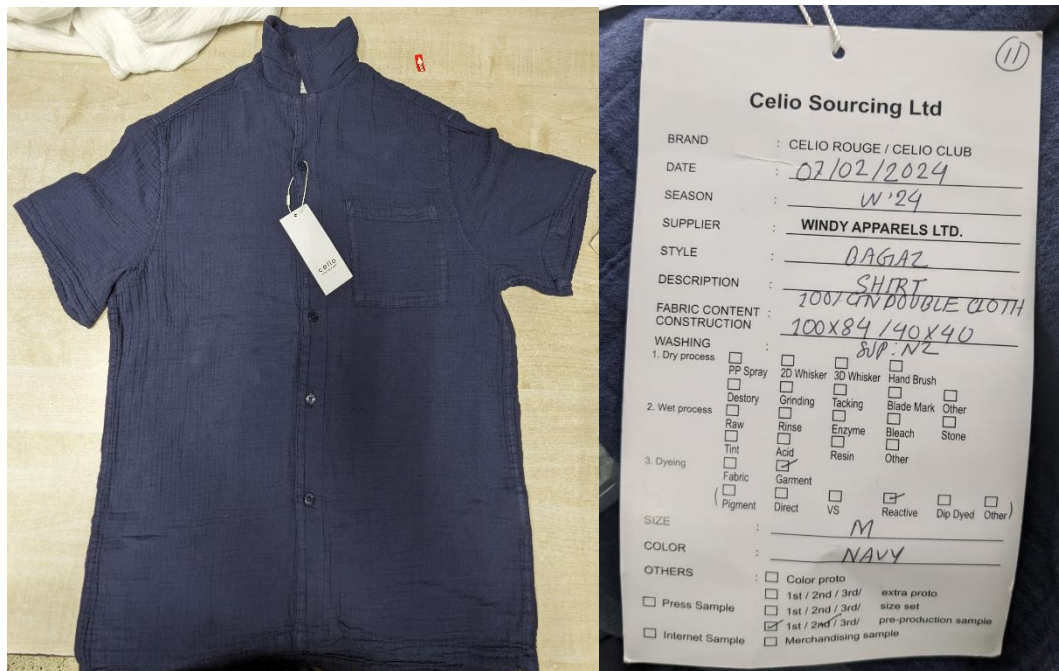


Fig 3.1.2.g: Sample submission to Buyer for Approval

Description :

After making the sample & finishing check by QC the sample handover to merchandiser & Merchandiser submits the sample to the buyer for approval. If there have some issues like measurement issues, quality issues, or Buyer comments on the sample. Merchandiser remakes the sample & again submits it for approval.

3.1.3 Test Report On Bagaz

Celio buyer test the sample very carefully & after they approve.

Some key points to test approval :

- a) Fibre composition
- b) Color fastness to washing
- c) Colorfastness to water
- d) Colorfastness to rubbing
- e) Colorfastness to light
- f) Colorfastness to perspiration
- g) Dimensional stability to washing
- h) General appearance after washing
- i) Tear strength
- j) Seam slippage

Test report below :

Garments Test # PASS
COLOR - NAVY

eurolins Modern Testing Services

celio* International
Test Report

Report No.: 66224-022513 Date: Mar. 02, 2024 Page 1 of 9

Applicant : WINDY APPRELS LTD
140. BARON, DAIKHAL-DEPZ ROAD, ASHULIA-DHAKA
ATTN: MR. MAHBUBUR RAHMAN
Tel: +8801731076763
Fax: /
E-mail: bayzid@windygroupbd.net, mahbub@windygroupbd.net,
sumon_taleb@celio.com, momin_abdul@celio.com

Sample Description : THREE (03) PIECES OF SUBMITTED GARMENTS SAMPLE SAID TO
BE: MENS SHIRT IN NAVY COLOR.



Supplier Name : WINDY APPRELS LTD
Sample Type : PRODUCTION
Sample Stage : FINISH PRODUCT
Use : SHELL FABRIC
Celio Style Name : BAGAZ
Style Name Supplier : /
Color Name : NAVY
Celio PO Numbers : 60104729
Fibre Composition : 100% COTTON
Fabric Type : /
Fabric Weight : /
Finish Name : /
Season : WINTER 24 (H-WINTER)
Buyer's Name : CELIO
Buying House : /
Product Type : /
CDC-Test Number : CDC-TESTS-008 (SELECTIVE TEST)
Country Of Destination : FRANCE
Country Of Origin (Made In) : BANGLADESH

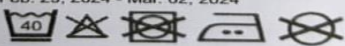
Log in Date : Feb. 29, 2024
Test Performance : Feb. 29, 2024 - Mar. 02, 2024
Provided Care Instruction : 
Test Performance & Results : Please refer to the following pages for the tests performed in accordance with the applicant's request and their results.

Fig 3.1.3(a) : Test report on BAGAZ

Report No.: 66224-022513

Date: Mar. 02, 2024

Page 3 of 9

TEST SUMMARY	
FIBRE COMPOSITION	M
COLOURFASTNESS TO WASHING	M
COLORFASTNESS TO WATER	M
COLOURFASTNESS TO RUBBING	M
COLOURFASTNESS TO LIGHT	M
COLOURFASTNESS TO PERSPIRATION	M
DIMENSIONAL STABILITY TO WASHING	M
GENERAL APPEARANCE AFTER WASHING	M
TEAR STRENGTH	M
SEAM SLIPPAGE	M

Abbreviation: M = Meet the Customer's Requirement
 F = Below the Customer's Requirement
 * = See Comment/ Remark
 # = See Report For Test Data
 -- = Not Requested
 NA = Not Applicable

Note: "Test result and evaluation are only related to tested items and performed method. Detailed information regarding measurement uncertainties are available on request if applicable".

Fig 3.1.3(b) : Test report on BAGAZ

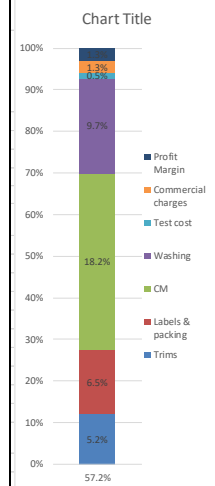
3.1.4 Costing for making BAGAZ

SHIRT COST SHEET						
SEASON	H'24	Date 6-Nov				
Style	BAGAZ					
COLOR		[] L/S Overshirt (without hood)				
Supplier / factory	Windy Apparels Ltdd	[] Extra Slim Fit				
Quantity projection	8000	[] Slim Fit				
Country	Bangladesh	[v] Regular Fit				
MP	18					
CMT	29.9%					
FABRIC	Description	Unit Price (USD)	Consumption	Wastage	Cost in US\$	Part of the price
MAIN FABRIC	PDM: 6343 , 100% Cotton Double cloth, 40x40/116x86, Color: Natural , Cutable width: 60", Weight: 115 GSM (+/-5%), Shrinkage (ISO 6330) : Warp-24%, Weft-18%	2.40	1.750	5%	4.410	
	Trim-1				-	
	Trim-2				-	
					-	
SUB TOTAL:					4.41	57.2%
TRIMS	Description	Unit Price (USD)	Consumption	Wastage	Cost in US\$	Part of the price
INTERLINING	EC2304	0.700	0.2	5%	0.147	
SEWING THREAD	20/3,20/2 & 40/2	0.150	1	5%	0.158	
BUTTON 1	20mm 4H Plastic Button	0.013	7	5%	0.096	
					-	
					-	
					-	
					-	
					-	
SUB TOTAL:					0.40	5.2%
LABELS & PACKING	Description	Unit Price (USD)	Consumption	Wastage	Cost in US\$	Part of the price
Main label		0.016	1	5%	0.017	
Fancy label		-	0	5%	-	
New brand label		-	0	5%	-	
Size label		0.007	1	5%	0.007	
Main Hangtag		0.011	1	5%	0.012	
Info tag		0.011	1	5%	0.012	
Price tag LOOP		0.013	1	5%	0.014	
RF ID + Price sticker		0.077	1	5%	0.081	
Care label,Distribution & barcode		0.011	3	5%	0.035	
RF label		0.037	1	5%	0.038	
Poly sticker		0.016	1	5%	0.017	
Fit sticker		0.010		5%	-	
Finishing cost	"B fold"	0.260	1	5%	0.273	
				5%	-	
				3%	-	
SUB TOTAL:					0.50	6.5%
FINISHING	Description	Unit Price (USD)	Consumption		Cost in US\$	Part of the price
WASHING	Garment Dyeing	0.75	1.000		0.750	
					-	
SUB TOTAL:					0.75	9.7%
CM					1.40	18.2%
TEST COST	Description	Unit Price (USD)	Consumption		Cost in US\$	Part of the price
REACH TESTING COST		0	1.000		-	
GARMENT TESTING COST (PHYSICAL)		0	1.000		0.040	
SUB TOTAL:					0.04	0.5%
COMMERCIAL CHARGES	TRANSPORTATION				0.10	1.3%
PROFIT MARGIN					0.10	1.3%
FOB					7.70	

Chart Title

Fabric	57.2%
Trims	5.2%
Labels & packing	6.5%
CM	18.2%
Washing	9.7%
Test cost	0.5%
Commercial charges	1.3%
Profit Margin	1.3%
TOTAL	100%

Fabric	57.2%
Trims	5.2%
Labels & packing	6.5%
CM	18.2%
Washing	9.7%
Test cost	0.5%
Commercial charges	1.3%
Profit Margin	1.3%
TOTAL	100%



Fabric	57.2%
Trims	5.2%
Labels & packing	6.5%
CM	18.2%
Washing	9.7%
Test cost	0.5%
Commercial charges	1.3%
Profit Margin	1.3%
TOTAL	100%

Fig 3.1.4: Costing of BAGAZ

3.1.5 Buyer Comments On BAGAZ

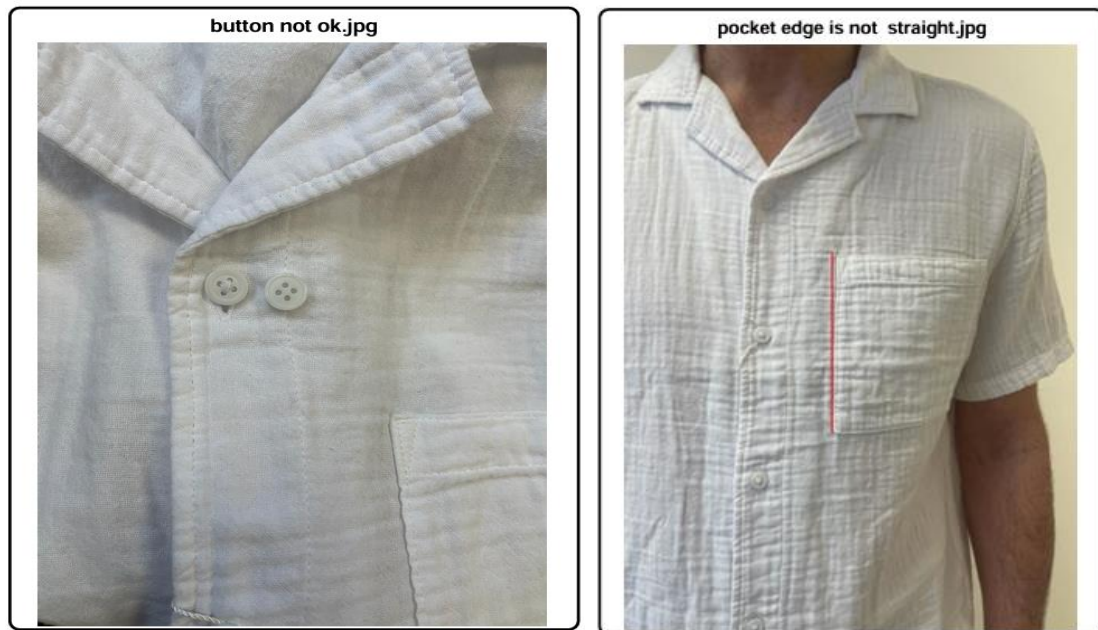


Fig 3.1.5 : Buyer Comments on BAGAZ

Here, Buyer comment on Pocket edge & button . Buyer's quality specialist measured the sample & found out that Pocket edge was not straight. And also found that button not matching with approval button .

Sample Type: PP Sample
 Size: M
 Combo: Beige + Black, NAVY,
 Sample Hang tag date: 30/Jan/2024
 Sample send date: 06 Feb 2024
 Check by: Tofazzal, Mathilde 14/02/2024

Comment by Merchandiser

Shell fabric: Actual **ok on the 3 pps**
 Plastic Button: Actual (Beige -Available) **ok on black and navy pps**
 Thread color: Actual **ok on the 3 pps**
 Main label: Actual **ok on the 3 pps**
 Size label: Actual **ok on the 3 pps**
 Care label: Actual **ok on the 3 pps**
 Barcode Distributor: Actual **ok on the 3 pps**
 Warning Label: Actual **ok on the 3 pps**
 I/Tags: Actual
 H/loop: Actual
 Folding: Actual
 Polybag: Available
 Polybag Sticker: Missing
 Price tag: Missing
 Wash& handfeel: Effect is bit less but okay to pass pps comments **ok on the 3 pps**
 Check by: Noman

Measurement: All measurements within tolerance, Supplier follow as per your updated size spec,

Fit & balance: Sample fit on dummy, See fitting photo. **the 3 pps : balance and fit are ok. See picture**

Functional and awareness: Sample fit on dummy, See fitting photo.

Construction and workmanship:

- Styling and workmanship is ok on PPS. Supplier follow as per your PPS comment, Please check and advise your good comments, **ok**
- PP sample collar and front placket top stitching 0.5cm and I will send mock up collar and front placket top stitch 0.2cm as per your PP sample comment. Supplier follow as per your mock up 0.2cm to proceed to bulk, **the mock up is approved: it's should be 0.2cm on bulk**
- Frond bit uneven stitching at bottom hem. Supplier improve,
- Found bit hiking at sleeve. Supplier improve.

Fabric & Trims:

*Since including interlining

Color & Wash: Beige + Black – Garment reactive dyeing.

Color & Wash: Navy – Garment reactive dyeing

Interlining:

Confirm used 1 layer at collar, Front placket. Ref: PA2550. Fuse, Supplier ETASIA.

Conclusion:

OK PRODUCTION undercondition for all combo according to these comments and with a perfect workmanship. Pls send us the 4 combos PPS REF with the 0.2cm stitching at the front placket. Thank you

Fig 3.1.5.a : Buyer Comments On BAGAZ

If Buyer comments on CPS sample, there must be careful to make the next samples like EPS, and PPS samples.

At majority time buyer comment on PPS sample, If PPS sample not approved, then PPS Ref sample make to approved.

Here, Always follow on buyer requirements & must improve the workmanship to produce samples.

Buyer: OKAIDI (France)

Style Name : PIT

The history of Okaidi is a well-known French retailer. It was 1994 when Jean Dusforest and Jean-Luc Souflet are established the simplified joint stock company in Roubaix France. Over the past 30 years, Okaidi goals have grown and changed, but their core values have not changed. One of France largest retailers. Jean Dusforest owns the Okaidi brand. The ID Group is the parent company and Obaibi is sister company. Okaidi France has 912 sales outlets over 70 countries with 6000 employees. Okaidi France has revenue of 852 Million Euros 2024. The Okaidi and Obaibi act for children 0-14 years old.

Our goal is to provide our customers with the most affordable, high quality and stylish items for all budgets.

Industry	Retail
Company Size	6000
Type	Privately Held
Founded	1994
Sourcing Office	Bangladesh, Chin, Canada, Hongkong
Head Office	Roubaix France
Annual Revenue	852M Euros Per Year

3.2 Boys Skinny Long Pant By Okaidi Buyer



Fig 3.2.a : Boys Skinny Long Pant By Okaidi

Okaidi

0096244 / PIT SKINNY PANTALON DENIM

7/28/23, 3:06 PM

Properties

Style *	PIT SKINNY PANTALON DENIM	Product Category	Okaidi	*Sizes	2A-10A, 12A, 14A
Description	Enf-G-Pantalon-PIT SKINNY PANTALON DENIM	Product line	Vetement Okaidi - Enfant - Garçon	Default Size	8A
Code	0096244	Family	Pantalon	*Structure Offre	Good Basic
Season	Ete 2024	SubFamily	Pantalon		
Brand*	Okaidi	*Construction	Chaine et Trame		
		*Size Range	10 - OK 2A - 14A		

Informations Générales

Product Manager	Marie BUTTET	Modelist	Caroline GIELCZYNSKI	Stylist	DIDIER ALLEMAND
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Refco

Image	Coloris
	dark blue light stone
Displaying 1 result(s)	

Documents

Document	Latest Revision	Revision Created	Revision Description	File	Image	3D View	Parent	Parent Type
EREC20CAVV1 - Recycled Polyester.pdf	1	7/28/23, 3:04 PM		EREC20CAVV1 - Recycled Polyester.pdf			0096244 / PIT SKINNY PANTALON DENIM	Style
FKSICAVV1 - Skinny.pdf	1	7/28/23, 3:04 PM		FKSICAVV1 - Skinny.pdf			0096244 / PIT SKINNY PANTALON DENIM	Style
label good price everyday.pdf	1	7/28/23, 3:04 PM		label good price everyday.pdf			0096244 / PIT SKINNY PANTALON DENIM	Style
Displaying 3 result(s)								

Fig 3.2.b :Introductory page of PIT skinny children long pant By OKAIDI Buyer

This is the children long sleeve denim pant introduction page, where some basic information about this brand, style name, number, description, composition, sizes year and season: brand: long sleeve pant; composition: 64.3% Bci Cotton, 15% pre-consumer cotton, 18.3% polyester, 2.4% elastane, 2A, 10A, 12A, 14A; year & season: 2024, spring.

From this tech pack picture and description, the merchandiser can easily understand which materials are required to develop the sample.

3.2.1 Details of the specific style (PIT)

We Collect the information and specific details for the style from the tech pack. In below the details:

- ❖ Fabric : 64.3% BCI COTTON, 15%PRE- CONSUMER COTTON, 18.3% POLYESTER,2.4%ELASTHAE
- ❖ Weight: 240 GSM
- ❖ Wash: Sustainable
- ❖ Button: 16.8 mm shank
- ❖ Sewing thread: 20/4,20/2, 40/2

3.2.1.a Item & Supplier Names

Item name	Item Description	Supplier
Shell fabric	ND- 3939	Nice Denim
Pocketing	DTM	Tasfia
Interlining	Dot Fusing	Max
Snap Button	16.8MM-3y-7y	SN Bets
Shank Button	18MM-8y-14y	SN Bets
Metal Zipper	DA Puller Silver	SAB
Plastic Button	4 Holes 14MM DTM	M&U
Adjustable Elastic	1.8CM	DPAL
Jacron	32.5*51mm for 2/8y 37.5*58mm for 9/14y	HAJA
Main Label	Skinny	DPAL
OK Tab		Yousuf day
Size Label		Yousuf day
Care Label		DPAL
Hand Tag		Yousuf day
Waist Tag		Yousuf day
Poly	Single	Montrims
Sewing Threads	20/4 20/2 40/2	Simtex

Fig 3.2.1.a : Item & Supplier Names

3.2.1.b Specific Sketches for PIT

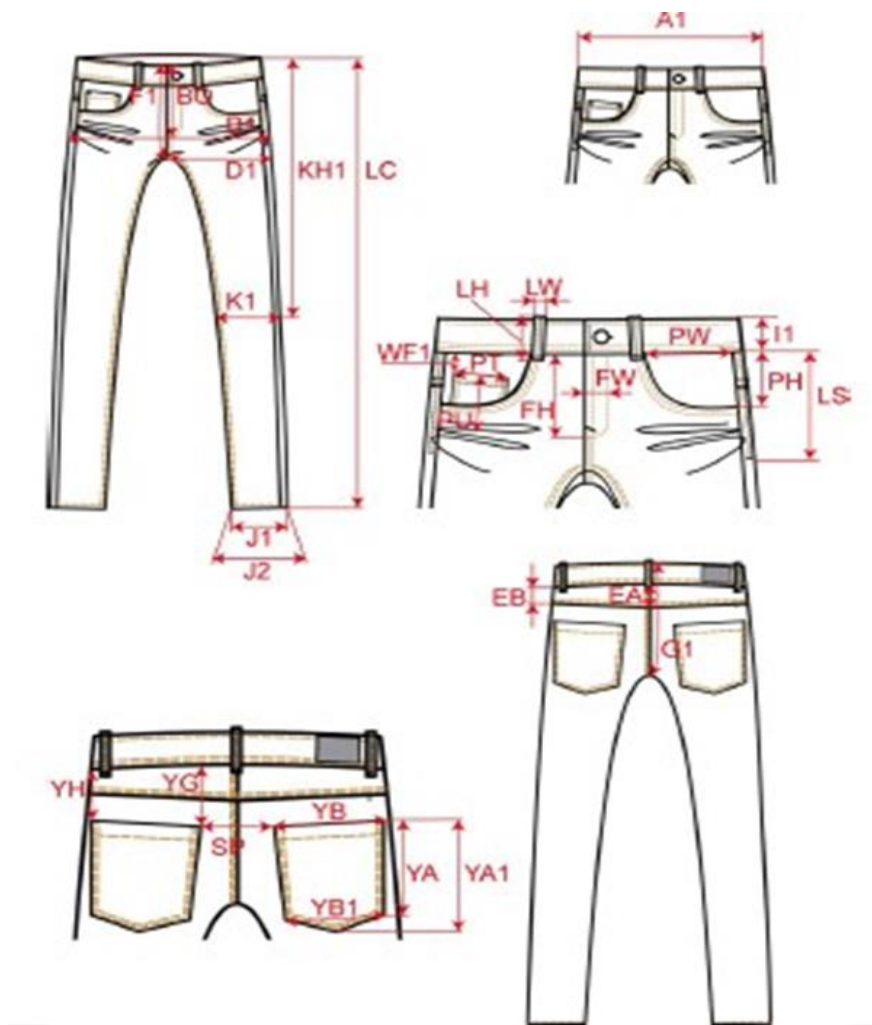


Fig 3.2.1.b: Specific Sketches for PIT

3.2.1.c Label & Trims For PIT



Fig 3.2.1.c: Care symbol for PIT

Description:

Care labels on clothing offer vital instructions to assist clients in effectively maintaining their apparel, so guaranteeing durability and excellence. The labels are commonly stitched into the clothing's seam and consist of standardized symbols accompanied by written instructions. Comprehending these symbols and instructions is essential for ensuring appropriate maintenance of garments.

Here are the symbols meaning:

- 1) Machine wash can be applied at 30 degree C.
- 2) Do not bleach wash
- 3) Do not tumble do not apply.
- 4) Do not dry clean.
- 5) Medium iron.

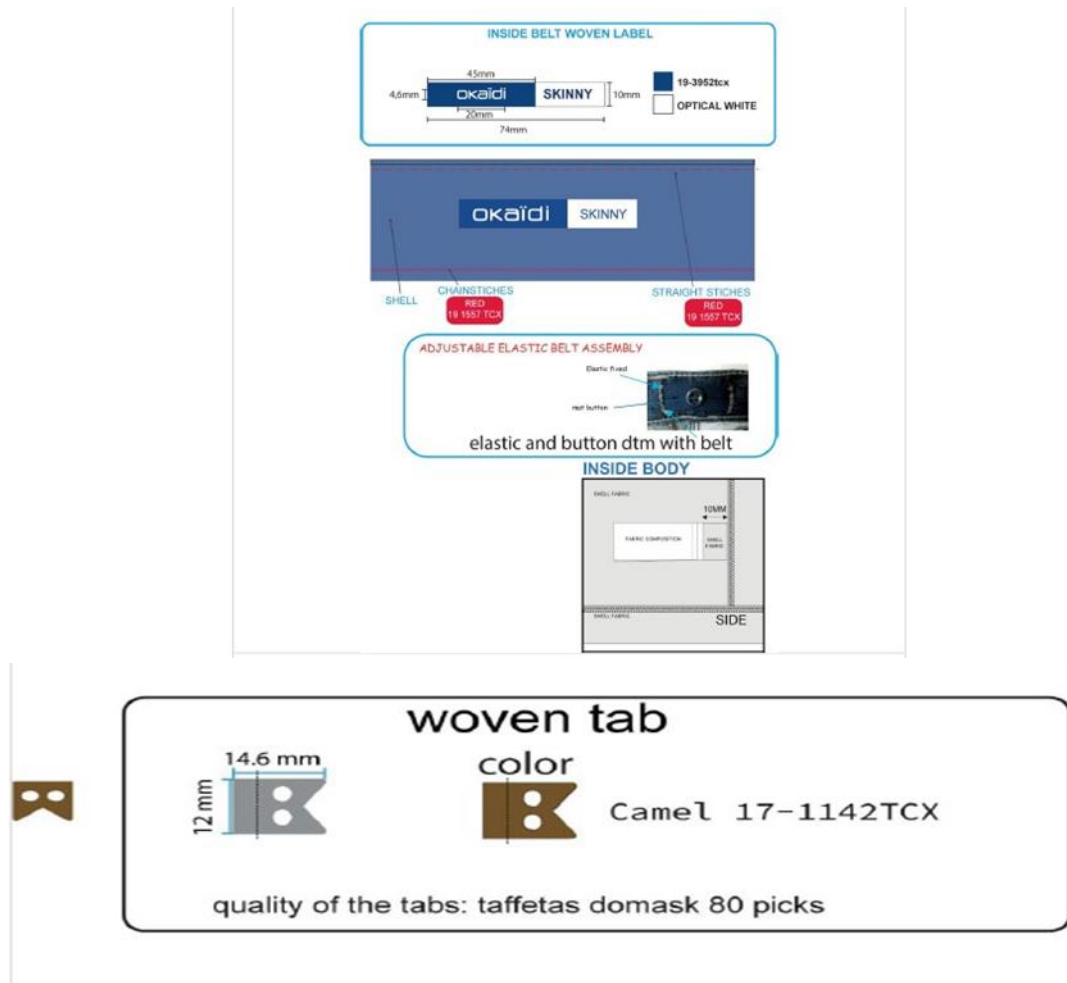


Fig 3.2.1.d: Trims for PIT

Description:

In the production of clothing, trimmings have a variety of effects on fit, appearance, durability, and brand identity. To create items that satisfy both market and design requirements, they must be carefully chosen and applied to sample outfits.

3.2.1.e Measurement Chart Of PIT

Dim	Description (EN)	Tol (-)	Tol (+)	Unité	2A	3A	4A	5A	6A	7A	8A	9A	10A	12A	14A
					B	B	B	B	B	B	B	B	B	B	B
A1	1/2 waist round (bottom piece)	-0.50	0.50		24.50	25.30	26.00	26.80	27.70	28.50	29.30	30.50	31.70	35.30	36.50
B0	hips positionning with belt	0.00	0.00		11.00	11.50	12.00	12.50	13.00	13.25	13.50	14.25	14.50	14.75	15.00
B1	1/2 hips	-0.75	0.75		27.00	28.25	29.50	30.75	32.00	33.25	34.50	36.15	37.80	41.10	42.75
D1	1/2 thigh	-0.50	0.50		16.10	16.90	17.60	18.30	19.00	19.70	20.40	21.40	22.40	23.90	24.90
KH1	knee position with belt	0.00	0.00		31.30	33.70	36.30	38.90	41.50	44.10	46.70	49.00	51.30	55.90	60.50
K1	1/2 knee	-0.50	0.50		10.65	11.25	11.70	12.15	12.60	13.05	13.50	14.05	14.60	15.70	16.80
J1	1/2 bottom leg width	-0.50	0.50		9.65	10.25	10.70	11.15	11.60	12.05	12.50	13.05	13.60	14.70	15.80
J2	1/2 bottom leg width stretched	-0.50	1.00		12.65	13.25	13.70	14.15	14.60	15.05	15.50	16.05	16.60	17.70	18.80
LC	side lenght	-1.00	2.00		53.00	58.10	62.40	66.70	71.00	75.30	79.60	82.60	85.60	92.60	100.00
F1	front crotch with belt	-0.50	0.50		16.00	16.50	17.00	17.50	18.50	19.00	20.00	21.00	22.00	23.00	25.00
G1	back crotch with belt	-0.50	0.50		23.00	23.50	24.00	24.50	25.50	26.00	27.00	28.00	29.00	30.00	32.00
LS	side topstitchings length	-0.50	0.50		9.00	10.00	11.00	12.00	13.00	14.00	15.00	16.00	17.00	18.00	19.00
I1	belt height	-0.25	0.25		3.50	3.50	3.50	3.50	3.50	3.50	3.50	4.00	4.00	4.00	4.00
LH	loop height	-0.25	0.25		5.00	5.00	5.00	5.00	5.00	5.00	5.00	5.50	5.50	5.50	5.50
LW	loop width	0.00	0.00		1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00	1.00
FH	fly height	0.00	0.00		7.50	8.00	8.50	9.00	9.50	9.75	10.00	10.25	10.50	10.75	11.00
FW	fly width	0.00	0.00		3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.50	3.50	3.50	3.50
PH	front opening pocket heigth	-0.50	0.50		4.00	4.25	4.50	4.75	5.00	5.25	5.50	5.75	6.00	6.25	6.50
PW	front opening pocket width	-0.50	0.50		6.50	6.75	7.00	7.25	7.50	7.75	8.00	8.25	8.50	8.75	9.00
WF1	ticket pocket position under belt	-0.25	0.25		1.80	1.80	2.00	2.00	2.00	2.40	2.60	2.80	3.00	3.00	3.00
PT	ticket pocket width	-0.25	0.25		5.00	5.25	5.50	5.75	6.00	6.00	6.25	6.25	6.50	6.75	7.00
PU	ticket pocket height	-0.25	0.25		5.50	5.75	6.00	6.25	6.50	6.75	7.00	7.25	7.50	7.75	8.00
EA	position of middle back yoke under belt	-0.25	0.25		3.25	3.50	3.75	4.00	4.25	4.50	4.75	4.75	5.00	5.25	5.50
EB	position side cut out under belt	-0.25	0.25		2.00	2.25	2.50	2.75	3.00	3.25	3.50	3.50	3.75	4.00	4.25
YB	back pocket width	-0.50	0.50		9.50	9.50	10.50	10.50	11.50	11.50	12.50	12.50	12.50	13.50	13.50
YB1	back bottom pocket width	-0.50	0.50		8.50	8.50	9.50	9.50	10.50	10.50	11.50	11.50	11.50	12.50	12.50
YA	back pocket height	-0.50	0.50		10.50	10.50	11.50	11.50	12.50	12.50	13.50	13.50	13.50	14.50	14.50
YA1	back pocket heigth at side	-0.50	0.50		8.50	8.50	9.50	9.50	10.50	10.50	11.50	11.50	11.50	12.50	12.50

Fig 3.2.1.e: Measurement chart of PIT

Description:

A measurement chart makes sure that all clothes are made to the same standard, so the fit is the same on all of them. Taking accurate measurements can help to avoid mistakes and issues that can happen when cutting and sewing. A measurement chart is a standard point of reference for everyone who works in manufacturing, from designers to pattern makers to cutters to sewers. It ensures that everyone is on the same page and knows the exact sizes each outfit needs. In the end, using a measuring chart is meant to meet customer needs.

3.2.2 Working Procedure of OKAIDI Buyer

Sample Development for Okaidi Buyer is very challenging & different. Because their style is very unique & modern. Okaidi buyer always follow good workmanship & it's a major requirement to do work with them. Step by step we will discuss about the working procedure of Okaidi buyer.

3.2.2.a Sample Required For OKAIDI Buyer

Proto Sample: Color proto sample, It's a development stage of sample. Here, no need actual trims & accessories.

Size set sample: Size set sample, It's make for fitting / measurement test. It's made with actual fabric Here, no need actual trims & accessories.

P.P sample: Pre-production sample, Measurement, color, trims & accessories all need actual based on buyer's requirement.

Photo sample: In this stage, factory has to take some photos of the sample and send to buyer. Here P.P & photo samples have to be sent at the same time.

At the Development stage, OKAIDI buyer needs these four types of samples.

3.2.2.b Fabric Consumption & Pattern

1			WINDY GROUP						
2			CENTRAL CAD DEPARTMENT						
3			COMPLEX, SATABH ROAD, GAZIPURA, TONGI,						
4			FABRIC BOOKING CONSUMPTION						
5	BUYER >>>> OKAIDI								
6	STYLE >>>> 69244							ATE: 19.04.2024	
7	SIZE RANGE >>>> 4A-14A								
8	GMTS DESCRIPTION : LONG PANT							SPEC DATE: 28.03.2023	
9	ORDER QUANTITY >>> 9500 PCS								
10	TYPE OF FABRIC		SIZE RATIO		C/ W	MARKER	INCHQTY	NET CONS. P/DOZ	REMARKS
11	44.3x BCI CTR 15xPCW CTR 12.3x POLY 2.4xSPH		5/2, 6/4, 8/3, 9/2, 12/4, 14/1 = 16 PCS		54"	13	23 16	10.30	
12	DERH/F/RD-3335(144-F)		FTD SHRINKAGE (L=3%, W=12%)						
13									
14	POCKTING		FR/PKT.1X2,		41"	1	30 16	1.50	
15									
16	INTERLINING		WAIST.1X2,S/FLY.1X1,		40"	2	19 16	2.00	
17									
21	ADJUSTABLE ELASTIC						12	9.00	
22									
23									
24									
25									
26									
27									
28	Marker- Incharge		Technical Manager				Received by merchandiser		

Fig 3.2.2.b: Consumption Of PTI

Description:

CAD section prepares the Consumption & Pattern based on Tech pack. CAD/ Pattern master follows the details & measurements of Tech pack to make the specific style of sample. Pattern master make the pattern very carefully because a simple mistake can harm the sample structure and affect the measurement.

Basically, sample makes in M size. For one one-piece M-size sample of OKAIDI, we need 1.23 yds of fabric. Fabric width was 60 inches.

3.2.2.c Cutting & Sewing Study

Initially, the pattern papers are sent to the cutting machine for sample cutting once the pattern is created based on the dimensions of the tech pack that the client has supplied. After laying up the pattern sheets on the fabric sample, the fabric is cut.

Since only a little bit of cloth is initially used to create the sample, cutting must be done with extreme precision. If a fabric cutting error is discovered, money and time are lost, which could prevent the buyer's order from being delivered on schedule. The cutting department is crucial in minimizing fabric waste and conserving a significant amount of fabric during bulk production.

However, this isn't the case in the sample department because there, cloth cutting is done in order to create some samples. For this reason, there are no significant alterations or particular data to omit from the sample portion. Sewing comes next in importance after cutting the fabric. For PIT there are mention sewing details on tech pack.

Sewing Process of PIT :

ART	OPERATION	M/C
	FRONT PART	
	COIN PKT ROLLING	SNL
	COIN PKT ATTACH	DNL
	FRONT POCKET FACING LACRA STITCH	SNL
	FRONT POCKET FACING EDGE SERGING (BOTTOM)	3 OL
	FRONT POCKET FACING ATTACH (BOTTOM)	SNL
	CLOSE FRONT PKT BAG	3 OL
	TURN & TOPSTITCH FRONT PKT BAG	SNL
	FRONT POCKET ATTACH	SNL
	FRONT POCKET MOUTH TOP STITCH	DNL
	TACK AT FRONT PKT . SIDE & WAIST	SNL
	FRONT S/FLY + D/ FLY EDGE O/L WITH D/FLY BOTTOM SERGING	3 OL
	FRONT SIDE LACRA STITCH*2	SNL
	FRONT RISE SERGING WITH S/FLY JOIN	3 OL
	S/FLY SAFETY & TOP STITCH	SNL
	FRONT ZIPPER ATTACH	DNL
	FLY J-STITCH BY TEMPLATE	SNL
	FRONT RISE LACRA STITCH	SNL
	RIGHT PART JOIN TO D/FLY & TOP STITCH	SNL
	FRONT RISE TOP STITCH & 2ND STC	DNL
	FRONT PKT WASH TACK	SNL
	SHAD LABEL ATTACH WITH POLY	SNL
	BACK PART	
	LABEL ATTACH AT BACK PART WITH POLY	SNL
	JOIN BACK YOKE(FOLDER) & TRIMS	CHAIN
	JOIN BACK RISE(FOLDER)	FOA
	MARK, BACK PKT ATTATCH POSITION	H
	BACK POCKET HEM	SNL
	BACK POCKET EDGE OL	3 OL
	CREASE BACK POCKET	IRN
	ATTATCH BACK POCKET WITH REINFORCEMENT	ANGULAR
	SIZE LABEL ATTACH TO BACK WITH POLY	SNL
	BACK PART CHEACK	Q I
	ASSEMBLY	
	MATCH FRONT & BACK & WAIST LOOP SET	H
	INSEAM JOIN (FOLDER) WITH IN SEAM POINT CUT	FOA
	SIDE SEAM JOIN	5 OL
	SIDE SEAM CORD STITCH	SNL
	MARK, BK YOKE + FRT FOR W/B ATT WITH LOOP POSITION	H
	MARK, WAIST BAND WITH HOLE & LABEL ATTACH POSITION	H
	WAIST BAND HOLE*04	BH
	WAIST BAND LABEL ATTACH	SNL
	LOOP MAKE (FOLDER) LOOP INSET ONE BY ONE	SNL
	LOOP ATTACH*05	VARTICAL
	LOOP REINFORCEMENT EDGE SERGING & CUT	3 OL
	LOOP REINFORCEMENT ATTACH	SNL
	WAIST SHAIRING	CHAIN
	ATTATCH WAIST BAND (FOLDER)	K-S
	WAIST MOUTH CUT & THREAD UNPICK	H
	WAIST BAND MOUTH CLOSE (LOWER)	SNL
	WAIST BAND MOUTH CLOSE(UPPER PART)	SNL
	WAIST BAND MOUTH 1/4 TOP STITCH	SNL
	BODY TURN & THREAD CUT	H
	BOTTOM HEM	SNL
	EYELET HOLE	EYELET
	BARTACK AT COIN, BACK PKTS & FLY & SIDE(10 NOS)	BT
	LOOP BOTTOM SIDE TUCK	SNL
	LOOP BARTACK *10	BT
	TTL	

Fig 3.2.2.c : Sewing Process of PIT

3.2.2.d QC Check List

WINDY GROUP SAMPLE SECTION			
Sample Check List		N	
Buyer	OKCidi		
Style No	96247		
Item			
Type of Sample	p.p sample		
Sample color			
Sample size			
Sample Qty			
	Actual	Avallavie	
Main Body Fabric	✓		
contrast Fabric	✓		
Pocketing	✓		
Fusing	✓		
Jersey	✓		
Main Body thread 1	40/2		
Main Body thread 2	40/2		
Main Body thread 3	40/2		
Over lock thread	40/3		
Bartack thread	✓		
Pocketing thread	✓		
Embroidary thread	✓		
Front Fly Zipper	✓		
Side Zipper	✓		
Leg Zipper	✓		
Pocket Zipper	✓		
Waist Elastic	✓		
Adjustable hole Elastic	✓		
Main Label	✓		
Size Label	✓		
Care Label	✓		
Shank Button	✓		
Sanap Button	✓		
Ring Sanap Button	✓		
Rivet	✓		
Lather Patch	✓		
Print	✓		
Piping/ Binding	✓		
Key hole	✓		
Draw cord	✓		
Twill Tape	✓		
Wash Comments	wash as per buyer standard		
Construction comments	sample have to make base on previous sample with update comment.		
Sample Submit Date			

Fig 3.2.2.d: QC Check List

3.2.2.e Sample Submission to Buyer for Approval



Fig 3.2.2.e.: Sample submission to Buyer for Approval

Description :

After making the sample & finishing check by QC the sample handover to merchandiser & Merchandiser submits the sample to the buyer for approval. If there have some issues like measurement issues, quality issues, or Buyer comments on the sample. Merchandiser remakes the sample & again submits it for approval.

3.2.3 Test Report on PIT

OKAIDI buyer test the sample very carefully & after they approve:

Some key points to test approval:

- a) Fibre composition
- b) Color fastness to washing
- c) Colorfastness to water
- d) Colorfastness to rubbing
- e) Colorfastness to light
- f) Colorfastness to perspiration
- g) Dimensional stability to washing
- h) General appearance after washing
- i) Tear strength

Test report bellow:



REPORT NO.: BGD24024179

OKAIDI LABTEST REPORT

APPLICANT: HOLLYWOOD GARMENTS (PVT) LTD
140 BARON, DAIKHALI, DEPZ ROAD, ASHULIA, SAVAR,
DHAKA, BANGLADESH.

DATE: 19.02.2024

ATTENTION: Mr. Shahjahan

OVERALL RATING	:	FAIL
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Sample Received Date	15.02.2024	Test Period	15.02.2024 to 19.02.2024	Service	Regular
----------------------	------------	-------------	--------------------------	---------	---------

Sample Description	Four (04) Pieces Submitted Boys Long Pant Are Marked As Dark Blue
--------------------	---

Buyer	OKAIDI	Supplier Category	B
Ref. No./ Style No	0096244	Fiber Content	80% Cotton 18% Polyester 2% Elastane
Style Name	PIT	Fabric Weight	/
Order / PO Number	413206-01	Country Of Origin	Bangladesh
Colour Code	K0092	Size Range	3Y-14Y
Colour Name	Dark Blue	Mill	Nice Denim
Season	S24	Garment Factory	HOLLYWOOD GARMENTS (PVT) LTD
IL Name	Mr. Sanaul	Package Type	Repeated Order (BGDT23142376-REV1)
Oekotex	-	Factory Code	U0004241



Test Report :



TEST REPORT



REPORT NO.: BGD24024179

EXECUTIVE SUMMARY:

Required Test	Conclusion	Data	Remark
pH Value	PASS		
Formaldehyde	PASS		
Colour Fastness To Rubbing After Wash	FAIL		
Colour Fastness To Light	PASS		
Colour Fastness To Ozone	PASS		
Tension Test	PASS		
Appearance After Wash	PASS		
Spirality After Wash	PASS		
Durability Wash	PASS		

Fig 3.2.3: PIT Test Report

3.2.4 Buyer Comments On PIT

Measurement Comments:

After checking we notice some of the measurements are discrepancies, please see measurements red in the chart (column C) Please respect our size chart precisely otherwise the garments will not be acceptable in final inspection.

Fitting Comments:

Fitting balance seems ok on dummy

Pattern Comment

pattern ok

Sample Comments:

- Bottom hem should be more stretchable. Please make sure to improve on bulk
- Reinforcement at under pockets and under loops ok
- Waistband workmanship ok
- Adjustable elastic assembly is ok, please make sure to meet the button pull test.
- Balance ok
- Be careful to do not leg twist
- Be careful about Lycra damage at seam area

Fig 3.2.4 : Buyer Comments on PIT

CHAPTER-04

DISCUSSION OF RESULTS

4.1 Tech Pack Analysis

The Tech Pack is the main document that a trader receives from a client. This tech pack encompasses a comprehensive range of garment specifications, including style, measurements, stitching, trim, color, and more. It assists traders in producing a high-quality sample with accurate information. Hence, it is imperative for the trader to meticulously evaluate the technical package.

4.1.1 Bagaz Short Sleeve Shirt

Point which includes in tech pack:

- A clean introductory page where every piece of information is available regarding the particular style.
- Tech sketches, Trims, and Care Labels are included here.
- Color ways samples are included at tech pack
- The measurement page includes all sizes ratios with acceptable tolerance

Points can be added for a clear idea:

- Fabric & interlining details are not included in tech pack. It can be added on tech pack.
- Wash instructions are not added in tech, it can be added.
- Sewing details can be added in tech pack, it can be help for smooth work for a developer.

4.1.2 PIT Boys Skinny Long Pant

Point which includes in tech pack :

- The tech pack provides detailed specifications for creating a complete and high-quality sample.
- The document provides specific information regarding the fabric, trims, labels, and other accessories.
- The instructions for stitching the sample are clearly and effectively provided in this tech kit.
- The tech bundle includes sample photos to assist developers in creating samples.

Points can be added for a clear idea:

- Fabric & Pockting details can be added in tech pack.
- Wash instructions are not added in tech, it can be added.
- Sewing details can be added in tech pack, it can be help for smooth work for a developer.

4.2 Challenges of making samples

- Sometimes materials can not be provided in time from the supplier, which give pressure on a merchandiser to make the sample & provide it to buyer.
- Measurement issue is a major problem in making a sample. Sometimes, After wash measurement can not match to required by buyer.
- Color shade matching is a major issue for a developer. If the color shade does not match to required shade buyer can not approve the sample.
- For a sample developer, he/she must be capable of hard communication skills. Because every person include to make the sample as like pattern maker, cutting operator, sewing operator & quality incharge. A merchandiser communicated with all sections to make the sample properly.

4.3 Requisition Form Of Sample

Requisition form is a paper with buyer's /tech pack's specific details. A merchandiser makes this form to provide this in the sample section to make sample properly.

In this form, merchandiser provides all of details like fabric, interlining, pocketing, buttons, zipper, etc. One of the first things that happens is that the merchandiser gets the tech pack from the buyer. needs to be put in one place, and the merchandiser sends the request to the sample department with directions on what to do next.

As long as the merchandiser uses sample requisition form, it will be easy for the sample staff to make the sample. Can quickly decide what need and don't need because the sample request form has everything need to make a full sample on one page.

4.3.1 Requisition Form Of BAGAZ


WINDY GROUP
 SAMPLE REQUISITION FORM

Merchandise Name	Bayzid				
Buyer	Cello				
Style	BAGAZ				
Item	SHIRT				
Type of Sample	PP REF				
Sample Requisition Date	19-Feb				
Sample Required Date	20-Feb				
Techpeck Issue Date					
Comments Issue Date					
Measure Chart Issue Date					
Ref. Sample Issue Date					
FABRIC		AS PROVIDED			
Color	NAVY	BEIGE	OPTICAL WHITE	BLACK	
Size	M	M	M	M	
Quantity	3 PCS	3 PCS	3 PCS	3 PCS	
Type of Wash					

Part - 1				Part - 2			
Fabric & Trims	Issue Date	Yes / No	REMARKS	Fabric & Trims	Issue Date	Yes / No	Remarks
Shell Fabric	22-Mar						Attached After Wash
Pocketing	22-Mar			Button	After wash		
Top Thread			40/2	Snap			
Bbn Thread			40/2	Rivet			
Overlock Thread			40/2	Adjst. Elastic			
Bartack Thread			40/2	Plain Elastic			
Lining Thread				Drow cord for HOOD			
Zipper				Print			
Contrast 1				Embroidary			
Contrast 2				Leather Patch			
Contrast 3							
Piping/ Binding							
Lining							
Jersey							
Sherpa							
Quilting							
Interlining			for Beige + optical white-				
Main Label			1/19/2022				
Size Label							

Note: Sampling Target

- * 07 Days for fit sample submission
- * 10 Days for Size-set sample submission
- * 07 Days for PP sample submission

Any comments must get by 07 days.

Fabric Swatch

Pocketing Swatch

Thread Swatch

Merchandise

Sample Checked By

Fig 4.3.1: Requisition form of BAGAZ

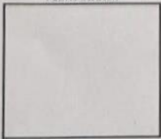
4.3.2 Requisition Form Of PIT


WINDY GROUP
 SAMPLE REQUISITION FORM

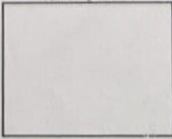
Merchandiser Name	SHEYAM										
Buyer	OKAIDI										
Style	96244 - PIT										
Item	BOYS SKINNY LONG PANT										
Type of Sample	TEST										
Sample Requisition Date	10-Feb										
Sample Required Date	11-Feb										
Techpeck Issue Date											
Comments Issue Date											
Measure Chart Issue Date											
Ref. Sample Issue Date											
Color	DARK DENIM BLEU LIGHT STONE										
Size	3Y	14Y							TTL	Always follow comments for size reconfirmation.	
Quantity	6	2							8PCS		
Type of Wash											

Part - 1					Part - 2				
Fabric & Trims	Issue Date	Yes / No	Remarks		Fabric & Trims	Issue Date	Yes / No	Remarks	
shell			ND 3939 64.3% BCI Cotton, 15% PCW Cotton, 18.3% Poly, 2.4% Spandex						
Pocketing			AS PER GIVEN TC		Button				
Top Thread			AS PER GIVEN 20/4		Snap				
Bbn Thread			AS PER GIVEN 20/2		Rivet				
Overlock Thread			AS PER GIVEN 40/2		Adjst. Elastic				
Bartack Thread			AS PER GIVEN 40/2		Plain Elastic				
Lining Thread					Twill Tape:				
Zipper					Print				
Contrast 1					Embroidary				
Contrast 2					Leather Patch				
Contrast 3	SIZE BREAKDO							TTL	
Piping/ Binding	PROTO							0	
Lining									
Jersey	PHOTO SAMPLE								
Sherpa									
Quilting	TEST SAMPLE							0	
Interlining									
Main Label	TTL	0	0	0					
Size Label									

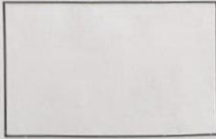
Fabric Swatch



Pocketing Swatch



Thread Swatch



Note: Sampling Target

- * 07 Days for fit sample submission
- * 10 Days for Size-set sample submission
- * 07 Days for PP sample submission
- Any comments must get by 07 days.

Merchandiser

Sample Checked By

Fig4.3.2 : Requisition form of PIT

4.4 Compare Between Celio & Okaidi

		CELIO	OKAIDI
01	Brand Overview	Celio's main segment is Men's Fashion. Celio has also sub brand CAMAIEU.	Okaidi's main segment is Children's fashion. Okaidi has also sub brand Obaibi.
02	Target Buyer	Celio's main target of customers aged 20-24 years. young professionals, students, and fashion-conscious men are the main customers of Celio.	Okaidi's main target of customers aged 0-14 years. Families with young children, focused on practicality, comfort, and style for their kids.
03	Purchasing Motivation	Inspired by men's style, modern trends, and budget-friendly prices.	kids need quality, comfort, and style, and because growing kids often have real needs that aren't met by other brands.
04	Brand Loyalty	Moderate, because other trendy names are also in the market.	High, because parents want names that they know they can trust for their kids.
05	Shopping Frequency	Based on trend periods, moderate to often.	Regularly, based on how kids grow and their needs change.

Fig 4.4 : Compare between Celio & Okaidi

CHAPTER-05

CONCLUSION

CONCLUSION

Samples can be developed under many names, such as development sample, design sample, proto sample, online sample, customer contact sample, size set sample, and fit sample. Development merchandisers do the work to make samples. Development merchandiser ensures that the product development process runs smoothly from concept to production, maintaining a balance between creativity, quality, and time efficiency.

- ✓ Development merchandiser work based on buyer requirements & technical file's instructions. In this thesis , 4.1 chapter – we learn about technical file .
- ✓ Development merchandiser take challenges to make samples , In this thesis ,4.2 chapter we learn about challenges of making samples .
- ✓ Sample section work on technical files, and buyer requirement & mostly based on merchandiser's instruction. In this thesis 4.3-we learn about merchandiser's instruction for sample development .

Through our thesis, we learned about different tech packs, what they include and what they don't include, and we discussed them nicely. Also, this thesis provides detailed information about fabric details, measurements, accessories, supplier names, Consumption, patterns & costing for make samples. We are submitting documents with samples, such as fabric & accessories. We also learned about the sample making procedure, sample requisition form, and how the samples department would work if it was implemented or not. Sample development is the main part of executing an order. That is why we need to be more concerned about developing samples with maximum accuracy.

REFERENCE

- WINDY GROUP

Sample Development

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