



Faculty of Engineering

Department Of Textile Engineering

Study on Production Process of Kids Wear

Course Title: Project (Thesis)

Course Code: TE-4214

Submitted By

Md Mahbub Sikder ID: 161-23-4643

Hasan Al Mamun ID: 151-23-4272

Academic Supervisor

Mst. Murshida Khatun

Assistant Professor

Department of Textile Engineering

This Report presented in partial fulfillment of the Requirement for the Degree of Bachelor of Science in Textile Engineering.

Advance in Apparel Manufacturing Technology

Fall-2019

Acknowledgement

First of all, I want to express my sincere thanks and gratitude to Almighty Allah for His sincere blessings so that we can successfully complete this report.

I feel grateful to my academic supervisor. **Murshida Khatun, Assistant Professor, Department of Textile Engineering, Daffodil International University.** She continues to guide us on the development and preparation of this report. He enriched us by sharing the necessary theoretical and practical ideas and supervised us in completing this report in a timely manner.

I would like to thank our **Prof. Dr. Md Mahbubul Haque**, Head of Department of **Textile Engineering** of Daffodil International University for his kind assistance in completing our report.

I am extremely thankful to the authorities of Euro-Tex Knitwear Ltd for allowing us to do a significant part of the experimental work at their chandelier. Without their support, We could not finish the project. In particular, I thank **Babu Kumar Saha Dip**, no work has been done in the factory without his permission.

Finally, we would like to take this opportunity to express our feelings of gratitude and love to our dear parents and my friends for their emotional support, strength, support and above all.

Declaration

We hereby declare that, this project has been done by us under the supervision of Mst. Murshida Khatun, Assistant Professor, Dept. of Textile Engineering, Faculty of Engineering, Daffodil International University. We also state that neither this project nor any part of this project has been submitted elsewhere for award of any degree or diploma.

Name	ID	Signature
Md Mahbub Sikder	161-23-4643	
Hasan Al Mamun	151-23-4272	

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

Letter of Approval

14th December 2019

To

The Head

Department of Textile Engineering

Daffodil International University

102, Shukrabad, Mirpur Road, Dhaka 1207

Subject: Prayer for approval of the Project Report of B.Sc in Textile Engineering.

Sir,

We have prepared a report on “**Study on Production Process of Kids Wear**” where the buyer was Original Marine. We were two persons who worked on this report whose student ID is **161-23-4643 & 151-23-4272**. We were involved here from the beginning of the project and gathered all the information from different sections. We investigated all the sections properly and directly worked with the Merchandisers. For that reason we have done this report very easily.

I, therefore, pray and hope that you will kindly grant this report for the final submission.

Yours Sincerely



Mst Murshida Khatun

Assistant Professor

Department of textile engineering

Daffodil International University

Abstract

We worked on the report of Original Marine. This report presents the final table inspection and final inspection report while producing different types of Kids wear. Different clothing defects are also presented in different types of baby T-shirts. The quality depends on the extent of the fault on the t-shirt and what kind of defect is present. Quality represents the reputation of the company and customer satisfaction. So every industry strives to produce good quality products. This report gives an idea of how to make faults in Kids Wear and how to reduce faults. So it helped to find out the different types of defects and we also know the manufacturing of High quality Kids Wear.

List of Content

Contents

Acknowledgement.....	i
Declaration.....	ii
Letter of approval.....	iii
Abstract	iv
Chapter-I Introduction.....	1
1.1 Objective.....	2
1.2 Limitation	2
Chapter-II Literature Review.....	3
2.0What is Kidsware?	4
2.1 Raw Materials	4
2.2 Assembling the front and back	5
2.3 Assembling the sleeves.....	5
2.4 Attaching the neckband	6
2.5 Finishing the neckline.....	6
2.7 Label setting.....	6
2.8 Finishing operations	7
2.9 Quality Control	7
2.10 Operation Breakdown and SMV of Baby T-shirt of Knit Garments	7
2.11 Summary of Kidsware Operation Bulletin	11
2.12 Sewing fault for Baby T-shirt:	12
2.13 Seaming Defects:.....	12
2.15 Assembly Defects:.....	13
2.16 Inspection Procedure for baby T-shirt	14
2.17 Measure garment dimensions	14
2.18 Check function of closures, buttons, zippers and other accessories	14
2.19 Verify proper packaging and labeling of garments	15
2.20 Conformance to legal requirements for garment labeling	15
2.21 Packaging inspection for garments	15
2.22 Test fabric for conformance to quality standards.....	16

2.23 Stitches per inch (SPI) check	16
2.24 Material composition check.....	17
2.25 Report on quality defects and severity	17
Chapter-III Experimental Details.....	18
3.1 Original Marine Order Garments:	18
3.2 knitting Report.....	23
3.3 Dyeing Inspection Report.....	24
3.4 Sample Develop or PP Sample:	26
3.4.2 Swatch Card:	28
3.4.3 Pre-Production Meeting:.....	29
3.5 Cutting Inspection Table:	31
3.6 SPI check Report.....	33
3.7.1 traffic light Summary.....	45
3.8 Machine cleaning and oil Report.....	53
3.9 Measurement Sheet.....	63
3.10 DHU level.....	74
Chapter-IV Discussion of Result.....	75
4.1 Discussion on SPI Report:	76
4.2 Discussion on Traffic Light Summary:	76
4.3 Discussion on Machine cleaning and Oil Checking report:	77
4.4 Discussion on Measurement Sheet.....	78
Chapter-V Conclusion	79
5.1 Conclusion.....	80
Referance.....	81

List of Tables

Table 2.1 Operation Breakdown and SMV of Kids wear of Knit Garments	10
Table 2.2 Summary of Kids Wear Operation Bulletin.....	11
Table 3.1.2 Closing Inspection	22
Table 3.2 Table knitting Inspection	23
Table 3.3 Table dyeing inspection	25
Table 3.5 cutting Inspection.....	31
Table 3.6 Table Finishing inspection	32
Table 3.6 Day 01 SPI Report.....	33
Table 3.7 Daily SPI Check report	34
Table 3.8 Daily SPI check report.....	36
Table 3.9 Daily SPI check report.....	38
Table 3.10 Daily SPI check report.....	40
Table 3.11 Daily SPI check report.....	42
Table 3.12 Daily SPI check report.....	44
3.8 Machine cleaning and Oil Report.....	61
Table 3.8.1 Machine cleaning and oil check report	62
Table 3.9 Measument Sheet.....	71
Table 3.10 DHU Level.....	74

List of Figures

Figure 3.1 Complete Garments (APZ1153+54+55NF).....	19
Figure 3.1.1 Closing Report	20
Figure 3.2 Knitting Report	23
Figure 3.3 Dyeing inspection or T & A Plan.....	24
Figure 3.4 Sample Develop	26
Figure 3.4.1 PP Sample	27
Figure 3.4.2 Swatch Card	28
Figure 3.4.3 Pre-Production Meeting Record.....	29
Figure 3.5 Cutting Inspection	30
Figure 3.6 Day 02 SPI Report.....	35
Figure 3.7 Day 03 SPI Report.....	37
Figure 3.8 Day 04 SPI Report.....	39
Figure 3.9 Day 05 SPI Report.....	41
Figure 3.10 Day 06 SPI Check Report.....	43
Figure 3.7.1 Traffic Light Summary Day 01	45
Figure 3.7.2 Traffic Light Summary Day 02	46
Figure 3.7.3 Traffic Light Summary Day 03	47
Figure 3.7.4 Traffic Light Summary Day 04	48
Figure 3.7.5 Traffic light summary Day 05.....	49
Figure 3.7.6 Traffic Light Summary Day 06.....	50
Figure 3.7.7 Traffic Light Summary Day 07	51
Figure 3.7.8 Traffic Light Summary Day 08	52
Figure 3.8 Machine cleaning & oil check report: Day 01	53
Figure 3.8.2 Machine cleaning & oil check report: Day 02	54
Figure 3.8.3 Machine cleaning & oil check report: Day 03	55
Figure 3.8.4 Machine cleaning & oil check report: Day 04	56
Figure 3.8.5 Machine cleaning & oil check report: Day 05	57
Figure 3.8.6 Machine cleaning & oil check report: Day 06	58
Figure 3.8.7 Machine cleaning & oil check report: Day 07	59
Figure 3.8.8 Machine cleaning & oil check report: Day 08	60
Figure 3.9 Measurement Sheet Day 01	63
Figure 3.9.2 Measurement Sheet Day 02	64
Figure 3.9.3 Measurement Sheet Day 03	65
Figure 3.9.4 Measurement Sheet Day 04	66
Figure 3.9.5 Measurement Sheet Day 05	67
Figure 3.9.6 Measurement Sheet Day 06	68
Figure 3.9.7 Measurement Sheet Day 07	69
Figure 3.9.8 Measurement Sheet Day 08	70

CHAPTER- I

INTRODUCTION

1.1 Objective

- To know how to give buyer order.
- To know about the fabric inspection.
- To know about the quality of fabrics
- To know how to make pattern, marker and how to lay the fabrics on the cutting table
- To know about the cutting process
- To know the requirement of different style of t-shirt manufacturing.
- To know about the sewing process
- To know the finishing process and inspection
- To know the different types of T-shirt manufacturing defect and fault
- To know the Manufacture of baby T-shirt

1.2 Limitation

- We faced some problem in starting time due to proper reference.
- We are collected data from one factory.
- Some data we can't collect due to factory rules.
- Some department didn't share their data due to they have not enough time.
- Lack of proper guide we can't collect all data.
- This factory only knitting producer.

CHAPTER-II

LITERATURE REVIEW

What is Kids Wear?

The clothing of children is defined as kids wear. Who have not yet grown up to full height. Best quality and best performance is done there. Well-designed also. Actually kids wear is much casual than adult clothing. Because kids wear must be fit to play and comfortable to move. Thus kids wear is very much important. And its quality must be taken care of.

2.1 Raw Materials

The majority of T-shirts are made of 100% cotton, polyester, or a cotton/polyester blend. Environmentally conscious manufacturers may use organically grown cotton and natural dyes. Stretchable T-shirts are made of knit fabrics, especially jerseys, rib knits, and interlock rib knits, which consist of two ribbed fabrics that are joined together. Jerseys are most frequently used since they are versatile, comfortable, and relatively inexpensive. They also are a popular material for applying screen prints and heat transfers. Some jerseys come in tubular form, simplifying the production process by reducing the number of seams. Rib knit fabrics is often used when a snugger fit is desired. Many higher quality T-shirts are made of durable interlock rib knit fabrics.

Neckbands add support to the garment and give the neckline of the T-shirt a more finished look. Neckbands are generally one-by-one inch rib knits, although heavier fabrics or higher quality T-shirts may require two-by-two rib knits. Neckband fabrics may be tubed rib knits of specific widths, or flat fabric that must be seamed. Additional T-shirt materials include tape or seam binding, made of a twill or another stiff fabric. Binding reinforces the neckline and shoulder seams and by covering the seams, it protects them from ripping apart under tension. Alternatively, elastic may be used at the shoulder seams so they remain flexible.

Thread is of course an essential element in sewing any garment. Several types and colors of thread may be used to make a single T-shirt. Some manufacturers use white thread for seams on all their shirts, regardless of color, thus eliminating the extra labor involved in changing the thread. Visible topstitching is done with a color of thread that blends with the fabric. Colorless, or monofilament, thread could be used for hems of any color fabric, again eliminating the need to change thread often, though monofilament thread may irritate the skin somewhat. Finally, optional decorative features may include trim, such as braiding.

2.2 Styling

- 1 The T-shirt style is designed and the dimensions are transferred to patterns. Adjustments are made for size differences and stylistic preferences.

- 2 The T-shirt sections are cut to the dimensions of the patterns. The pieces consist of a tubed body, or separate front and back sections, sleeves, perhaps pockets, and trim.

2.3 Assembling the front and back

- 3 For fabric that is not tubed, the separate pieces for the front and back sections must be stitched together at the sides. They are joined at the seam lines to form a simple, narrow, superimposed seam and stitched together using an over edge stitch. Care must be taken to avoid a needle cutting the yarn of the fabric, which can lead to tears in the garment.

2.4 Assembling the sleeves

- 4 The hems of sleeves are generally finished before they are fitted into the garment, since it is easier to hem the fabric while it is flat. An automated system moves the sleeves to the sewing head by conveyor. The edge may be finished by folding it over, forming the hem and stitching, or by applying a band. The band may be attached as a superimposed seam or folded over the edge as binding.
- 5 If the T-shirt body is tubular, the sleeve material is first sewn together, and then set into the garment. Alternatively, if the T-shirt is “cut and sewn,” the un-seamed sleeve is set into place. Later during the final stage of sewing the shirt, the sleeve and side seams are sewn in one action.

Stitching the hem

- 6 The garment hem is commonly sewn with an overedge stitch, resulting in a flexible hem. The tension of the stitch should be loose enough to allow stretching the garment without tearing the fabric. Alternative hem styles include a combination of edge finishing stitches.

Adding pockets

- 7 Pockets may be sewn onto T-shirts intended for casual wear. Higher quality T-shirts will insert an interlining into the pocket so that it maintains its shape. The interlining is inserted into the pocket as it is sewn onto the T-shirt front. Pockets may be attached to the garment with automated setters, so the operator only has to arrange the fabric pieces, and the mechanical setter positions the pocket and stitches the seam.

Stitching the shoulder seams

- 8 Generally, shoulder seams require a simple superimposed seam. Higher quality T-shirt manufacturers may reinforce seams with tape or elastic. Depending on the style of the T-shirt, the seams at the shoulder may be completed before or after the neckband is attached. For instance, if a tubular neckband is to be applied, the shoulder seams must first be closed.

2.5 Attaching the neckband

- 9 For crew neck shirts, the neck edge should be slightly shorter in circumference than the outer edge where it is attached to the garment. Thus, the neckband must be stretched just the right amount to prevent bulging. Tubular neckbands are applied manually. The bands are folded, wrong sides together, stretched slightly, and aligned with the neckline. The superimposed seam is stitched with an over edge stitch.

Bound seams are finished with a cover stitch and are easy to achieve. Bound seams may be used on a variety of neckline styles. The process entails feeding ribbed fabric through machines which fold the fabric and apply tension to it.

Some neckbands on lower-priced shirts are attached separately to the front and back necklines of the garment. Thus when the shoulder seams are stitched, seams are visible on the neckband.

V-necks require the extra step of either lapping or mitering the neckband. In the former process, one side is folded over the other. A mitered seam is more complex, requiring an operator to overlap the band accurately and stitch the band at center front. An easier method for a V-neck look is to attach the band to the neckline and then sew a tuck to form a V.

2.6 Finishing the neckline

- 10 Necklines with superimposed seams may be taped, so that the shirt is stronger and more comfortable. Tape may be extended across the back and over the shoulder seams to reinforce this area as well and to flatten the seam. The seam is then cover stitched or top stitched.

2.7 Label setting

- 11 One or more labels are usually attached at the back of the neckline. Labels provide information about the manufacturer, size, fabric content, and washing instructions.

Optional features

- 12 Some T-shirts will have trim or screen prints added for decorative purposes. Special T-shirts for infants have larger openings at the head. The shoulder seams are left open near the neck, and buttons or other fasteners are attached.

2.8 Finishing operations

- 13 T-shirts are inspected for flaws in the fabric, stitching, and thread.
- 14 High-quality T-shirts may be pressed through steam tunnels before they are packaged. Packaging depends on the type of T-shirt and the intended distribution outlet. For underwear, the shirts are folded and packaged in pre-printed bags, usually of clear plastic, that list information about the product. Shirts may be boarded, or folded around a piece of cardboard, so that they maintain their shape during shipping and on the shelf. Finally, they are placed into boxes by the dozen or half-dozen.

2.9 Quality Control

Most of the operations in manufacturing clothing are regulated by federal and inter-national guidelines. Manufacturers may also set guidelines for the company. There are standards that apply specifically to the T-shirt industry, which include proper sizing and fit, appropriate needles and seams, types of stitches, and the number of stitches per inch. Stitches must be loose enough to allow the garment to stretch without breaking the seam. Hems must be flat and wide enough to prevent curling. T-shirts must also be inspected for proper application of neck-lines, which should rest flat against the body. The neckline should also recover properly after being slightly stretched.

2.10 Operation Breakdown and SMV of Baby T-shirt of Knit Garments

T-shirt named for its T shape, collarless and short sleeves. Generally, a T-shirt made by light cotton fabrics, very comfortable to wear, casual wearing dress. A T-shirt is more comfortable than Polo shirt, male and female both can wear it. This article is all about T-shirt manufacturing, operation breakdown of T-shirt. Total SMV of T-shirt is 8.41. From this article, you will know, list of operation, machine list, SMV of every single operation, the production target of T-shirt manufacturing in the sewing section. So, let's have a look at Operation Breakdown and SMV of T-shirt of Knit Garments.

2.10 Operation Breakdown and SMV of Baby T-shirt of Knit Garments

N O	OPERATION	M/C	S.M. V	TG T	MAN REQ	MAN ALCT	Plan Work Statio n
1	CARE LABEL ATTACH	SNL	0.12	500	0.36	0.5	1
2	PLACKET ATTACH POSITION MARK	MN L	0.25	240	0.74	0.5	1
3	PLACKET ROLLING & MARK	SNL	0.32	188	0.95	1	1
4	PLACKET ATTACH	SNL	0.4	150	1.19	1	1
5	PLACKET CUT & NOSE TK	SNL	0.27	222	0.8	1	1
6	FRONT & BACK PART MATCH	MN L	0.15	400	0.45	0.5	1
7	SHOULDER JOINT	4OL	0.3	200	0.89	1	1
8	NOSE NECK RIB MEASURE & CUT	MN L	0.2	300	0.59	0.5	1
9	NOSE NECK RIB TK WITH BODY	SNL	0.32	188	0.95	1	1
1 0	NOSE NECK RIB JOIN	4OL	0.32	188	0.95	1	1

1 1	NECK TS	FL	0.25	240	0.74	0.5	1
1 3	PLACKET CLOSE & 1/16 UPPER	SNL	0.32	188	0.95	1	1
1 2	PLACKET CLOSE & 1/16 LOWER	SNL	0.32	188	0.95	1	1
1 4	PLACKET BOX	SNL	0.4	150	1.19	1	1
1 5	NECK PIPING	FB	0.23	261	0.68	1	1
1 6	MAIN LBL ATTACH WITH CORNER FOLD	SNL	0.32	188	0.95	1	1
1 7	SLV HEM	FL	0.33	182	0.98	1	1
1 8	SLEEVE AND BODY MATCH	MN L	0.15	400	0.45	1	1
1 9	SLEEVE JOINT	4OL	0.45	133	1.34	1	1
2 0	ARMHOLE T/S	FL	0.32	188	0.95	1	1
2 1	SIDE SEAM	4OL	0.7	86	2.08	2	2
2 2	SLEEVE CLOSE & OPEN TACK	SNL	0.37	162	1.1	1	1

2 2	BODY HEM	FL	0.33	182	0.98	1	1
2 2	BUTTONHOLE	BH	0.3	200	0.89	1	1
2 2	BUTTON ATTACH MARK	BS	0.27	222	0.8	1	1
2 2	BUTTON PUSH	MN L	0.2	300	0.59		
2 2	FINAL THREAD CUT & STICKER REMOVE	MN L	0.5	120	1.49	1	1
Total			8.41		25	25	27

Table 2.1 Operation Breakdown and SMV of Kids wear of Knit Garments

Here,

- 5OL – 5 thread overlock
- 4OL – 4 thread overlock
- SNL – Single needle lock stitch
- FB – Flat belt
- KS – Kansai machine
- BS – Button stitch m/c
- FL – Flat lock m/c
- BH – Button hole m/c
- M/C – Machine
- TGT – Target
- MAN REQ – Man Requirement
- MAN ALCT – Man Allocation

2.11 Summary of Kids Wear Operation Bulletin

Inline	SMV
SEWING	6.96
MANUAL	1.45
IRON	0
TOTAL	8.41
Man level	25
Tact time	0.336
100% Target/hour	178
75% Target/hour	134
65% Target/hour	116
Machine Type	Requisition
5OL	0
4OL	5
SNL	10
FB	1
KS	0
BS	1
FL	4
BH	1
Total	21
Manpower	Requisition
Operator	21
Iron Man	0
MANUAL	3
Total	24
Manpower	Requisition

Table 2.2 Summary of Kids Wear Operation Bulletin

2.12. Sewing fault for Kids Wear:

Sewing is the process of attaching two fabric parts by using stitches which is made with a needle and thread. Sewing is one of the basic steps of garments manufacturing process. Also sewing section is the most significant section of a RMG. Different Types of fabrics or defects arise in sewing section which should be reduced to maintain the required quality of apparel. As its importance, this article has shown all the defects which produced in sewing section garments manufacturing factory.

2.13 Sewing Defects:

1. Needle damage: for example, drawn-off from the fabric or making of large hole to the fabrics.
2. Skipped stitch
3. Thread drawn-off.
4. Seam pucking
5. Wrong stitch density.
6. Uneven stitch.
7. Staggered stitch.
8. Defected stitch.
9. Oil spot or stain.

2.14 Seaming Defects:

1. Uneven width.
2. Uneven seam line.
3. Not secured by back stitch.
4. Twisting.
5. No matching of check or stripe.
6. No matching of seam.
7. Unexpected materials are attached with the sewing.
8. Not sewn by matching face side or back side of fabrics.

9. Use of wrong stitch type.
10. Wrong shade matching of sewing thread.

2.15 Assembly Defects:

- Defected finished components by size i.e. imperfect size and shape of finished components.
- Imperfect garments size.
- Use of wrong ticket.
- Missing of any parts or predetermined design of garments.
- Imperfect alignment of components i.e. button, hook, and so on) in proper place.
- Wrong placing or creasing of interlining.
- Looseness or tightness of interlining.
- Folding of any parts of garments that is seen to bad appearance.
- Shade variation of garments.
- False direction of fabric parts in the garments.

<http://www.garmentsmerchandising.com/list-of-defects-found-in-sewing-section/>

2.16 Inspection Procedure for baby T-shirt

The textile and apparel supply chain often puts retailers and brands thousands of miles away from their production sites, making inspection an important part of the manufacturing process to assure quality. From raw materials to finished goods, Intertek's textile and apparel inspection services can identify defects and non-compliance during different stages of the production process. With more than 1,000 inspectors around the globe, and 700 in China alone, Intertek offers Pre-production, During Production Inspection or Garment Inline Inspection services, and Before Delivery Inspection to assess textile and apparel products pre-shipment in order to evaluate your products both pre-, during and post-production.

2.17 Measure garment dimensions

The most important function of any piece of clothing is that it fits the end consumer as intended. Every garment importer can attest that customers will often return a garment if it doesn't fit as expected. Ill-fitting garments don't just create extra costs for you in the form of unsellable products. They can also create long-term problems as once-loyal consumers disavow your brand and turn to a competitor with better quality control.

Unlike mass manufacturing for other products, which often uses precise machinery and automation, the work of manufacturing garments is still largely done by hand. This results in a greater margin for error in each piece of clothing. Discrepancies in dimensions are inevitable when manufacturing garments. That's why any thorough garment inspection should include detailed measuring of dimensions.

2.18 Check function of closures, buttons, zippers and other accessories

Most garments aren't simply a few pieces of fabric stitched together. Rather, they also include functional and stylistic accessories like buttons, snaps, zippers, ribbons and elastic bands. A broken closure on a garment usually renders the clothing item unwearable and, therefore, unsellable. Most consumers find poor quality closures to be a nuisance and frustration to repair. Poor quality or attachment of these accessories can lead to negative customer reviews and can even cause bodily harm to consumers.

Garment inspection should include on-site function checks of closures to test durability and ensure they're securely attached to the garment. Common tests include:

- **Pull test:** Pull at the accessory with a pull gauge for 10 seconds to confirm it stays securely attached to the garment.

- **Fatigue test:** Use the accessory as intended for 50 cycles (e.g. button and unbutton 50 times) in quick succession and confirm it's still functional and the garment is undamaged after testing.
- **Stretch test:** Stretch elastic bands and straps for proper elasticity and check for any breakage in elastic fibers or stitching.

QC professionals generally conduct pull tests and fatigue tests on two pieces of each style of garment. It's normally unnecessary to carry out these tests on every piece in the sample during inspection because the processes used in attaching accessories to garments tend to be consistent throughout a shipment. But the quality of elastic materials used in production of some garments can vary between pieces. So inspectors usually perform a stretch test on the full sample size when relevant.

2.19 Verify proper packaging and labeling of garments

Verifying proper packaging and labeling of garments is an essential part of most final inspection. Proper packaging garments arrive at their final destination in the same condition they left your supplier's facility. Aside from inspecting packaging, your QC team should also check the labeling of garments to ensure compliance to legal requirements.

2.20 Conformance to legal requirements for garment labeling

The United States government requires all garments sold in the country to have labels that include the following information:

- **Fiber content of clothing** compliant with the Textile Fiber Products Identification Act
- **Country of origin:** where the item was manufactured or where the most significant manufacturing process occurred
- **Manufacturer identity:** either the company name or the Registered Identification Number (RN) of the manufacturer, importer or another firm marketing, distributing or otherwise handling the product

2.21 Packaging inspection for garments

Most garments are sealed in polybags by factory staff before being packaged in retailer and shipping cartons for transit. Incorrectly packaging and sealing your garments can lead to dust and moisture permeating and soiling your products. And failing to comply with legal requirements for suffocation warnings on polybags could lead to fines.

Inspecting packaging for potential quality issues in transit and distribution includes verifying:

- Polybag sealing method
- Polybag size
- Appropriate labeling, barcodes and price tags
- Retail artwork and printing
- Carton assortment

When ordering a number of different sizes of garments be sure to consider how to sort these garments among shipping cartons. For example, how many women's dresses of each size—small, medium, large and extra-large—should each carton contain? Imagine the frustration of receiving 20 extra-small dresses and only three extra-large dresses when you intended to receive the same proportion of every size. You can prevent this problem by including assortment in the specifications you provide your supplier and inspection team.

2.22 Test fabric for conformance to quality standards

For some products, such as promotional goods, the quality of input materials might not drastically impact salability. But fabric quality is a major determinant of the quality and salability of the finished product when manufacturing garments. Product testing of your garments, both on-site and in a qualified laboratory, provides assurance that your product meets your quality standards

2.23 Stitches per inch (SPI) check

A check for stitches per inch (SPI) involves the QC inspector simply counting the number of stitches in one inch of a selected area of the garment. An SPI check is easy to conduct, as it only requires a tape measure and adequate lighting. Checking SPI on two pieces of each style in a shipment is normally adequate.

While a SPI check is relatively nontechnical and easy to perform, that doesn't make it any less important than other testing. Stitch density is an important determinant of a garment's quality and durability. Garments with a higher SPI are less likely to fall apart with regular use and tend to last longer than those with a lower SPI.

2.24 Material composition check

- Some obvious differences in fabric composition can be detected by hand feel alone during a garment inspection. But most garment importers require material composition testing by a qualified lab that's outfitted with proper equipment and controls. Material composition should reflect the breakdown of fiber types listed on the product label. Fabric composition that doesn't match what's printed on the labeling can cause financial and legal trouble that can irreversibly damage your brand.

2.25 Report on quality defects and severity

An untrimmed thread

- Shading variance between different pieces of the same style or different parts of the same piece
- A loose needle left in the garment

Most garment importers would agree that a loose needle left in a garment is a more severe issue than an untrimmed thread because of the hazard it poses to the consumer. But the severity of other defects might vary based on your intended market and sale price. Setting defect classifications before quality control inspection for garments will help ensure that QC staffs consider all defects in accordance to your specific quality standards.

<https://www.intouch-quality.com/blog/5-essential-garment-inspection-steps-to-protect-your-quality>

CHAPTER-III

EXPERIMENT DETAILS

3.1 Original Marine Order Garments:



Figure 3.1 Complete Kids Wear (APZ1155NF)

Eurotex knitwear ltd & euro knit spinn composite ltd (Nayamati)

Nayamati, Fatulla, Narayanganj

Closing Report

Buyer	Order No.	Style	Color	Order Qty	Qty (+5%)	Sewing Planned Month	Shipment Date	Knitting+Dyeing		Cutting	Print/Emb. Send	Print/Emb. Recive	Sew. Line	Sewing Input	Sewing Output	Poly	shipped
								Knitted+Dye ing Kg	Dyeing Finish Kg								
ORIGINAL MARINES	AZP 1155 NF	T-SHIRT S/S	BRIGHT - WHITE AOP	6890	7235	OCT	27-Oct	665	564	7527	7527	5185	2ND-G	7300	7300	6750	6750
ORIGINAL MARINES			BRIGHT WHITE	5830	6122			665	564	6270	6270	6270	2ND-G	6270	6121	6000	6000
ORIGINAL MARINES	AZP 1155 NF	T-SHIRT S/S	BRIGHT WHITE	5863	6156	Oct	27-Oct	665	564	6270	6270	6228	2ND-G	6206	6095	5821	5821
ORIGINAL MARINES			YELLOW BASIC	6928	7275			585	560	7410	7410	7343	2ND-G	7352	7337	6929	6929
ORIGINAL MARINES	AZP 1155 NF	T-SHIRT S/S	BRIGHT WHITE	1651	1734	OCT	27-Oct	665	564	1779	1534	1693	2ND-G	1759	1660	1651	1651
ORIGINAL MARINES			PINK SHINE	1397	1467		27-Oct	585	560	1493	1463	1405		1493	1400	1397	1397
			TOTAL	28560	29988			3830	3376	30749	30474	28124	0	30380	29913	28548	28548

Figure 3.1.1 Closing Report

Eurotex Knitwear Ltd & euro knit 21pin composite Ltd (Nayamati)

Nayamati, Fatulla, Narayanganj Closing Report

Buyer	Order No.	Style	Color	Order Qty	Qty(+5%)	Sewing Plan Month	Shipment Date	Knitting+Dyeing		Cutting	Print/Emb. Send	Print/Emb. Recieve	Sew. Line	Sewing input	Sewing output	Poly	Shipped
								knitted +Dyeing kg	Dyeing Finish kg	Total	Total	Total		Total	Total	Total	Total
ORIGINAL MARI NES	AZP 1155 NF	T-Shirt S/S	BRIG HT-WHITE AOP	6890	7235	Oct	27 Oct	665	564	7527	7527	5185	2 ND -G	7300	7300	6750	6750
ORIGINAL MARI NES			BRIG HT-WHITE	5830	6122			665	564	6270	6270	6270	2 ND -G	6270	6121	6000	6000
ORIGINAL MARI NES	AZP 1153 NF	T-Shirt S/S	BRIG HT-WHITE	5863	6256	Oct	27 Oct	665	564	6270	6270	6228	2 ND -G	6206	6095	5821	5821
ORIGINAL MARI NES			YELLO W-BASIC	6929	7275			585	560	7410	7410	7343	2 ND -G	7352	7337	6929	6929
ORIGINAL MARI NES	AZP 1154 NF	T-Shirt S/S	BRIG HT-WHITE	1651	1734	Oct	27 Oct	665	564	1779	1534	1693	2 ND -G	1759	1660	1651	1651

ORIGI NAL MARI NES			PINK SHIN E	1397	1467			585	560	1493	1463	1405		1493	1400	1397	1397
			TOTA L	28560	29988			3830	3376	3074 9	30474	28124	0	30380	29913	28584	28548

Table 1.1.2 Fabric Inspection

3.2 Knitting Report:

EUROTEX KNITWEAR LIMITED												19-Nov		
Buyer	Order No	TNA	Color	Fab. Type	GSM	FIN DIA	M/C DIA	Y/COUNT	Y/BRAND	Y/LOT	Sl (mm)			
ORIGINAL MARINES	AZP 1153 NF	10-Oct	BRIGHT WHITE	LY SJ	170	66	36X24	40/1	ARMADA	423	2.95			
			MX 2			ANY	ANY		PHP	4053014	2.95			
			YELLOW BASIC			66	36X24		ARMADA	423	2.95			
			BRIGHT WHITE			ANY	ANY				2.95			
	AZP 1154 NF		PINK SHINE			70	38X24				2.95			
	AZP 1155 NF		BRIGHT WHITE								2.95			

Figure 1.2 Fabric Inspection

Eurotex Knitwear Ltd & euro knit 23pin composite Ltd (Nayamati)
Nayamati,Fatulla,Narayanganj

Buyer	Order No.	TNA	Color	Fab. Type	GSM	FIN DIA	M/C DIA	Y/COUNT	Y/BRAND	Y/LOT	Sl(mm)
ORIGINAL MARINES	AZP 1153 NF	10-Oct	BRIGHT WHITE	LY SJ	170	66	36x24	40/1	ARMADA	423	2.95
			ANY			ANY			PHP	4053014	2.95
			MX 2			66	36x24		ARMADA	423	2.95
			YELLOW BASIC			ANY					2.95
	AZP 1154 NF		BRIGHT WHITE			70	38x24				2.95
			PINK SHINE								2.95
	AZP 1155 NF		BRIGHT WHITE			2.95					

Table 3.2 Table knitting Inspection

3.3 Dyeing Inspection or T & A Plan:

Textex Knitwear Ltd
Jambi, Fatuliah, Narayasingg

AA Plan for Production

3865

T & A Plan

19-Nov-19

Order Name	Dyeing TNA Order No	Style No	Color Name/ Pentone No	Fabric Type	Finish Pro	Order Qty-- Pcs	Req Finish Fabric	Req Gray Fabric	Knit Complete	Knit Balance	Dyeing Complete	Dyeing Balance	Del 2 Cut Complete	Finish Fab Del Ba
Original Marinas	17-10-19	AZP 1153 NF	BRIGHT WHITE 11-0601 TCX	L-5/3 [170]	OPEN	12,792	492	579	734	155	847	268	543	51
			MX 2 - 5%	L-5/3 [170]	OPEN	18	21	37	16	37	16	32	14	
			YELLOW BASIC	L-5/3 [170]	OPEN	564	663	707	44	707	44	608	44	
AZP 1153 NF Total						12,792	1,074	1,264	1,478	214	1,591	327	1,583	99
		AZP 1154 NF	BRIGHT WHITE 11-0601 TCX	L-5/3 [170]	OPEN	3,048	145	170	173	3	173	3	143	4
			PINK SHINE (REACTIVE)	L-5/3 [170]	OPEN	122	144	176	32	176	32	143	19	
AZP 1154 NF Total						3,048	267	314	349	35	349	35	282	15
		AZP 1155 NF	BRIGHT WHITE 11-0601 TCX	L-5/3 [170]	OPEN	12,720	587	690	700	10	700	10	585	2
			BRIGHT WHITE 11-0601 TCX (L-5/3 [170])		OPEN	693	843	843	0	843	0	715	22	
AZP 1155 NF Total						12,720	1,280	1,533	1,543	10	1,543	10	1,300	20
Original Marinas Total						28,560	2,621	3,111	3,370	259	3,483	372	2,765	144

Figure 3.3 Dyeing inspection or T & A Plan

Order No	Style No	Color Name/pentone No	Fabric Type	Finish Pro	Order Qty-pcs	Req-Finish Fabric	Req-Gray Fabric	Knit Complete	Knit Balance	Dyeing Complete	Dyeing Balance	Del 2 Cut Complete	Finish Fab Del Ba
AZP 1153 NF		BRIGHT WHITE 11-0601 TCX	L-S/J[170]	OPEN	12,797	492	579	734	155	847	268	543	51
		MX 2-5%	L-S/J[170]	OPEN		18	21	37	16	37	16	32	14
		YELLOW BASIC	L-S/J[170]	OPEN		564	663	707	44	707	44	608	44

AZP 1153 NF Total					12,79 7	1,074	1,264	1,478	214	1,591	327	1,183	109
AZP 1154 NF		BRIGHT WHITE 11-0601 TCX	L- S/J[17 0]	OPE N	3.048	145	170	173	3	173	3	141	-4
		PINK SHINE(REACTI VE)	L- S/J[17 0]	OPE N		122	144	176	32	176	32	141	19
AZP 1154 NF Total					3.048	267	314	349	35	349	35	282	15
AZP 1155 NF		BRIGHT WHITE 11-0601 TCX	L- S/J[17 0]	OPE N	12,72 0	587	690	700	10	700	10	585	-2
		BRIGHT WHITE 11-0601 TCX	L- S/J[17 0]	OPE N		693	843	843	0	843	0	715	22
AZP 1155 NF Total					12,72 0	1,280	1,533	1,543	10	1,543	10	1,300	20
					28,56 0	2,621	3,111	3,370	259	3,483	372	2,765	144

Table 3.3.1 Table dyeing inspection

3.4 Sample Develop or PP Sample:

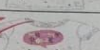
BUYER:- ORIGINAL MARINES															
SL. NO	O/NO.	PICTURE	BODY COLOR	FABRICATION	NECK	NECK TAPE	SLEEVE CUFF	BOTTOM	SAMPLE SIZE	TOTAL QTY.	Cutting	Print	Sewing	Finishing	REMARKS
1	29.0		YELLOW BASIC	PEGASO 170 gr.MQ	DTM SELF FABRIC	N/A	N/A	N/A	6/9	12					30/09.19 → ALIM 3+9=7
	23/9		BRIGHT WHITE 11-0601 TCX	92% COTTON 8% ELASTHAN	DTM SELF FABRIC	N/A	N/A	N/A	6/9	12					
TOTAL QTY.										24 Pcs					
2	23/9		BRIGHT WHITE 11-0601 TCX	PEGASO 170 gr.MQ	DTM SELF FABRIC	N/A	N/A	N/A	6/9	12					23.09.19
	26/9		PINK SHINE	92% COTTON 8% ELASTHAN	DTM SELF FABRIC	N/A	N/A	N/A	6/9	12					
TOTAL QTY.										24 Pcs					
3			BRIGHT WHITE 11-0601 TCX(AOP)	PEGASO 170 gr.MQ	DTM SELF FABRIC	N/A	N/A	N/A	6/9	12					23.09.19
			BRIGHT WHITE 11-0601 TCX	92 %COTTON 8%ELASTHAN	DTM SELF FABRIC	N/A	N/A	N/A	6/9	12					
TOTAL QTY.										24 Pcs					

Figure 3.4 Sample Develop

3.4.1 PP Sample:



Figure 3.4.1 PP Sample

3.4.2 Swatch Card:



Figure 3.4.2 Swatch Card

3.4.3 Pre-Production Meeting:

EKL EUROTEx KNITWEAR LTD.
Nayamati, Kutubpur, Fatullah Narayanganj, Bangladesh

1 of 3

PRE-PRODUCTION MEETING RECORD:

BUYER: <u>O/M</u>		P.O: <u>A2P 1153 NF</u>		MEETING DATE:	
STYLE/MODEL:		DESCRIP: <u>T-SHIRT</u>		DELIVERY DATE:	
FABRIC DETAILS:				CUTTING DATE: (TRAIL)	
FABRIC TYPE: <u>S/T 92T-07700 8.4-PLAS.</u>					
FABRIC DETAILS:	1 WAY	2 WAY	STRIPE	CHECKED	SOLID
					PRINT ☒

FABRIC INSPECTION DETAILS:

FABRIC WIDTH:							
FABRIC DEFECTS:	SHADING	BOWING	DBL-PICK	SLUP	KNOT	SPOT	THICK YARN
						☒	

FABRIC TEST RESULTS:		YES	NO	RESULTS
FABRIC TEST REPORT		☒		PENDING
P.P TEST REPORT		☒		
TOP TEST REPORT		☒		
ORT TEST REPORT		☒		
FUSING/LINING:				
COLOR OF INTER LINING:				

MARKING ON FABRIC	
PENCIL	POWDER
☒	☐
OTHER	

SAMPLE APPROVALS	
P-PRODUCTION SAMPLE APPROVED	☒
SIZE SET APPROVED	☒
ANY PTTN CORECTION	☒
SEAL SAMPLE APPROVED	☒

GARMENT PART	FUSN METHOD	ART
COLLAR		
COLLAR BAND		
FRONT PLKT		
CUFFS		

SEWING THREAD

O/L	BUTTON	B/HOLE	BARTACK
☒			

SAMPLE COMMENTS:

Figure 3.4.3 Pre-Production Meeting Record

3.5 Cutting Inspection:

ORIGINAL MARINES	AZP	YELLOW BASIC=692 9PS BRIGHT WHITE=58 63PS	Cutting Start Date		Print Sent		Pm Rev		Sew Imp		Tang 2000		Sip 3000		Output 777		27-Nov-19
			3-Oct-19	4-Oct-19	5-Oct-19	6-Oct-19	7-Oct-19	8-Oct-19	9-Oct-19	10-Oct-19	11-Oct-19	12-Oct-19	13-Oct-19	14-Oct-19	15-Oct-19	16-Oct-19	
ORIGINAL MARINES	AZP 1354	BRIGHT WHITE=16 51PS PINK=139	5-Oct-19	BRIGHT WHITE	177	5-Oct-19	1774	7-Oct-19	1774	21-Oct-19	1774	28-Oct-19	1500	3245	820	3048	27-Oct-19
			5-Oct-19	PINK	222	9-Oct-19	1463	9-Oct-19	1463	23-Oct-19	1463	29-Oct-19	2000	203	1000		
												30-Oct-19			1500		
												31-Oct-19					
ORIGINAL MARINES	AZP 1355 NT	BRIGHT WHITE AOP=6890 PS BRIGHT WHITE=58 70PS	3-Oct-19	WHITE-AOP	633	5-Oct-19	3237	6-Oct-19	3235	14-Oct-19	7458	14-Oct-19	1612	3986	1612	24-Oct-19	2500
			3-Oct-19	BRIGHT WHITE	644	8-Oct-19	6270	8-Oct-19	6270	9-Oct-19	6128	15-Oct-19	2000	2235	2000	26-Oct-19	4000
												16-Oct-19	2083		2083	27-Oct-19	2500
												17-Oct-19	2500	2500	2500	28-Oct-19	3200
												19-Oct-19	2500	2686	2000	29-Oct-19	700
												20-Oct-19	2500	2287	1603		
												21-Oct-19			1221		
												22-Oct-19			324		
												24-Oct-19			173		
					1277		13797		13791		13586		13195	13694	13516		12800

Figure 3.5 Cutting Inspection

3.5 Cutting Inspection Table:

Buyer	Order No	Color	Receive Data	Color	Qty.	Cutting Date	Qty.	Print sent	Qty.	Print receive	Qty.	Sewing input	Target	Input	Output
Original Marine	AZP 1153 NF	Basic=6929PS Bright White 5163PS	3Oct19	Yellow	545	6Oct-19	7410	6Oct 19	7410	20Oct19	7374	21-Oct	779	3000	779
			3Oct19	B white	461	6Oct-19	6270	6Oct 19	6270	8Oct-19	6270	22-Oct	2206	3206	2206
												23-Oct	2500		2500
												24-Oct	2500	5402	2327
												26-Oct	2500		2500
												27-Oct	2500	1956	2500
												28-Oct	2500		1120
					1006		13680		13680		13602		12985	13564	13432
Original Marine	AZP 1154 Nf	Bright White=1651 Pink=139	5Oct19	B.whit e	177122	6Oct-19	1774	6Oct	1774	21Oct	1773	28Oct	1500		
			5Oct19	Pink		9Oct-19	1463	9Oct	1463	23Oct	1461	29Ovt	2000	3045	800
												30Oct		203	1000
												31Oct			1300
					299		3237		3235		3234			3248	3100
Original Marine	AZP 1155 Nf	White AOP=6890PS Bright White=5830PS	3OCT19	W.AO P	633	5Oct	7527	6Oct	7521	14Oct	7458	14Oct	1612	3967	2500
			3Oct19	BW	644	8Oct	6270	8Oct	6270	9Oct	6128	15Oct	2083	2700	4000
												16Oct	2000	2000	2400
												17Oct	2500	2025	3200
												19Oct	2500	20236	700
												20Oct	2500	1500	
												21Oct		1245	
												22Oct		173	
												24Oct		324	
					1277		13792		13797		13586		13694	13516	12800

Table 3.5 Cutting Inspection

3.6 Finishing process:

Buyer	Order No.	Style	Color	Order Qty	Input Sewing	Sewing Output	Poly Sale	Poly	Balance	Delivery
	AZP 1155 NF	T-Shirt S/S	BRIGHT WHITE	6890	7300	7300	Oct,27	7300	0	Nov, 18
			BRIGHT WHITE	5830	6270	6121	Oct,27	6121	51	Nov, 18
	AZP 1153 NF	T-Shirt S/S	BRIGHT WHITE	5863	6206	6206	Nov,0 3	6206	0	Nov, 18
			YELLOW BASIC	6929	7352	7352	Nov,0 3	7352	0	Nov, 18
	AZP 1154 NF	T-Shirt S/S	BRIGHT WHITE	1651	1759	1660	Nov, 07	1660	+99	Nov, 18
			PINK SHINE	1397	1400	1400	Nov, 07	1400	0	Nov, 18

Table 3.6 Finishing inspection

3.6 SPI Check Report:

Version No:1.00

Buyer: 0714

Item: P-SHIRT

SL No.	Name Of Operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Time	Remarks
01	SHOULDER	11-12	11	2.5	11-12	11	2.5	OK
02	LABEL JOINT	11-12	11	2.7	11-12	10	2.7	OK
03	NECK JOINT	11-12	11	2.8	11-12	11	2.10	OK
04	BACK SLIT	11-12	10	2.10	11-12	11	2.12	OK
05	SLEEVE JOINT	11-12	11	2.12	11-12	10	2.14	OK
06	SLEEVE JOINT	11-12	11	2.15	11-12	10	2.15	OK
07	SIDE SEAM	11-12	10	2.17	11-12	10	2.28	OK
08	SIDE SEAM	11-12	11	2.18	11-12	11	2.19	OK
09	BATH LABEL	11-12	10	2.20	11-12	10	2.20	OK
10	BATH LABEL	11-12	17	2.22	11-12	10	2.22	OK
11	SLEEVE HEM	11-12	12	2.23	11-12	10	2.23	OK
12	SLEEVE HEM	11-12	11	2.25	11-12	11	2.25	OK
13								
14								
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								
25	SHOULDER	11-12	11	2.5	11-12	10	2.5	OK
26	LABEL JOINT	11-12	10	2.7	11-12	11	2.7	OK
27	NECK JOINT	11-12	10	2.8	11-12	11	2.8	OK
28	BACK SLIT	11-12	11	2.10	11-12	10	2.9	OK
29	SLEEVE JOINT	11-12	11	2.12	11-12	10	2.10	OK
30	SLEEVE JOINT	11-12	11	2.14	11-12	11	2.12	OK
31	SIDE SEAM	11-12	10	2.15	11-12	11	2.13	OK
32	SIDE SEAM	11-12	10	2.17	11-12	11	2.15	OK
33	BATH LABEL	11-12	11	2.18	11-12	11	2.20	OK
34	BATH LABEL	11-12	11	2.20	11-12	10	2.22	OK
35	SLEEVE HEM	11-12	10	2.21	11-12	10	2.25	OK
36	SLEEVE HEM	11-12	11	2.25	11-12	11	2.27	OK
37								
38								
39								
40								

DATE: 26/10/17

S.V.L.C

QC/Q.IN

APM/PM

Figure 3.6 Day 01 SPI Report

Version No: 1.00

DAILY SPI CHECK REPORT

Style: AZP1153NF		Item: T-Shirt				Date: 25-1019		
Buyer: Original Marine						Line No: G		
SL NO.	Name of operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Time	Remarks
	Shoulder	11-12	11	8.5	11-12	11	2.5	
	Label Join	11-12	11	8.7	11-12	10	2.7	
	Neck join	11-12	11	9.8	11-12	11	2.10	
	Back Slit	11-12	10	9.10	11-12	11	2.12	
	Sleeve join	11-12	11	9.12	11-12	10	2.14	
	Sleeve join	11-12	11	9.15	11-12	10	2.15	
	Side Seam	11-12	10	9.17	11-12	11	2.20	
	Side Seam	11-12	11	9.18	11-12	10	2.22	
	Bath Label	11-12	11	9.20	11-12	10	2.29	
	Bath Label	11-12	11	9.22	11-12	10	2.30	
	Sleeve Item	11-12	12	9.23	11-12	10	2.29	
	Sleeve Item	11-12	11	9.25	11-12	11	2.25	
			26-10-19					
	Shoulder	11-12	11	9.5	11-12	10	2.5	
	Label Join	11-12	10	9.7	11-12	11	2.7	
	Neck join	11-12	10	9.8	11-12	11	2.10	
	Back Slit	11-12	11	9.10	11-12	10	2.12	
	Sleeve join	11-12	11	9.12	11-12	10	2.14	
	Sleeve join	11-12	11	9.15	11-12	11	2.15	
	Side Seam	11-12	10	9.17	11-12	10	2.20	
	Side Seam	11-12	11	9.18	11-12	11	2.22	
	Bath Label	11-12	11	9.20	11-12	11	2.29	
	Bath Label	11-12	11	9.22	11-12	11	2.30	
	Sleeve Item	11-12	12	9.23	11-12	10	2.29	
	Sleeve Item	11-12	11	9.25	11-12	11	2.25	

Table 3.6 Daily SPI Check report

Version No: 1.00

Buyer: Q/M Style: A2P 1153 NF Date: 27/10/19

Sl. No.	Name Of Operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Time	Remarks
01	SHOULDER	11-12	11	2.5	11-12	11	2.5	SHOULDER
02	ARMHOLE JOINT	11-12	10	2.7	11-12	11	2.7	ARMHOLE
03	NECK JOINT	11-12	10	2.8	11-12	10	2.8	NECK
04	BACK SLIT	11-12	11	2.10	11-12	11	2.10	BACK
05	NECK JOINT	11-12	11	2.12	11-12	11	2.12	NECK
06	ARMHOLE JOINT	11-12	10	2.14	11-12	11	2.15	ARMHOLE
07	SLEEVE JOINT	11-12	10	2.15	11-12	11	2.16	SLEEVE
08	SLEEVE JOINT	11-12	11	2.17	11-12	10	2.18	SLEEVE
09	SIDE SEAM	11-12	11	2.18	11-12	11	2.20	SIDE SEAM
10	SIDE SEAM	11-12	11	2.20	11-12	11	2.22	SIDE SEAM
11	BODY HEM	11-12	11	2.22	11-12	11	2.24	BODY HEM
12	BODY HEM	11-12	11	2.25	11-12	10	2.25	BODY HEM
13	BATH LABEL	11-12	10	2.27	11-12	11	2.28	BATH LABEL
14	BATH LABEL	11-12	11	2.30	11-12	11	2.30	BATH LABEL
15	SLEEVE HEM	11-12	11					SLEEVE HEM
16	SLEEVE HEM	11-12	11					SLEEVE HEM
17								
18								
19								
20								
21								
22								
23								
24								
25	SHOULDER	11-12	11	2.5	11-12	10	2.5	SHOULDER
26	ARMHOLE JOINT	11-12	11	2.7	11-12	11	2.7	ARMHOLE
27	NECK JOINT	11-12	11	2.9	11-12	11	2.8	NECK
28	BACK SLIT	11-12	11	2.10	11-12	11	2.9	BACK
29	NECK JOINT	11-12	11	2.12	11-12	10	2.10	NECK
30	ARMHOLE JOINT	11-12	10	2.14	11-12	11	2.12	ARMHOLE
31	SLEEVE JOINT	11-12	10	2.15	11-12	12	2.15	SLEEVE
32	SLEEVE JOINT	11-12	11	2.17	11-12	11	2.17	SLEEVE
33	SIDE SEAM	11-12	12	2.18	11-12	11	2.18	SIDE SEAM
34	SIDE SEAM	11-12	11	2.20	11-12	10	2.20	SIDE SEAM
35	BODY HEM	11-12	11	2.22	11-12	11	2.22	BODY HEM
36	BODY HEM	11-12	10	2.24	11-12	12	2.24	BODY HEM
37	BATH LABEL	11-12	11	2.25	11-12	10	2.25	BATH LABEL
38	BATH LABEL	11-12	11	2.27	11-12	11	2.27	BATH LABEL
39	SLEEVE HEM	11-12	11					SLEEVE HEM
40	SLEEVE HEM	11-12	11					SLEEVE HEM
41								
42								
43								
44								
45								
46								
47								
48								
49								
50								

DATE: 28/10/19

LQC _____ S.V/L.C _____

QC/Q.IN _____

APM/PM _____ AQM/QM _____

Figure 3.7 Day 02 SPI Report

Version No: 1.00

DAILY SPI CHECK REPORT

EKLQAD0015

[illegible]

Table 3.7 Daily SPI check report

Version No.

Buyer: 07		Line No: 17		Time		Remarks	
Item: T-SHIRT							
Sl. No.	Name Of Operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Time
01	SHOULDER	11-12	10	2.5	11-12	10	2.5
02	LABEL JOINT	11-12	11	2.7	11-12	10	2.7
03							
04	NECK JOINT	11-12	11	2.9	11-12	10	2.8
05	BACK SLIT	11-12	10	2.10	11-12	11	2.10
06							
07	SLEEVE JOINT	11-12	10	2.12	11-12	10	2.12
08							
09	SLEEVE JOINT	11-12	10	2.13	11-12	10	2.14
10							
11	SIDE SEAM	11-12	11	2.15	11-12	11	2.15
12							
13	SIDE SEAM	11-12	10	2.17	11-12	11	2.28
14							
15	BODY HEM	11-12	10	2.18	11-12	11	2.20
16							
17	BODY HEM	11-12	10	2.20	11-12	10	2.22
18							
19	SLEEVE HEM	11-12	11	2.22	11-12	11	2.23
20							
21	SLEEVE HEM	11-12	10	2.25	11-12	10	2.25
22							
23							
24							
25							
26	SHOULDER	11-12	10	2.5	11-12	10	2.5
27	LABEL JOINT	11-12	11	2.7	11-12	11	2.7
28							
29	NECK JOINT	11-12	10	2.10	11-12	11	2.8
30	BACK SLIT	11-12	10	2.11	11-12	11	2.10
31							
32	SLEEVE JOINT	11-12	10	2.12	11-12	10	2.12
33	SLEEVE JOINT	11-12	11	2.13	11-12	10	2.14
34							
35	SIDE SEAM	11-12	10	2.15	11-12	10	2.15
36							
37	SIDE SEAM	11-12	10	2.17	11-12	10	2.17
38							
39	BODY HEM	11-12	10	2.18	11-12	10	2.18
40							
41	BODY HEM	11-12	11	2.19	11-12	10	2.20
42							
43	SLEEVE HEM	11-12	10	2.20	11-12	11	2.20
44							
45	SLEEVE HEM	11-12	10	2.25	11-12	10	2.25
46							
47							
48							
49							
50							

DATE: 21/10/19

LINE CHIEF

QC INCHARGE

QM

Figure 3.8 Day 03 SPI Report

Version No: 1.00

DAILY SPI CHECK REPORT

EKLQAD0015

[illegible]

Table 3.8 Daily SPI check report

Version No: 1

0015

Buyer: 0117
Item: T-SHIRT
Style: A2P1154
Date: 29/10/19
Line No: 6

Sl. No.	Name Of Operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Time	Remarks
01	SHOULDER	11-12	11	3.5	11-12	10	2.5	2.5
02	LADEL JOINT	11-12	11	3.7	11-12	11	2.7	2.7
03	NECK JOINT	11-12	10	3.8	11-12	10	2.8	2.8
04	BACK SLIT	11-12	11	3.10	11-12	10	2.10	2.10
05	SLEEVE JOINT	11-12	11	3.12	11-12	10	2.11	2.11
06	SLEEVE JOINT	11-12	11	3.15	11-12	11	2.12	2.12
07	SIDE SEAM	11-12	10	3.17	11-12	10	2.13	2.13
08	SIDE SEAM	11-12	11	3.18	11-12	11	2.15	2.15
09	BODY HEM	11-12	10	3.19	11-12	11	2.17	2.17
10	BODY HEM	11-12	10	3.20	11-12	10	2.18	2.18
11	BATH LABEL	11-12	11	3.22	11-12	11	2.20	2.20
12	BATH LABEL	11-12	11	3.23	11-12	12	2.22	2.22
13	SLEEVE HEM	11-12	10	3.25	11-12	11	2.24	2.24
14	SLEEVE HEM	11-12	11	3.27	11-12	11	2.25	2.25
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								
25								
26	SHOULDER	11-12	11	3.5	11-12	10	2.5	2.5
27	LADEL JOINT	11-12	12	3.7	11-12	11	2.7	2.7
28	NECK JOINT	11-12	11	3.8	11-12	11	2.8	2.8
29	BACK SLIT	11-12	10	3.10	11-12	10	2.10	2.10
30	SLEEVE JOINT	11-12	10	3.12	11-12	10	2.11	2.11
31	SLEEVE JOINT	11-12	11	3.15	11-12	11	2.12	2.12
32	SIDE SEAM	11-12	11	3.17	11-12	10	2.15	2.15
33	SIDE SEAM	11-12	11	3.18	11-12	11	2.17	2.17
34	BODY HEM	11-12	12	3.20	11-12	11	2.18	2.18
35	BODY HEM	11-12	10	3.22	11-12	11	2.20	2.20
36	BATH LABEL	11-12	12	3.24	11-12	10	2.22	2.22
37	BATH LABEL	11-12	11	3.25	11-12	10	2.24	2.24
38	SLEEVE HEM	11-12	12	3.27	11-12	11	2.25	2.25
39	SLEEVE HEM	11-12	11	3.30	11-12	11	2.26	2.26
40								
41								
42								
43								
44								
45								
46								
47								
48								
49								
50								

DATE: 29/10/19

S.V.L.C. RUN QC/Q.IN. ADM/PM. AQM/QM

Figure 3.9 Day 04 SPI Report

EKLQAD0015

EKLQAD0015

Table 3.9 Daily SPI check report

AD0015

Version No: _____

Buyer: OP

Item: Shirt

Sl. No.	Name Of Operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Remarks
01	SHOULDER	11-12	11	2.5	11-12	11	2.5
02	LAPEL JOINT	11-12	10	2.7	11-12	10	2.7
03	NECK JOINT	11-12	10	2.8	11-12	10	2.8
04	BACK SLIT	11-12	10	2.10	11-12	11	2.12
05	SLEEVE JOINT	11-12	11	2.12	11-12	10	2.15
06	SLEEVE JOINT	11-12	10	2.13	11-12	10	2.18
07	SIDE SEAM	11-12	10	2.15	11-12	10	2.20
08	SIDE SEAM	11-12	10	2.20	11-12	10	2.22
09	BODY HEM	11-12	11	2.22	11-12	11	2.24
10	BODY HEM	11-12	10	2.24	11-12	10	2.26
11	SLEEVE HEM	11-12	10	2.28	11-12	11	2.28
12	SLEEVE HEM	11-12	10	2.30	11-12	11	2.30
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25	SHOULDER	11-12	10	2.5	11-12	11	2.5
26	LAPEL JOINT	11-12	10	2.7	11-12	10	2.7
27	NECK JOINT	11-12	11	2.8	11-12	11	2.8
28	BACK SLIT	11-12	10	2.10	11-12	10	2.12
29	SLEEVE JOINT	11-12	10	2.12	11-12	10	2.14
30	SLEEVE JOINT	11-12	10	2.14	11-12	11	2.15
31	SIDE SEAM	11-12	11	2.15	11-12	11	2.20
32	SIDE SEAM	11-12	11	2.20	11-12	10	2.22
33	BODY HEM	11-12	10	2.22	11-12	11	2.25
34	BODY HEM	11-12	10	2.23	11-12	10	2.27
35	SLEEVE HEM	11-12	10	2.24	11-12	10	2.28
36	SLEEVE HEM	11-12	11	2.25	11-12	11	2.30
37							
38							
39							
40							
41							
42							
43							
44							
45							
46							
47							
48							
49							
50							

DATE: 23/10/19

LINE CHIEF: _____

QC INCHARGE: _____

Figure: 2.10 Day 05 SPI Report

Version No: 1.00

DAILY SPI CHECK REPORT

EKLQAD0015

[illegible]

Table 3.10 Daily SPI check report

DAILY SPI CHECK REPORT

Buyer: ORIGINAL M		Style: DEP 1155 NF			Date: 13/10/19			
Item: T-SHIRT					Line No: 9			
Sl. No.	Name Of Operation	REQ SPI	Actual SPI	Time	REQ SPI	Actual SPI	Time	Remarks
01	SHOULDER	11-12	11	2.5	11-12	10	2.5	OK
02								
03	CARTEL JOINT	11-12	10	2.7	11-12	11	2.7	OK
04								
05	NECK JOINT	11-12	11	2.8	11-12	10	2.8	OK
06								
07	BACK SLIT JOINT	11-12	10	2.10	11-12	10	2.10	OK
08								
09	SLEEVE JOINT	11-12	10	2.12	11-12	10	2.12	OK
10	SLEEVE JOINT	11-12	10	2.15	11-12	11	2.15	OK
11								
12	SIDE SEAM	11-12	11	2.18	11-12	10	2.17	OK
13								
14	SIDE SEAM	11-12	10	2.20	11-12	11	2.18	-
15								
16	BODY HEM	11-12	10	2.22	11-12	11	2.20	OK
17								
18	SLEEVE HEM	11-12	11	2.23	11-12	11	2.22	OK
19	SLEEVE HEM	11-12	10	2.25	11-12	10	2.25	-
20								
21	BATH LABEL	11-12	10	2.27	11-12	10	2.27	OK
22								
23	DATE: 14/10/19							
24								
25								
26	SHOULDER	11-12	10	2.5	11-12	11	2.5	OK
27								
28	CARTEL JOINT	11-12	11	2.7	11-12	10	2.7	OK
29								
30	NECK JOINT	11-12	11	2.8	11-12	10	2.8	OK
31								
32	BACK SLIT JOINT	11-12	10	2.10	11-12	10	2.10	OK
33								
34	SLEEVE JOINT	11-12	10	2.12	11-12	11	2.12	OK
35	SLEEVE JOINT	11-12	10	2.15	11-12	10	2.15	-
36								
37	SIDE SEAM	11-12	11	2.17	11-12	10	2.20	OK
38								
39	SIDE SEAM	11-12	11	2.18	11-12	11	2.22	-
40								
41	BODY HEM	11-12	10	2.20	11-12	10	2.25	OK
42								
43	SLEEVE HEM	11-12	11	2.22	11-12	10	2.27	-
44	SLEEVE HEM	11-12	10	2.24	11-12	11	2.30	-
45								
46	BATH LABEL	11-12	10	2.26	11-12	10	2.32	OK
47								
48								

S.V/LC

QC/Q.IN

APM/PM

AQM/QM

Figure 3.11 Day 06 SPI Check Report

[illegible]

Table 3.11 Daily SPI check report

3.7.1 Traffic Light summary

Buyer: Original Marine
Order: AZP1153+1154+1155NF
Style: T-Shirt

Order: AZP 1153 NF
Style: T-SHIRT
Nayamati, Fatullah, Narayanganj.
Traffic Light Summary
Version No: 1.00
Date: 22/10/19

Operation	Operator Name	Code No	QC Supervisor.....			1			2			3			4			Total Qty Checked	Total Defect	Defect %	Remarks
			Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect							
SHOULDER	SALMA	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
LABEL JOINT	NARMINA	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
NECK JOINT	ELIAS	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BACK SLIT	RUKUL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SLEEVE JOINT	SADDAM	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SLEEVE JOINT	SADDAM	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SIDE SEAM	AKBAR	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SIDE SEAM	MADHUL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BODY HEM	SHAMOL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BODY HEM	SHAMOL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BATH LABEL	TANJILA	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SLEEVE HEM	RENU	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SHOULDER	SALMA	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
LABEL JOINT	NARMINA	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
NECK JOINT	ELIAS	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BACK SLIT	RUKUL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SLEEVE JOINT	SADDAM	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SLEEVE JOINT	SADDAM	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SIDE SEAM	AKBAR	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SIDE SEAM	MADHUL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BODY HEM	SHAMOL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BODY HEM	SHAMOL	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
BATH LABEL	TANJILA	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	
SLEEVE HEM	RENU	14	-	-	-	-	-	-	-	-	-	-	-	-	-	-	56	3	5.35%	OK	

QC Supervisor: QC/G.in
APM/PM: APM/PM
AQM/QM: AQM/QM

Figure 3.7.1 Traffic Light Summary Day 01

Order: **A2P 1153 NF**
 Style: **T-SHIRT**

Nayamati, Fatullah, Narayanganj.

Traffic Light Summary

QC Supervisor:.....

Date: **24/10/13**

EKLQAD0022
Version No: 1.00

Operation	Operator Name	Code No	1		2		3		4		Total QTY Checked	Total Defect	Defect %	Remarks
			Pcs	Def.	Pcs	Def.	Pcs	Def.	Pcs	Def.				
SHOULDER LABEL JOINT	SALMA	14	14	-	14	-	14	2	14	-	56	2	3.57%	2/10/13
NECK JOINT	EDRIS	14	14	2	14	-	14	-	14	1	56	3	5.36%	2/10/13
BACK SPLIT	SUHEIL	14	14	1	14	-	14	2	14	-	56	3	5.36%	2/10/13
SLEEVE JOINT	SADDAH	14	14	1	14	1	14	-	14	-	56	2	3.57%	2/10/13
SIDE SEAM	AKBAR	14	14	1	14	1	14	2	14	-	56	4	7.14%	2/10/13
SIDE SEAM	MASUDUL	14	14	1	14	1	14	-	14	1	56	3	5.36%	2/10/13
BODY HEM	ZIA	14	14	1	14	1	14	-	14	1	56	4	7.14%	2/10/13
BODY HEM	HAKIM	14	14	1	14	1	14	1	14	-	56	4	7.14%	2/10/13
BATH LABEL	TANZILA	14	14	-	14	2	14	-	14	1	56	3	5.36%	2/10/13
SLEEVE HEM	KEZU	14	14	1	14	1	14	-	14	1	56	4	7.14%	2/10/13
DATE: 26/10/13														
SHOULDER LABEL JOINT	SALMA	14	14	-	14	1	14	-	14	1	56	3	5.36%	2/10/13
NECK JOINT	EDRIS	14	14	-	14	1	14	2	14	-	56	3	5.36%	2/10/13
BACK SPLIT	ALI	14	14	1	14	1	14	-	14	1	56	4	7.14%	2/10/13
SLEEVE JOINT	SADDAH	14	14	-	14	-	14	2	14	-	56	2	3.57%	2/10/13
SLEEVE JOINT	SADDAH	14	14	-	14	-	14	2	14	-	56	2	3.57%	2/10/13
SIDE SEAM	AKBAR	14	14	2	14	1	14	-	14	1	56	4	7.14%	2/10/13
SIDE SEAM	MASUDUL	14	14	1	14	-	14	1	14	-	56	3	5.36%	2/10/13
BODY HEM	ZIA	14	14	1	14	-	14	1	14	-	56	3	5.36%	2/10/13
BODY HEM	HAKIM	14	14	1	14	-	14	1	14	-	56	3	5.36%	2/10/13
BATH LABEL	TANZILA	14	14	-	14	-	14	2	14	1	56	4	7.14%	2/10/13
SLEEVE HEM	KEZU	14	14	2	14	-	14	1	14	1	56	5	8.93%	2/10/13

LQC S.V/LC P.M. QC/G.M. APM/PM

Figure 3.7.2 Traffic Light Summary Day 02

Order: **A201153 NF**
 Style: **T-SHIRT**

Nayamati, Fatullah, Narayanganj.

Traffic Light Summary

QC Supervisor: Date: **27/10/17**

Operation	Operator Name	Code No	1		2		3		4		Total Qty Checked	Total Defect	Defect %	Remarks
			Pcs	Def.	Pcs	Def.	Pcs	Def.	Pcs	Def.				
SHOULDER	SALMA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
LABEL JOINT	NARMA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
NECK JOINT	FIDRIS	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BACK SLIT	ALT	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SIDE SEAM	AKBAR	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SIDE SEAM	MAZIDUL	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BODY HEM	ZIA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BODY HEM	MAKIM	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BATH LABEL	TANJICA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SLEEVE HEM	RENU	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
DATE: 28/10/17														
SHOULDER	SALMA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
LABEL JOINT	NARMA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
NECK JOINT	FIDRIS	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BACK SLIT	ALT	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SIDE SEAM	AKBAR	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SIDE SEAM	MAZIDUL	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BODY HEM	ZIA	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BODY HEM	MAKIM	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
BATH LABEL	RENU	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK
SLEEVE HEM	RENU	14	14	-	14	-	14	-	14	-	56	2	3.57%	OK

QC/G.In APM/PM AOM/OM

Figure 3.7.2 Traffic Light Summary Day 03

Buyer: OIM
Order: A2P1153 NF
Style: T-SHIRT

ENL Enrotek Knitwear Limited
Nayamati, Fatullah, Narayanganj.

Traffic Light Summary

QC Supervisor: Date: 29/10/19

Operation	Operator Name	Code No	1			2			3			4			Total QTY Checked	Total Defect	Defect %	Remarks
			Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect				
SHOULDER	SALMA		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
LABEL JOINT	NABMA		14	-	SKIP	14	-	1.14%	14	-	-	14	-	-	56	1	1.78%	
NECK JOINT	RIDRIS		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
BACK SLIT	ALI		14	-	-	14	-	-	14	-	-	14	-	-	56	1	1.78%	
SLEEVE JOINT	SADDAH		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
SLEEVE JOINT	SADDAH		14	-	OPEN	14	-	OPEN	14	-	-	14	-	-	56	1	1.78%	
SIDE SEAM	AKBAR		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
SIDE SEAM	MARINUL		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
BODY HEM	TANSTIAHAKIM		14	-	SKIP	14	-	-	14	-	-	14	-	-	56	3	5.35%	
BODY HEM	ZIA		14	-	SKIP	14	-	-	14	-	-	14	-	-	56	3	5.35%	
BATH LABEL	TANSTILA		14	-	-	14	-	-	14	-	-	14	-	-	56	3	5.35%	
SLEEVE HEM	KERU		14	-	SKIP	14	-	STARTED 14	14	-	-	14	-	-	56	4	7.14%	
DATE: 30/10/19																		
SHOULDER	SALMA		14	-	SKIP	14	-	-	14	-	OPEN	14	-	-	56	3	5.35%	
LABEL JOINT	NABMA		14	-	-	14	-	-	14	-	STARTED 14	14	-	-	56	2	3.57%	
NECK JOINT	RIDRIS		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
BACK SLIT	ALI		14	-	SKIP	14	-	-	14	-	-	14	-	-	56	3	5.35%	
SLEEVE JOINT	SADDAH		14	-	-	14	-	-	14	-	OPEN	14	-	-	56	2	3.57%	
SLEEVE JOINT	SADDAH		14	-	-	14	-	-	14	-	-	14	-	-	56	1	1.78%	
SIDE SEAM	AKBAR		14	-	-	14	-	-	14	-	OPEN	14	-	-	56	2	3.57%	
SIDE SEAM	MARINUL		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
BODY HEM	ZIA		14	-	OPEN	14	-	-	14	-	-	14	-	-	56	3	5.35%	
BODY HEM	ZIA		14	-	OPEN	14	-	-	14	-	-	14	-	-	56	3	5.35%	
BATH LABEL	TANSTILA		14	-	-	14	-	-	14	-	-	14	-	-	56	2	3.57%	
SLEEVE HEM	KERU		14	-	SKIP	14	-	STARTED 14	14	-	-	14	-	-	56	3	5.35%	

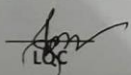
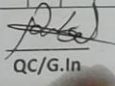
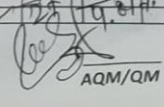
 S.V/L.C.
  B.M.
  QC/G.In.
  APM/PM.
  AQM/QM.

Figure 3.7.3 Traffic Light Summary Day 04

er: ORIGINAL MARINES
 der: A2P1155NF
 Style: T-SHIRT

Nayamati, Fatullah, Narayanganj.

Traffic Light Summary

QC Supervisor.....

Date: 12/11/19

Operation	Operator Name	Code No	1			2			3			4			5			Total QTY Checked	Total Defect	Defect %	Remarks
			Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect				
SHOULDER LABEL JOINT	SALMA RUHA		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
NECK JOINT	RIORI		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
BACK SLIT JOINT	RUHA		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SLEEVE JOINT	SADAM		14	-	-	14	-	-	14	-	-	14	-	-			56	1	1.79%	OK	
SLEEVE JOINT	SADAM		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SIDE SEAM	AKBAR		14	-	-	14	-	-	14	-	-	14	-	-			56	1	1.79%	OK	
SIDE SEAM	MAHMO		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
BODY HEM	ZIA		14	-	-	14	-	-	14	-	-	14	-	-			56	3	5.36%	OK	
SLEEVE HEM	REZV		14	-	-	14	-	-	14	-	-	14	-	-			56	1	1.79%	OK	
SLEEVE HEM	SADAM		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
BATH LABEL	TANJIL		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SHOULDER LABEL JOINT	SALMA RUHA		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
NECK JOINT	RIORI		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
BACK SLIT JOINT	RUHA		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SLEEVE JOINT	SADAM		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SLEEVE JOINT	SADAM		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SIDE SEAM	AKBAR		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
SIDE SEAM	MAHMO		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
BODY HEM	ZIA		14	-	-	14	-	-	14	-	-	14	-	-			56	3	5.36%	OK	
SLEEVE HEM	REZV		14	-	-	14	-	-	14	-	-	14	-	-			56	1	1.79%	OK	
SLEEVE HEM	SADAM		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	
BATH LABEL	TANJIL		14	-	-	14	-	-	14	-	-	14	-	-			56	2	3.57%	OK	

DATE: 12/11/19

QC In L.C. Q.In FL In APM QM FM

Figure 3.7.4 Traffic light summary Day 05

Buyer: D/M
Order: A2P 1155 NF
Style: T-SHIRT

Traffic Light Summary

QC Supervisor: Date: 15/10/13

Operation	Operator Name	Code No	1		2		3		4		5		Total QTY Checked	Total Defect	Defect %	Remarks
			Pcs	Def.	Pcs	Def.	Pcs	Def.	Pcs	Def.	Pcs	Def.				
SHOULDER LABEL JOINT	SALMA	14	14	-	14	OPEN	14	-	14	-	-	56	2	3.57%	100%	
NECK JOINT	ELIAS	14	14	-	14	SKIP	14	-	14	-	-	56	3	5.36%	3.125	
BACK SLIT	RUKUL	14	14	SKIP	14	-	14	SKIP	14	-	-	56	3	5.36%	3.125	
SLEEVE JOINT	SHADAM	14	14	-	14	OPEN	14	-	14	-	-	56	2	3.57%	100%	
SLEEVE JOINT	SHADAM	14	14	-	14	OPEN	14	-	14	-	-	56	2	3.57%	100%	
SIDE SEAM	AKCAR	14	14	-	14	OPEN	14	-	14	OPEN	-	56	3	5.36%	100%	
SIDE SEAM	MURDUL	14	14	OPEN	14	OPEN	14	SKIP	14	-	-	56	3	5.36%	100%	
BODY HEM	FLA	14	14	-	14	SKIP	14	-	14	SKIP	-	56	3	5.36%	-	
SLEEVE HEM	RENU	14	14	-	14	-	14	SKIP	14	-	-	56	2	3.57%	100%	
BATH LABEL	TANJILA	14	14	SKIP	14	-	14	-	14	OPEN	-	56	3	5.36%	100%	
Date: 15/10/13																
SHOULDER LABEL JOINT	SALMA	14	14	-	14	SKIP	14	OPEN	14	-	-	56	2	3.57%	100%	
NECK JOINT	ELIAS	14	14	SKIP	14	-	14	-	14	SKIP	-	56	3	5.36%	3.125	
BACK SLIT	RUKUL	14	14	-	14	-	14	SKIP	14	-	-	56	1	1.78%	100%	
SLEEVE JOINT	SHADAM	14	14	-	14	OPEN	14	-	14	-	-	56	2	3.57%	100%	
SLEEVE JOINT	SHADAM	14	14	OPEN	14	-	14	OPEN	14	-	-	56	4	7.14%	-	
SIDE SEAM	AKCAR	14	14	-	14	SKIP	14	-	14	-	-	56	2	3.57%	100%	
SIDE SEAM	MURDUL	14	14	SKIP	14	SKIP	14	-	14	OPEN	-	56	2	3.57%	100%	
BODY HEM	FLA	14	14	-	14	SKIP	14	-	14	SKIP	-	56	4	7.14%	100%	
SLEEVE HEM	RENU	14	14	-	14	-	14	SKIP	14	-	-	56	1	1.78%	100%	
SLEEVE HEM	RENU	14	14	SKIP	14	-	14	OPEN	14	-	-	56	3	5.36%	-	
BATH LABEL	TANJILA	14	14	-	14	SKIP	14	-	14	SKIP	-	56	3	5.36%	100%	

QC In FL In APMV A-QM FM

Figure 3.7.5 Traffic Light Summary Day 06

Buyer: D/171
Order: A2PH88NF
Style: T-SHIRT

EKL Eurotex Knitwear Limited
Nayamati, Fatullah, Narayanganj.

Traffic Light Summary

QC Supervisor:.....

Date: 12/11/13

Operation	Operator Name	Code No	1		Defect	2		Defect	3		Defect	4		Defect	5	Defect	Total QTY Checked	Total Defect	Defect %	Remarks
			Pcs	Def.		Pcs	Def.		Pcs	Def.		Pcs	Def.							
SHOULDER	SALMA	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
CABEL JOINT	SUNA	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
NECK JOINT	ABRIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BACK SLIT	SUNIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SIDE SEAM	ABRIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SIDE SEAM	MARION	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BODY HEM	ABRIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BODY HEM	HAKIM	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BOTH LABEL	TANTIA	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE HEM	RENU	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE HEM	RENU	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SHOULDER	SALMA	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
CABEL JOINT	SUNA	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
NECK JOINT	ABRIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BACK SLIT	SUNIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE JOINT	SADDAM	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SIDE SEAM	ABRIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SIDE SEAM	MARION	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BODY HEM	ABRIL	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BODY HEM	HAKIM	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
BOTH LABEL	TANTIA	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE HEM	RENU	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK
SLEEVE HEM	RENU	14	14	-	-	14	-	-	14	-	-	14	-	-	-	-	56	2	3.57%	OK

QC In: L.C. Q.In: APM FL.In: QM FM

Figure 3.7.6 Traffic Light Summary Day 07

Buyer: Q/M
Order: A201155NF
Style: T-SHIRT

EKL Eurotex Knitwear Limited
Nayamati, Fatullah, Narayanganj.

Traffic Light Summary

QC Supervisor:..... Date: 20/10/13

Operation	Operator Name	Code No	1			2			3			4			Total QTY Checked	Total Defect	Defect %	Remarks
			Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect	Pcs	Def	Defect				
SHOULDER	SALMA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
LAPEL JOINT	SALMA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
NECK JOINT	MDRIS		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BACK SLIT	RUHUL		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SLEEVE JOINT	SADDAM		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SLEEVE JOINT	SADDAM		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SIDE SEAM	AKBAR		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SIDE SEAM	MARZUL		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BODY HEM	ZIA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BODY HEM	HAKIM		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BATH LAPEL	TANJILA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SLEEVE HEM	KEZU		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
DATE: 21/10/13																		
SHOULDER	SALMA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
LAPEL JOINT	SALMA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
NECK JOINT	MDRIS		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BACK SLIT	RUHUL		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SLEEVE JOINT	SADDAM		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SLEEVE JOINT	SADDAM		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SIDE SEAM	AKBAR		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SIDE SEAM	MARZUL		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BODY HEM	ZIA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BODY HEM	HAKIM		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
BATH LAPEL	TANJILA		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
SLEEVE HEM	KEZU		14	2	OPEN	14	2	OPEN	14	2	OPEN	14	2	OPEN	56	2	3.57%	
DATE: 21/10/13																		

Figure 3.7.7 Traffic Light Summary Day 08

3.8 Machine cleaning and Oil checking report:

Buyer: Original Marine

Order: AZP1153+54+55NF

Style: T-Shirt

Facility :
 Factory : ~~Exp. Text. K. S. T. 2000~~ Item : T-SHIRT Date : 22/10/13
 Line No. : 6 Section : Sewing Buyer : O/M Style No. : 23/10/13
 P.O. No. : 000-1153-NF Color : BRIGHT WHITE

Nayamati, Ratunan, Narayanganj.
 Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign.	Certified by PQI	Remarks
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken			
22/10/13	SHOULDER	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES			
"	NECK JOINT	F/L	Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE JOINT	OTL	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SIDE SEAM	OTL	Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
"	BODY HEM	F/L	Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
22/10/13	SHOULDER	OTL	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
22/10/13	NECK JOINT	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE JOINT	OTL	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SIDE SEAM	OTL	Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
"	BODY HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			

QC/Q. IN. APN/PM. AQM/QM.

Figure 3.8.1 Machine cleaning & oil check report: Day 01

Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility : Date : 24/10/19

Factory : DAZZLE KUTTER Item : T-SHIRT Buyer : O/M Style No. :
 Line No. : 6 Section : SEWING P.O. No. : A2P-453-116 Color : YELLOW

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign.	Certified by PQI	Remarks
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken			
24/10/19	SHOULDER	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	24/10/19		
			Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES			
	NECK JOINT	FIL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES			
			Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES			
SLEEVE JOINT	OTL	Clean	NOT	OK	YES	✓	OK	YES	✓	OK	YES	24/10/19			
		Oil Check	NOT	OK	YES	✓	OK	YES	✓	OK	YES				
SIDE SEAM	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES				
		Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES				
BODY HEM	FIL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	24/10/19			
		Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES				
SLEEVE HEM	FIL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES				
		Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES				
24/10/19	SHOULDER	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	24/10/19		
			Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES			
	NECK JOINT	FIL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES			
			Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES			
SLEEVE JOINT	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	24/10/19			
		Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES				
SIDE SEAM	OTL	Clean	NOT	OK	YES	✓	OK	YES	✓	OK	YES				
		Oil Check	NOT	OK	YES	✓	OK	YES	✓	OK	YES				
BODY HEM	FIL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	24/10/19			
		Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES				
SLEEVE HEM	FIL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES				
		Oil Check	✓	OK	YES	✓	OK	YES	✓	OK	YES				

APM/PM AQM/QM

Figure 3.8.2 Machine cleaning & oil check report: Day 02

Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility: Date: 27/10/17

Factory: Euro-Text Knitwear Item: T-shirt Buyer: B/M Style No.:
 Line No.: 6 Section: SEWING P.O. No.: A2P-1453-N.E. Color: Yellow

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign	Certified by PQI	Remarks		
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken					
27/10/17	SHOULDER	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	NECK JOINT	F/L	Clean	✓	NOT		✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	SLEEVE JOINT	OTL	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	SIDE SEAM	OTL	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	BODY HEM	F/L	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	SLEEVE HEM	F/L	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
27/10/17	SHOULDER	OTL	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	NECK JOINT	F/L	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	SLEEVE JOINT	OTL	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	SIDE SEAM	OTL	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	BODY HEM	F/L	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	
"	SLEEVE HEM	F/L	Clean	✓			✓			✓			[Signature]				
			Oil Check	✓			✓			✓						✓	
			Clean	✓			✓			✓						✓	

LQC: [Signature] S.V/L.C: [Signature] QC/Q.IN: [Signature] APM/PM: [Signature] AQM/QM: [Signature]

Figure 3.8.3 Machine cleaning & oil check report: Day 03

KL EUPHORIA KINTAL...
Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility :
Factory : KL EUPHORIA KINTAL Item : T-SHIRT Buyer : C/M Date : 29/11/13
Line No. : 6 Section : SEWING P.O. No. : AP-1547 Style No. :
Color : BRIGHT WHITE

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign	Certified by PQI	Remarks
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken			
29/11	SHOULDER	O/L	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
"	NECK JOINT	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE JOINT	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SIDE SEAM	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	BODY HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
29/11	SHOULDER	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	NECK JOINT	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE JOINT	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SIDE SEAM	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	BODY HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
"	SLEEVE HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			

APM/PM AQM/QM

Figure 3.8.4 Machine cleaning & oil check report: Day 04

Eurotex Knitwear Limited
Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility : Date : 12/10/19

Factory : EUROTEX KNITWEAR Item : T-SHIRT Buyer : AM Style No. :
Line No. : 6 Section : SEWING P.O. No. : A22/1155/PF Color : BRIGHT WHITE

Date	Name of Operation	Machine No.	Description	Before Start			After Lunch			Before Closing			Operator Sign.	Certified by POI	Remarks
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken			
12/10/19	SHOULDER	OTL	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	-		
			Oil Check	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
12	NECK JOINT	F/L	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
9	SLEEVE JOINT	OTL	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
11	SIDE SEAM	OTL	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
12	BODY HEM	F/L	Oil Check	NOT	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
11	SLEEVE HEM	F/L	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
12/10/19	SHOULDER	OTL	Clean	✓	C	C	✓	C	C	✓	C	C	-		
			Oil Check	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
11	NECK JOINT	F/L	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	NOT	C	C	✓	C	C	✓	C	C			
9	SLEEVE JOINT	OTL	Oil Check	NOT	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
11	SIDE SEAM	OTL	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
9	BODY HEM	F/L	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			
11	SLEEVE HEM	F/L	Oil Check	✓	C	C	✓	C	C	✓	C	C	-		
			Clean	✓	C	C	✓	C	C	✓	C	C			
			Clean	✓	C	C	✓	C	C	✓	C	C			

Prepared : Line Chief/SV : Q.C.IN : P.M. : Q.M. :

Figure 3.8.5 Machine cleaning & oil check report: Day 05

EKL Eurotex Knitwear Limited
Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility : Date : 15/10/19

Factory : Eurotex Knitwear Item : T-shirt Buyer : 0/01 Style No. :
Line No. : 6 Section : Sewing P.O. No. : A20155 Color : WHITE

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign.	Certified by PQI	Remarks
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken			
15/10/19	Shoulder	O/L	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	NECK JOINT	F/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	NOT			✓	OK		✓	OK				
"	SLEEVE JOINT	O/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	SIDE SEAM	O/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	BODY HEM	F/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	SLEEVE HEM	F/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
16/10/19	Shoulder	O/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	NECK JOINT	F/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	SLEEVE JOINT	O/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	SIDE SEAM	O/L	Clean	NOT			✓	OK		✓	OK		ZPS		
			Oil Check	NOT			✓	OK		✓	OK				
"	BODY HEM	F/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				
"	SLEEVE HEM	F/L	Clean	✓	OK		✓	OK		✓	OK		ZPS		
			Oil Check	✓	OK		✓	OK		✓	OK				

LQC APM L.C. APM P.IN APM QC/Q.IN APM APM/PM APM AQM/QN APM

Figure 3.8.6 Machine cleaning & oil check report: Day 06

Eurotex Knitwear Limited
Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility : Date : 27/10/19

Factory : Eurotex Knitwear Item : T-SHIRT Buyer : O/M Style No. :
Line No. : 5 Section : SEWING P.O. No. : A-2-P-1155-116 Color : BRIGHT WHITE

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign.	Certified by PQI	Remarks
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken			
27/10/19	SHOULDER	O/L	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	[Signature]		
			Oil Check	✓	C	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
9	NECK JOINT	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
11	SLEEVE JOINT	O/L	Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
11	SIDE SEAM	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
11	BODY HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
11	SLEEVE HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
27/10/19	SHOULDER	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
11	NECK JOINT	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	NOT	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
11	SLEEVE JOINT	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
11	SIDE SEAM	O/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
11	BODY HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			
11	SLEEVE HEM	F/L	Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓	[Signature]		
			Oil Check	✓	✓	✓	✓	✓	✓	✓	✓	✓			
			Clean	✓	✓	✓	✓	✓	✓	✓	✓	✓			

LQC : [Signature] S.V/L.C : P.I.N : [Signature] QC/Q.IN : [Signature] APM/PM : AQM/QM : [Signature]

Figure 3.8.7 Machine cleaning & oil check report: Day 07

Eurotex Knitwear Limited
Nayamati, Fatullah, Narayanganj.
Quality Department (Sewing Section)
Machine Cleaning & Oil Checking Report

Facility :

Factory : Eurotex Knitwear Item : L. S. T. SHIRT Buyer : TH Date : 26/10/19
Line No. : 6 Section : Sewing P.O. No. : APP-1155-19 Style No. :
Color : BRIGHT WHITE (AOP)

Date	Name of Operation	Machine No.	Job Description	Before Start			After Lunch			Before Closing			Operator Sign.	Certified by PQI	Remarks			
				Done	Result	Act. Taken	Done	Result	Act. Taken	Done	Result	Act. Taken						
26/10/19	SHOULDER	O/L	Clean	✓	OK	YES	✓	OK	YES	✓	OK	YES	[Signature]					
			Oil Check	✓	"	"	✓	"	"	✓	"	"						
	NECK JOINT	F/L	Clean	✓	"	"	✓	"	"	✓	"	"				[Signature]		
			Oil Check	✓	"	"	✓	"	"	✓	"	"						
SLEEVE JOINT	O/L	Clean	✓	"	"	✓	"	"	✓	"	"	[Signature]						
		Oil Check	✓	"	"	✓	"	"	✓	"	"							
SIDE SEAM	O/L	Clean	✓	NIT	"	✓	"	"	✓	"	"				[Signature]			
		Oil Check	✓	NIT	"	✓	"	"	✓	"	"							
BODY HEM	F/L	Clean	✓	"	"	✓	"	"	✓	"	"	[Signature]						
		Oil Check	✓	"	"	✓	"	"	✓	"	"							
SLEEVE HEM	F/L	Clean	✓	"	"	✓	"	"	✓	"	"				[Signature]			
		Oil Check	✓	"	"	✓	"	"	✓	"	"							
21/10/19	SHOULDER	O/L	Clean	✓	"	"	✓	"	"	✓	"	"	[Signature]					
			Oil Check	✓	"	"	✓	"	"	✓	"	"						
	NECK JOINT	F/L	Clean	✓	"	"	✓	"	"	✓	"	"			[Signature]			
			Oil Check	✓	"	"	✓	"	"	✓	"	"						
SLEEVE JOINT	O/L	Clean	✓	"	"	✓	"	"	✓	"	"	[Signature]						
		Oil Check	✓	"	"	✓	"	"	✓	"	"							
SIDE SEAM	O/L	Clean	✓	"	"	✓	"	"	✓	"	"				[Signature]			
		Oil Check	✓	"	"	✓	"	"	✓	"	"							
BODY HEM	F/L	Clean	✓	"	"	✓	"	"	✓	"	"	[Signature]						
		Oil Check	✓	"	"	✓	"	"	✓	"	"							
SLEEVE HEM	F/L	Clean	✓	"	"	✓	"	"	✓	"	"				[Signature]			
		Oil Check	✓	"	"	✓	"	"	✓	"	"							

LQC [Signature] S.VI [Signature] P.IN [Signature] QC/Q.IN [Signature] APM/RM [Signature] AQM/QM [Signature]

Figure 3.8.8 Machine cleaning & oil check report: Day 08

3.8.1 Machine cleaning & Oil Checking table:

Date	name of Operation	Machine No	Job	Before Start			After Lunch			Before Closing		
			Description	Done	Result	Act. Taken	Done	Result	Act. taken	Done	Result	Act. Taken
27-10-19	Shoulder	O/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Neck joint	F/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Sleeve Joint	O/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Side Seam	O/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Body Item	F/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Sleeve Item	F/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes

			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
28-10-19	Shoulder	O/L	Clean									
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Neck joint	F/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Sleeve Joint	O/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Side Seam	O/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Body Item	F/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
	Sleeve Item	F/L	Clean	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes
			Oil Check	Done	Ok	Yes	Done	Ok	Yes	Done	Ok	Yes

Table 3.8.1.1 Table-M/C cleaning and oil check report

3.9 Measurement Sheet:

Buyer-Original Marine

Order -AZP-1153+1154+1155NF

Style: Kids wear

Buyer: ORIGINAL MARINES
P.O NO:
Style NO: AZP 1153NF
Item: T. SHIRT

Eurotex Knitwear Limited
Nayamati, Kutubpur, Fatullah, Narayanganj.

Measurement Sheet

Floor: 2nd
Line: 9
Date: 21/10/19

EKLQAD0
Version No:

Trial Cutting ☐ Inline ☐ Pre-Final ☐ Final ☐

Process	TOL (+,-)	Spec	R/24	Spec	18/24	Spec	18/24	Spec	18/24	Spec	18/24
CHEST		28.6	±0.5	27	28.6	±0.5	27	28.6	±0.5	27	28.6
BOTTOM		33.4	±0.5	32	33.4	±0.5	32	33.4	±0.5	32	33.4
LENGTH		32.5	±0.5	31	32.5	±0.5	31	32.5	±0.5	31	32.5
ARMHOLE		14.4	±0.5	13	14.4	±0.5	13	14.4	±0.5	13	14.4
SHOULDER		8.3	±0.5	8	8.3	±0.5	8	8.3	±0.5	8	8.3
SHOULDER SLOPED		24.6	±0.5	23	24.6	±0.5	23	24.6	±0.5	23	24.6
SLEEVE LENGTH		8.8	±0.5	8	8.8	±0.5	8	8.8	±0.5	8	8.8
BACK SLIT		8	✓	✓	8	✓	✓	8	✓	✓	8
SLEEVE OPENING		10.3	±0.5	✓	10.3	±0.5	✓	10.3	±0.5	✓	10.3
NECK DEPTH		4.5	✓	✓	4.5	✓	✓	4.5	✓	✓	4.5
NECK OPENING		12.6	±0.5	✓	12.6	±0.5	✓	12.6	±0.5	✓	12.6
CLOSER COLLAR		0.7	✓	✓	0.7	✓	✓	0.7	✓	✓	0.7
FEAR ARM DEPTH		1.7	✓	✓	1.7	✓	✓	1.7	✓	✓	1.7
HEAD CIRCUMFERENCE		50.8	✓	✓	50.8	✓	✓	50.8	✓	✓	50.8
LOWER SLEEVE LENGTH		2.5	✓	✓	2.5	✓	✓	2.5	✓	✓	2.5

BEFORE IRON AFTER IRON

Remarks

QA QSV P.IN QC/Q.IN APM/PM AQM/QM Sc

Figure 3.9.1 Measurement Sheet Day 01

P.O NO: **A2D 113 NF**
 Style NO:
 Item: **T-SHIRT**

Measurement Sheet

Line: **6**
 Date: **27/10/13**
26/10/13

EKLQAD0014
 Version No: 1.00

Process	TOL (+/-)	Spec	20/36	Spec	6/3	Spec	18/24	Spec	9/12	Spec	3/6
CHEST			27.6	25	25	25	25	25	25	25	25
BOTTOM			24.3	25	25	25	25	25	25	25	25
LENGTH			41.3	25	25	25	25	25	25	25	25
ARMHOLE			15	25	25	25	25	25	25	25	25
SHOULDER			6.7	25	25	25	25	25	25	25	25
SHOULDER TO SHOULDER			25.4	25	25	25	25	25	25	25	25
SLEEVE LENGTH			25.7	25	25	25	25	25	25	25	25
BACK SUT			8	25	25	25	25	25	25	25	25
SLEEVE OPENING			10.8	25	25	25	25	25	25	25	25
NECK DEPTH			4.6	25	25	25	25	25	25	25	25
NECK OPENING			13	25	25	25	25	25	25	25	25
BADDER COLLAR			0.5	25	25	25	25	25	25	25	25
REAR NECK DEPTH			1.8	25	25	25	25	25	25	25	25
HEAD CIRCUMFERENCE			61.4	25	25	25	25	25	25	25	25
LOWER SLEEVE LENGTH			2.5	25	25	25	25	25	25	25	25

Remarks: # SLEEVE HEM UNEVEN, BADDERING AND SKIP STITCH # BODY HEM SAWEDGE AND SKIP # SIDE SEAM ARMHOLE POINT UP/DOWN # NECK JOINT LOOSENESS # MAIN LABEL JOINT SLANTED # BOTH LABEL SLANTED AND BACK PART JOINT.

QA QSV QC/QM APM/PM AQM/QM Sr. QM/FM

Figure 3.9.2 Measurement Sheet Day 02

Buyer: 014
P.O NO: A2P 1133 NE
Style NO:
Item: T-SMGT

Nayamati, Kutubpur, Fatullah, Narayanganj.

Measurement Sheet

Floor: EN3
Line:
Date: 24/10/13
Version No: 1.00

Trial Cutting ☐ Inline ☐ Pre-Final ☐ Final ☐

Process	TOL (+,-)	Spec	3/6	Spec	6/9	Spec	3/12	Spec	12/18	Spec	18/24
CHEST		24.6	X.5	X.5	24.6	X.5	X.5	24.6	X.5	X.5	24.6
BOTTOM		28.6	X.5	X.5	28.6	X.5	X.5	28.6	X.5	X.5	28.6
LENGTH		21.9	X.5	X.5	21.9	X.5	X.5	21.9	X.5	X.5	21.9
ARMHOLE		11.6	X.5	X.5	11.6	X.5	X.5	11.6	X.5	X.5	11.6
SHOULDER		5	X.4	X.4	5	X.4	X.4	5	X.4	X.4	5
SHOULDER TO SHOULDER		20.6	X.5	X.5	20.6	X.5	X.5	20.6	X.5	X.5	20.6
SLEEVE LENGTH		7.4	X.5	X.5	7.4	X.5	X.5	7.4	X.5	X.5	7.4
BACK SPLIT		7	X.5	X.5	7	X.5	X.5	7	X.5	X.5	7
SLEEVE OPENING		8.2	X.5	X.5	8.2	X.5	X.5	8.2	X.5	X.5	8.2
NECK DEPTH		4.1	X.5	X.5	4.1	X.5	X.5	4.1	X.5	X.5	4.1
NECK OPENING		11	X.5	X.5	11	X.5	X.5	11	X.5	X.5	11
BORDER COLLAR		0.8	X.5	X.5	0.8	X.5	X.5	0.8	X.5	X.5	0.8
REAR NECK DEPTH		1.3	X.5	X.5	1.3	X.5	X.5	1.3	X.5	X.5	1.3
HEAD CIRCUMFERENCE		48.2	X.5	X.5	48.2	X.5	X.5	48.2	X.5	X.5	48.2
LOWER SLEEVE LENGTH		2.5	X.5	X.5	2.5	X.5	X.5	2.5	X.5	X.5	2.5

Remarks: SLEEVE HEM RAWEDGE. SKIP STITCH AND PICKERING # NECK JOINT LOOSENER # SIDE SEAM UNEVEN AND OPEN SEAM AND CARE LABEL W/PPING SIDE # BODY HEM SKIP AND RAWEDGE

QA ☐ QSV ☐ QC/QM ☐ AQM/QM ☐ Sr. QM/FM ☐

Figure 3.9.3 Measurement Sheet Day 03

Buyer: *VII*
P.O NO: *AEPIIS3 NF*
Style NO:
Item: *T. SHIRT*

Measurement Sheet

Line: *9*
Date: *22/10/13*
22/11/13

EKLQAD0014
Version No: 1.00

Process	TOL (+,-)	Spec	Spec	Spec	Spec	Spec	Spec	Spec	Spec
<i>TRIAL CUTTING</i>									
<i>INLINE</i>									
<i>PRE-FINAL</i>									
<i>FINAL</i>									
<i>CHEST</i>		<i>8/12</i>	<i>18/24</i>	<i>30/36</i>	<i>12/18</i>	<i>6/9</i>			
<i>LENGTH</i>									
<i>ARMHOLE</i>									
<i>SHOULDER</i>									
<i>SHOULDER TO LAUNDER</i>									
<i>SLEEVE LENGTH</i>									
<i>BACK SPLIT</i>									
<i>NECK OPENING</i>									
<i>NECK DEPTH</i>									
<i>NECK OPENING</i>									
<i>BORDER COLLAR</i>									
<i>HEADNECK DEPTH</i>									
<i>HEADCIRCUMFERENCE</i>									
<i>LOWER SLEEVE LENGTH</i>									

Remarks: *# BODY HEM RAISED AND SKIP STITCH # SLEEVE HEM DUCKERING AND JOINT STITCH*
UNEVEN # MAIN LABEL SLANTED # NECK JOINT LOOSE NERS # SIDE SEAM
UNEVEN AND CARE LABEL WRING SIDE

QA: *[Signature]* QSV: *[Signature]* QC/Q.IN: *[Signature]* APM/PM: *[Signature]* AQM/OM: *[Signature]*

Figure 3.9.4 Measurement Sheet Day 04

Buyer: 0171
P.O NO: A2P1154 NF
Style NO: 7-SHIRT
Item: 7-SHIRT

Nayama, Kaituma, Kaituma, Kaituma

Measurement Sheet

Line: 6
Date: 23/10/15
29/10/15

Version No: 1.00

Process	TOL (+,-)	Spec	3/6	Spec	6/9	Spec	7/12	Spec	18/24	Spec	30/36
CHEST			96.6	X	96.6	X	96.6	X	96.6	X	96.6
BOTTOM			95.6	X	95.6	X	95.6	X	95.6	X	95.6
LENGTH			28.9	X	28.9	X	28.9	X	28.9	X	28.9
ARM HOLE			11.6	X	11.6	X	11.6	X	11.6	X	11.6
SHOULDER			5	X	5	X	5	X	5	X	5
SHOULDER TO SHOULDER			20.6	X	20.6	X	20.6	X	20.6	X	20.6
SLEEVE LENGTH			7.4	X	7.4	X	7.4	X	7.4	X	7.4
BACK SLIT			7	X	7	X	7	X	7	X	7
SLEEVE OPENING			8.2	X	8.2	X	8.2	X	8.2	X	8.2
NECK DEPTH			4.1	X	4.1	X	4.1	X	4.1	X	4.1
NECK OPENING			11	X	11	X	11	X	11	X	11
BORDER COLLAR			0.7	X	0.7	X	0.7	X	0.7	X	0.7
NEAR NECK DEPTH			1.5	X	1.5	X	1.5	X	1.5	X	1.5
HEAD CIRCUMFERENCE			46.2	X	46.2	X	46.2	X	46.2	X	46.2
LOWER SLEEVE LENGTH			2.5	X	2.5	X	2.5	X	2.5	X	2.5
ROUCHES HEIGHT			3.8	X	3.8	X	3.8	X	3.8	X	3.8

Remarks: # FRILL JOINT CUPDOWN # BODY HEM AND SLEEVE HEM UNEVEN
BATH LABEL SLANTED AND BACK DRY

QA: [Signature] QSV: [Signature] PM/RM: [Signature] AQM/QM: [Signature] Sr. QM/FM: [Signature]

Figure 3.9.5 Measurement Sheet Day 05

Buyer: 5/M
P.O NO: ALP HSNF
Style NO:
Item: T-SHIRT

Eurotex Knitwear Limited
Nayamati, Kutubpur, Fatullah, Narayanganj.

Measurement Sheet

Floor: 2ND
Line:
Date: 17/10/13

EKLQAD0014
Version No: 1.00

Process	TOL (+/-)	Spec	18/24	Spec	6/9	Spec	12/18	Spec	30/36	Spec	2/6
CHEST			86	✓	86	✓	86	✓	86	✓	86
BOTTOM			80.4	✓	80.4	✓	80.4	✓	80.4	✓	80.4
LENGTH			69.5	✓	69.5	✓	69.5	✓	69.5	✓	69.5
ARMHOLE			14.4	✓	14.4	✓	14.4	✓	14.4	✓	14.4
SHOULDER			6.3	✓	6.3	✓	6.3	✓	6.3	✓	6.3
SHOULDER TO SHOULDER			24.6	✓	24.6	✓	24.6	✓	24.6	✓	24.6
SLEEVE LENGTH			32.1	✓	32.1	✓	32.1	✓	32.1	✓	32.1
BACK SLIT			8	✓	8	✓	8	✓	8	✓	8
SLEEVE OPENING			11.7	✓	11.7	✓	11.7	✓	11.7	✓	11.7
NECK DEPTH			11.6	✓	11.6	✓	11.6	✓	11.6	✓	11.6
NECK OPENING			12.6	✓	12.6	✓	12.6	✓	12.6	✓	12.6
BORDER COLLAR			0.7	✓	0.7	✓	0.7	✓	0.7	✓	0.7
HEAD NECK DEPTH			1.7	✓	1.7	✓	1.7	✓	1.7	✓	1.7
HEAD CIRCUMFERENCE			50.8	✓	50.8	✓	50.8	✓	50.8	✓	50.8
MUSCLE WIDTH			10.1	✓	10.1	✓	10.1	✓	10.1	✓	10.1

Remarks: # BODY HEM OPEN AND RAW EDGE # SLEEVE HEM JOINT STITCH UNEVEN AND SKIP STITCH # BOTH LABEL JOINT OPEN SEAM AND SKIPPED # SLEEVE JOINT OPEN SEAM # NECK SHAPE UNEVEN AND SKIP

QSV P.I.N QC/Q.IN APM/PM AQM/QM Sr. QA/ENR

Figure 3.9.6 Measurement Sheet Day 06

Buyer: *01M*
P.O NO: *REP 115 NK*
Style NO:
Item: *L.S. T-SHIRT*

Eurotex Knitwear Limited
Nayamati, Kutubpur, Fatullah, Narayanganj.

Measurement Sheet

Floor: *2nd*
Line: *6*
Date: *20/10/19*

EKLQAD0014
Version No: 1.00

Trial Cutting ☐ Inline ☐ Pre-Final ☐ Final ☐

Process	TOL (+,-)	Spec	3/5	Spec	6/8	Spec	12/18	Spec	4/24	Spec	30/36
CHEST		24.6	±1	±1	±1.5	±1	±1.5	±1	±1	±1	±1
BOTTOM		28.6	±5	±5	±5	±5	±5	±5	±5	±5	±5
LENGTH		61.9	±5	±5	±5	±5	±5	±5	±5	±5	±5
BOMHOLE		11.6	±1	±1	±1	±1	±1	±1	±1	±1	±1
SHOULDER		5	±1	±1	±1	±1	±1	±1	±1	±1	±1
SHOULDER TO SHOULDER		20.6	±1	±1	±1	±1	±1	±1	±1	±1	±1
SLEEVE LENGTH		24.9	±1	±1	±1	±1	±1	±1	±1	±1	±1
BACK SUT		7	±1	±1	±1	±1	±1	±1	±1	±1	±1
SLEEVE OPENING		6.7	±1	±1	±1	±1	±1	±1	±1	±1	±1
NECK DEPTH		4.1	±1	±1	±1	±1	±1	±1	±1	±1	±1
NECK OPENING		11	±1	±1	±1	±1	±1	±1	±1	±1	±1
BORDER COLLAR		2.7	±1	±1	±1	±1	±1	±1	±1	±1	±1
ARM NECK DEPTH		1.3	±1	±1	±1	±1	±1	±1	±1	±1	±1
HEAD CIRCUMFERENCE		49.2	±1	±1	±1	±1	±1	±1	±1	±1	±1
MUSCLE WIDTH		8.1	±1	±1	±1	±1	±1	±1	±1	±1	±1

Remarks: *# BODY HEM PUCKERING AND OPEN SEAM # SLEEVE JOINT OPEN SEAM AND SKIT # SLEEVE HEM JOINT STITCH UNEVEN AND SKIP STITCH # MAIN LABEL JOINT SLANTED # NECK JOINT LOOSE NES # BATH LABEL JOINT SLANTED,*

QA *[Signature]* QC/Q.IN *[Signature]* APM/PM *[Signature]* AQM/QM *[Signature]* Sr. QM/

Figure 3.9.7 Measurement Sheet Day 07

Buyer: C/M
P.O. NO: R2P 115NF
Style NO:
Item: T-SHIRT

ECL Eurotex Knitwear Limited
Nayamati, Kutubpur, Fatullah, Narayanganj.

Measurement Sheet

Floor: 2nd
Line:
Date: 15/10/19
16/10/19

EKLQAD0014
Version No: 1.00

Trial Cutting ☐ Inline ☐ Pre-Final ☐ Final ☐

Process	TOL (+/-)	Spec	30/36	Spec	9/12	Spec	6/3	Spec	18/24	Spec	12/18
CHEST		29.6	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
BOTTOM		26.2	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
LENGTH		41.7	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
ARMHOLE		15	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
SHOULDER		6.7	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
SHOULDER-TO-SHOULDER		25.6	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
SLEEVE LENGTH		35.9	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
BACK SPLIT		8	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
SLEEVE OPENING		8.2	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
NECK DEPTH		4.6	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
NECK OPENING		13	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
BORDER COLLAR		0.7	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
REAR NECK DEPTH		1.8	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
HEAD CIRCUMFERENCE		51.5	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1
MUSCLE WIDTH		10.5	±1	21.5	±1	26.6	±1	21.5	±1	28.9	±1

Remarks: * OPEN SEAM AND SKIP STITCH AT BODY HEM # COOP JOINT OPEN
SLEEVE HEM BT RAW EDGE AND UNEVEN JOINT STITCH.

QA QC/Q.IN APM/PM AQM/QM Sr. QM/FM

Figure 4 Measurement Sheet Day 08

Table 3.9 Measurement Sheet

Process	TOL (+-)	Spec	30/36			Spec	6/9			Spec	18/24			Spec	9/12			Spec	3/6		
Chest		29.6	+5	+1	+5	25.6	+5	+5	+5	28.6	+5	+5	+5	26.6	+5	+5	+1	24.6	+5	+1	+5
Bottom		34.7	+5	+5	+5	29.7	+5	+5	+5	38.4	+5		+5	30.8	-5	+5	+5	28.6	+5	+5	+5
Length		41.7		+5	+5	33.5	+5	+5	+5	34.5		+5	-5	35.1	+5		+5	31.6	+5	+5	+5
Armhole		15.0	+5	+5	+5	14.4	+5	-5	+5	14.4	+5	+5	+5	13.1	+5	+5	+5	11.6	+5	+5	+5
Shoulder		6.7	+3	+5	+3	5.3	+3			6.3	+3	+5	+5	5.7	+3	+5		5	+3	+5	+5
Shoulder to Shoulder		25.6	+1	+5	+1	21.6	+5	+5	+5	24.6	+1	+5	+1	22.6	+5	+1	+5	20.6	+5	+1	+5
Sleeve Length		9.2	+3		+3	7.8		-3	+3	8.9	+5	+3	+5	8.4		-3	+5	7.4	+5	+3	
Back Sut		8				7		+1		8				7				7			
Sleeve Opening		10.8	+5	+3		8.8	+5	+5	+5	10.3	+3		+3	9.4		+3	+5	8.2	-2	+5	+3
Neck Depth		4.6			+5	4.2				4.5				4.3				4.1			
Neck Opening		13	+5	+7		11.4	+5	+5	+5	12.6	+5	+5	+5	11.8	+5	+5	+5	11	+3	+5	
Border Coller		0.7			+8	0.7				0.7				0.7				0.7			
R. Neck Depth		1.8				1.4				1.7				1.5				1.3			
Head Circum		51.5				48.7				50.8				49.4				48.2			
Lower Sleeve Length		2.5		+3	+2	2.5	-3	+3	+3	2.5	+3			2.5	+3		+2	2.5		-3	
Buyer : OM Order No: AZP1154NF Style: T-Shirt																					
				18/24				6/9					9/12								
Chest		28.6	+5	+5	+5	25.6	+5		+5	26.6	+5	+5	+1								

Bottom		38.4	+5		+5	29.7	+5	+5	+5	30.8	-.5	+5	+5								
Length		34.5		+5	-.5	33.5	+5	+5	+5	35.1	+5		+5								
Armhole		14.4	+5	+5	+5	14.4	+5	-.5	+5	13.1	+5	+5	+5								
Shoulder		6.3	+3	+5	+5	5.3	+3			5.7	+3	+5									
Shoulder to Shoulder		24.6	+1	+5	+1	21.6	+5	+5	+5	22.6	+5	+1	+5								
Sleeve Length		8.9	+5	+3	+5	7.8		-.3	+3	8.4		-.3	+5								
Back Sut		8				7		+1		7											
Sleeve Opening		10.3	+3		+3	8.8	+5	+5	+5	9.4		+3	+5								
Neck Depth		4.5				4.2				4.3											
Neck Opening		12.6	+5	+5	+5	11.4	+5	+5	+5	11.8	+5	+5	+5								
Border Coller		0.7				0.7				0.7											
R. Neck Depth		1.7				1.4				1.5											
Head Circum		50.8				48.7				49.4											
Lower Sleeve Length		2.5	+3			2.5	-.3	+3	+3	2.5	+3		+2								
Buyer : OM Order No: AZP1155NF Style: T-Shirt																					
			3/6				6/9				9/12				30/36						
Chest		24.6	+5	+1	+5	25.6	+5		+5	26.6	+5	+5	+1	29.6	+5	+1	+5				
Bottom		28.6	+5	+5	+5	29.7	+5	+5	+5	30.8	-.5	+5	+5	34.7	+5	+5	+5				
Length		31.6	+5	+5	+5	33.5	+5	+5	+5	35.1	+5		+5	41.7		+5	+5				
Armhole		11.6	+5	+5	+5	14.4	+5	-.5	+5	13.1	+5	+5	+5	15.0	+5	+5	+5				
Shoulder		5	+3	+5	+5	5.3	+3			5.7	+3	+5		6.7	+3	+5	+3				
Shoulder to Shoulder		20.6	+5	+1	+5	21.6	+5	+5	+5	22.6	+5	+1	+5	25.6	+1	+5	+1				
Sleeve Length		7.4	+5	+3		7.8		-.3	+3	8.4		-.3	+5	9.2	+3		+3				
Back Sut		7				7		+1		7				8							
Sleeve Opening		8.2	-.2	+5	+3	8.8	+5	+5	+5	9.4		+3	+5	10.8	+5	+3					
Neck Depth		4.1				4.2				4.3				4.6			+5				

Neck Opening		11	+3	+5		11.4	+5	+5	+5	11.8	+5	+5	+5	13	+5	+7					
Border Coller		0.7				0.7				0.7				0.7			+8				
R. Neck Depth		1.3				1.4				1.5				1.8							
Head Circum		48.2				48.7				49.4				51.5							
Lower Sleeve Length		2.5		-.3		2.5	-.3	+3	+3	2.5	+3		+2	2.5		+3	+2				
Remarks																					

3.10 DHU Level:

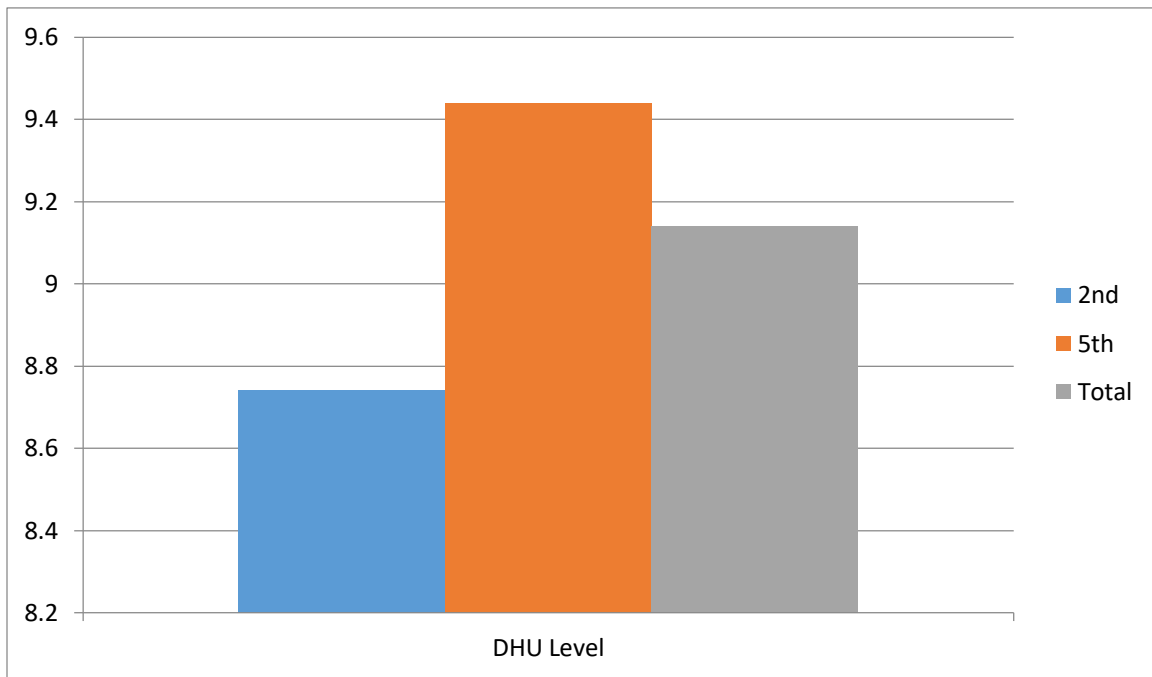


Fig 3.10: DHU Level

DHU Level
Less than 5, Green
5-7 Yellow
Above 7, Red

Fig 3.11

Chapter- IV

Discussion of Result

4.1 Discussion on SPI Report:

We make a report which Buyer is original Marine. Buyer give the SPI, actually it's totally depend on the Buyer requirement. Our requirement was 11-12 but their actual SPI was 10-11. Our buyer accepted this SPI report. Eurotex Knitwear Ltd have one garments schedule which is 9am to 6pm. So they SPI is checked around 10am. SPI checked Shoulder, label joint, Neck joint, Sleeve joint, Side seam, Body Hem etc. SPI checked daily two times start the work and another one is after the lunch. On this order almost 8days needed to completed in sewing section and every day we got almost same SPI somewhere we got 12 But their average SPI was 10-12.

4.2 Discussion on Traffic Light Summary:

First of all we make the operation table. One worker complete 14pcs baby t-shirt per hour and we got 3 to 5 defect from per line. Their common defect was

Sl No.	Defect
01	Skip
02	Open
03	Tension Tight
04	Uneven

One worker work in single operation not make complete garments. One complete garments we got from one line. So One worker per shift complete 56 operation so we can say that one worker per shift completed 56 baby T-shirt and from 56 t-shirt and we got 2 to 3 defect in average. One shift completed 672 t-shirt from one line and after check 27 defect find out so their average defect percentage (%) was 4.07%.

Sl No	Day	Total Qty check	Total defect	Defect %
01	Day 01	672	26	3.76%
02	Day 02	672	27	4.07
03	Day 03	672	29	4.79%
04	Day 04	672	27	4.07%
05	Day 05	672	30	4.46%
06	Day 06	672	27	4.07%
07	Day 07	672	25	3.72%
08	Day 08	672	27	4.07%

4.3 Discussion on Machine cleaning and Oil Checking report:

In this report they reported machine cleaning and oil check. This is very important part for every section because of oil spot and dark spot are basically added from here so machine cleaning and checking very important. For the different operation used different types of machine. Basically they reported machine cleaning and Oil checked report per shift three times, Before start the work and after the lunch and Before closing. Different types of operation used different machine are

Operation Name	Machine Name	Needle Used	Result
Shoulder joint	Over Lock	Double Needle	Ok
Rib joint	Plain	Single	Ok
Neck top seam	Lock/Flat	Single	Ok

4.4 Discussion on Measurement Sheet:

This is the final part of the sewing section. In this table Buyer give the actual requirement then we measure here actual measurement stable or not. Buyer requirement have some of the point are considered +1, -1, +.5, -.5. Buyer given one complete t-shirt measurement then after making the order T-shirt we measure individual then if the garments is ok then we forward it. In this table we also checked over all garments and we measure some point like Chest, Bottom, Length, Arm Hole, Back Suit, Sleeve Opening. Here we got many types of defect like Open seam, Body Hem Puckering, sleeve join open, Skip, Stitch Uneven, skip Stitch.

CHAPTER- V

CONCLUSION

5.1 CONCLUSION

Industry is one of the main and most powerful sector in Bangladesh. This sector increases day by day in our country. As the same time competitors are increasing at the same time. However according to our thesis topics we created a report which was manufacturing a Baby T-shirt with three style. For this topics I would like to thanks my academic supervisor who help us lots without her support I didn't complete this project. Otherwise we have worked as internee for about 1.5 months. We have worked on all the sections there, but we mainly worked in merchandizing section with merchandiser. We are making the SPI Summary report which depends on Buyer requirements. Buyer requirement was 11 to 12 but we took 10 to 11 then they accepted our condition. After that we checked the traffic light summary. This part is very important for manufacturing any kind of garments. Then we mainly focused on the machine cleaning and oil checking report. It minimizes our defects. We checked it two times daily. After finishing all the side we measured the overall garments, here we checked the full garments. We got many types of defects which are very harmful for production. All the workers and employees. We are very much thankful to our supervisor also. He guided us in a very friendly way. We appreciate that.

Reference

- (Washim), A. A. (2018-10-02, October 02). *Operation Breakdown and SMV of T-shirt of Knit Garments - ORDNUUR*. Retrieved from <https://ordnur.com/>:
<https://ordnur.com/apparel/operation-breakdown-and-smv-of-t-shirt-of-knit-garments/>
- Huang, G. (2017, July 17). *5 Essential Garment Inspection Steps to Protect Your Quality*. Retrieved from www.intouch-quality.com: <https://www.intouch-quality.com/blog/5-essential-garment-inspection-steps-to-protect-your-quality>
- Islam, M. (2016, August 21). *List of Defects Found in Sewing Section*. Retrieved from <http://www.garmentsmerchandising.com/>: <http://www.garmentsmerchandising.com/list-of-defects-found-in-sewing-section/>
- https://en.wikipedia.org/wiki/Children%27s_clothing
- <https://clothingindustry.blogspot.com/2018/12/operation-breakdown-apparel-industry.html>