



Daffodil
International
University

Faculty of Engineering

Department of Textile Engineering

**Study on Different Types of Sewing Faults and their
Remedies**

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of **Bachelor of Science in Textile Engineering**

Advance in Apparel Manufacturing Technology

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LETTER OF APPROVAL

28 August, 2022

To

The Head

Department of Textile Engineering

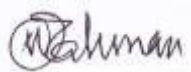
Daffodil International University

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

Dear Sir

I am simply writing to that this report titled as “**Study on Different Type of Sewing Faults and their Remedies**” has been prepared by the under study bearing ID No: 192-23-5662. Is finished for assessment. The entire report is readied in light of the best possible examination at **Mosharaf Apparel Ltd.** The under study was straight forwardly associated with their undertaking exercises. Therefore, it will highly be appreciated if you kindly accept this report and consider it for final evaluation.

Yours Sincerely



Md. Mominur Rahman

Assistant Professor

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

ACKNOWLEDGEMENT

At first, I'd like to express my deepest thanks to the Almighty “**ALLAH**” for giving strength and ability to complete the project report at **Mosharaf Apparel Ltd.** successfully.

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Finally, I must also thanks and express a sense of gratitude to my beloved parents for their mental support and strength throughout completing project report.

DECLARATION

I declare that the work which is being presented in this report entitled, “**Mosharaf Apparel Ltd**” is original work of my own, has not been presented for a degree of any other university and all the resources of collected information for this report have been duly acknowledged



Israt Jahan Mim
ID: 192-23-5662

This is to certify that the above declaration made by the candidate is correct to the best of my knowledge.

Supervisor:



Md. Mominur Rahman
Assistant Professor, TE, DIU

ABSTRACT

These days Sewing faults has a negative impact on actual production which directly effect on our economic status. Given that Bangladesh's top business is ready-made clothing, improving garments quality might be quite important. The major goal of this study is to minimize rework rate by minimizing faults Quality faults occurring during this process adversely affect the product quality and product efficiency and also increase the production cost. Learned during our research how important it is to comprehend the many types of garment faults. Gained knowledge about all types of garment flaws after reading this, including fabric defects, cutting and spreading defects, sewing defects, and finishing defects. Observe that the overall QC passed percentage is 276.26%, the overall reject percentage is 1.7%, the overall average defect percentage is 26.21%, and the overall alter percentage is 23percent in the three-line audit report.

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CHAPTER-1

INTRODUCTION

1.1 Background of the Study

Sewing is one of the most important processes in the textile and apparel industries. It is crucial for keeping clothing's quality high. As a result, it's crucial to avoid any faults when sewing any kind of apparel. This article covers a wide range of sewing errors and defects, as well as a wide range of fixes and techniques for fixing them. These faults in the garment industry are set up by the classification of defects and the knowledge of an inspector to make conclusions. It will be a difficult effort discover garment problems if you have no concept what they are, but if we must be knowledgeable about all types of garment defects. If we know what they are, it will be easy to find those defects. If we work in the garments sector, we have to aware of all forms of garment faults. The classification of problems and the ability of an inspector to draw conclusions influence these flaws in the clothing sector. Garment manufacturers are responsible for maintaining a specified Garments quality standard for each and every product they supply or deliver to customers. In apparel manufacturing industry garments defects is one of the most important factors.

1.2 Object of the Study

- 1 To know about different sewing faults and their remedies.
- 2 To minimize the sewing defects from the garments.
- 3 To analyze the cutting, sewing and finishing fault data.
- 4 To identify the causes of sewing fault and try to solve this.

1.3 Limitation of the Study

During the study I faced the following limitation:

- 1 I couldn't collect all the data due to some restriction.
- 2 Lack of experience.
- 3 Lack of sufficient guides.
- 4 Couldn't maintain proper time.
- 5 Time was also a limitation.

CHAPTER-2

LITARETURE REVIEW

2.1 Sewing Faults

In the Garments industry, poor sewing quality is a typical problem that slows down production. Pay attention to how low-quality products affect the overall industrial economy. Sewing errors are a problem for low production rates and subpar products, therefore reducing them is essential for quality and productivity improvement. Sewing errors increase the price of the product, increase time waste, increase the amount of time needed to redo something, and result in poor-quality products. Therefore, the primary goals of this project are to minimize stitching errors and reduce the need for reworking.

2.2 Types of Sewing Faults

- a) Defects due to problem of stitch formation.
- b) Defects due to fabric disposition.
- c) Defects due to fabric damage along stitch line

2.3 Problems of stitch formation

- Skip Stitch
- Staggered stitches.
- Variable stitch density
- Unbalance Stitch.
- Thread breakage
- Damage Fabric.
- Uneven Stitch.
- Puckering.
- Dirt Shading

2.3.1 Staggered Stitch

When sewing is done by thick and tough fabric with thin needle. Can be caused by yarns in the fabric deflecting the needle away from a straight line of stitching, giving a poor appearance.



Figure: 2.3.1 Staggered Stitch

2.3.2 Skip Stitch

In machines such as bobbin hook and over lock, this occurs when the needle does not catch the eye of the thread attached to the tip of the needle resulting in a skip stitch.

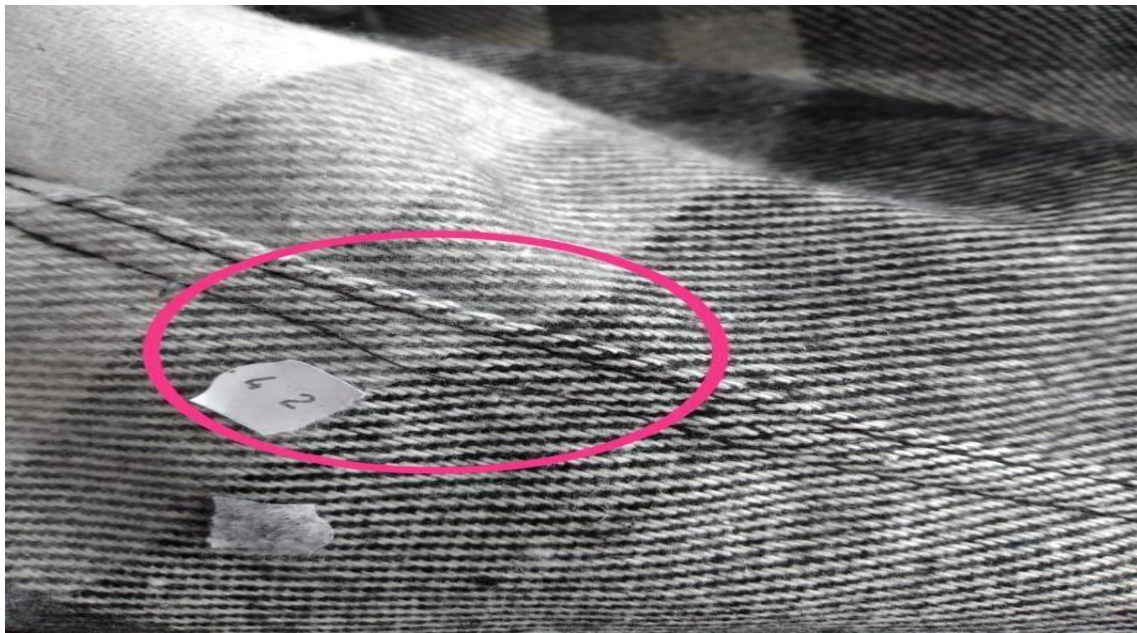


Figure: 2.3.2 Skip Stitch

Causes

- If the distance between one loop to another is more.
- If the yarn and needle sizes are not similar in average.
- Needle deflection.

Remedies

- Adjust tension properly.
- Needle size and thread should be adjusted.
- Timing of hook or looper with a needle should be adjusted properly

2.3.3 Seam Puckering

Seam puckering is the most common issue in the garment sewing industry. These concerns have an effect on the overall quality of the garment produced. Clothing puckering at the seams can be caused by a variety of factors.



Figure: 2.3.3 Seam Puckering

Causes

- When two or more layers of fabric are sewed together, one shrinks more than the others, resulting in a distinctive seam pucker.
- The construction of the fabric.
- Sewing thread extension.
- Shrinkage of sewing threads.

Remedies

-
- Using a thread with less tension.
 - The percentage of fabric and sewing thread shrinkage should be same.
 - The sewing machine's enhanced feed mechanism.

2.3.4 Broken Stitch

When stitching thread braking and Process start and end stitch line not connecting in a same point properly with each other's it called broken stitch. Broken stitch is one of the most common defects in any of sewing oriented manufacturing unit.



Figure: 2.3.4 Broken Stitch

Causes

- A scarcity of skilled trimmers.
- Incorrect setup.
- Inaccurate timing between the needle and the looper or hook.
- Low-quality thread was used.

Remedies

- Used a higher-grade thread.
- Proper thread unwinding from the package.
- Trimming should be done with greater caution.

2.3.5 Unbalanced Stitch

Stitches are coming out uneven or skipping entirely.



Figure: 2.3.5 Unbalanced Stitch

Causes

- Wrong thread pathway was used.
- If the threads aren't properly greased.
- Incorrect thread passing.

Remedies

- Make thread tension adjustments.
- Proper thread passing.
- Higher-quality threads should be used.

2.3.6 Open Seam

An open seam is one where the seam allowance, the piece of fabric between the edge of the material and the stitches, is visible.



Figure: 2.3.6 Open Seam

Causes

- Due to proper sewing allowance.
- Due to improper thread tension.

Remedies

- Taking proper sewing allowance.

2.3.7 Variable Stitch Density

It occurs especially with sticky or slippery materials and also when feeding is uneven



Figure:2.3.7 Variable Stitch Density

Cause

- Uneven feeding material

2.4 Damage of Fabric on Seam Line

It may be happened in case of new or fine needles. There are two types of damage area available given below:

2.4.1 Mechanical Damage

The following steps are to be taken to keep the fabrics free from this type of defects. By using perfect size & shape of the needle & needle point without any defect.

By reducing the speed of sewing machine. By using lubricant.

Operation/ Process Name	M/C No.	Blunt/Broken Needle Parts	Found	Rejec	NDF	NDR	Follow up Action
08/26	367		✓				
08/27	8159		✓				
08/28	0759		✓				
08/29	1021		✓				
08/30	0807		✓				
08/31	8159		✓				
08/32	08162		✓				
08/33	0858		✓				
08/34	58		✓				
08/35	08/26		✓				
08/36	08/27		✓				
08/37	8107		✓				
08/38	18		✓				
08/39	0758		✓				
08/40	760		✓				
08/41	286		✓				
08/42	082		✓				
08/43	21		✓				
08/44	1808		✓				

Store Officer

In-Charge/Asst. Man

Figure: 2.4.1 Damage Needles

2.4.2 Needle Heating Damage

The following steps are to be taken to keep the fabrics free from this type of defect. By changing needle size & shape so that there is less generating of heat to the needle. By sewing smaller length at higher speed. By using lubricant to the needle.

2.4.3 Crease Mark

Crease is the common fault in sewing section. It is visible deformation in the fabric.



Figure: 2.4.3 Crease Mark

Causes

- If tension not perfect.
- If the fabric and thread shrinkage percentage should not be equal.
- If the timing should not be perfect.

Remedies

- Tension should be perfect.
- Thread and fabric shrinkage percentage must be equal.

2.4.4 Label Missing

Point up-down is also a common fault in fabric



Figure: 2.4.4 Label Missing

Causes

- Over passing the parts from one operator to another.
- Operator mistake to joining level but passed to another

Remedies

- Operator should be careful to join level.
- Operator helper should be checking all parts before passing other to another

2.4.5 Uncut/ Loose Thread

One of the common faults which are casually passed by checker of sewing also finishing section



Figure: 2.4.5 Uncut/ Loose Thread

Causes

- Because of insecure join stitches ends not together closely.

2.4.6 Dirt's & Spot

The main reason for these is satins, spots and marks that are picked up by the garment during the processing.



Figure: 2.4.6 Dirt's & Spot

Causes

Stains from oil spots, colors from previously sewn garments.

- This is the main cause since the clothing is more susceptible to contaminations such rust, grease, and dust.

Remedies

- Pyratex LV: It is formulated to take on heavy-duty stains like paint, oil, grease stains, lipstick, cosmetic. Etc.
- Adco Rust Stain remover: It is a dry-side spotter similar in action to acetone. It dissolves and aids in the removal of lacquers, nail polish, shellac adhesives, varnish, grass stain, plastic.

2.4.6 Needle Hole



Chapter-3

EXPERIMENTAL DITEILS

In "M.N. Dyeing Group," I've gathered some information. Then, based on the various sorts of faults identified in the stitching portion, a defect percentage was determined. The most typical faults identified in the sewing sector are broken stitches, uneven stitches, seam puckering, open seams, needle holes, and so on.

Data Analysis:

For data analysis must have an idea about DHU. DHU means “Defect per Hundred Units”. It means number of defects found per 100 garments.

$$\text{DHU} = (\text{Total defects} / \text{Total inspection}) * 100$$

3.1 Inline Operation Audit report for Line-E

Inline Operation Report-01

Here is the figure of Inline Audit Report. Which have Visit-1 and Visit-2 report

Mosharaf Apparel Ltd.									
Baniarchala, Bhabanipur, Gazipur Sadar, Gazipur.									
Line	E	Factory	MA.L	Date	Moshtor				
Buyer	H&M	Order No	420712-1678	L.S	MOSTOFA				
Style	Tilly	Color	BEIGE	L.QC	ZAKIR				
Defect Code List		Visit-1			Visit-2			Total Qty	Total Defects
Code	Operation	Qty Audit	Defects code	QTY.	Qty Audit	Defects code	QTY.		
S1	Open seam	7	S1	07	7	-	-	14	01
S2	Raw material/wrong side	7	S18	7	7	S1	09	14	02
S3	Oil or dirt stains	7	S18	7	7	-	-	14	01
S4	Holes in material	7	-	-	7	S1	09	14	01
S5	measurement out of range	7	S33	7	7	-	-	14	01
S6	Twisting	7	S18	7	7	-	-	14	01
S7	Wrong trim	7	S19	7	7	-	-	14	01
S8	Uneven Stitch line	7	-	-	7	S15	09	14	01
S9	Skip stitch	7	S18	07	7	-	-	14	01
S10	SPI not correct	7	-	-	7	-	-	14	01
S11	Uncut thread	7	S18	7	7	S18	0	14	03
S12	Uneven shoulder length	7	S18	7	7	-	-	14	01
S13	Rib shading	7	S1	07	7	S1	09	14	02
S14	Stripe mismatch	7	S1	7	7	S28	09	14	02
S15	Irregular bottom hem	7	S28	7	7	S1	09	14	02
S16	wrong placket shape	7	S15	7	7	-	-	14	02
S17	pogr joints	07	-	-	7	S15	02	14	02
S18	Raw edges	7	S15	7	7	-	-	14	02
S19	Seam puckering	7	S18	7	7	-	-	14	02
S20	Wrong hole placement	7	-	-	7	-	-	14	02
S21	Uneven sleeve length	7	S18	7	7	-	-	14	11
S22	Back neck tape uneven	7	S9	7	7	-	-	14	+
								14	-

Figure: 3.1 Inline operation Report for E

3.1 Table for Inline Report of E

Line	E	Factory	M.A.L-	Data	24.12.18
Buyer	H&M	Order No.	420412-1676	Line Supervisor	Mustofa
Style	Tilly	Color	BEIGE	Line Q/C	zakir

Defects code list		VISIT-1			VISIT-2			Total qty.	Total Defects
Code	Operation	QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.		
S1	Open seam	07	S1	07	07	-	-	14	01
S2	Raw material/shades/wrong side	07	S18	07	07	S1	09	14	02
S3	Oil or dirt stains	07	S18	07	07	-	-	14	01

After day 1 inspection have found open seam-1, Which quantity it was 07, Defects code-S1.

Raw material/shades/wrong side-2, which quantity it was 07 and Defects code-S18.

Oil dirt stains-1 faults. Quantity was 07 and Defects code S18.

Inline Operation Report-02

b) Inline Audit report 2

Line	E	Factory	M.NDG- 13	Date	23-07-2022				
Buyer	H&M	Order No.	420412-1676	Line supervisor	Mostofa				
Style	Tilly	Color	BEIGE	Line Q/C	Zakir				
Defects code list		VISIT-1			VISIT-2			Total qty.	Total Defects
Code	Operation	QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.		
S1	Holes in material	07	-	-	07	S1	09	14	01
S2	Measurementt out of range	07	S33	07	07	-	-	14	01
S3	Wrong size label	07	-	-	07	-	-	14	-
S4	Twisting	07	S18	07	07	-	-	14	01

From Inline Operation report, found Holes in Material- 1defect which quantity was 07 and Defect Code S1.

Measurement out of range defect which quantity was 7 and Defect Code S1

c)Inline Operation Report-03

Defects code list		VISIT-1			VISIT-2			Total qty.	Total Defects
Code	Operation	QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.		
S1	Wrong trim	07	S19	07	07	-	-	14	01

S2	Uneven stitch line	07	-	-	07	S15	09	14	01
S3	Skip stitch	07	S18	07	07	-	-	14	01
S4	Uncut thread	07	S18	07	07	S18	9	14	1
S5	SPI not correct	07	-	-	07	-	-	14	-

After 3rd day inspection have found 1 Wrong Trim which Defect Code is S19.

1Uneven Stitch Line Defect code was S15, Skip Stitch 1 and Defect Code S18

1Uncut Thread quantity 7 and Defect Code S18.

d) Inline Operation Report-04

Defects code list		VISIT-1			VISIT-2			Total qty.	Total Defects
Code	Operation	QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.		

S1	Rib shading	07	S1	07	07	S1	09	14	02	Inline
S2	Stripe mismatch	07	S1	07	07	S28	09	14	02	
S3	Irregular bottom hem	07	S28	07	07	S1	09	14	02	
S4	Wrong placket shape	07	S15	07	07	-	-	14	02	
S5	Seam Mismatch	07	-	-	07	S15	02	14	02	
S6	Raw edges	07	S15	07	07	-	-	14	02	
S7	Seam puckering	07	S18	07	07	-	-	14	02	

Operation audit, found Rib Shading-2 quantity 14, Defect Code S1.

Stripe mismatch-2 quantity 14 and Defect Code S28.

Irregular bottom hem-2 faults, Quantity-14 and Defect Code-S28.

wrong Placket shape-02, Quantity-14 and Defect Code- S18.

e) Inline Operation Report-05

Defects code list		VISIT-1			VISIT-2			Total qty.	Total Defects
Code	Operation	QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.		

S1	Seam Mismatch	07	-	-	07	S15	02	14	02
S2	Raw edges	07	S15	07	07	-	-	14	02
S3	Seam puckering	07	S18	07	07	-	-	14	02
S4	Wrong button/hole placement	07	-	-	07	-	-	14	-
								Total Qty 297	Total Defects =28

So, From Audit Report 5 found Seam mismatch-02 which total quantity 14 and defect code S15.

Raw edges -02 which total quantity 14 and Defect Code-S15

Seam puckering-07 which total quantity 14 and Defect Code-S1

3.2 Inline Operation Audit report for Line-B

a) Inline Operation Report-01

Here is the figure of Inline Audit Report. Which have Visit-1 and Visit-2 report

Mosharaf Apparel Ltd.									
Baniarchala, Bhabanipur, Gazipur Sadar, Gazipur.									
Line	B		Factory	MAL		Date			
Buyer	H&M		Order No	F2416-655		L.S	Sahid		
Style	Tilly		Color	White		L.QC	Amin		

Defect Code List		Visit-1			Visit-2			Total Qty	Total Defects
Code	Description / Operation	Qty Audit	Defects code	QTY	Qty Audit	Defects code	QTY		
S1	Open seam / Shoulder joint	7	—	—	7	—	—	14	0
S2	Raw material/wrong side / Sleeve hem	7	S18	01	7	—	—	14	01
S3	Oil or dirt stains / Sleeve joint	7	—	—	7	—	—	14	01
S4	Holes in material / II	7	—	—	7	—	—	14	0
S5	measurement out of range / Neck	7	—	—	7	—	—	14	0
S6	Twisting / Neck rib	7	—	—	7	—	—	14	0
S7	Wrong trim / Neck rib tape	7	S18	01	7	—	—	14	01
S8	Uneven Stitch line / Back tape	7	—	—	7	—	—	14	0
S9	Skip stitch / Back Tape	7	S18	01	7	—	—	14	01
S10	SPI not correct / Loop joint	7	S18	02	7	—	—	14	02
S11	Uncut thread / Neck top stitch	7	—	—	7	—	—	14	0
S12	Uneven shoulder length / Loop joint	7	—	—	7	—	—	14	0
S13	Rib shading / Bottom hem	7	—	—	7	—	—	14	0
S14	Stripe mismatch / Bottom hem	7	S18	2	7	—	—	14	02
S15	Irregular bottom hem / II	7	—	—	7	S1	01	14	01
S16	wrong placket shape / Side seam	7	S18	2	7	—	—	14	02
S17	pogr joints / Side seam	7	—	—	7	S18	01	14	01
S18	Raw edges / II	7	S18	2	7	S18	1	14	03
S19	Seam puckering	7	S1	2	7	S3	1	14	03
S20	Wrong hole placement	7	—	—	7	S18	1	14	01
S21	Uneven sleeve length	7	—	—	7	—	—	14	0
S22	Back neck tape uneven	7	—	—	7	—	—	14	0

Figure:3.2 Inline Audit Report Sheet.

3.2 Table for Line operation Audit Report- B

Line	E	Factory	M.NDG-3	Date	23-07-2022
Buyer	H&M	Order no.	152416-6545	Line supervisor	Jahid
Style	Richard Set	Colour	White	Line Q/C	Amin

	Defects Code List	Operation	VISIT-1	VISIT-2	Total qty.audit	Total defects				
Code	Description		QTY. Audit	Defects code	QTY	QTY. Audit	Defects code	QTY.		
S1	Open seam	Shoulder Joint	07	-	-	07	-	-	14	0
S2	Raw material/s hades/wrong side	Sleeve hem	07	S18	01	07	-	-	14	01
S3	Oil or dirt stains	Sleeve joint	07	-	-	07	-	-	14	1
S4	Holes in material	Sleeve joint	07	-	-	07	-	-	14	0
S5	Measurement out of range	Neck rib tack	07	-	-	07	-	-	14	0
S6	Wrong size label	Neck rib tack	07	S18	01	07	-	-	14	01

Open Seam on Shoulder Joint Total Quantity14 fault-0,

Raw material Wrong Side on Sleeve hem Total Quantity-14 Fault found-1 and Defect Code-S18.

Oil or dirt stains on Sleeve joint Total Quantity-14 Fault found-1.

No Holes in material on Sleeve joint Total Quantity-14 has found.

b) Inline Operation Report-2

Defects code list			VISIT-1			VISIT-2				Total qty.	Total Defec ts
Code	Operation	QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.				
S1	Twisting	Neck rib	07	-	-	07	-	-	14	0	
S2	Wron g trim	Half piping	07	S18	01	07	-	-	14	01	
S3	Uneven stitch line	Back tape	07	-	-	07	-	-	14	0	
S4	Skip stitch/loos	Back tape	07	S18	01	07	-	-	14	01	

S5	Uncut thread	Neck top stitch	07	-	-	07	-	-	14	0
S6	SPI not correct-	Loop joint	07	S18	02	07	-	-	14	02

Twisting on Neck rib has found 0 fault Total quantity was 14

Wrong trim on Half Piping Total Quantity-14 Defect Code-S18 Fault found-

01 Uneven stitch line on Back tape Total Quantity-14 and no fault.

Defect Code is S18, 1 Fault found on Back tape Total Quantity-14

Uncut thread on top Neck topstitch was-0

SPI not correct on Loop joint has 2 faults which Total quantity was-14

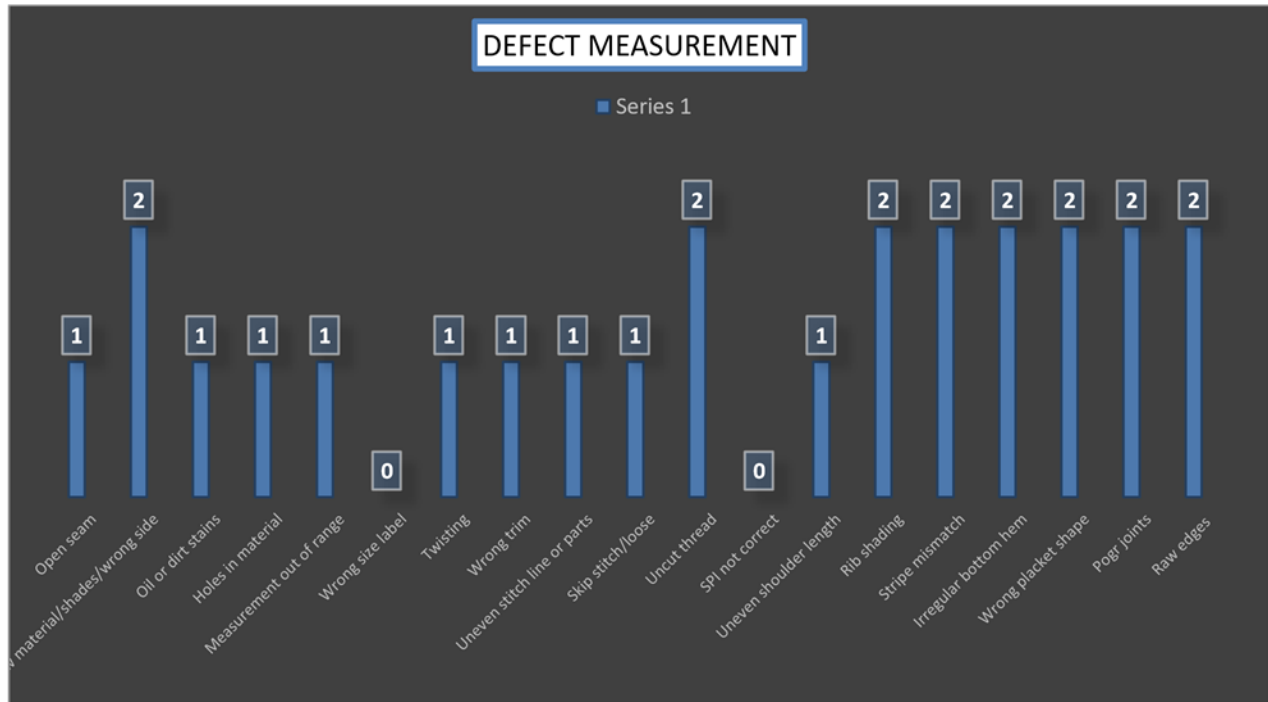
C) Inline Operation Report-2

Defects code list				VISIT-1			VISIT-2			Total qty.	Total Defec ts
Code	Operation		QTY. Audit	Defects code	QTY.	QTY. Audit	Defects code	QTY.			
S1	Uncut thread	Neck top stitch	07	-	-	07	-	-	14	0	
S2	SPI not correct-	Loop joint	07	S18	02	07	-	-	14	02	
S3	Uneven- shoulder length	Loop joint	07	-	-	07	-	-	14	0	
S4	Rib shading	Bottom hem	07	-	-	07	-	-	14	0	
S6	Stripe mismatch	Bottom hem	07	S18	02	07	-	-	14	00	
S7	Irregula-r bottom hem	Bottom hem	07	-	-	07	S1	01	14	01	
S8	Wrong -- placket shape	Side seam	07	S18	02	07	-	-	14	00	
S9	Pogr joints	Side seam	07	-	-	07	S18	01	14	01	
S10	Raw edges	Side seam	07	S18	02	07	S18	01	14	02	

CHAPTER-4

RESULT & DISCUSSION

4.1 Analysis Inline Report-E



4.1.1 Sewing Faults

- Open seam- 01
- Raw material /Shades/Wrong side- 02
- Oil or dirt stains- 01
- Holes in material- 01
- Measurement out of range- 01
- Wrong label- 00
- Twisting- 01
- Wrong trim- 01
- Uneven stitch line-01
- Skip stitch- 01
- Uncut thread- 02
- SPI not correct- 00

-
- Uneven shoulder length- 01
 - Rib shading- 02
 - Stripe mismatch-02
 - Irregular bottom hem-02

4.1.2 DHU Calculation for Line- E

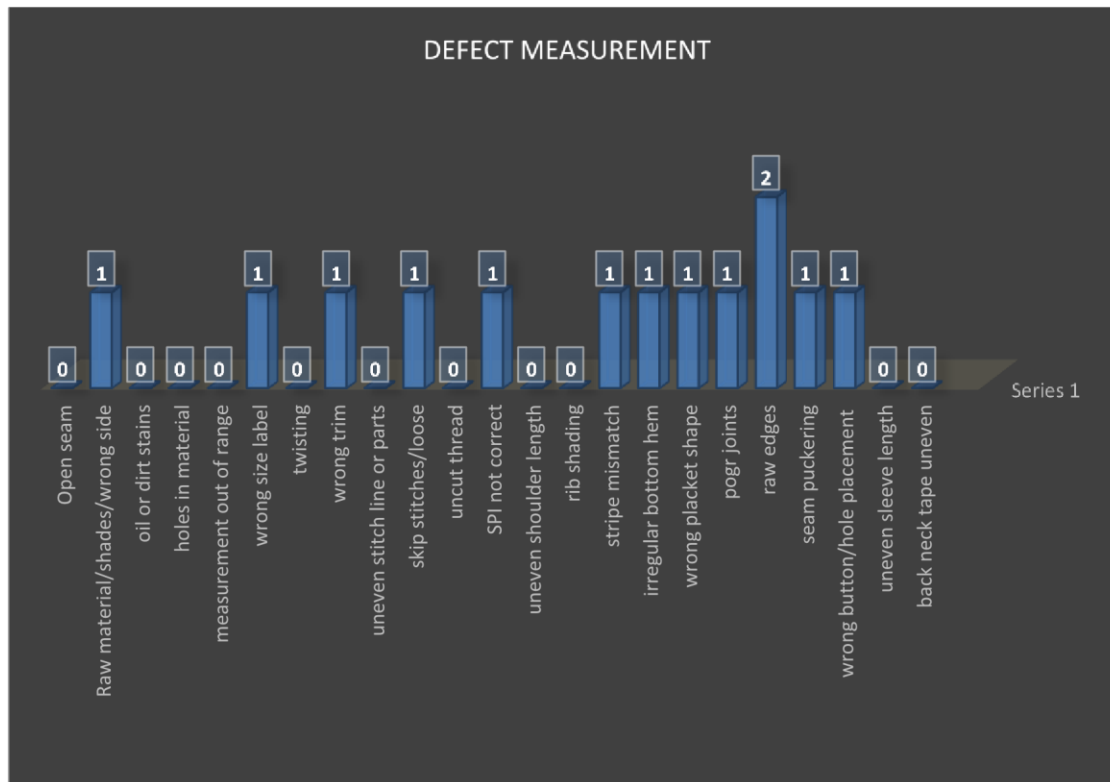
Total no. of defects found-25

Total quantity audited- 294

DHU= (Total no. of defects/Total no. of quantity audited*100= (25/294) * 100 = 8.50 %

The buyer was H&M, and the style name was TILLY, according to the table. Worked there were line supervisor 1, line q/c 1, and employee 22. As far as I can see, there are two common flaws present. One has an open seam, while the other has an uneven stitch. I discovered that the entire amount was 294 and that the overall fault was 25. They came to see us twice. S1, S18, S15, S19, and S33 are the flaws found there. Uneven stitch line or portions (S18) and open seam (S1) are two flaws that have been seen several times.

4.2 Analysis Inline Report-B



4.2.1 Sewing faults

- Open seam- 00
- Raw material /Shades/Wrong side- 01
- Oil or dirt stains- 00
- Holes in material- 00
- Measurement out of range- 01
- Wrong label- 01
- Twisting- 01
- Wrong trim- 01
- Uneven stitch line-01
- Skip stitch- 01
- Uncut thread- 02
- SPI not correct- 01

-
- Uneven shoulder length- 01
 - Rib shading- 02
 - Stripe mismatch-00
 - Irregular bottom hem-02

4.2.2 DHU Calculation for Inline-B

Total no. of defects-15

Total no. of quantity audited-322

$$\begin{aligned}\text{DHU} &= (\text{Total no. of defects} / \text{Total no. of quantity audited}) * 100 \\ &= (15/322) * 100 \\ &= 4.650\%\end{aligned}$$

The buyer was H&M, and the style name was Richard Set, according to the chart. Employees 24, line supervisor 1, line q/c 1, and line supervisor 1 worked there. As far as I can tell, there is one common flaw in there. It's an irregular stitch line or sections of a stitch line. They came to see us twice. This fault has happened multiple times in their uneven stitch line or components S18. There are 13 total flaws, with a total defect rate of 91%. I discovered that the entire amount was 322 and that the overall fault was 18. Following that, I received DHU 4.650% percent.

4.1 Summary

About all types of garment flaws after reading this, including fabric defects, cutting and spreading defects, sewing defects, and finishing defects. Observe that the overall QC passed percentage is 276.26%, the overall reject percentage is 1.7%, the overall average defect percentage is 26.21%, and the overall alter percentage is 23percent in the three-line audit report.

- **Graph of Report Summery of Audit Report**

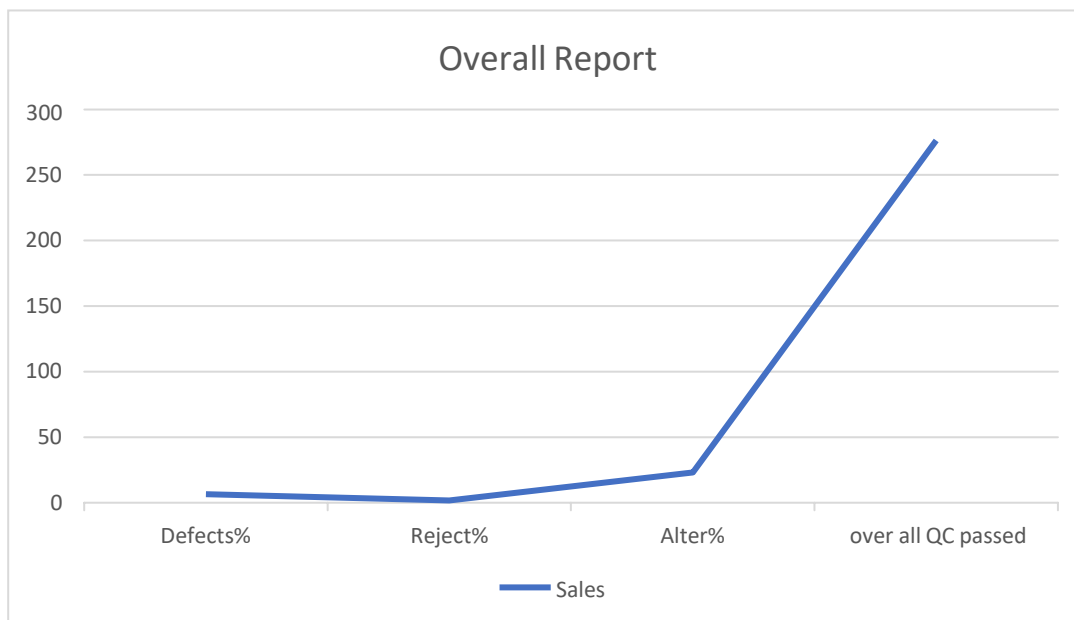


Figure: 4.3.1 Graph of overall Report Summery

CHAPTER-5

CONCLUSION

5 Conclusion

The project was about study on Different Sewing Faults and their Remedies.

- For Broken Stitch found 01 broken stitch problem for that used a higher-grade thread. Proper thread unwinding from the package. Trimming should be done with greater caution
- For Skip stitch defect need to adjust tension properly. For 04 this type of defect should Needle size and thread should be adjusted. Timing of hook or looper with a needle should be adjusted properly. This type of defect hampers garments quality.
- For The following steps are to be taken to keep the fabrics free from this type of defect. By changing needle size & shape so that there is less generating of heat to the needle. By sewing smaller length at higher speed. By using lubricant to the needle.
- By this report got the observation in every product the most common of Sewing faults were about measurement and others issue. Until find at least, including fabric defects, cutting and spreading defects, sewing defects, and finishing defects.

Observe that the overall QC passed percentage is 276.26%, the overall reject percentage is 1.7%, the overall average defect percentage is 26.21%, and the overall alter percentage is 23percent in the three-line audit report

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