



Faculty of Engineering

Department of Textile Engineering

Study on Development Sample of Merchandising

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A thesis submitted in partial fulfillment of the requirements for the degree of

Bachelor of Science in Textile Engineering

Advance in Apparel Manufacturing Technology

Study on Development Sample of Merchandising

LETTER OF APPROVAL

28 August, 2022

To

The Head

Department of Textile Engineering

Daffodil International University

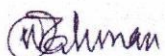
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Subject: Approval of Thesis Report of B.Sc. in TE Program

Dear Sir

I am just writing to let you know that this report titled as “Study on Development Sample of Merchandising” has been prepared by the student bearing ID 181-23-5291 and 181-23-5229 is completed for final evaluation. The whole report is prepared based on the factory data with required belongings. The students were directly involved in their industrial attachment activities and the report become vital to spark of many valuable information for the readers. Therefore, it will highly be appreciated if you kindly accept this report and consider it for final evaluation.

Yours Sincerely


28.08.2022

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Assistant Professor

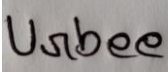
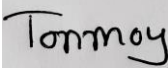
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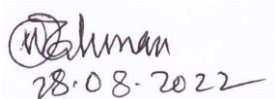
DECLARATION

We hereby declare that the work which is being presented in this report entitled, “Study on Development Sample of Merchandising” is original work of our own, has not been presented for a degree of any other university and all the resource of materials uses for this thesis have been duly acknowledged.

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In the end, we acknowledge with due respect the constant support and patience of our parents. We are grateful to them for trusting us.

ABSTRACT

This report is based on the part of development of sample in the sector of merchandising. This thesis report is about to know and analyze fully about the topic. It has been made to analyze and try to know the activities, requirements, and the must needed information for approving a sample. The development sheet, fabrications, care labels, Accessories, style sheet sketch etc. has analyzed. The report is included about the requirements of buyers for various type of products. Researched about 3 types of development sheet to know what buyer comments for approving the sample. By approving the sample of development, final work can be start for creating the product in a large amount. But if there has any major problem in the development sample, there has a chance to cancellation of order. By giving sample with proper requirements how an order can get for bulk production and every step of development of sample are presented here with proper documents and description. The discussion of the report is presented by some statistical analysis of data, information with picture and a graph. Finally, the report is ended with conclusion including that for starting bulk production, the development of sample is must needed. A complete sense of proper Development sample report in Merchandising is presented here with analyze.

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CHAPTER- 1

INTRODUCTION

1.1 Background of the Study

The very first step in the introduction of a new style is sample development. The merchandisers must classify various product styles and their specifics in order to organize the information provided in the specification sheet (tech pack) in a single format after receiving it.

As a result, the kid should receive clear instructions from the merchandiser of clothing.

He or she could help the sample coordinators by informing the merchandiser about the product style. the sampling department's development samples should be prepared.

Product development is the process of turning a drawing or design into a three-dimensional object. garment, bearing in mind both mechanical and aesthetic considerations. There is a garment business that a strong connection exists between sample sections and clothing merchandisers. In a clothing store, sampling.

1.2 Objectives of the Study

- To analyze among different types of development samples.
- To find out the limitations of development samples.
- To identify the challenges of getting approval of a sample before beginning bulk manufacturing.

1.3 Importance of the Study

This report contains a lot of information. It will convey different message in different perspective .A student, scholar, a normal person can go through to the report .From a simple sample type to analyzing of development sheet are presented here. There we added various valid document by maintaining all rules. This report is a document with full of information and briefings which will help anyone to get a clear idea about Development sample of Merchandising. This thesis report will help a student to have a clear idea about the whole process of the sample development .On

the other hand, a researcher will get more information about the challenges, sample items, requirements, final result of a sample etc. Graduates can take information from this report for their further research or project. Overall, this report is helpful and also important for all whom are working as well as wants to know the whole about the study on development of sample.

1.4 Limitations of the Study

We encountered the following issues while working on our thesis:

- We are unable to collect data because of some limitations.
- Without the approval of a higher authority, we are unable to deliver some essential internal documents.
- We were unable to gather the relevant data due to scheduling constraints.

CHAPTER 2

LITERATURE REVIEW

2.1 Garments Sample

The customer can determine how and if to confirm the order based on the sample, which is the garment's prototype or model. One of the key steps in the manufacturing of clothes is the garment sample procedure, which is crucial for securing export orders and luring customers. Now we can easily explain that the garments which we need to develop as buyer requirement for buyer approval before bulk production is called the Garments Sample.

2.2 Introduction of development sample

First of all sample need to develop for starting bulk production. In garment sampling, we receive the design from customer then its hand over to the Research & Development(R&D) Section. At first need to develop proto sample which is called the first sample. Development merchandisers develop the proto sample according to buyer requirements and design.

2.3 Merchandising

Merchandising is the process of planning right merchandise at right time in the right quantity & at the right price to meet the needs of the company's target buyer.

Apparel merchandising contains a constant watch of the production of the apparel products. It is an complicated and details oriented job. If it can be done properly can be very gratifying. On the country, if it is done with lack of knowledge, unsatisfactory skill and diligence, it can be disparaging. As the job of the merchandiser is to have the right product, at the right time, in correct quantity and in correct quality, the merchandiser should have continual eye on the manufacture and communicate with the manufacturer to get the goods as per the requirement of the customer. The ultimate aim an apparel merchandiser is to satisfying customer needs is met.



The manufacturing factory as per the requirement supplies the fabric and a ledger is maintained regularly to assess the production status. The accessories are very important material for garments such as label, Bandroll, Sticker, poly bag, button, zipper, sewing thread, packing materials are collected from outside sometime mentioned by the buyer through back-to-back L/Cs.

The merchandising department also looks for the sources for procuring yarns to produce fabric. Merchandising department in garment industry observes the production status regularly and ensures timely delivery of the shipment.

2.4 Duties and responsibilities of a merchandiser

A Merchandiser's Key Responsibility is as follows:

- Product Development
- Market and product Exploration
- Selling the concept
- Booking orders
- Confirming Deliveries
- Designing and Sampling follow up
- Costing

Study on Development of Sample in Merchandising

- Raw Material
- Flow Monitoring
- Production Follow Ups
- Payments Follows
- Internal and external communication with buyers
- Sampling
- Lab dips
- Accessories and trims
- Preparing internal order sheets
- Preparing purchase orders
- Advising and assisting production,
- Advising quality department about quality level
- Mediating production and quality departments
- Giving shipping instructions and following shipping mark.
- Helping documentation department.
- Taking responsibility for inspections and
- Following up the shipment.

Developing sample The most crucial step in the production of garment is sample development. The journey from a yarn to a finished garment takes a while. The first step in merchandising is to develop a sample. First, samples must be produced for buyer approval. Buyers may desire any kind of sample. First, the buyer sent us a tech pack with samples of various apparel. The tech pack contains every necessity they have. All information is included in the tech pack, including the type of fabric to be used, the color of the fabric, the embellishments to be added to the garment, and the sorts of stickers to be applied. The buyer sent the development merchandiser a

pdf of the tech pack. We must first print the tech pack and produce a hard copy in the office file after getting it from the buyer. We initially create a summary of the tech pack that will be helpful for our work. The company's software must then be style-wise requisitioned for all of the tech pack's styles. The tech pack file was then delivered to pattern master along with the request number. At that point, we reserve the cloth and send the R&D department the color swatch. The fabric was sent to the dyeing and finishing area after being dyed. The fabric was then sent by R&D to our sample cutting division. At that time, the style's pattern was ready. The cutting section received the pattern and tech pack from the pattern master. The cutting guy sent some strike-off fabric to the print master if the buyer requested the strike-off. After printing the cloth, the print master sent it to us for strike off, and we sent it to the buyer for approval. The fabric was then cut according to pattern by the cutting man. The cutting guy sent the body fabric section to the print master for print if the style has a print. The cutting man received the front section print master after it had been printed. The cutting worker then gives the sample in charge all of the bodily parts. To be sewn, the sample in charge guy sent it to the sewing division. The sewing in charge receives all the accessories and sewing thread at such moment from us merchandisers. With all of these, he led the stylist. And the dressmaker quickly and correctly stitched it. The sewing supervisor sent the sample to the iron division once the sewing was finished. By using the measurement chart from the tech pack, the iron guy correctly irons the samples. The QC department was then sent the samples with tech pack for final packing by the sewing supervisor. The QC man receives all the accessories, cards, and measurement charts that are needed for samples at once from the merchandiser. He carefully measured each sample before checking it.

2.5 Sample section

A sample is a product that is used to evaluate the quality, style, design, or any other aspect of a set of products, a lot, or a batch. The buyer will approve or remark on any changes in design, style, or quality based on the samples. Samples will demonstrate the manufacturer's or exporter's quality of production.

Study on Development of Sample in Merchandising

Development samples and manufacturing samples are two broad categories for clothing samples. There are many types of samples are required for completing a garments order:

The different types of samples made by the Apparel Merchandiser are listed below. All the samples are defined one by one.

- Proto sample /First sample: Proto samples are known as the first sample. At least three sample should be made – 2 samples to send to the buyer for approval. Out of these 2 sample, buyer keeps one sample and send back to the second sample to the factory. Third sample should be made as a factory's counter sample of proto.
- Fit sample: Buyer wants fit sample just before the preproduction sample to see the fitness of the garments.
- Size set sample: The purpose of the size set sample is checking the garment fit of more sizes. The size set samples are normally made for common sizes. Like S, L, XL,XXL. A number of samples required for size set depend on the buyer's requirement. Pattern grading is Confirmed in size set sample. If the merchandiser team found some sizes are not giving accurate fit, they do correction on the pattern grading until they get the accurate fit. After the size set approval, the supplier can develop the PP sample.
- Salesman sample: Customer want salesman sample or SMS sample after approve the proto sample to see their market assessment. In salesman sample we sent 20 pieces of sample.
- Photo shoot sample: For taking a photo for the catalogue and e-commerce sites photo shoot samples are made, and the photo is taken on model or dress form.
- Development sample: The proto, fit and size set samples are considered as development sample.
- PP sample: Before bulk production we sent the pre-production sample to the buyer.
- TOP sample
- Counter sample: When suppliers develop the sample then they make some extra sample for repeating order .

Study on Development of Sample in Merchandising

- Showroom sample: The apparel manufacturers and suppliers prepare a sample for the displaying on the in-house design room or in the exhibition.
- GPT sample: The sample that is collected from the bulk production and send to a testing lab for garment performance test (GPT), are known as GPT sample
- Gold seal sample /sealed sample
- Red tag sample
- Digital Garment Sample

2.6 (i) Sample Development

The procedure of sampling is crucial. It serves as an example of how mass production will be carried out. Although sampling is challenging, it will help buyers become more interested in the sector. And the development merchandisers accomplish this process correctly. The buyers typically place the order once they are pleased with the samples' quality. Because it ensures that the customer is happy with the product being created, garment sampling is a crucial activity in the manufacturing of garments. This is crucial because if the buyer is dissatisfied with the samples, the following are put at risk.

- Placement of the order.
- Acceptance of the some or the entire quantity of garments produced.

There may be a different sampling section in a company. But as the merchandiser is the person who is cooperating with the buyers regarding samples and other requirements, this sampling section will work according to guidance. Also the samples are to be made according to the buyers price ranges and quality levels, merchandiser has to recommend.

2.6(ii) Purpose of sample development

- To allow the buyer to judge the production capabilities of the producer.
- To provide a means for making adjustments in the bulk production process.

Study on Development of Sample in Merchandising

- To let the manufacturer evaluation the thread and fabric consumption, and develop cost quotations.
- To let the buyer know the potential of an exporter.

2.6 (iii) The details attached to the garments sample

After conformation of order, each sample sent to the buyer has the following details(technical specification) attached to it, with the help of a tag. It contains the details of both, what the buyer has demanded and what the supplier fabric/trim & accessories like as hang tag, band roll, care label, price code, bar code etc they have used.

- Item Name
- Article Number
- EAN Code
- Color
- Fabric
- Composition
- Description
- Quantity
- Style no/ Size
- Store

2.6 (iv) Sampling process

The process of sample section differs continuously, and the development process will covers a wide range of unique products from new fibers, fiber blends, new yarns, fabric structures, finishes and surface effects new technology and all types of made up products such as woven, knit wear, hosiery, cut and sewn garments, household products, technical and medical products.

There are different stages of sampling. The first stage covers the development of the preliminary concept or design idea and getting the approval by the buyer.

The second stage covers the process after getting approval of the first prototype sample and carry out the functions of sourcing and ordering component, testing the product and carry out trails once the finalized sample specifications has been pinched up.

The third and final phase includes a range of activities that are carried out before large scale or bulk production capacity outside the producer/developers if this is needed.

Samples that are made in development stage are as following:

- Proto sample
- Fit sample
- Photo shot sample
- Size set sample
- Pre-production sample

In production stage factory need to submit few more samples that includes:

- Top of production sample
- Shipment sample(Before final shipment)

2.7 Process Flow Chart after receiving new style in development stage

First of all Merchandiser receive the sample request according to design file from buyer. They work on it. They analysis and sent it to the CAD section. In CAD the designer follow the design file and develop the design with a standard direction which is help to make the sample fabric printing. After that merchandiser sent the booking of the fabric and arrange the required accessories for the garments. Then handover the order sheet with proper measurement to the CAD section for pattern making and fabric cutting.

Tech pack Received From Buyer

Make File and study thus file

Need to check Sample Color Standard

Make a summary for easy work

Create Fabric Requisition and send file to sample section

Create Accessories booking for Proto Sample and SMS Sample

Need to book sewing thread for Proto Sample and SMS Sample

Need to book fabric for Proto and S/off Sample

Study on Development of Sample in Merchandising

After proto fabric booking need to book Fabric for SMS Sample

Follow up Pattern master to make proto sample pattern

Follow up R&D section for Proto sample fabric

Need to check Proto Sample Accessories

If everything in house then need to follow up sewing section.

Need to follow up related all section Every day for smooth working

Must be note down every step in summary.

After proto sample send need to work for SMS Sample.

After sent SMS Sample need to ent GSS/Seal sample for buyer approval just before bulk production.

There are many buyers in a industry, such as

- Aldi, Lidl, NKD, Ernsting Family (Germany)
- Auchan, Sun city- (France)

- Vroom & Dress man, Vespo Group- (Netherland)
- Target Australia, Best & Less, Cotton On- (Australia)
- Pierre Cardin, Local Boyz– (UK)
- Renner- (Brazil)
- Giant Tiger- (Canada)

From those buyers we worked and made our report with NKD which is a buyer from Germany.

2.8 (i) Buyer NKD



NKD is the mother buyer of the organization. We have worked on NKD buyer develop stages. NKD buyers order quantity is very much. NKD is the German buyer. NKD is the leading value retailer among the clothing discounters and provides its customers with a wide product range of current seasonal fashion for the whole family, as well as home textiles and home accessories. This clothing discounter with around 9,000 employees is one of the leading clothing retailers in Central Europe . All the brands have running work. Here all the stages are discussed below.

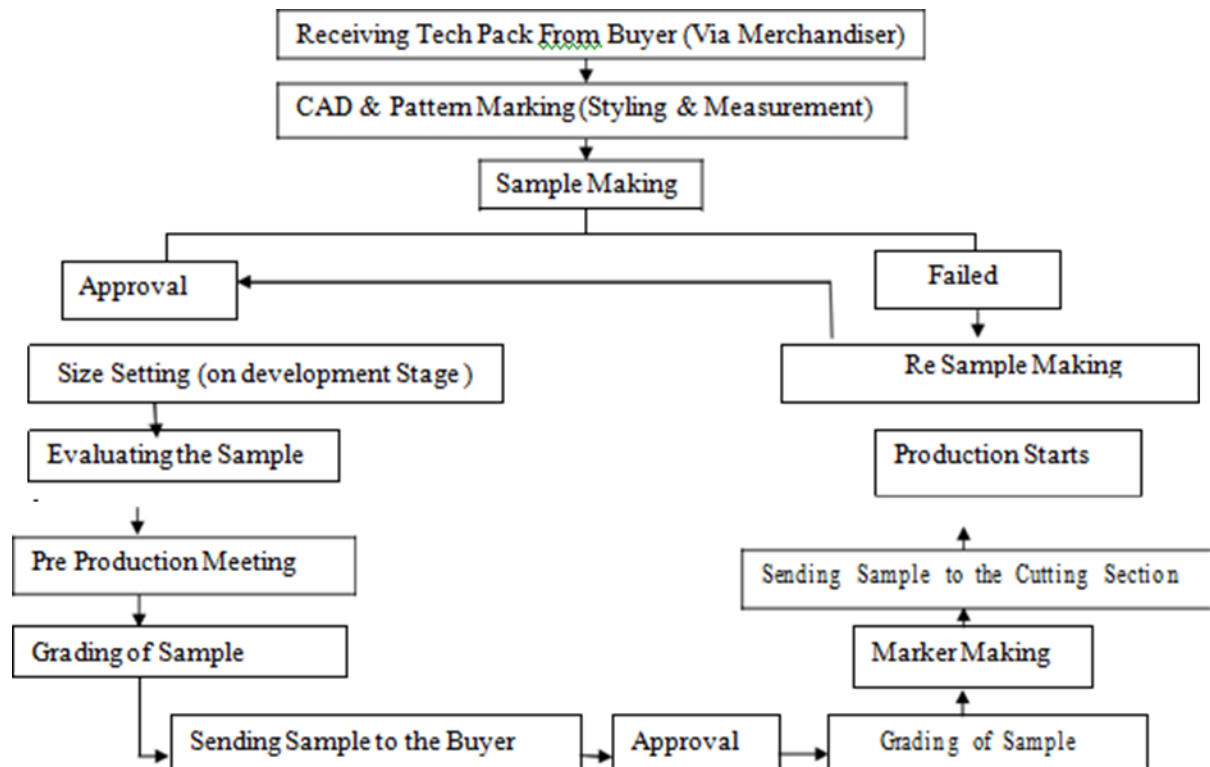
2.8 (ii)NKD Buyer SOP

NKD required sampling stages are-

- Proto Sample
- Revise buyer sample
- Red tag Sample
- Testing sample
- Washing Sample
- P.P sample
- E.com sample.
- Inspection Sample.
- Gold Seal Sample
- GPT sample.

All this stages of sample need to develop for NKD in sampling stage.

2.9 Sampling process flow chart



CHAPTER 3

EXPERIMENTAL DATA

3.1 Development Sample for Jacket

3.1.1 Order Details

- Proto Sample.
- Style-No: 2088741
- Buyer: NKD
- Designer: Schikora.
- Style Description: Cardigan & jacket.
- Order received date: 8 December, 2021.

3.1.2 Tech Pack

Style-No: 2088741

NKD

Style Info		Product Group:		56	05	03			
Style-No:	2088741	Designer:	Schikora						
Product Manager:	Ascherl	Member of QA:	Haeupl						
description	cardigan & jacket								
short model text:	stand up,ft.college, tipping								
Pictures / drawing:									
 2088741									
Kind of goods:	assortment		Sizeranges	M; L; XL; 2XL					
Start of sale:	week 48 (Monday)		Collection Theme:	David					
NOS:	no								
	Quality	Weight	Construction / Thread/Fabric	Gage	Yarn count	Washing	Finishing	Function	Others
shell fabric	60% cotton, 40% polyester	260 GSM	French Terry				double dyed, inside brushed		
Colorways									
	black								
Plan-Order-No.:	2088741000								
Brick:	D								

Figure 3.1.1: Tech Pack

Study on Development of Sample in Merchandising

According to this first page of the order sheet of NKD, here we found some primary details about Style number, Designer, Details, Product Image.

Also found some details about Fabric quality, Here given the fabric will be Shell Fabric with 60% Cotton and 40 % Polyester. The GSM must be 260. The Thread of the fabric will be French Terry which will finished with double dyed and brushed inside.

3.1.3 Size Measurement

NKD

Sweater / Sweat jacket	
NKD order no.:	
NKD model no.: 2088741	
Person in charge: Welterer, Hüpfel	
date of changes: 29.09.2017, 04.03.2022	

based on B 21-01-02_002	
Article description: Mens sweater / sweat jacket cuffs at sleeve and bottom with collar and pockets	

All measurements are taken in cm unit from the closed and flat laying garment. The size chart contains finished dimensions, no pattern dimensions. Shrinkage of the fabric/ trims have to be taken into consideration during pattern development.

		44/46			48/50			52/54			56/58			60/62			64/66			TOL +/- double sizes							
		S	S1	S2	S3	M	S1	S2	S3	L	S1	S2	S3	XL	S1	S2	S3	XXL	S1	S2	S3	XXXL	S1	S2	S3	Men Teener	
200	1/2 chest	52				56				60				64				68				72				1,5	
500	1/2 bottom	40				44				48				52				56				60				1,5	
501	1/2 bottom cuff attachment seam (pattern) / 1/2 bottom width above cuff	49				53				57				61				65				69				1,5	
525	bottom cuff height	6				6				6				6				6				6				0,5	
720	1/2 armhole	24				25				26				27				28				29				0,5	
725	1/2 upperarm width	19,6				20,3				21				21,7				22,4				23,1				0,5	
705	sleeve length from shoulder	64,5				65,1				65,7				66,3				66,9				67,5				1	
700	sleeve length from c.b.	86,5				88,1				89,7				91,3				92,9				94,5				1,5	
810	1/2 cuffwidth relaxed	9,5				10				10				10,5				10,5				11				0,5	
816	1/2 cuff attachment seam (pattern) / 1/2 sleeve width above cuff	13,5				14				14				14,5				14,5				15				0,5	
800	cuff height	6				6				6				6				6				6				0,5	
155	across shoulder	44				46				48				50				52				54				1	
125	neck opening straight seam to seam	19				20				21				22				23				23,5				0,5	
130	neckdrop front / HSP to seam	10				10,5				11				11,5				12				12				0,5	
135	neckdrop back / HSP to seam	2				2				2				2,5				2,5				2,5				0,5	
140	1/2 neck opening stretched minimum	30,5				30,5				30,5				30,5				30,5				31,5				-0/+2	
605	bodylength from HSP = seam	70				72				74				76				78				78				1,5	
Collar																											
105	collar height c.b.	8				8				8				8				8				8				0	
113	1/2 edge of collar at top edge	22				23				24				25				26				27				0,5	
Pocket																											
870	position side pocket from HSP	44				45				46				47				48				49				0	
856	position side pocket from side seam upper edge	9				9				9,5				9,5				10				10				0	
856	position side pocket from side seam lower edge	5				5				5,5				5,5				6				6				0	
840	side pocket opening	15				15				15				16				16				16				0	
Seams																											

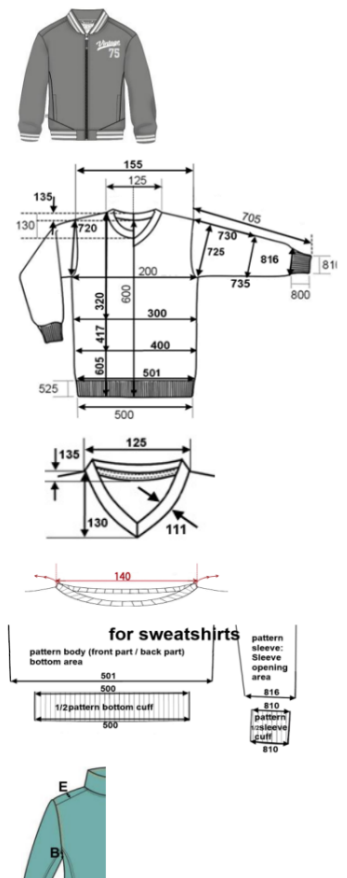


Figure:3.1.3 (measurement table)

Here in the second page of the sheet, The Size measurement is given for developer. All measurements are taken in cm unit from the closed and flat laying garment. The size chart contains finished dimensions, no pattern dimensions. Shrinkage of the fabric/ trims have to be taken into consideration during pattern development.

3.1.3 Style sheet Sketch

Style-No: 2088741

Stylesheet Sketch

Style No: 2088741

NKD

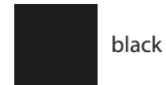
Style : MEN'S JACKET	Collection :	Designer: Ingrid Schikora
Date of creation: 03.03.2022		



bodycolor:



1x1 rib at collar, bottom and slvs :



tipping on collar, slv - and body cuffs:



1,2 cm wide neck ripstape :



bodystitching:

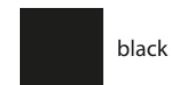


Figure:3.1.3 sketch of product

Here given the sketch of the garment. And in the right side of the sketch the given box of color indicates the color choices of buyer requirements. The Body color, Tipping on collar, Storm front. Wide neck ripstape and bodystitching.

The color code like 11-4201 TCX , 17-1503 TCX are given for perfect match with buyer choices. The code are given from Pantone book.

plastic zip fr. EKL , no. 8 with metal puller:



colours:

DTM zip puller colour
black oxidized

black

metal puller with woven hanger:



black oxidized

black

cloud dancer
11-4201 TCX

4,5 cm

1 cm



creation date 21.04.22 14:44:25

© NKD Group GmbH, v. 6.0 Nav, technical specification

Page 6 of 11

The zip quality used in the garment is detailed in this part. The puller of the zip is made of metal and it is colored with 11-4201 TCX from pantone book.

On the left the zipper picture of the company is given as sample show. And the measurement of the puller which is made of woven hanger is given besides this. It is 4-5 cm in length and 1 cm in width.

3.1.4 Stitching DTM

Stylesheet Sketch

Style No: 2088741

NKD

Style : MEN'S JACKET	Collection :	Designer: Ingrid Schikora
Date of creation: 03.03.2022		

All stitchings DTM

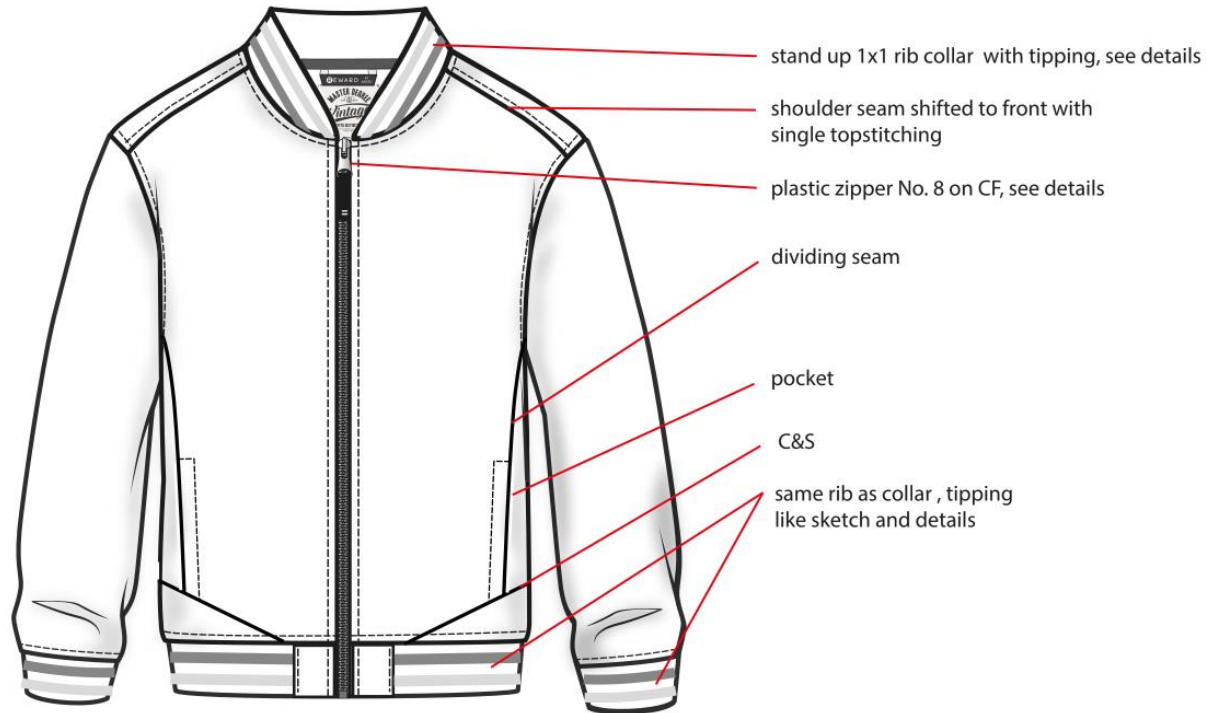


Figure:3.1.4 sketch of product stitching DTM

This part of stylesheet clears the stitching types and style. On the collar it uses 1*1 rib with tipping.

The shoulder seam shifted to front with single topstitching.

Plastic zipper no. 8 in used on CF.

The front pocket is seemed with dividing seam.

The lower part of cuff and body are same rib as collar, tapping like sketch.

Stylesheet Sketch

Style No: 2088741

Style-No: 2088741

NKD

Style : MEN'S JACKET	Collection :	Designer: Ingrid Schikora
Date of creation: 03.03.2022		

only for tipping on collar



only for tipping on cuffs



Figure:3.1.5 Tipping on collar and cuffs

On this part of the development sheet, the collar and cuffs design and outlooks is detailed.

The only for Tipping on collar and cuffs are shown in this part.

3.1.5 Embroidery

embroidery

Please keep to given Pantone colours and use DIGITAL version of Stylesheet

for size S-L : H 10,9 cm x W 13,2 cm

for size XL-XXL: H 12,5 cm x W 15,1 cm

Position: at left chest, 14 cm measured from HSP



Figure:3.1.6 Embroidery

Here given the embroidery details with measurement for various size with color.

Here Given to keep the Pantone color and use DIGITAL version of Stylesheet

for size S-L : H 10,9 cm x W 13,2 cm

for size XL-XXL: H 12,5 cm x W 15,1 cm

Position: at left chest, 14 cm measured from HSP

woven loop label

for all sizes: H 1,4 cm x W 1,0 cm
position: at LHS sideseam , 13 cm
above hem edge

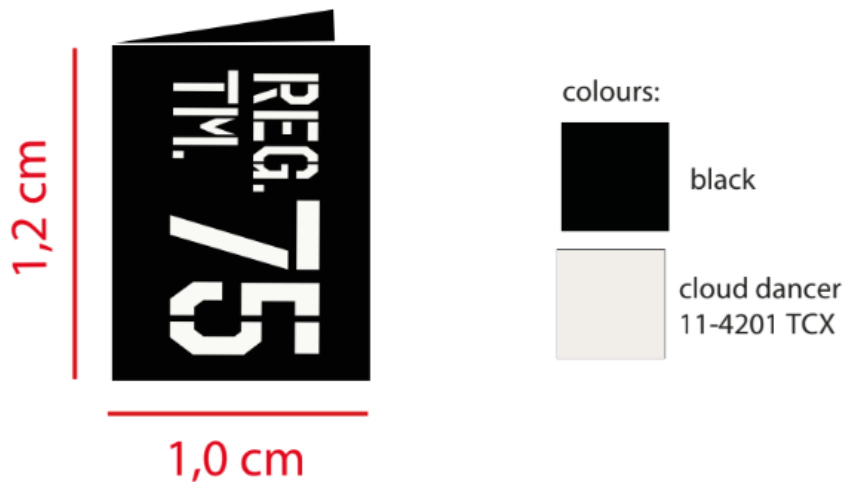


Figure:3.1.7 (i)Woven loop label

The side woven loop level is designed in this part with measurement and color also. This part is made of woven with Black and Cloud Dancer 11-42-01 TCX code of pantone book. The whole part is black and the middle design is written with this color code. The length of this loop is 1,2 cm as size and 1 cm with width.

3.1.6(i) Size Level

Woven loop label

Please keep to given Pantone colours and use DIGITAL version of Stylesheet

for all sizes 6,5 cm x 1,1 cm

Position: Inserted at neckline seam and centered



colours:



black



cloud dancer
11-4201 TCX



Figure:3.1.7 (ii) Size label

The size level is shown here, with color and size. The size level designed with 2 colors, Black and Cloud Dancer (11-4201 TCX). And length is 5,6 cm and width is 1.1 cm

The design is clearly shown with the size mark.

Study on Development of Sample in Merchandising

Style : MEN'S JACKET	Collection :	Designer: Ingrid Schikora
Date of creation: 03.03.2022		

woven label, twill weave, printed

for all sizes: H 6,6 cm x W 6,3 cm

position: on inner backyoke, 1,4 cm below neckline seam
and centered



colours:

cloud dancer
11-4201 TCX

black

stitching colour:

black



Figure :3.1.7(iii) Twill weave print

Here the level described with Size, color and design. Two colors are used in this level, Black and Cloud dancer 11-4201 TCX. And the stitching color is also described that is black. And the design is shown clearly for the buyer.

3.1.6 (ii) Care Label

Printing Description Carelabels

NKD

Style-No: 2088741

EANs

Size	EAN	pcs.
M	2020887410035	1.468
L	2020887410028	2.248
XL	2020887410042	1.844
2XL	2020887410011	1.487

Etikett/Label 1

DE	Obermaterial 60% Baumwolle, 40% Polyester
GB	shell fabric 60% cotton, 40% polyester
IT	esterno 60% cotone, 40% poliestere
HR	gornji material 60% pamuk, 40% polyester
SI	vrhni material 60% bombaž, 40% polyester
CZ	vrchní materiál 60% bavlna, 40% polyester
PL	wierzchni materiał 60% bawełna, 40% polyester



NKD
 produziert für/produced for/
 izdelano za/prozvedeno za/
 prodotto per/vyrobeno pro/
 wyprodukowano dla
 NKD Group GmbH, Buehlstr. 5-7
 95463 Bindlach / Germany
 prodaje: NKD moda s.r.o.
 Zavrtinca 17, HR-10 000 Zagreb
 prodaje: NKD Moda s.r.o.
 Pivovarska 132, 261 01 Ptuj
 EAN 2020887410035 *

Etikett/Label 2

DE	von links waschen/mit ähnlichen Farben waschen/von links bügeln/vor dem Waschen Klett- und Reißverschlüsse schließen
GB	Wash inside out/Wash with similar colors/iron inside out/Close velcro and zip fastenings before washing
IT	lavare alla rovescia/lavare con gli stessi toni/stirare alla rovescia/prima del lavaggio chiudere cerniere e chiusure a velcro
HR	prati s krive strane/prati sa sličnim bojama/gladati sa krive strane/zatvoriti zatvarače na očke i patentne zatvarače prije pranja
SI	Prati obrnjeno narobe/Perte s podobnimi barvami/Pred likanjem obrnite narobe/Pred pranjem zaprite ježke in zadrga
CZ	Perte z rubu/Perte s prádlem podobné barvy (Zehélie z rubu/Před praním zapněte zipy a zavěte suché zipy
PL	Prac na lewej stronie/Prac z podobnymi kolorami/Prasować na lewej stronie/Před praním zamknąć zamki błyskawiczne i paski na rzepy

* Please refer to the table on the left regarding the EANs which have to be used

For details on typesetting please see next page. If you use packaging please ignore next page and fill in the text in all languages in given packaging layout.

Figure :3.1.7(iv) Care Label

Here care level is designed with choices of buyer. In the left side the number of care level pieces shown as per size of garment. Two care level are here with instructions of the garments.

In developing stage the care level are also developed by the merchandisers. Instructions of buyer is followed to make those care level. More over the fabric quality, fabric structure is also maintained in this stage.

3.1.7 Printing description of Care level

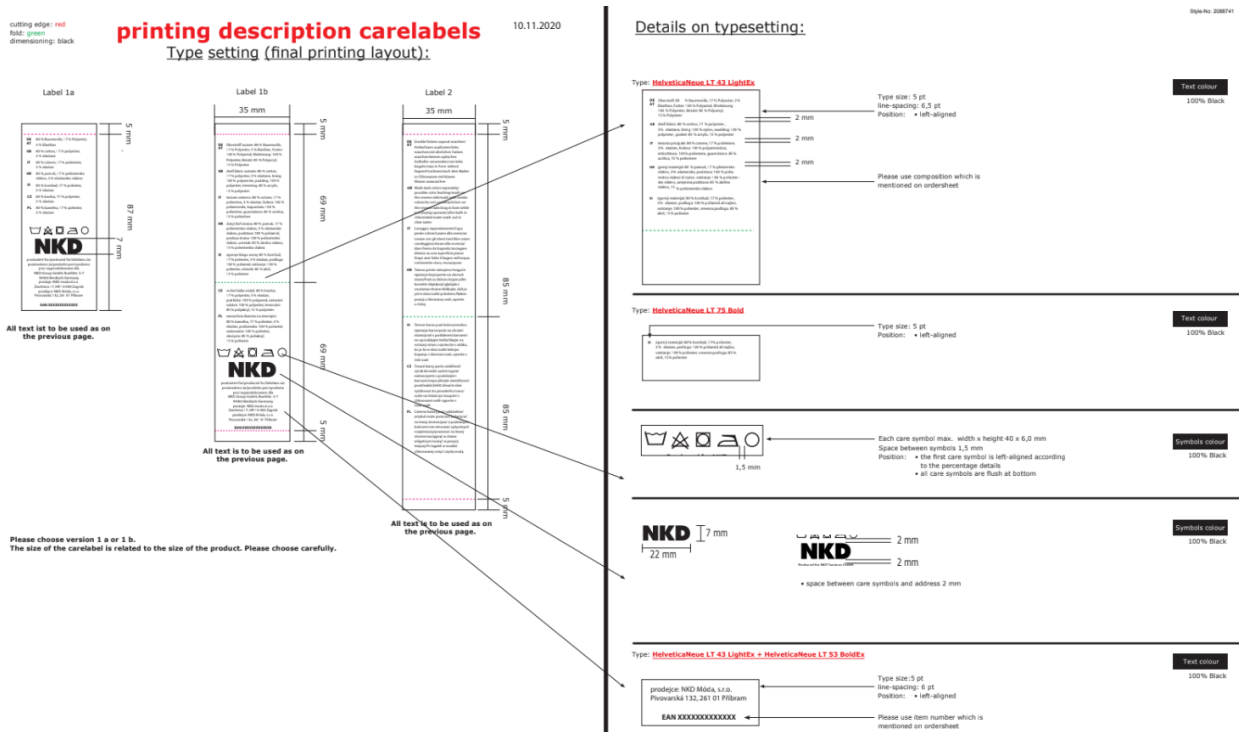


Figure :3.1.7(v) Printing description care Label

Every single instruction of the care level is shown in this part of the development sheet. The type setting is also detailed in this. The Company mark, uses instruction all are printed in this. And the development sheet shown those details clearly.

Study on Development of Sample in Merchandising

	Quality	Weight	Construction / Thread/Fabric	Gage	Yarn count	Washing	Finishing	Function	Others
shell fabric	60% cotton, 40% polyester	260 GSM	French Terry				double dyed, inside brushed		
Colorways									
	black								
Plan-Order-No.:	2088741000								
Brick:	D								
Accessories									
	black								
please see attached stylesheet									
Kind of sample	Quantity	Size	Deadline in house	Sample checking by	Remark				
Lab Dip	1 Piece(s)								
Quality Swatch	1 Piece(s)								
Print Swatch									
size set sample	2 Piece(s)	M; XL		Agency					
pre production sample	1 Piece(s)	M							
FRI	1 Piece(s)								
photosample	4 Piece(s)	M	07.07.2022						
Remarks:									

Labelling		
NKD own brand:	Reward	
price label	Hangtag big	printed by supplier on supplier account
Care- & Compositionlabel		
Ökotex 100	hang tag	

Type of Print
no print

Transport packaging	flat packed
---------------------	-------------

pcs. per sales unit	1
---------------------	---

Harmful substances, safety requirements, EN
The current version of the NKD RSL (Restricted Substances List) can be found in the Supplier Manual for binding attention
* In case of available and valid Ökotex-Certificate, which cover complete article including accessories single testings are not necessary anymore

Certificates	
Ökotex 100	Product class: II

Depending on Incoterm, which is mentioned on order sheet, the supplier has to send the tests and/or certificates as following:

Incoterm FOB / CPT = 14 days before given FCR date
 Incoterm FCA / ex works = 14 days before given FCA / ex works date
 Incoterm DDP = 14 days before delivery Bindlach
 Certificates = immediately after order placement

Category test package	A
-----------------------	---

There the shell fabric are using with GSM 260.Its includes 60% cotton and 40% polyester .Construction is French terry and finishing with double dyed inside brushed.For Lap dip,quality swatch and FRI 1 piece

Study on Development of Sample in Merchandising

of sample used .For size set sample ,2 pieces are used .Finally for photo sample 4 pieces are used in M size .Size set sample are used in M,XL.The product colorways is Black.

Lot-optimisation

Lotype	001	Qty per Lot	4	Qty of Lots	655	Qty of Items	2.620
	M	L	XL	2XL			
black	1	1	1	1			

Lotype	002	Qty per Lot	5	Qty of Lots	400	Qty of Items	2.000
	M	L	XL	2XL			
black	1	2	1	1			

Lotype	003	Qty per Lot	6	Qty of Lots	351	Qty of Items	2.106
	M	L	XL	2XL			
black	1	2	2	1			

Lotype	Online-shop					Qty of Items	321
	M	L	XL	2XL			
black	62	91	87	81			

Total per size / colour				
	M	L	XL	2XL
black	1.468	2.248	1.844	1.487
Total per size	1.468	2.248	1.844	1.487

Total quantity of items:	7.047	Total quantity of lots (excluding onlineshop / ppp):	1.406
--------------------------	-------	--	-------

Total per colour	
black	7.047

Figure :3.1.8 Lot Optimization

There is 3 lot type 001,002,003 and finally online shop. Qty of Items 001(2.620) for 002 (2.000) and for 003(321).Total quantity per size/color for black =(M) 1.468 ,L=2.248,XL=1.844,2XL=1487.Total quantity of items :7.047(Black) and total quantity of lots is 1.406.

The product was approved after 3 rejection .In the phase 25 sample has been made .

3.2 Development Sample for Polo Shirt

Style-No: 2089833

Style Info

NKD

Style-No:	2089833	Product Group:	57	02	04
Product Manager:	Ascherl	Designer:	Schikora		
		Member of QA:	Haeupl		

description	poloshirt
short model text:	pique,c+s,print,embro,badge

Pictures / drawing:



2089833

Kind of goods:	assortment	Sizeranges	M; L; XL; 2XL; 3XL						
Start of sale:	week 16 (Monday)	Collection Theme:	Bernd						
NOS:	no								
	Quality	Weight	Construction / Thread/Fabric	Gage	Yarn count	Washing	Finishing	Function	Others
shell fabric	100% cotton	180 GSM	Pique			Enzyme wash	carded		

Figure:3.2.1 Product sketch

3.2.1 Order Details

Style NO: 2089833

Type: Polo shirt

Fabric: 100% Cotton

GSM: 180

Washing type: Enzyme wash

Finishing: Carded

3.2.2 Sample View

Date of creation: 23.05.2022



bodycolour:



dark sapphire
19-4020 TCX

1x1 rib collar:



dark sapphire
19-4020 TCX

tipping at collar: colours:



white
haute red
19-1758 TCX

1x1 sleeve rib:



dark sapphire
19-4020 TCX

tipping at slv rib:



white

inserts at front:



haute red
19-1758 TCX



white

underlap:



haute red
19-1758 TCX

Figure:3.2.1 (i) Sample view

Study on Development of Sample in Merchandising

Here the garment having a full impression for development. Total color is given here, by the code Of color from pantone book. Like dark sapphire 19-4020 TCX, White, Haute red 19-1758TCX. And the body color is Dark Sapphire. With color the design of the complete product is also given here for buyer.

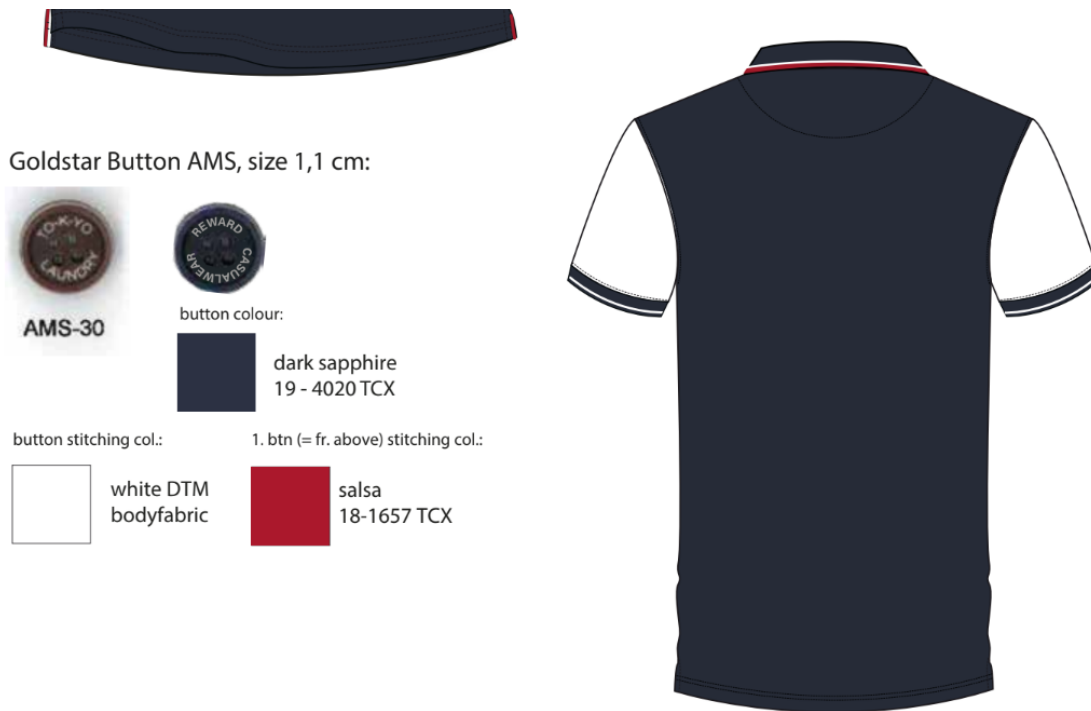


Figure:3.2.1 (ii) Sample view

And here the back part of the final garment shown with collar and cuff design and those design color. On the left side of the garment button with two types are mentioned which will be added for design purpose and use purpose in the garment.

Also the color code from pantone book is mentioned of the collar and cuff.

The button size is also mentioned by the developer. The size of the button Goldstar Button AMS which size is 1,1 cm. The button color Dark sapphire as the body color of the polo shirt. And the written part of the button is White DTM.

Study on Development of Sample in Merchandising

Style : MEN'S POLOSHIRT	Collection :	Designer: Ingrid Schikora
Date of creation: 23.05.2022		

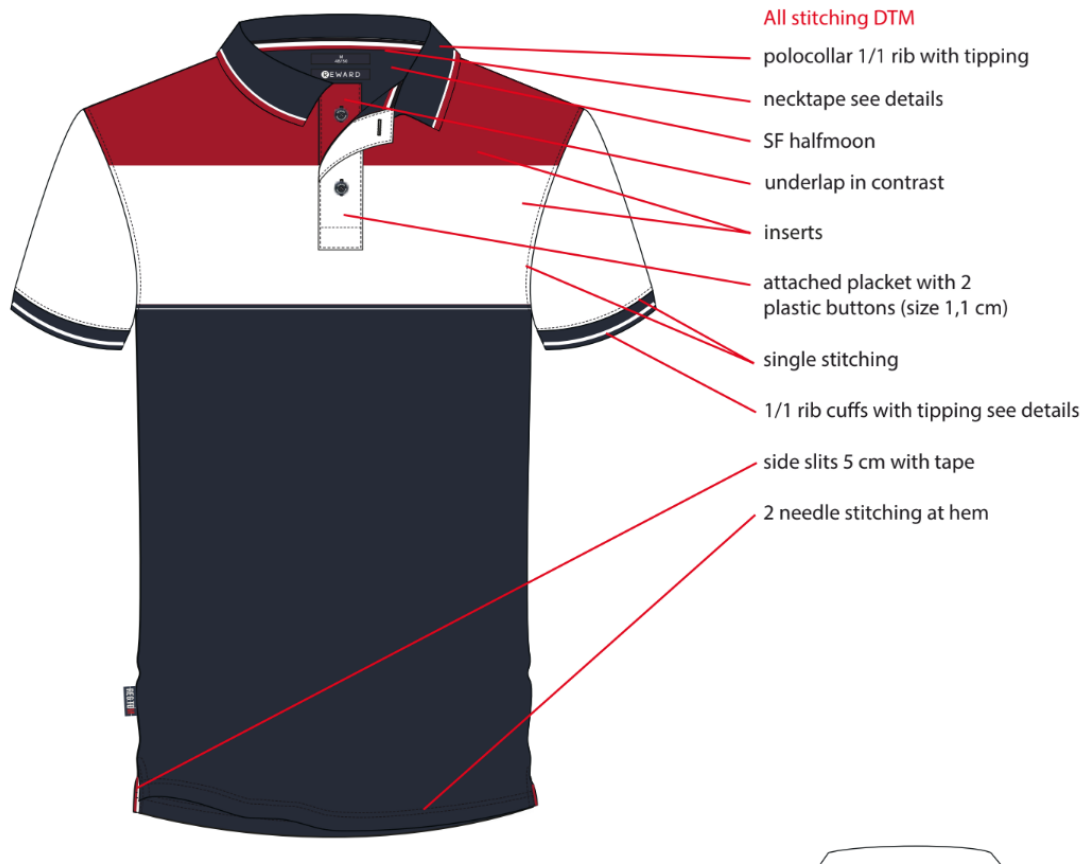


Figure:3.2.1 (iii) All Stitching DTM

Here indicates the structure of Polo collar, Neck tape, Buttons, placket etc.

Given ,Polo collar 1/1 rib with tipping ,Neck tape see details, SF halfmoon ,underlap in contrast, inserts, attached placket with 2 plastic buttons (size 1,1cm) single stitching see details

side slits 5 cm with tape

2 needle stitching at hem

3.2.3 Neck tape and Side slit Tape

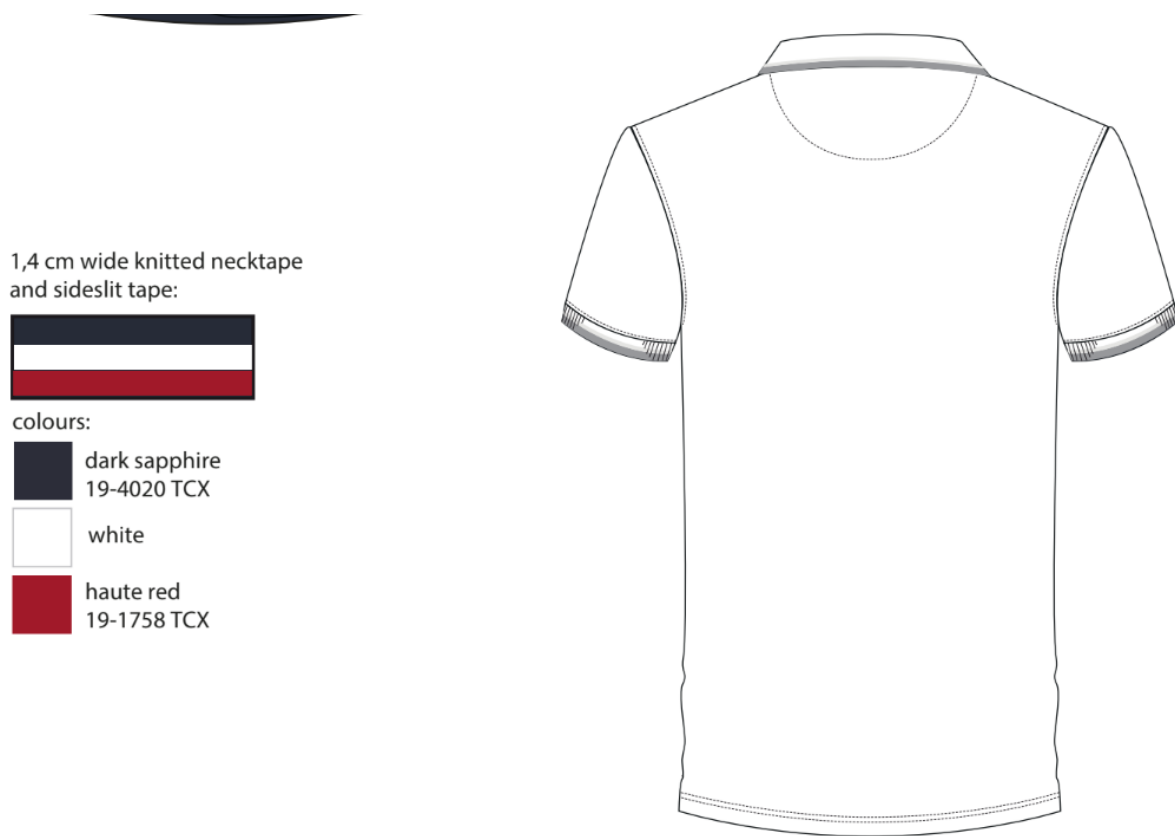


Figure:3.2.1 (iv) Neck tape and Side slit Tape

Here the neck tape and the side slit tape design with color is given.

The color of the neck tape and side slit are Dark sapphire 19-4020 TCX, White, Haute red 19-1758 TCX.

It's a 1,4 cm wide knitted neck tape and side slit tape. The design is given here.

Front print:

pigment print, embro and badge

Please keep to given Pantone colours and use DIGITAL version of Stylesheet

pls fit the AW size to the poloshirt size

Position: at front on chest, like sketch



colours:



blanc de blanc
11-4800 TCX



dark sapphire
19-4020 TCX



creme brulee
13-1006 TCX



haute red
19-1758 TCX



white

Figure:3.2.1 (v) Front print

The front print of the polo shirt is given here. The print design, embroidery and badge is clearly given for development.

In the middle of the design portion The Red marked two lines indicates Button Placket.

The Sides red arrows indicates to fit the design to the polo shirt with the perfect shape and size.

The print and embroidery colors are also given.

Blanc de blanc 11-4800 TCX, Dark sapphire 19-4020 TCX, Crame Brulee 13-1006 TCX, Haute red 19-1758 TCX and White are given to find perfect color design of print and embroidery.

3.2.4 (i) Print and Yarn Stitching parts

print



thick yarn stitching

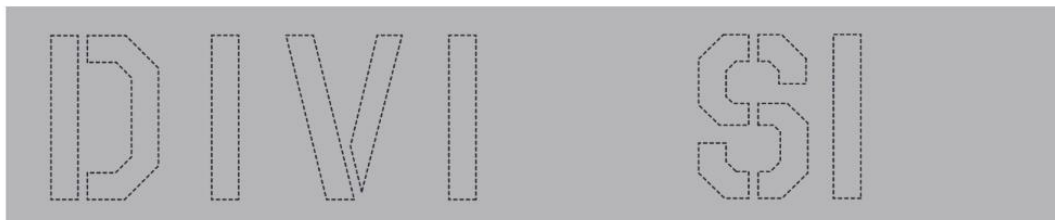


Figure:3.2.2 Print and yarn stitching

On the first part of the design of print the whole part was given. And here The print, yarn stitching, embroidery are given separately for better.

Here we see the printed part covers the larger part of the design. And the yarn stitching part is a small part over the printed design. The yarn stitching part decorates the printed design.

3.2.4(ii) Embroidery and printed badge with embroidered outline

embroidery

REGISTERED TRADEMARK

printed badge with embroidered outline



After showing the whole design, the separate part are shown in this part, so here the embroidery part is given here, where we see a embroidery over printed part is done by developer as buyers choices. And a round logo which done with printed badge with embroidered outline and its shown clearly.

3.2.5(i) Label

Style-No: 2089833

Stylesheet

Sketch

Style No: 2089833

NKD

Style : MEN´S POLOSHIRT	Collection :	Designer: Ingrid Schikora
Date of creation: 23.05.2022		

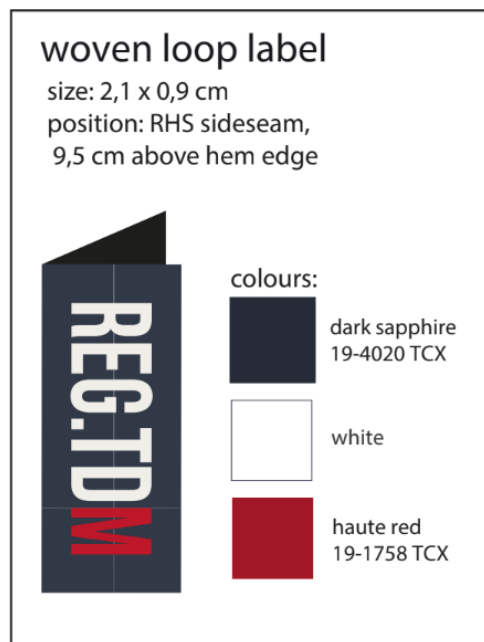


Figure:3.2.3 (i) Label

The label designed with colors dark sapphire, White and Haute red. The size is 2,1 * 0,9 cm.

The position of this label also indicated that RHS side seam, 9.5 cm above hem edge.

And the design is also shown very clearly.

3.2.5(ii) Size level

woven labels

Please keep to given Pantone colours and use DIGITAL version of Stylesheet

position: 1,4 cm below necktape at inner CB. 0,7 cm distance between the labels

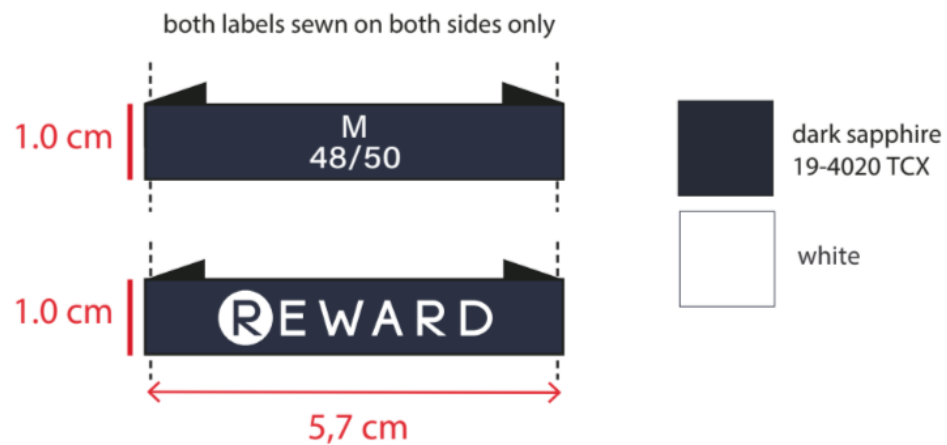


Figure:3.2.3(ii) Size label

The Size level with the color and design given. The length is 5,7 cm and width is given 1 cm of the both levels.

3.2.5(iii) Care level

cutting edge: red
fill: green
dimensioning: black

printing description carelabels
Type setting (final printing layout):

10.11.2020

Label 1a
Label 1b
Label 2

All text is to be used as on the previous page.

Please choose version 1 a or 1 b.
The size of the carelabel is related to the size of the product. Please choose carefully.

All text is to be used as on the previous page.

Details on typesetting:

Type: **HelveticaNeue LT 43 LightItz**
Type size: 5 pt
line-spacing: 6,5 pt
Position: left-aligned

Type: **HelveticaNeue LT 23 Bold**
Type size: 5 pt
Position: left-aligned

Each care symbol max. width x height 40 x 4,0 mm
Space between symbols 1,5 mm
Position: the first care symbol is left-aligned according to the percentage details
all care symbols are flush at bottom

NKD 7 mm
22 mm
2 mm
2 mm
space between care symbols and address 2 mm

Type: **HelveticaNeue LT 43 LightItz + HelveticaNeue LT 93 BoldItz**
Type size: 5 pt
line-spacing: 6 pt
Position: left-aligned

Please use item number which is mentioned on undersheet

Test colour
100% Black

Test colour
100% Black

Test colour
100% Black

Test colour
100% Black

Printing Description Carelabels

Style-No: 2089833

EAAs

Size	EAN	pcs.
M	2020898330049	1.973
L	2020898330032	2.426
XL	2020898330056	3.197
2XL	2020898330018	2.428
3XL	2020898330025	3.964

Etikett/Label 1

DE Obermaterial 100% Baumwolle
AT shell fabric 100% cotton
OB esterno 100% cotone
HR gornji materijal 100% pamuk
BI vrhnji materijal 100% bombaž
CZ vrchní materiál 100% bavlna
PL wierzchni materiał 100% bawełna

NKD
produziert/produced for/
idešno za proizvedeno za/
prodotto per/vyrobena pro/
wyprodukowano dla
NKD Group GmbH, Buelstr. 5-7
65463 Bensheim / Germany
prodaje: NKD moda d.o.o.
Zemljica 17, HR-10 000 Zagreb
prodaje: NKD Moda s.r.l.
Pievevalla 132, 261 01 Pirmam
EAN 2020898330049 *

* Please refer to the table on the left regarding the EAAs which have to be used

Etikett/Label 2

DE von links waschen/mitt. strotchen
AT Farben waschen/von links
bügeln
OB Wash inside out/Wash with
similar colors/iron inside out
IT lavare alla rovescia/lavare con
gli stessi colori/stirare alla
rovescia
HR prati s krive strane/prati sa
sličnim bojama/glačati sa krive
strane
BI Prati obrnjeno narobe/Perite s
podobnimi barvami/Prad
likarjen obrnito narobe
CZ Perle z rubu/Perle s prádtem
podobné barvy/Zeháte z rubu
PL Prac na lewej stronie/Prac z
podobnymi kolorami/Prasować
na lewy stronie

For details on typesetting please see next page. If you use packaging please ignore next page and fill in the text in all languages in given packaging layout.

Figure:3.2.3(iii) Care label

Care level making description and what should have and printing shown in this part.

3.2.6 Measurement Table

Style-No: 2089833

NKD		Placket with 2 or 3 buttons																															
based on B 21-04-05_002 with XS		NKD order no.:																															
		NKD model no.: 2089833																															
		Person in charge: Hing!																															
Article description: Men - Polo Shirt, 1/2 sleeves with or without cuff		date of changes: 15.06.2022																															
		All measurements are taken in cm and from the closed and laid lying garment. The size chart contains finished dimensions, no pattern dimensions. Shrinkage of the fabric items have to be taken into consideration during pattern development.																															
		40/42				44/46				48/50				52/54				56/58				60/62				64/66							TOL double allow
		XS	S1	S2	S3	S	S1	S2	S3	M	S1	S2	S3	L	S1	S2	S3	XL	S1	S2	S3	XXL	S1	S2	S3	XXXL	S1	S2	S3				
200	1/2 chest	46				50					54			58				62				66				70						1,5	
500	1/2 bottom	44				48					52			58				62				68				72						1,5	
700	1/2 armhole	20				21					22			23				24				25				26						0,5	
725	1/2 upperarm width	18				19					20			21				22				23				24						0,5	
150	across shoulder	41,5				43,5					45,5			47,5				49,5				51,5				53,5						1	
125	neck opening straight	15,5				16,5					17,5			18,5				19,5				20,5				21,5						0,5	
130	neckdrop front	8,5				9,5					10,5			11,5				12,5				13				13,5						0,5	
135	neckdrop back	2				2					2			2				2				2				2						0,5	
140	1/2 neck opening stretched minimum	30,5				30,5					30,5			30,5				31				31				31						-0,5	
Collar																																	
105	collar height c.b. (for stripe with collar band (incl. collar band))	8				8					8			8				8				8				8						0	
104	collar band height (for stripe with collar band)	2,5				2,5					2,5			2,5				2,5				2,5				2,5						0,5	
B	collar wing	6				6					6			6				6				6				6						0	
Sleeve with cuff																																	
705	sleeve length WITH cuff from shoulder	20				21					22			23				24				25				26						1	
805	1/2 sleeve opening WITH cuff (measured at edge)	13,5				14,5					15,5			16,5				17,5				18,5				19,5						0,5	
800	sleeve cuff height	2				2					2			2				2				2				2						0,5	
Placket with 3 buttons																																	
C	placket length	15				15					15			15				15				15				15						0	
D	placket width	3,5				3,5					3,5			3,5				3,5				3,5				3,5						0	
Seam																																	
E	lower cut & sewer position from HSP	28				29					30			31				32				33				34						0	
F	upper cut & sewer position from HSP	12				12,5					13			13,5				14				14,5				15						0	
605	bodylength from shoulder point	70				72					73			75				77				79				81						1,5	



Figure:3.2.4 Measurement Table

The measurement for the different size of garments given here by the developer.

Besides this the garment (polo shirt) button placket with collar is also given.

3.2.7 Lot-Optimization Table

Lot-optimisation

Lotttype	001	Qty per Lot	6	Qty of Lots	750	Qty of Items	4.500
	M	L	XL	2XL	3XL		
white	1	1	1	1	2		

Lotttype	002	Qty per Lot	7	Qty of Lots	751	Qty of Items	5.257
	M	L	XL	2XL	3XL		
white	1	1	2	1	2		

Lotttype	003	Qty per Lot	9	Qty of Lots	431	Qty of Items	3.879
	M	L	XL	2XL	3XL		
white	1	2	2	2	2		

Lotttype	Online-shop					Qty of Items	352
	M	L	XL	2XL	3XL		
white	41	63	83	65	100		

Total per size / colour					
	M	L	XL	2XL	3XL
white	1.973	2.426	3.197	2.428	3.964
Total per size	1.973	2.426	3.197	2.428	3.964

Total quantity of items:	13.988	Total quantity of lots (excluding onlineshop / ppp):	1.932
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Total per colour	
white	13.988

Harmful substances, safety requirements, EN
The current version of the NKD RSL (Restricted Substances List) can be found in the Supplier Manual for binding attention
* In case of available and valid Ökotex-Certificate, which cover complete article including accessories single testings are not necessary anymore

Certificates	
Ökotex 100	Product class: II
Packaging materials	

Depending on Incoterm, which is mentioned on order sheet, the supplier has to send the tests and/or certificates as following:

Incoterm FOB / CPT	= 14 days before given FCR date
Incoterm FCA / ex works	= 14 days before given FCA / ex works date
Incoterm DDP	= 14 days before delivery Bindlach
Certificates	= immediately after order placement

Category test package	B
------------------------------	----------

There is 3 lot type 001,002,003 and finally online shop.Qty of Items 001(4.500) for 002 (5.257) and for 003(3.287).Total quantity per size/colour for black =(M) 1.468 ,L=2.248,XL=1.844,2XL=1487,3XLTotal quantity of items :13988 (White) and total quantity of lots is 1.932.

From the developer the sample development is done with very careful process. All the details are noted for the next process and every details and information are given in the development sheet by the development merchandiser.

3.3 Development sample for T-shirt

3.3.1 Order details:

Style no: 2090183

Description: T-shirt

Short Model Text: r-neck, print, turn up

Shell fabric: 100% Cotton

Weight: 160 GSM

NKD

Style Info					
Style-No:	2090183	Product Group:	56	02	03
Product Manager:	Ascherl	Designer:	Schikora		
		Member of QA:	Haeupl		

description	t-shirt
short model text:	r-neck, print, turn up

Pictures / drawing:



2090183

Kind of goods:	assortment	Sizeranges	M; L; XL; 2XL	
Start of sale:	week 6 (Monday)	Collection Theme:	David	
NOS:	no			

	Quality	Weight	Construction / Thread/Fabric	Gage	Yarn count	Washing	Finishing	Function	Others
shell fabric	100% cotton	160 GSM	Single Jersey			Enzyme wash	carded		

Colorways									
	white								

Figure:3.3.1 Sketch of T shirt

Study on Development of Sample in Merchandising

Construction of the Fabric thread: Single Jersey

Washing: Enzyme wash

Finishing: Carded

Colorways: White

	Quality	Weight	Construction / Thread/Fabric	Gage	Yarn count	Washing	Finishing	Function	Others
shell fabric	100% cotton	160 GSM	Single Jersey			Enzyme wash	carded		

Colorways									
	white								

Plan-Order-No.:	2350625001								
Brick:	B								

Accessories									
	white								
please see attached stylesheet									

Kind of sample	Quantity	Size	Deadline in house	Sample checking by	Remark
Lab Dip	1 Piece(s)				
Quality Swatch	1 Piece(s)				
pre production sample	1 Piece(s)	M			
FRI	1 Piece(s)				
photosample	4 Piece(s)	M	12.09.2022		

Remarks:

Here the sample quantity is given for M size. And the deadline is given for timely delivery.

Here given to have sample

Lab dip, Quality swatch, Pp sample, Fri for each 1 pieces and Photo sample for 4 pieces.

Study on Development of Sample in Merchandising

Labelling		
NKD own brand:	Reward	
price label	Hangtag big	printed by supplier on supplier account
Care- & Compositionlabel		
hangtag		
Ökotex 100	hang tag	

Type of Print	
pigment print / waterbased print	

Transport packaging	
flat packed	

pcs. per sales unit	1
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Harmful substances, safety requirements, EN	
The current version of the NKD RSL (Restricted Substances List) can be found in the Supplier Manual for binding attention	
* In case of available and valid Ökotex-Certificate, which cover complete article including accessories single testings are not necessary anymore	

Certificates	
Ökotex 100	Product class: II
Packaging materials	

Depending on Incoterm, which is mentioned on order sheet, the supplier has to send the tests and/or certificates as following:

Incoterm FOB / CPT	= 14 days before given FCR date
Incoterm FCA / ex works	= 14 days before given FCA / ex works date
Incoterm DDP	= 14 days before delivery Bindlach
Certificates	= immediately after order placement

Category test package	A
------------------------------	---

Fig:3.3.2 Sample chart

Here the Price level, Printed by which supplier, transport packing, sales unit amount, certification and product class is shown.

On the lower level, category test package given and FOB, FCA ,DDP time given.

Hangtag HAKA - T-Shirt 6249

15.09.2021

Vorderseite/front:



Rückseite/back:



Farben/Colours

	4c based
	C 0 M 0 Y 0 K 80 Pantone 425 C
	C 0 M 0 Y 0 K 20 Pantone Cool Gray 1 U
	C 0 M 0 Y 0 K 100 Schwarz/Black

Schriftarten/font:

Vorderseite/front:

Myriad Pro Light
Myriad Pro Bold
Laufweite/character distance of the font: 205

NKD.com:
Myriad Pro Bold 80 % Horizontal Skaliert

Rückseite/back:

Myriad Pro Semibold
Laufweite/character distance of the font: 0

Figure:3.3.3 Hangtag

The front and back of level is shown here with color code and design.

3.3.2 Care level:

Printing Description Carelabels

NKD

Style-No: 2090183

EAJs

Colourway white		
Size	EAJ	pcs.
M	2020901830030	2.459
L	2020901830023	2.933
XL	2020901830047	3.910
2XL	2020901830016	2.934

Etikett/Label 1

DE	Cbermaterial 100% Baumwolle
AT	
GB	shell fabric 100% cotton
IT	esterno 100% cotone
HR	gornji material 100% pamuk
SI	vrhnji material 100% bombaž
CZ	vrchni material 100% bavlna
PL	wierzchni material 100% baweina
	
NKD	
produziert für/produced for/ izdelano za/proizvedeno za/ prodotto per/vyrobeno pro/ wyprodukowano dla NKD Group GmbH, Buehlstr. 5-7 95463 Bindlach / Germany prodaje: NKD moda d.o.o. Zavrtnica 17, HR-10 000 Zagreb prodaje: NKD Moda s.r.l. Pivovarska 132, 261 01 Pttriam EAN 2020901830030 *	

Etikett/Label 2

DE	von links waschen/mit ähnlichen
AT	Farben waschen/von links bügeln
GB	Wash inside out/Wash with similar colors/iron inside out
IT	lavare alla rovescia/lavare con gli stessi toni/stirare alla rovescia
HR	prati s krive strane/prati sa sličnim bojama/glačati sa krive strane
SI	Prati obrnjeno narobe/Perte s podobnimi barvami/Pred likanjem obrnite narobe
CZ	Perte z rubu/Perte s prádlem podobné barvy /Žehlete z rubu
PL	Prac na lewej stronie/Prac z podobnymi kolorami/Prasować na lewej stronie

* Please refer to the table on the left regarding the
EAJs which have to be used

For details on typesetting please see
next page. If you use packaging
please ignore next page and fill in the
text in all languages in given
packaging layout.

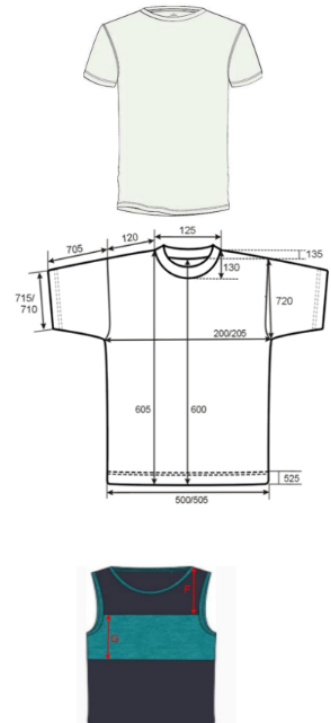
Figure:3.3.4 Care Label

Care levels are made by the developer. This care level printing quality also maintained by the developer.

3.3.3 Measurement of t-Shirt:

NKD		YFM T-shirt S/J																
B 07-06-01		NKD order no.:																
		NKD model no.:																
Article description: YFM T-Shirt round neck or v-neck, sj 100% CO, short or long sleeve		Person in charge: Häuptl																
		date of changes: 26.05.2020, 29.06.2020, 02.11.2021																
All measurements are taken in cm unit from the closed and flat lying garment. The size chart contains finished dimensions, no pattern dimensions. Shrinkage of the fabric/ trims have to be taken into consideration during pattern development.																		
		44/46			48/50			52/54			56/58			60/62			TOL +/- double size	
		S	S1	S2	S3	M	S1	S2	S3	L	S1	S2	S3	XL	S1	S2	S3	
203	back width 13cm from c.b.	39,5				41,5				43,5				45,5			47,5	1
200	1/2 chest	46				50				54				58			62	1,5
500	1/2 bottom	45				49				54				58			62	1,5
155	across shoulder	42,5				44,5				46,5				48,5			50,5	1
Help measurement armhole																		
	HELP MEASUREMENT: 1/2 armhole round measured FRONT	24				25				26				27			28	
720	1/2 armhole	20,5				21,5				22,5				23,5			24,5	0,5
725	1/2 upperarm width	18				19				20				21			22	0,5
717	1/2 sleeve head width 8cm from SP	13,3				14				14,7				15,4			16,1	0
1 / 2 Sleeve																		
705	sleeve length from shoulder SHORT SLEEVE	19,5				20,5				21,5				22,5			23,5	1
715	1/2 sleeve opening SHORT SLEEVE	14,5				15,5				16,5				17,5			18,5	0,5
1 / 1 Sleeve																		
705	sleeve length from shoulder LONG SLEEVE	64				64				65				65			66	1
715	1/2 sleeve opening LONG SLEEVE	10				10,5				11				11,5			12	0,5
R- Neck																		
130	neckdrop front ROUND NECK	9,5				10				10				10,5			10,5	0,5
125	neck opening straight seam to seam	20				21				22				23			24	0,5
V-Neck																		
130	neck drop front V-NECK	14,5				14,5				15				15			15,5	0,5
125	neck opening straight seam to seam	17				18				19				20			21	0,5
135	neckdrop back	2				2				2				2			2	0,5
140	1/2 neck opening stretched minimum	30,5				30,5				30,5				31			31	-0/+2
800	neck cuff width	1,5				1,5				1,5				1,5			1,5	0
Chest Insert																		
F	chest cut & sewn position from HSP	20,5				21				21,5				22			22,5	0
G	chest insert height	15,5				16				16,5				17			17,5	0
Pocket measurement for style with pocket																		
E	pocket width	11				11				11,5				11,5			12	0
F	pocket length	12				12				12,5				12,5			13	0
G	pocket position from HSP	22				23				23				24			24	0
H	pocket position from c.f.	5,5				5,5				6				6			6,5	0
605	bodylength from shoulder point	68				70				72				74			76	1

P:\Qualitätsmanagement\3_Backkanten\NKD_56Backkaten MT B 07-06-01 YFM T-shirt S2 round neck or v-neck, long or short sleeve



The measurement for t-shirt is given in the development sheet for better and accurate measure of the garments.

3.3.4 Product Body and neck color

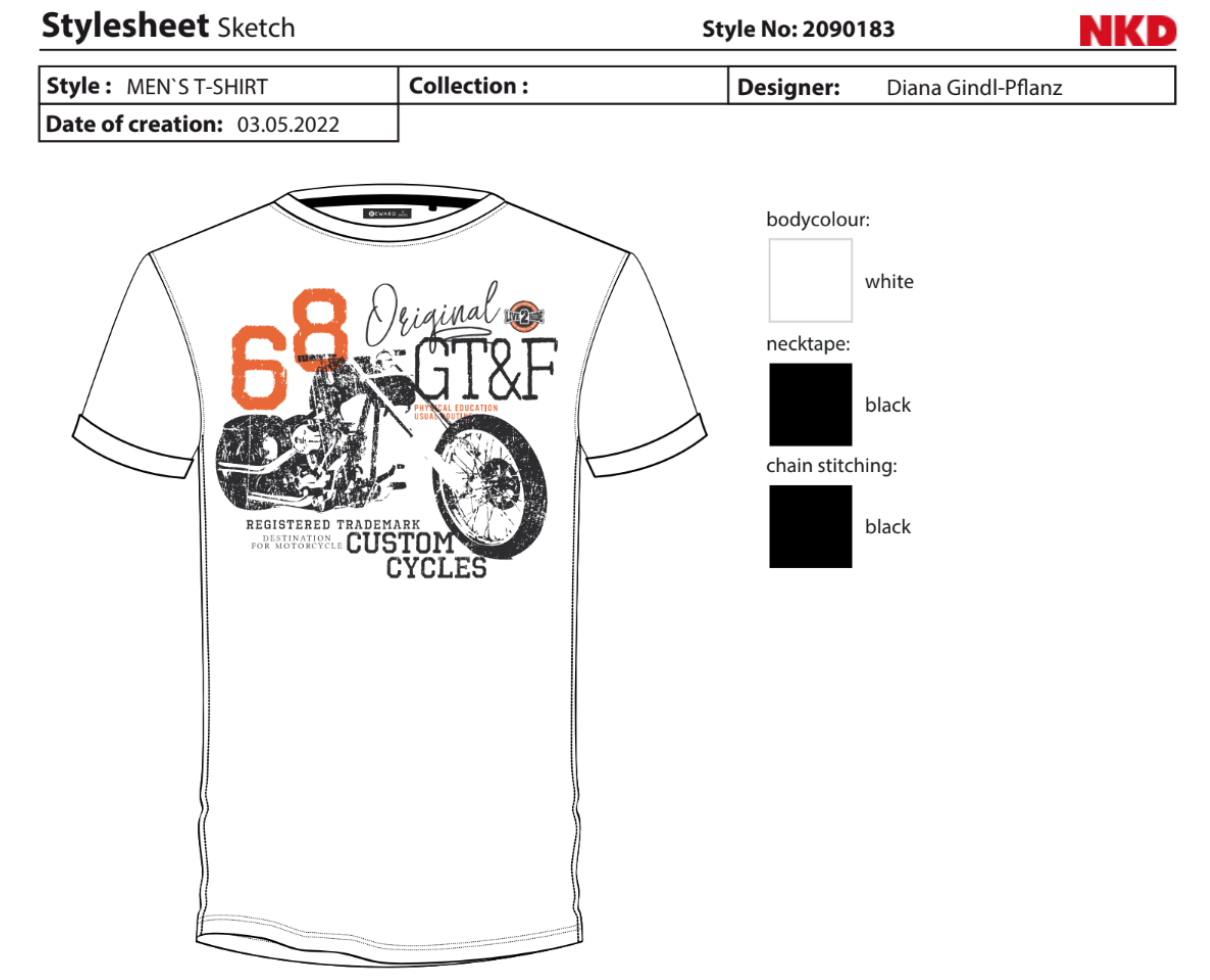


Figure:3.3.4(i) Product Body and neck color

Here the body color, Neck tape color and the chain stitching color given.

3.3.5 Stitchinng:

Style : MEN'S T-SHIRT	Collection :	Designer: Diana Gindl-Pflanz
Date of creation: 03.05.2022		

All stitching DTM

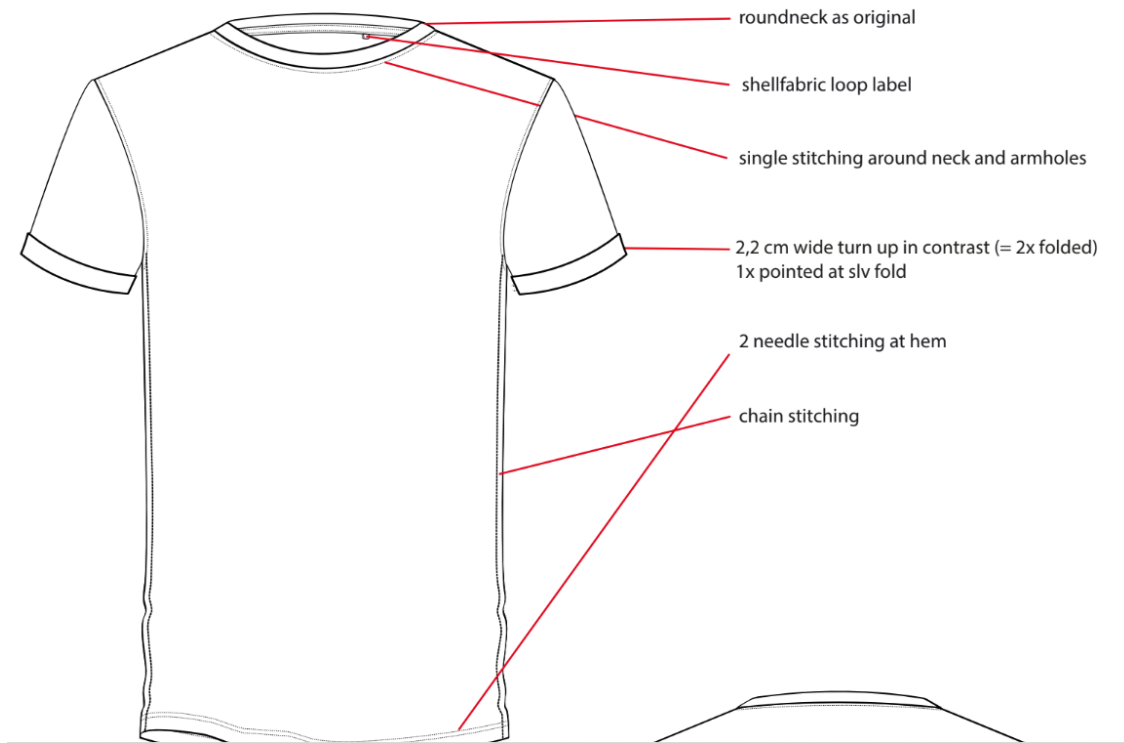


Figure :3.3.4(ii) Stitching

In this part, the stitch quality and types are explained.

Round neck as original, Shell fabric loop label, single stitching around neck and armholes,

2 needle stitching at hem

chain stitching on side seam, Stylesheet Sketch 2,2 cm wide turn up in contrast (= 2x folded) 1x pointed at slv fold.

3.3.6 Embroidery:



Figure :3.3.5 Embroidery

Here the embroidery design shown with color and size of the garment. The given color is jet black 19-0303TCX, Golden poppy 16-1462 TCX. The print is of Pigment print.

3.3.7 Size level

print

Please keep to given Pantone colours and use DIGITAL version of Stylesheet

for all sizes 2,1 cm x 4,6 cm

Position: 2 cm below neckline



colours:



jet black 19-0303 TCX



bright white 11-0601 TCX

Figure:3.3.5(ii) size label

The care level design, size and color given here by the developer. Two color given is jet black 19-0303TCX , bright white 11-0601 TCX .

3.3.8 Lot Optimisation

Lot-optimisation

Lotttype	001	Qty per Lot	4	Qty of Lots	961	Qty of Items	3.844
	M	L	XL	2XL			
white	1	1	1	1			

Lotttype	002	Qty per Lot	5	Qty of Lots	961	Qty of Items	4.805
	M	L	XL	2XL			
white	1	1	2	1			

Lotttype	003	Qty per Lot	7	Qty of Lots	482	Qty of Items	3.234
	M	L	XL	2XL			
white	1	2	2	2			

Lotttype	Online-shop					Qty of Items	353
	M	L	XL	2XL			
white	75	87	103	88			

Total per size / colour				
	M	L	XL	2XL
white	2.459	2.933	3.910	2.934
Total per size	2.459	2.933	3.910	2.934

Total quantity of items:	12.236	Total quantity of lots (excluding onlineshop / ppp):	2.384
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Total per colour	
white	12.236

Figure :3.3.6 Lot Optimization

Here the quantity of development sample given, with size number. There is 3 lot type 001,002,003 and finally online shop.Qty of Items 001(961) for 002 (961) and for 003(482).Total quantity per size/colour for black =(M)2.459,L=2.933,XL=3.910,2XL=2.934.Total quantity of items :White, 12.236 and total quantity of lots is2.384.

CHAPTER 4

RESULT AND DISCUSSION

4.1 Analysis of Development Sample for Jacket

Received an order of buyer NKD for the style:2088741. At first here the proto sample had developed.

Proto sample has been given and also buyer sent some comments on this proto sample.

Buyer said If the Sample fitting is ok then it can go for PP(Pre-production) sample. Then sent to the Fitting sample. After that the fit sample is ok and buyer confirm the gold seal sample, then bulk production has been started.

4.1.1 Analyzing various Characteristics of Jacket

Types	Description	Product Number
Fabrication	Generally, fabric used 60 % Cotton &40% polyester French terry, 260 GSM	2088741
Revise Comments	Mainly buyer do comments on measurements, Fitting issue	
Sample Stage	Lab dip Quality swatch Size set sample FRI Photo sample	
Accessories	All types of accessories used like Woven label, Care label, Size label, Hangtag, Country label all are used. Zipper 1, material coil, size 5, function 1 open end, slider DADHR5	

4.1.2 Challenges for Jacket

- Buyers reject that product for 3 times as the color didn't match as desire.
- The accessories whose are used in the product wasn't appropriate as buyers demand.
- To obtain the elasticity with a heavy construction was tough to maintain.
- To maintain the luster with matte color was also a challenge.
- The zipper size was not good in quality in buyer's comments.
- Side seam, style line maintenance.

4.1.3 Overall View for the development sample of Jacket

Products	Sample given	Fault %	Approval time	Matching with Buyer requirements
Jacket	25	23%	4th	96%

4.1.4 Rejection and Comments for Jacket

Time	Approval	Comments
1st	Reject	Colors aren't match. Match with pantone book
2nd	Reject	Accessories of jacket aren't the desire. The size is too large in the middle.
3rd	Reject	The comment of buyer pattern didn't match. There has fitting issue .
4th	Approved	It maintains all the demands of this products.

4.2 Analysis of Development Sample for Polo Shirt

Received an order of buyer NKD for the style:2089833.

At first here develop the proto sample.

For 1st fit sample Comments type:

Changes in measurement: Across shoulder and sleeve length measurement changed a little bit.

After correction of the sleeve length and across shoulder measurement as buyer requirement we sent Second fit sample. then the second fit sample is ok. Start work for PP Sample and send to the buyer. Buyer confirmed the PP sample then start bulk production.

4.2.1 Analyzing various characteristics of Polo Shirt

Types	Description	Product Number
Fabrication	Generally,100% cotton pique fabric, Enzyme wash effect,180 GSM	2089833
Revise Comments	Buyer mainly comment on artwork, fitting issue and design.	
Sample stages	Lab dip Quality swatch Initial Approval sample Size set sample PP sample FRI Photo sample	
Accessories	All types of accessories used like Woven label, Care label, Size label, Hangtag, Country label all are used. Button, placket.	

4.2.2 Challenges for Polo Shirt

There faced a problem in stitching at hem .

Firstly there was 3 needle to solve the problem ,here used 2 needle.

Print with thin yarn stitching was a problem.

Problem in embroidery upper in the design .

Placket design maintenance.

4.2.3 Overall View for the Development Sample of Polo Shirt

Products	Sample given	Fault %	Approval time	Matching with Buyer requirements
Polo shirt	10	12%	2nd	97%

4.2.4 Rejection and Comments for Polo Shirt

Time	Approval	Comments
1st	Reject	Stitching problem in hem,Slit tape problem ,Desing in front part aren't appropriate .
2nd	Approved	Ready for the bulk production.
Time	Approval	Comments
1st	Reject	Stitching problem in hem,Slit tape problem ,Desing in front part aren't appropriate .

4.3 Analysis of Development Sample for T-Shirt

Received an order of buyer NKD for the style:2090183.

At first here develop the proto sample.

2nd red tag sample Comments.

- Changes in vendor measurement: In this sample Across shoulder and Sleeve length measurement buyer changed again.
- Fit Comments: Approved. Buyer said overall fit is acceptable on stand. But improve as well the requirements.
- Workmanship: Little folded at body s/b improve, Top hem little uneven s/b improve in bulk Production.
- Constructions: Same as the Tech Pack

Sample status: Sample reviewed and technically approved with improve required. Buyer said to proceed GSS with following above and commercial comments.

4.3.1 Analyzing various characteristics of t-shirt

Types	Characteristic	Product No
Fabrication	Generally,100% cotton pique fabric, Enzyme wash effect,180 GSM.	2090183
Revise Comments	Buyer mainly comment on measurement issues.	
Sample stages	Lab dip Quality swatch Size set sample FRI Photo sample	
Accessories	All types of accessories used like Woven label, Care label, Size label, Hangtag, Country Label all are used.	

4.3.2 Challenges for T-Shirt

This product got rejection for care label .

The color of printing didn't match with the requirement

Products tends to shrink while stitching

The product seems and feels so hard instade of being soft .

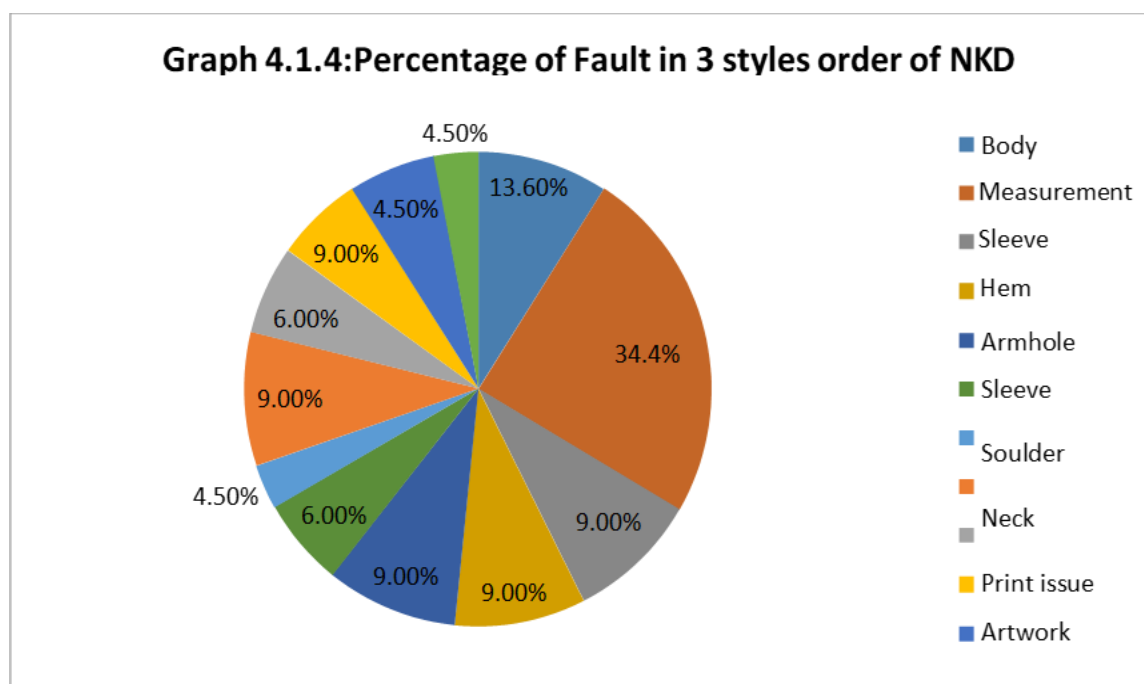
Measurement issues.

4.3.3 Overall View of Development sample for T-shirt

Products	Sample given	Fault %	Approval time	Matching with Buyer requirements
T-shirt	30	29	5th	97%

4.3.4 Rejection and Comments for T shirt

Time	Approval	Comments
1st	Reject	The round neck measurement isn't perfect. Across shoulder and Sleeve length have problem.
2nd	Reject	Non ability of actual trims and fabrics.
3rd	Reject	Rework on Printing
4th	Reject	Farben on panton 425C.MYRIAD PRO BLOD Check p book .
5th	Approved	Ready for bulk production.



Measurement Fault % of three products combinedly

Graph shows the percentage of fault of sample of 3 products Jacket, Polo shirt and T-shirt. Here is fault percentage as buyer comments in measurement is (34.4%). Fault percentage in body (4.5%). Buyer comments on sleeve(4.5%), Fault percentage in Hem(9.00%), In armhole fault percentage 13.6%, Neck fault percentages 9.00%, In shoulder fault percentage 4.5%. And Artwork Fault (9.00%), Color shade defects 9.00%.

It has been observed that the develop sample activity of several products. And we found different types of comments.

4.4 Differences between 3 products of this report

Fabrication	Product 1 (jacket) 2088741	Product 2 (Polo Shirt) 2089833	Product 3 (T-Shirt) 2090183
	60 % Cotton & 40% polyester French terry.	100% cotton pique fabric Enzyme wash effect	100% cotton S/j fabric Enzyme wash effect.
GSM	260 GSM	180 GSM.	180 GSM
Comments	Measurements, Fitting issue	Artwork, fabrication, print, design.	Measurement issue, accessories, Fabrication, Neck, shoulder, armhole,
Sample Stage	5 sample stage are done here, Lab dip Quality swatch Size set, Photo sample FRI	Lab dip Quality swatch Initial Approval sample, size, pp, photo sample FRI	Lab dip Quality swatch Size set sample FRI Photo sample
Accessories	Woven label, Care label, Size label, Hangtag, Country label all are used.	Woven label, Care label, Size label, Hangtag, Country label all are used.	Woven label, Care label, Size label, Hangtag, Country label all are used.
Approval	Product approved in 4 th observation by buyers	Product approved in 2nd observation by buyers.	Product approved in 5th observation by buyers.

CHAPTER – 5

CONCLUSION

Study on Development of Sample in Merchandising

The project was about study on development sample of merchandising, Their requirements, sampling stages, fabrication, revise comments all about. We found the idea about buyer order sheet, Fabrication, develop a sample in first stage, and how to make buyer approval of these sample for production. This study on development sample carries importance to the whole process of bulk production by researching those development sheet of three products we reached in a final decision which are presented by this phase. This report is concluded as,

- In Jacket (2088741) has been observe that, after 3 rejection the product got the approval from the buyer. In Polo shirt (2089833) has been found that this product got approval in 2nd time with 97% matching of buyer requirements.
- For t-shirt, after 5th observation by buyer, the sample gets approval. Match with buyers demand 97%
- The jacket matches 96% with the buyer requirements, Polo shirt 97% and t shirt 97% for starting bulk production.
- Fault % of jacket, polo shirt and t shirt are 23%,12% and 29%(Gradually).
- For getting approval, samples have been given 25,10,30 for jacket, polo shirt and t shirt.
- Most common reason of rejections are Measurement and stitching issue as well as print of front, alienation of color, accessories, pattern etc.
- Heavy construction, zipper quality side seam and style miss were also the reason of rejection for Jacket.
- By this report the observation found that, in every product the most common comments of buyers were about measurement issue. Until find at least 95% matching with the requirements the order got rejections. Fabrication, accessories requirements, sampling stages and comments variations all are different for 3 products (jacket, polo shirt , t shirt).

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