



**Faculty of Engineering**

Department of Textile Engineering

**Title of the project**

**Study on Different Types of Sewing Fault & it's Remedies.**

**Course Title:** project (Thesis)

**Course code:** TE-4214.

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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

**Fall-22**



## LETTER OF APPROVAL

Date:

To

The Head

Department of Textile Engineering

Daffodil International University

Daffodil Smart City, Dhaka

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

Sir

I am just writing to let you know that this report titled as “Study on Different Types of Sewing Fault and its Remedies”. It has been prepared by the student bearing ID 191-23-657 and 191-23-647 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 becomes vital to spark 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

A handwritten signature in black ink, appearing to read 'Md. Abdullah Al Mamun', is written above a horizontal line.

Md. Abdullah Al Mamun

Associate Professor

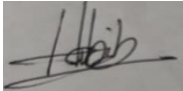
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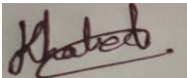
## DECLARATION

we declared that this report “study on different types of Sewing faults & it’s Remedies” is done by us under the supervision of Md. Abdullah Al Mamun, Associate professor of the department of Textile Engineering, Daffodil International University. which data is collected by us from factories with taking permission from the Authorities. This report is not presented before any other university. We also declared that our supervisor has the right to cancel this report.

A handwritten signature in black ink, appearing to read "Habib", written on a light-colored background.

Md. Habib

ID: 191-23-657

A handwritten signature in black ink, appearing to read "Khaled", written on a light-colored background.

Khaled Ifthekar

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## ACKNOWLEDGEMENT

In the name of Allah, the most merciful. We are thankful to Almighty Allah for giving us the ability and opportunity to work on the paper.

Then we would like to thank our Respected teacher also our Supervisor Abdullah Al Mamun sir, Assistant professor, department of Textile Engineering, Daffodil International University, whose worthy guidance helps us and inspired us to complete the paper. We also very much thank Magpie Composite Textile Ltd and SNOWTEX Outwear Ltd Authorities for giving us permission to collect data from these factories for project work.

Also, thanks to all employees who help us to collect information and give us knowledge about factory work environment which was very helpful to finish the paper.



## **DEDICATION**

We Dedicate the paper to our loving parent who always support us in our good work.

## **ABSTRACT**

Garments defect means the undesirable operation Happens during production in garments. This is big problem in RMG sector. The main reason of garments rejections is Sewing fault which is the main reason of low productivity. It is very necessary to know about sewing fault to increase productivity. The aim of the paper is to know Identifying different types of sewing fault like- puckering, uneven stitch, Raw edge, needle cut, stitch skip etc. without identifying it is not possible to produce good quality product. we have collected some end table inspection report from factories where we are doing our internship to Identify defects and after analyzation we found some defects. Then we choose some defects and start works to found its remedies. we successfully found those remedies which we present in this paper.

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## CHAPTER- 01

### 1.0 INTRODUCTION:

#### **1.1 Background:**

Textile means those all process which is used to make a complete garment like, knitting, dyeing, printing, cutting and sewing. Sewing is a process of attaching fabric edge by using one or more Needle. In Apparel Industry sewing is a major thing. Sewing have some faults, In this paper we will explain about faults and its remedies.

#### **1.2 Objectives:**

- To Observes the types of Sewing Faults Occur in Factory.
- To observes the reason of occurring Sewing Faults in factory.
- To know the Remedies of those Sewing fault & improves product Quality by avoiding those Faults.

#### **1.3 Importance of Study:**

As a Textile engineer It is very important to know about sewing faults. Sewing fault is the main reason of production quantity loss. To improve production quantity and quality it is necessary to know the faults types those occurring reason and their remedies. Without knowing these thing a person who is connected with textile industry will be not success to identify production loss and the process where improvement is required. That's the reason the topic is important.

## CHAPTER-02

### 2.0 LITERATURE REVIEW

#### **2.1 sewing:**

Sewing is the process of attaching fabric one edge to another edge using one or more needle. The small unit of sewing is called stitch. More stitch density means more strength. In Apparel Industry sewing is must use for makes a complete-garments. After cutting fabric panels are send to sewing section and then those panels sewn according to sewing layout given by IE department. In sewing section different types of sewing machine according garments design. In industry most of the time polyester thread is used because its strength is good and cheaper than other thread.

#### **2.2 Different types of sewing machine:**

- plain machine.
- Vertical machine.
- Overlock machine(4Thread).
- Overlock (5 thread)
- Flat lock machine (1,2,3 Needle).
- Button hole Machine.
- Button Attaching Machine.
- Bar-tack machine.
- Feed of the arm chain stitch machine.

## 2.2.1 Some pictures of Sewing Machine:



**Figure:2.2.1-Plain Machine**



**Figure:2.2.2-Overlock Machine.**



**Figure:2.2.3-Bar Tack Machine.**



2.2.4 Figure: feed of the Arm chain stitch machine

## 2.3 Garments Defect:

This is undesirable action occurred during sewing which decrease the marketability of garments. Producers main target is to produce fault free products to increase profit. They check garment during production in production line also in end of the line to reduce faults. If found any fault this garment sends for rectify, if rectify is not possible this count as a reject garment.

### 2.3.1 Types of Garments Defect:

**Minor Defect:** This can be defined as a defect which do not affect the usability of a garments.

**Major Defect:** This can be defined as a defect which decrease the marketability of a garments.

**Critical Defect:** This defect is a big defect which is not tolerable defect in Textile Industry.

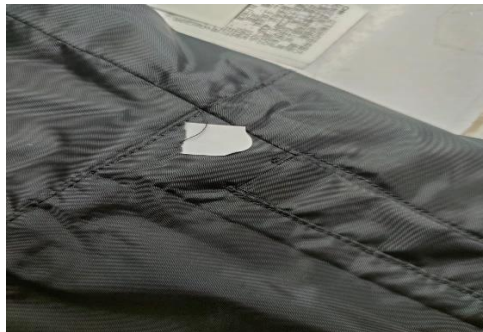
This can be harmful for consumers. Like: broken Needle in finished garments, presence of insect etc. This defects measurements Standard can be different for different factories.

## 2.4 Some Sewing Faults:

- Open seam.
- Uneven stitch.
- Oil spot.
- Dirty spot.
- Broken stitch.
- Uncut thread.
- Skip stitch.
- Uneven hi-low.

**Uncut thread:**

Excess thread is hanging on garments after manufacturing, which is happened for unskilled workers. Workers training is required to avoid this problem.



**Figure: 2.4.1 Uncut Thread.**

**Open stitch:**

when a thread edge comes out after sewing is called open stitch.



Figure: 2.4.2 Open Stitch

**Causes:**

- Back stitch missing in sewing end edge.

**Remedies:**

- Proper back stitch should be used in sewing end edge.

**Oil spot:**

A spot is found in the garments surface which do not have any deep color is called oil spot. This decrease the quality of garments



Figure:2.4.3 Oil Spot.

**Causes:**

- If excess lubrication.
- If machine part is not clean.

**Remedies:**

- Machine cleaning is required before use.
- Should avoid Excess lubrication.
- Should service the machine properly.

## CHAPTER-3

### 3.0 Experimental work

#### **Methodology:**

We work in different factory where work in different section like knitting, dyeing, cutting, sewing. In sewing work in end line inspection, where we watch many types of faults which is occurred for sewing. So, we took total 12 days end line inspection report to identify different types of defect, 7 Days from Magpie Composite Textile Ltd (MCTL) and 5 days Reports from Snowtex Outwear Ltd (SOL). After identifying we will try to reduce those problem.

#### **DHU%:**

Defect per hundred Unit Garments. To know the garments production quality this method is used In Textile Industry. The formula is

$$\text{DHU} = \frac{\text{Total number of faults}}{\text{total inspected pcs}} \times 100$$

#### **3.1 Data collection:**

We have collected all the data using in this project are from both factories where we complete our internship. We took permission for collecting all data from the factory authorities. This data is collected from end line quality inspection table.



### 3.2 End line table Inspection Report:

#### 3.2.1 End Table inspection Report-1

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

832/833 Dewan Edris Road, Amara, Rangpur, Bangladesh. Phone: 01711-111111

**END TABLE INSPECTION REPORT GARMENTS**

Date: 17-01-2023

Line: 17  
Colour: NAVY White

Buyer	Mo. No.:	Item:										Total	%
NEW WAVE	510352	T-SHIRT										765	
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%	
Inspection	173	108	157	183	155						765		
Good	125	100	130	155	150						760	4.31	
Defect	10	07	05	06	04						5	0.13	
Reject				01							1		
Defect Repair/Repair Pass													
Defect Name											6	0.78	
Open/Broken Strip/Stitch			11	11	1						3	0.13	
Shading		1											
Puckering													
Neck Shape Inconsistency													
Poor Tention						WORK	WORK	WORK			3	0.39	
Uneven	1										3	0.39	
Rawedge													
Oil Mark						WORK	WORK				7	0.91	
Dirty Mark													
Damage On packing up-down	111	111									6	0.78	
Union/Over Sts.											6	0.78	
Wrong Trims Needle/Thread	11	11									4	0.52	
Label Join						NO	NO	NO					
Stv. Uneven DIRT	11												
Size Mistake													
Bottom/Cup/AH Shape													
Print/Emb/Strip Univen													
Uncut Thread											6	0.78	
Others open sis	1												
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%	
Inline Q.C Sign											765		
Pro. Sup. Sign											730		
O.C Sup. Sign											33	4.31	
1st	Def. Qty.		2nd Highest			Def. Qty.		3rd Highest				Def. Qty.	

ASMA Q.I.      Q.C.      Pro. Sup.      P.M.      Q.M.      Approved

Figure:3.2.1 End Table Inspection Report-1

### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer				Color			Item			Line	
17-01-23	NEW WAVE				Navy white			T-Shirt			17	
Hours	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
inspection	175	108	157	165							765	
Good	165	100	150	160							730	
Defect	10	07	06	05							33	4.31
reject											1	0.13
Defect repair pas												
Defect Name												
Skip stitch		1	2	2	1						6	.78
Broken stitch												
Shading		1									1	.13
Puckering												
Poor tension												
Uneven stitch	1		1		1						3	.39
Raw edge												
Oil mark			1	1	1						3	.39
Dirty mark												
Opening up-down	3	3									6	.91
Over stitch												
Wrong Trim												
Needle cut	2	2									4	.78
Sleeve Pleat	2		1	1							4	.78
Wrong trim												
Label join	1										1	.13
Uncut thread												
Size mistake												
Open stitch	1	1		3	1						6	.78

Table:3.1 Line Inspection report -1

The report is collected in 17/01/23 from MCTL. The item type is T-shirt and color is Navy white and the buyer name is NEW WAVE. The line number is 17. From the report we can

see that total 765 garments is inspected and where 730 garments is good 30 defect item found and one item is rejected and the total DHU % is 4.31.

### 3.2.2 End Table inspection Report-2

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

832/833 Dewan Edris Road, Amtala, kathgara, Ashulia, Savar, Dhaka, Bangladesh.

Line: 16  
 Colour - PINK

**END TABLE INSPECTION REPORT GARMENTS** Date: 08-01-2023

Buyer: LAHAL Mo. No.: 172912 Item: Ladies Tan Top

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	133	142	206	202	201	256	254	251	257	259	2161	
Good	125	135	200	198	193	250	250	245	250	255	2099	
Defect	06	06	04	03	05	06	03	04	06	04	44	2.08
Reject											01	
Defect Repair/Repair Pas												
Defect Name												
Open/Broken/Skip Sis.	11		1	1			1	1		1	04	0.32
Spading		11		11	1			11			07	0.32
Puckening												
Neck Shape												
Poor Tention												
Uneven			1	11	1	11	1		1	11	13	0.60
Rawedge		111	1	11	1							
Oil Mark									11		10	0.46
Dirty Mark	11		11	1	11	1					08	0.37
Damage												
Union/Over Sis.	11		1		11	1			1			
Wrong Trims											08	0.37
Label Join									11			
Siv- Uneven - OPEN		11	1		1	11			11	1	09	0.41
Size Mistake	11											
Bottom/Cup/AH Shape												
Print/Emb/Ship Univen												
Unclut Thread												
Others												
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline O.C Sign	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham	sum	
Pro. Sup. Sign	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham	sum	
O.C Sup. Sign	1st	Def. Qty.	2nd Highest			Def. Qty.		3rd Highest				Def. Qty.

Q.I. Q.C. Pro. Sup. Q.M. Approved By

Figure:3.2.2-End Table inspection Report-2

### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer	Color	Item	Line
08-01-23	LA-HAL	Pink	Ladies top	<b>16</b>

Hours	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
inspection	133	142	206	202	201	256	254	251	257	259	2161	
Good	125	135	200	196	193	250	250	245	256	255	2099	
Defect	6	05	04	03	05	06	03	04	05	04	45	2.08
reject												
Defect repair pas												
Defect Name												
Skip stitch	2		1	1			1	1		1	7	0.32
Broken stitch												
Shading		2		2	1			2			7	0.32
Puckering												
Poor tension												
Uneven stitch												
Raw edge		3	1	2	1	2	1		1	2	13	0.60
Oil mark												
Dirty mark	2		2	1	2		1		2		10	0.46
Opening up-down												
Over stitch	2		1		2	1		1	1		8	0.37
Open stitch		2	1		1	1			2		8	0.37
Needle cut												
Sleeve Pleat												
Wrong trim												
Label join												
Uncut thread												
Size mistake	2				1	2		2	1	1	9	0.41
Wrong trim												

**Table:3.2 Line Inspection report -2**

The report is collected in 08/01/23 from MCTL. The item type is ladies Top and color is pink and the buyer name is LA-HAL. The line number is 16. From the report we can see that total 2161 garments is inspected and where 2099 garments is good 45 defect item found and no item is rejected and the total DHU % is 2.08.

### 3.2.3 End Table inspection Report-3

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

832/833 Dewan Edris Road, Amtala, kathgara, Ashulia, Savar, Dhaka, Bangladesh.

Line: 14      **END TABLE INSPECTION REPORT GARMENTS**      Date: 18-01-2023

Buyer: Honoriten      Mo. No.: 2490-031-003-31      Item: T. shirt

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	766	795	2301	216	2051	200	204	205			1660	
Good	160	170	200	210	200	200	200	200			1600	2.68%
Defect	06	05	04	06	04	06	07	05			45	
Reject												
Defect Name												
Defect Name												
Open/Broken/Skip Sis.	11	1	11	11	11	1	11	1			15	0.91%
Shading												
Puckering												
Neck Shape												
Poor Tension											05	0.56%
Uneven	111		1		1		11	1				
Rawedge												
Oil Mark												
Dirty Mark												
Damage												
Union/Over Sts.												
Wrong Trims				111				11			07	0.44%
Label Join											05	0.31%
Siz. Uneven												
Size Mistake				11				11			05	0.56%
Bottom/Cup/AH Shape	1		11									
Print/Emb/Strip Uneven												
Uncut Thread												
Others												
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
Pro. Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
Q.C Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
1st	Def. Qty.	2nd Highest	3rd Highest	Def. Qty.								

Q.I.      Q.C.      Pro. Sup.      P.M.      Q.M.      Approved

**Figure:3.2.3 End Table inspection Report-3**

### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer	Color	Item	Line
------	-------	-------	------	------

18-01-23	HANGTENG	Grey	T-shirt	<b>14</b>
----------	----------	------	---------	-----------

Hours	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
inspection	166	195	204	216	204	206	207	205			1603	
Good	160	190	200	210	200	200	200	200			200	2.68%
Defect	06	05	04	06	04	06	07	05			43	
reject												
Defect repair pas												
Defect Name												
Skip stitch	2	1	2	2	2	1	2	1			13	0.81
Broken stitch												
Shading												
Puckering												
Poor tension												
Uneven stitch	3		1		1	1	2	1			9	0.56
Uneven sleeve		1	1		1	2					05	0.31
Raw edge												
Oil mark												
Dirty mark												
Opening up-down												
Over stitch												
Open stitch												
Needle cut												
Sleeve Pleat												
Wrong trim												
Label join		1		3			2	1			7	0.44
Uncut thread												
Size mistake												
Wrong trim												
Bottom join stich		2		2		2	1	2			9	0.56

**Table:3.3 Line Inspection report -3**

The report is collected in 18/01/23 from MCTL. The item type is T-shirt and color is grey and the buyer name is HANGTENG. The line number is 14. From the report we can see that total 2161 garments is inspected and where 2099 garments is good 45 defect item found and no item is rejected and the total DHU % is 2.68.

### **3.2.4 End Table inspection Report-4**

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

832/833 Dewan Edris Road, Amtala, Kathgara, Ashulia, Savar, Dhaka, Bangladesh.

Line : 01 ..... **END TABLE INSPECTION REPORT GARMENTS** Date 21.01.23

Buyer	Mo. No. : C510183										Item : POLE SHIRT	
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	120	160	120	160	170	170	170	160			1290	
Good	111	152	100	157	160	160	167	158			1216	
Defect	8	8	10	3	10	10	3	2			67	4.87
Reject											6	0.46
Defect/Repair/Repair Pass												
Defect Name												
Open/Broken/Skip Sta. (HEM)											19	1.47
Shading												
Puckering												
Neck Shape												
Poor Tension												
Uneven (BACK T HEM)											19	1.47
Rawedge											7	0.54
Oil Mark												
Dirty Mark												
Damage (OPEN SEAM)											6	0.46
Unions/Over Sta.												
Wrong Trims (DOWN STP)											6	0.46
Label Join												
Slv. Uneven												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Embr/Strip Uneven												
Uncut Thread												
Others											16	1.16
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
In-line Q.C Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
Pro. Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
Q.C Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
1st	Def. Qty.		2nd Highest		Def. Qty.		3rd Highest		Def. Qty.			

Q.I. *[Signature]* Q.C. *[Signature]* Pro. Sup. *[Signature]* P.M. *[Signature]* Q.M. *[Signature]* Approved By

Figure:3.2.4 End Table inspection Report-4.



### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer	Color	Item	Line
21-01-23	NEW WAVE	Black	POLO-shirt	<b>01</b>

Hours	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
Inspection	120	160	170	165	170	170	175	160			1290	
Good	111	152	160	157	160	160	167	150			1216	
Defect	8	08	10	07	08	10	08	09			69	4.57
reject	01			01	02			01			05	0.38
Defect repair pas												
Defect Name												
Skip stitch(Hem)	2	3	2	1	3	3	2	3			19	1.47
Broken stitch												
Shading												
Puckering												
Poor tension												
Uneven stitch												
Uneven back tape	3	2	3	2	2	3	2	2			19	1.47
Raw edge (HEM)	1		2	1							04	0.31
Oil mark												
Dirty mark												
Opening up-down												
Over stitch												
Open stitch /seam		1		1		1	2	1			06	0.46
Needle cut												
Sleeve Pleat												
Wrong trim												
Label join												
Uncut thread												
Size mistake												
Wrong trims down stitch			2		1	1		2			06	0.46
others	2	2	1	3	2	2	2	1			15	1.16

Table:3.4 Line Inspection report -4

The report is collected in 21/01/23 from MCTL. The item type is POLO-shirt and color is black and the buyer name is NEW WAVE. The line number is 1. From the report we can see that total 1290 garments is inspected and where 1216 garments is good 69 defect item found and 05 item is rejected and the total DHU % is 4.57

### 3.2.5 End Table inspection Report 5

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

Line : 16  
 colour: Fuchsia  
 832/833 Dewan Edris Road, Amtala, kathgara, Ashulia, Savar, Dhaka, Bangladesh  
**END TABLE INSPECTION REPORT GARMENTS**  
 Date: 10-01-2023

Buyer	Mo. No. : 172970										Item	
LA-HAL											Ladig Top	
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	54	85	105	125	146	165	124	146			250	
Good	50	80	100	120	140	160	120	140			210	
Defect	3	4	4	5	5	4	3	4			32	3.36
Reject											03	0.31
Defect Repair/Repair Pas												
Defect Name												
Open/Broken/Skip Sis.												
Shading											5	0.52
Puckering												
Neck-Shape Broken SIS												
Poor Tention												
Uneven											8	0.84
Rawedge												
Wrink											5	0.52
Wavy Mark												
Damage											8	0.84
Union/Over Sts.												
Wrong Trims											7	0.73
Label Join												
Siv. Uneven												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Emb/Strip Univen												
Uncut Thread											4	0.42
Others open SIS												
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	250	
Pro. Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	210	
Q.C Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	32	3.36
1st	Def. Qty.		2nd Highest		Def. Qty.		3rd Highest		Def. Qty.			

Q.I. *[Signature]* Q.C. *[Signature]* Pro. Sup. *[Signature]* *[Signature]* *[Signature]* Q.M. *[Signature]* Approved By

Figure:3.2.5 End Table inspection Report-5

### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer		Color			Item			Line			
10-01-23	LA-HAL		Fuchsia			Ladies Top			16			
Hours	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
Inspection	54	85	105	125	146	165	124	146			950	
Good	50	80	100	120	140	160	120	140			910	
Defect	3	04	4	05	05	04	03	4			32	3.36
reject		1						01			2	0.31
Defect repair pas												
Defect Name												
Skip stitch(Hem)			1	1		1	1	1			05	0.52
Broken stitch												
Shading												
Puckering												
Poor tension												
Uneven stitch	1	1	1	1	2	1		1			08	0.84
Uneven back tape												
Raw edge (HEM)												
Oil mark	1		1		1		1	1			05	0.52
Dirty mark												
Opening up-down												
Over stitch	1	1	1	1	1	1	1	1			08	0.84
Open stitch/seam		1	1	1	1						04	0.72
Needle cut												
Sleeve Pleat												
Wrong trim												
Label join	1	1		1	1	1	1	1			07	0.73
Uncut thread												
Size mistake												
Wrong trims down stitch												
others												

Table:3.5 Line Inspection report -5

The report is collected in 10/01/23 from MCTL. The item type is Ladies Top and color is Fuchsia and the buyer name is LA-HAL. The line number is 16. From the report we can see that total 950 garment is inspected and where 910 garments is good 32 defect item found and 02 item is rejected and the total DHU is 3.36%.

### 3.2.6 End Table inspection Report-6

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

832/833 Dewan Edris Road, Amtala, kathgara, Ashulia, Savar, Dhaka, Bangladesh.

Line : 16  
 Colour: Fuchsia  
 END TABLE INSPECTION REPORT GARMENTS  
 Date: 11-01-2023

Buyer: LA-11AL Mo. No.: 172370 Item: Ladies Top

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	63	74	95	125	146	176	203	223	208	176	1500	
Good	60	70	90	120	140	170	200	220	200	170	1470	
Defect	3	3	4	5	5	5	7	7	6	5	51	3.40
Reject											51	3.40
Defect Repair/Repair Pas											02	0.13
Defect Name												
Open/Broken/Skip/Sis	1	1									10	0.67
Shading												
Puckering												
Neck Shape Broken SK												
Poor Tention												
Uneven				1	1	1	1	1	1	1	13	0.87
Rawedge												
Dirty Mark											7	0.47
Damage												
Union/Over Sts.	1	1	1	1	1			1	1	1	11	0.73
Wrong Trims												
Label Join	1	1	1	1	1	1	1	1	1	1	15	1.0
Slv. Uneven												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Emb/Strip Uneven												
Uncut Thread											2	0.13
Others open sis												
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	1500	
Pro. Sup. Sign	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	1470	
Q.C Sup. Sign	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	Hom	51	
1st	Def. Qty.		2nd Highest			Def. Qty.		3rd Highest				Def. Qty.

Q.I. *mscl* Q.C. *Hom* Pro. Sup. *Hom* P.M. *Hom* Q.M. *Hom* Approved By *Hom*

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Figure:3.2.6 End Table inspection Report-6.

### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer		Color			Item			Line			
11-01-23	LA-HAL		Fuchsia			Ladies Top			01			
HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
Inspection	63	74	95	125	146	176	208	229	208	176	1500	
Good	60	70	90	120	140	170	200	220	200	170	1440	
Defect	03	3	4	5	5	6	7	7	6	5	51	3.40
reject							1	1			2	.13
Defect repair pas												
Defect Name												
Skip stitch (Hem)	1	1	1		1	2	1	1	1	1	10	0.67
Broken stitch												
Shading												
Puckering												
Poor tension												
Uneven stitch			1	2	1	2	3	2	1	1	13	0.87
Uneven back tape												
Raw edge (HEM)												
Oil mark		1	1		1			1	2	1	7	0.47
Dirty mark												
Opening up-down												
Over stitch	1	1	1	1	1		1	2	2	1	11	.73
Open stitch /seam				1	1						2	.13
Needle cut												
Sleeve Pleat												
Wrong trim												
Label join	1	1	1	1	1	2	2	2	2	2	15	1.0
Uncut thread												
Size mistake												
Wrong trims down stitch												
others												

Table:3.6 Line Inspection report -6

The report is collected in 11/01/23 from MCTL. The item type is Ladies top and color is Fuchsia and the buyer name is LA-HAL. The line number is 1. From the report we can see that total 1500 garments is inspected and where 1440 garment is good 51 defect item found and 02 item is rejected and the total DHU is 3.40%.

### 3.2.7 End Table inspection Report-7

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from MCTL:

16  
 e: .....  
 Colours: 12-13-10  
 0327033 Dewan Edris Road, Amtala, kathgara, Ashulia, Savar, Dhaka, Bangladesh

**END TABLE INSPECTION REPORT GARMENTS**

Buyer: LAHAL Mo. No.: 172958 Date: 12-01-2023 Item: Ladies Top

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Good	83	125	137	124	85	127	110	124			935	
Defect	80	120	150	120	80	120	105	120			895	
Reject	3	5	5	4	5	6	5	4			37	3.95
Defect Repair/Repair Pas			11								03	0.32
Defect Name											03	0.32
Open/Broken/Skip Sis.												
Shading						111					6	0.64
Puckering												
Neck Shape Broken SIS						11					4	0.42
Poor Tention												
Uneven											4	0.42
Rawedge												
Oil Mark												
Dirty Mark												
Damage												
Union/Over Sts.											5	0.53
Wrong Trims											11	1.17
Label Join												
Slv. Uneven												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Emb/Strip Univen												
Uncut Thread												
Where open SIS											7	0.74
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham			935	
Pro. Sup. Sign	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham			895	
Q.C Sup. Sign	Ham	Ham	Ham	Ham	Ham	Ham	Ham	Ham			37	3.95
	1st	Def. Qty.	2nd Highest			Def. Qty.	3rd Highest					

Q.I. Q.C. Pro. Sup. P.M. Q.M. Approved By

Figure:3.2.7 End Table inspection Report-7



### END LINE TABLE INSPECTION REPORT OF MCTL

Date	buyer		Color			Item			Line			
12-01-23	LA-HAL		12.13.10			Ladies Top			16			
HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total	DHU %
Inspection	83	125	157	124	85	127	110	124			935	
Good	80	120	150	120	80	120	105	120			895	
Defect	3	5	5	4	5	6	5	4			37	3.95
reject			2			1					2	.32
Defect repair pas												
Defect Name												
Skip stitch (Hem)	1			1		3	1				6	.64
Broken stitch												
Shading												
Puckering			1		1	2					4	.42
Poor tension												
Uneven stitch	1	1					1	1			4	.42
Uneven back tape												
Raw edge (HEM)												
Oil mark												
Dirty mark												
Opening up-down												
Over stitch		1	1		1		1	1			5	.53
Open stitch/seam		2	1	1	1		1	1			7	.74
Needle cut												
Sleeve Pleat												
Wrong trim												
Label join	1	1	2	2	2	1	1	1			11	1.17
Uncut thread												
Size mistake												
Wrong trims down stitch												
others												

Table:3.7 Line Inspection report -7

The report is collected in 12/01/23 from MCTL. The item type is Ladies top and color is 12.13.10 and the buyer name is LA-HAL. The line number is 1. From the report we can see that total 935 garment is inspected and where 895 garment is good 37 defect item found and 02 item is rejected and the total DHU is 4.17%.

### 3.3 Sewing Garments Inspection Report of MCTL (7 days)

Date	Check pcs	Skip Stitch	shading	Uneven stitch	Uneven Back tape	Raw edge (HEM)	Dirty Mark	Oil Stain	Opening up down	Over Stitch	Needle Cut	Sleeve pleat	Label join	Size mistake	Wong- Trim	other	puckering	Open stitch	Total
08/01/23	2161	7	7	0	0	13	10	8		8				9					62
10/01/23	950	5		8				5		8			7					7	40
11/01/23	1500	10		13				7		11			15					2	58
12/01/23	935	6								5			11				4	7	33
17/1/23	765	6	1	3				3	6		4	4	1					6	34
18	1603	13		9									7			15			44
21	1290	19			19	4								6	15			6	69
<b>Total</b>	9204	66	8	33	19	17	10	23	6	32	4	4	41	9	6	30	4	28	340
		19.41%	2.35%	9.70%	5.59%	5%	2.94%	6.76%	1.76%	9.41%	1.17%	1.17%	12.05%	2.64%	1.74%	8.82%	1.18%	8.24%	

**Table: 3.8 Sewing Garments Inspection Report of MCTL (7 days)**

This the summary of 7day garments inspection report which is collected from MCTL. From the report we can see the total number of inspected garments and total defect in garment also the rejected garments quantity. we can see the most occurring fault is skip stitch in MCTL which is 19.41% and second is uneven stitch and the last is puckering which is 1.18 % and DHU=3.69%.

### 3.4 End line table Inspection Report of SNOWTEX Outwear Ltd.

#### 3.4.1 End Table inspection Report-1

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from SNOWTEX Outwear Ltd:

SNOWTEX			"Connecting All By Quality & It's Our Passion"				QUALITY INSPECTION SHEET (JACKET)											
Code	Position	Operator ID	Tally	TTL	Code	Defects Name	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	TTL	
a	Pocket Bag H				1	Broken Stitch												
b	Pocket Bag C				2	Pleat												
c	Pocket Flap H				3	Open Seam		a	bas	✓	✓							
d	H pocket Zipper				4	Skip Stitch			w									
e	Pocket Flap C				5	Flackering												
f	Pocket H				6	Down Stitch												
g	Pocket C				7	Uneven/High-low												
h	C/F Placket T/S				8	Raw Edge												
i	Side Panel Joint				9	Uncut Thread												
j	C/F Zipper Joint				10	Slanted												
k	C/F Zipper T/S				11	Missing Operation												
l	C/F Placket Joint				12	Needle Mark												
m	Velcro 1				13	Tension problem												
n	Velcro 2				14	Twisting/Bias												
o	Front Panel				15	Oil/Stain/Dirty Mark												
p	Back Yoke				16	Shiny/Poor Pressing												
q	Log/Half moon				17	Reject												
r	Arm Hole				18	Wrong SPI												
s	Armhole T/S				19	Poor Joint												
t	Sleeve Shall				20	Waviness												
u	Sleeve Lining				21	Print/Emb. Damage												
v	Side seam				22	Fabric Damage												
w	Cuff rolling				23	Incomplete Tack												
x	Collar Joint				24	Poor Puffiness												
y	Collar Band & T/S				25	Color Shading												
z	Hem Facing Joint				26	Size Mistake												
aa	Hem Rolling				27	Burn Mark												
ab	Care/ Buyer Lbl				28	Peel off												
ac	Level 2				29	Measurement Problem												
ad	Bartack 1				30	Displace												
ae	Bartack 2				31	Asymmetric												
af	Shall & Lining Joint 1				32	Others												
ag	Shall & Lining Joint 2				9.1	Uncut Thread												
ah	Shall & Lining Joint 3				2.1	Pleat												
ai	Hood Joint				8.1	Raw-edges												
aj	Hood Rolling		sorital		33	Tape Broken												
ak	Piping 1				34	Air Bubble												
al	Piping 2				35	Tape Crack/Burn												
am	Far Joint & T/S				7.1	Uneven												
an	Quilting 1				36	Double Tapping												
ao	Quilting 2				37	Coated out												
ap	Insulation/ Down				38	Tape Folded												
aq	Snap/ Button 1				38	OvershortTape												
ar	Snap/ Button 2				28	Peel off												
as	Seam Tape 1				11.1	Missing tape												
at	Seam Tape 2				Defects Qty	2	4	5	5	3								
au	Seam Tape 3				Defective GMTs	1	1	1	1	1								
av	Heat Seal & Logo				Inspected Qty	30	30	34	44	43	43							
aw	Bonding 1				Passed Qty	30	30	40	40	40								
ax	Bonding 2				D.H.U													
Total					Defect rate (D.R)													
Defect Repair Status					Defective Garments Handover Quantity													
					Repair Garments Back Quantity													
					Balance Quantity	0	0	0	0	0								

Figure: 3.4.1 End Table inspection Report-1.

## END LINE TABLE INSPECTION REPORT OF SNOWTEX Outwear Ltd.

Date	buyer	Color	Item	Line
08/01/23	BERNE	YELLOW	JACKET	2d 06

HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total
Inspection	32	34	44	43	43						196
Good	30	30	40	40	40						180
defect	2	4	5	5	3						19
Defect Name											
pleat			1								1
skip stitch			1								1
Open seam	1	1	1	1	1						5
Uneven high-low				1	1						2
Raw edge			1	1							2
Oil mark	1										1
Uncut thread		2	1	1							4
Missing operation											
Embroidery damage											
Open stitch /seam											
Needle cut											
Sleeve Pleat											
Label join											
Uncut thread											
Size mistake											
Wrong trims down stitch											
Others											
Total defect number=16											

Table: 3.9 End table inspection report of SOL-1

The report is collected in 08/01/23 from SOL. The item type is jacket and color is yellow and the buyer name is BERNE. The line number is 2D06. From the report we can see that total 196 garment is inspected and where 180 garments good 19 defect item found and no item is rejected. Which DHU=8.16%

### 3.4.1 End Table inspection Report-2

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from SNOWTEX Outwear Ltd:

SNOWTEX		"Connecting All By Quality & It's Our Passion"										QUALITY INSPECTION SHEET (PANT)				
Code	Position	Operator ID	Tally	TTL	Defects Name	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	TTL
a	Side Pocket Jnt				1 Broken Stitch	0			0							
b	Side Pocket TRS				2 Plett											
c	Fashin Jnt				3 Open Seam	1			1							
d	Pocket Tag				4 Side Stitch											
e	Fly Jnt				5 Puckering											
f	Front Rise O/L				6 Down Stitch											
g	Fly TRS				7 Unsewn/Incl shape	1			1							
h	Zipper Jnt				8 Raw Edge											
i	Fly zipper Jnt				9 Uncut Thread											
j	Fly Mark				10 Stained											
k	Front Rise Jnt				11 Missing Operation											
l	Side Pocket Jnt				12 Needle Mark											
m	Side Pocket TRS				13 Tension problem											
n	Back Rise Jnt				14 Trimming/Seam											
o	Pocket Bag Jnt				15 Oil/Stone/Dirt/Mark											
p	Side Seam				16 Shiny/Poor Pressing											
q	In Seam				17 Reject											
r	Loop Make				18 Wrong SPI											
s	Loop Attach				19 Poor Jnt											
t	Main Label Jnt				20 Wavy/ness											
u	Belt Make				21 Poor Emb. Damage											
v	Belt Jnt				22 Fabric Damage											
w	Belt TRS				23 Incomplete Tack											
x	Loop Tag				24 Poor Puffness											
y	Hem				25 Color Shading											
z	Button Hole				26 Size Mistake											
aa	Button Stitch				27 Burn Mark											
ab	Loop BarTag				28 Peel off											
ac	Cargo Pocket				29 Measurement Problem											
ad	Cargo Pocket Flap				30 Displace											
ae	Waist				31 Asymmetric											
af	Backack				32 Others											
ag					33 Uncut Thread											
ah					34 Plett											
ai					35 Raw-edge											
aj					36 Tape Broken											
ak					37 Air Bubble											
al					38 Tape Crack/Burn											
am					39 Uneven											
an					40 Double Tipping											
ao					41 Coated out											
ap					42 Tape Folded											
aq					43 Overstitch/Tape											
ar					44 Peel off											
as					45 Missing tape											
at					46 Defective Qty	06	04	09	08	08						
au					47 Defective GMTs	11	11	11	11	11						
av					48 Inspected Qty	25	14	25	25	25						
aw					49 Passed Qty	20	20	25	25	25						
ax					50 D.H.U											
					51 Defect rate (D.R)											
					52 Defective Garments Handover Quantity	11	11	11	11	11						
					53 Repair Garments Back Quantity	11	11	11	11	11						
					54 Balance Quantity	14	6	14	14	14						

Figure:3.4.2 End Table inspection Report-2

## END LINE TABLE INSPECTION REPORT OF SOL

**Table: 3.10 End table inspection report of SOL-2**

Date	buyer	Color	Item	Line
17/01/23	Kontoor	black	pants	2d 09

HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total
Inspection	25	14	31	32	41						143
Good	20	10	25	25	35						105
Defect GMTs	6	4	7	8	8						33
Defect Name											
pleat											
skip stitch			1								1
Open seam	2	2	3	3	6	3					19
Uneven high-low	3	1	3	3	2						12
Raw edge											
Oil mark											
Uncut thread											
Missing operation		1		3							4
Embroidery damage											
Open stitch/seam											
Needle cut											
Sleeve Pleat											
Broken stitch	1		1	1		1					4
Label join											
Uncut thread											
Size mistake											
Wrong trims down stitch											
others											
Total defect number=40											

The report is collected in 17/01/23 from SOL. The item type is Pants and color is BLACK and the buyer name is Kontoor. The line number is 2D09. From the report we can see that total 143 garment is inspected and where 105 garments good 33 defect item found and no item is rejected. Which DHU=27.97%

### 3.4.3 End Table inspection Report-3

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from SNOWTEX Outwear Ltd:

SNOWTEX		"Connecting All By Quality & It's Our Passion"										QUALITY INSPECTION SHEET (PANT)				DQEL-QA-009-CHK-V04 21-10-2020	
Code	Position	Operator	Tally	TTL	Code	Defects Name	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	TTL
a	Side Pocket Jnt				1	Broken Stitch											
b	Side pocket T/S				2	Plant			ai		ai		ai	ai	ai	ai	
c	Fashion Jnt				3	Clear Seam			ak			ai	ai	ai	ai	ai	
d	Pocket Tag				4	Slip Stitch											
e	Fly Jnt				5	Puckering											
f	Front Rise O/L				6	Down Stitch											
g	Fly T/S				7	Uneven/High/Low/Slap	ai	ai	ai	ai	ai	ai	ai	ai	ai	ai	
h	Zipper Jnt				8	Raw Edge	ai	ai	ai	ai	ai	ai	ai	ai	ai	ai	
i	Fly zipper Jnt				9	Unsat Thread	ai	ai	ai	ai	ai	ai	ai	ai	ai	ai	
j	Fly Mark				10	Blanket											
k	Front Rise Jnt				11	Missing Operation											
l	Rise Pocket Jnt				12	Needle Mark											
m	Rise Pocket T/S				13	Tension problem											
n	Back Rise Jnt				14	Turning Bias											
o	Pocket Bag Jnt				15	Over/Under Dry Mark											
p	Side Seam				16	Shiny/Poor Pressing											
q	In Seam				17	Reject											
r	Loop Make				18	Wrong SPI											
s	Loop Alter				19	Poor Joint											
t	Main Label Jnt				20	Wavy/ness											
u	Beel Make				21	Print/Emb. Damage											
v	Beel Jnt				22	Fabric Damage											
w	Beel T/S				23	Incomplete Tack											
x	Loop Tag				24	Poor Fullness											
y	Hem				25	Color Shading											
z	Button Hole				26	Size Mistake											
aa	Button Stitch				27	Stain Mark											
ab	Loop Backlap				28	Peel off											
ac	Cargo Pocket				29	Measurement Problem											
ad	Cargo Pocket Flap				30	Displace											
ae	Waist				31	Asymmetric											
af	Backstitch				32	Others											
ag	Waist - साहित्य - सविन				9.1	Unsat Thread											
ah	Waist - साहित्य - सविन				2.1	Plant											
ai	Waist - साहित्य - सविन				8.1	Raw-edge											
aj	Waist - साहित्य - सविन				33	Tape Broken											
ak	Waist - साहित्य - सविन				34	Air Bubble											
al	Waist - साहित्य - सविन				35	Tape Crack/turn											
am	Waist - साहित्य - सविन				7.1	Uneven											
an	Waist - साहित्य - सविन				36	Double Tapping											
ao	Waist - साहित्य - सविन				37	Coated out											
ap					38	Tape Folded											
aq					39	Over/short/Tape											
ar					28	Peel off											
as					11.1	Missing tape											
at					Defects Qty	44	44	44	44	44	44	44	44	44	44	44	
au					Defective GM/Ts	6	5	7	6	5	6	6	6	6	5	5	
av					Inspected Qty	40	30	40	30	24	25	30	50	44	50	44	55
aw					Passed Qty	34	25	33	24	25	25	44	44	44	44	44	
ax					D.H.U												
ay					Defect rate (D.R)												
az					Defective Garments Handover Quantity	44	44	44	44	44	44	44	44	44	44	44	
ba					Repair Garments Back Quantity	44	44	44	44	44	44	44	44	44	44	44	
bb					Balance Quantity	0	0	0	0	0	0	0	0	0	0	0	

Figure:3.4.3 End Table inspection Report-3



## END LINE TABLE INSPECTION REPORT OF SOL

Table: 3.10 End table inspection report of SOL-3

Date	buyer			Color			Item			Line	
17/01/23	kontoor			black			pants			2d11	
HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total
Inspection	40	30	40	30	30	50	50	60			330
good	34	25	33	24	25	44	44	55			284
Defect GMTs	6	5	7	6	5	6	6	5			46
Defect Name											
pleat			2				2				4
skip stitch											
Open seam			3			2	2	5			12
Uneven high-low	4	3	2	4							13
Raw edge	2	2									4
Oil mark											
Uncut thread											
Missing operation											
Embroidery damage											
Needle cut											
Sleeve Pleat											
Broken stitch											
Label join											
Uncut thread											
Size mistake											
Wrong trims down stitch											
others											
Total defect number=33											

The report is collected in 17/01/23 from SOL. The item type is pants and color is black and the buyer name is kontoor. The line number is 2D 11. From the report we can see that total 330 garment is inspected and where 284 garments good 46 defect item found. Which

DHU=10%

### 3.4.4 End Table inspection Report-4

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from SNOWTEX Outwear Ltd:

SNOWTEX		"Connecting All By Quality & It's Our Passion"		QUALITY INSPECTION SHEET (PANT)													
Code	Position	Operator ID	Tally	TTL	Code	Defects Name	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	TTL
a	Side Pocket Jnt				1	Broken Stitch											
b	Side pocket T/S				2	Pleat											
c	Fashin Jnt				3	Open Seam											
d	Pocket Tag				4	Skip Stitch											
e	Fly Jnt				5	Puckering											
f	Front Rise O/L				6	Down Stitch											
g	Fly T/S				7	Uneven/High-Low Shape											
h	Zipper Jnt	M			8	Raw Edge											
i	Zipper T/S	M			9	Uncut Thread											
j	Fly Mark				10	Skirted											
k	Front Rise Jnt				11	Mixing Operation											
l	Bon Pocket Jnt				12	Needle Mark											
m	Bon Pocket T/S				13	Tension problem											
n	Back Rise Jnt				14	Twisting/Bias											
o	Pocket Bag Jnt				15	Oil/Stain/Dirty Mark											
p	Side Seam	SS	M		16	Shiny/Poor Pressing											
q	In Seam	SS	M		17	Reject											
r	Loop Make				18	Wrong SPI											
s	Loop Attest				19	Poor Joint											
t	Main Lable Jnt				20	Wayness											
u	Belt Make				21	Print/Emb. Damage											
v	Belt Jnt				22	Fabric Damage											
w	Belt T/S				23	Incomplete Tack											
x	Loop Tag				24	Poor Puffiness											
y	Hem		M		25	Color Shading											
z	Button Hole				26	Size Mistake											
aa	Button Stitch				27	Burn Mark											
ab	Loop BarTag				28	Peel off											
ac	Curgo Pocket				29	Measurement Problem											
ad	Curgo Pocket Flap				30	Displace											
ae	Waist				31	Asymmetric											
af	Barback				32	Others											
ag					32.1	Uncut Thread											
ah					32.2	Pleat											
ai					32.3	Raw-edge											
aj					33	Tape Broken											
ak					34	Air Bubble											
al					35	Tape Crack/Burn											
am					7.1	Uneven											
an					36	Double Tapping											
ao					37	Coated out											
ap					38	Tape Folded											
aq					39	Overstitch/Tape											
ar					28	Peel off											
as					11.1	Missing tape											
at					Defects Qty		10	10	10	10	10	0	11	10	11	10	10
au					Defective GMFs		10	08	10	10	08	0	09	08	09	08	08
av					Inspected Qty		60	58	60	60	58	53	51	52	51	50	50
aw					Passed Qty		50	50	50	50	60	53	51	52	51	50	50
ax					D.H.U												
					Defect rate (D/R)		10	10	10	10	06	07	09	08	09	10	10
					Defective Garments Handover Quantity		10	08	10	10	08	0	09	08	09	08	08
					Repair Garments Back Quantity		0	0	0	0	0	0	0	0	0	0	0
					Balance Quantity		0	0	0	0	0	0	0	0	0	0	0

Figure:3.4.4 End Table inspection Report-4

## END LINE TABLE INSPECTION REPORT OF SOL

**Table:3.11 End table inspection report of SOL-4**

Date	buyer		Color				Item				Line
18/01/23	kontoor		black				Pants				2d04
HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total
Inspection	60	58	60	60	58	60	60	60	60	60	596
Good	50	50	50	50	50	53	51	52	51	50	507
Defect	10	8	10	10	8	7	9	8	9	10	89
Defect Name											
pleat				2	2	1	1				6
skip stitch											
Open seam	2	3	3	3		4	2	2	2	2	23
Uneven high-low	3	3	3	2	2						13
Raw edge											
Oil mark											
Uncut thread											
Missing operation							2	2	2	2	8
Embroidery damage											
Sleeve Pleat											
Broken stitch											
Label join											
Uncut thread								2		2	4
Size mistake											
down stitch	2		4	3	3	4	1	3	2	2	24
Total defect number=72											

The report is collected in 18/01/23 from SOL. The item type is pants and color is black and the buyer name is kontoor. The line number is 2D04. From the report we can see that total 596 garment is inspected and where 507 garments good 89 defect item found. Which

DHU=12.02%

### 3.4.6 End Table inspection Report-5

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from SNOWTEX Outwear Ltd:

SNOWTEX				QUALITY INSPECTION SHEET (JACKET)													
"Connecting All By Quality & It's Our Passion"				09-09-2020													
Code	Position	Operator ID	Tally	TTL	Code	Defects Name	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	TTL
a	Pocket Bag H				1	Broken Stitch											
b	Pocket Bag C				2	Pinat											
c	Pocket Flap H				3	Open Seam											
d	H pocket Zipper				4	Skip Stitch											
e	Pocket Flap C				5	Puckering											
f	Pocket H				6	Down Stitch											
g	Pocket C				7	Unsewn/Highlow											
h	C/F Pocket T/S				8	Raw Edge											
i	Side Panel joint				9	Uncut Thread											
j	C/F Zipper Joint				10	Slanted											
k	C/F Zipper T/S				11	Missing Operation											
l	C/F Pocket Joint				12	Needle Mark											
m	Velcro 1				13	Tension problem											
n	Velcro 2				14	Typtag@Bul_Lap											
o	Front Yoke				15	Oil/Stain/Dirty Mark											
p	Back Yoke				16	Shiny/Floor Pressing											
q	Loop/Half moon				17	Reject											
r	Arm Hole				18	Wrong SPT											
s	Armhole T/S				19	Poor Joint											
t	Sleeve Shall				20	Wagyness /Rely											
u	Sleeve Lining				21	Print/Emb. Damage											
v	Side seam				22	Fabric Damage											
w	Cuff rollage				23	Incomplete tack											
x	Collar/Shoulder				24	Poor Puffiness											
y	Collar Band & T/S				25	Color Shading											
z	Hem Facing Joint				26	Size Mistake											
aa	Hem Rolling				27	Burn Mark											
ab	Care/ Buyer Lbl				28	Peel off											
ac	Level 2				29	Measurement Problem											
ad	Bartack 1				30	Displace											
ae	Bartack 2				31	Asymmetric											
af	Shal & Lining Joint 1				32	Others											
ag	Shal & Lining Joint 2				9.1	Uncut Thread											
ah	Shal & Lining Joint 3				2.1	Pinat											
ai	Hood Joint				8.1	Raw-edge											
aj	Hood Rolling				33	Tape Broken											
ak	Piping 1				34	Air Bubble											
al	Piping 2				35	Tape Crack/Burn											
am	Fur Joint & T/S				7.1	Uneven											
an	Quilting 1				36	Double Taping											
ao	Quilting 2				37	Control out											
ap	Insulation/ Down				38	Tape Folded											
aq	Snap/ Button 1				39	Over/short/Tape											
ar	Snap/ Button 2				28	Peel off											
as	Seam Tape 1				11.1	Missing tape											
at	Seam Tape 2					Defects Qty	9	14	12	20	13	5	14	14	14	8	
au	Seam Tape 3					Defective GMTs	11	14	14	11	11	11	11	11	11	11	
av	Heat Seal & Logo					Inspected Qty	15	14	14	13	11	11	11	11	11	11	
aw	Bonding 1					Pressed Qty	5	4	4	5	2	2	4	8	8	12	
ax	Bonding 2					D.H.U											
Total							Defect rate (D.R)										
Defect Repair Status							Defective Garments Handover Quantity	111	144	111	111	111	111	111	111	111	111
							Repair Garments Back Quantity	111	144	111	111	111	111	111	111	111	
							Balance Quantity	111	144	111	111	111	111	111	111	111	

Figure:3.4.5 End Table inspection Report-5

### END LINE TABLE INSPECTION REPORT OF SOL

we have collected some sewing end line report from Magpie composite textile ltd & SNOWTEX Outwear Ltd and this report is one of them which is collected from SOL

Date	buyer	Color	Item	Line
19/01/23	BERNE	GREY	Jacket	2D03

HOURS	1hr	2hr	3hr	4hr	5hr	6hr	7hr	8hr	9hr	10hr	total
Inspection	13	14	13	18	18	9	22	14	25	18	164
Good	3	4	5	2	2	2	10	8	15	12	63
Defective GMTs											
Defect Name											
pleat		1						2			3
skip stitch											
Open seam											
Uneven high-low	1		2				2		3	2	10
Raw edge	1	2	2	2	2				5	4	18
Oil mark											
Uncut thread											
Missing operation											
Embroidery damage											
Needle cut											
PUCKERING	2										2
Broken stitch											
Label join											
Uncut thread								2		2	4
Size mistake											
down stitch	6	2	2	2	2	1	4				19
Needle mark		8	4	2	2	2	4	3	2		27
Total defect number=63											

**Table: 3.12 End table inspection report of SOL-5**

The report is collected in 19/01/23 from SOL. The item type is jacket and color is grey and the buyer name is BERNE. The line number is 2d03. From the report we can see that total 164 garment is inspected and where 63 garments good.

And DHU= 50.67%

### 3.5 Sewing Garments Inspection Report of SOL (5 days)

Date	Check pcs	pleat	skip stitch	Open seam	Uneven high-low	Raw edge	Oil mark	Uncut thread	Missing operation	Embroidery damage	puckering	Broken stitch	Label join	Uncut thread	down stitch	Needle mark	Total
08/01/23	196	1	1	5	2	2	1	4		1							17
11/01/23	143			17	12				4			4					37
17/01/23	330	2		14	13	4											33
18/01/23	596	6		23	13			4	8			11			24		89
19/1/23	1463	3			10	18					2				19	27	79
<b>Total</b>	1411 pcs	12	1	59	50	24	1	8	12	1	2	15			43	27	255
		<b>4.70%</b>	<b>0.39%</b>	<b>23.14%</b>	<b>19.60%</b>	<b>9.41%</b>	<b>.39%</b>	<b>3.14%</b>	<b>4.70%</b>	<b>0.39%</b>	<b>0.78%</b>	<b>5.89%</b>			<b>16.86%</b>	<b>10.59%</b>	

**Table: 3.13 Sewing Garments Inspection Report of SOL (5 days).**

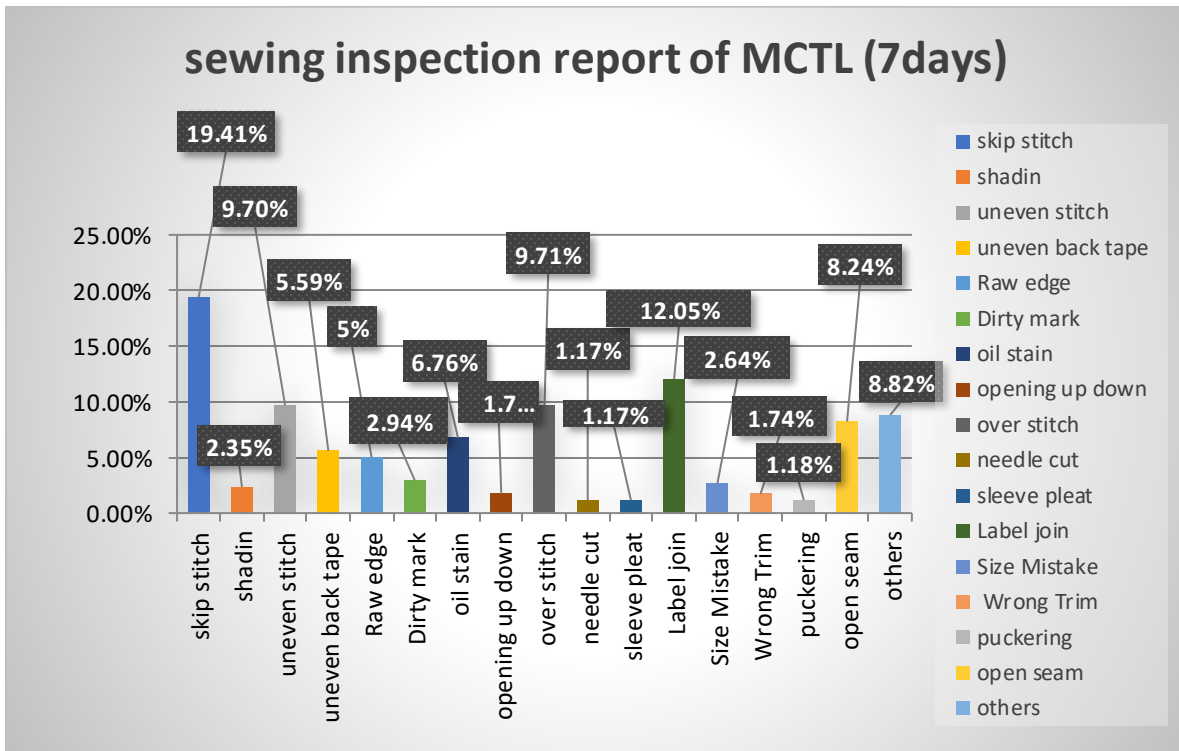
DHU=18.07%

This is the summary of SOL 5day Garments Inspection Report. From the report we can see that total garments inspection quantity of each day and total fault amount in percentage. Here the most occurring faults is open seam which is 23.24% and second is uneven high low 19.60 % and the minimum amount is skip stitch in SOL which is 0.39%.

## CHAPTER 4

### 4.0 RESULT AND DISCUSSION

#### 4.1 Sewing End Line Inspection Report of MCTL (Summary)



**Figure:4.1** sewing inspection report of MCTL (7days)

This is the summary of End Line Inspection Report which we have collected from Magpie Composite Textile Limited. We have collected 7 days reports from different Line and Different Buyers Products. And the Result is visible in the pie chart, which are 21% skip stitch, 11% Uneven Stitch, 11% puckering, 9% open seam, Label Join 13%, 2% shading, 2% Needle cut, 2% wrong trim, 7% sleeve Pleat, 3% Raw edge, 2% Uneven Back Tape, 7% sleeve Pleat, 3% Dirty Mark and 5% others.

So, most occurring Fault in Magpie composite Textile ltd is skip stitch uneven stitch and Label Join.

## 4.2 Sewing End Line Inspection Report of SOL(Summary)

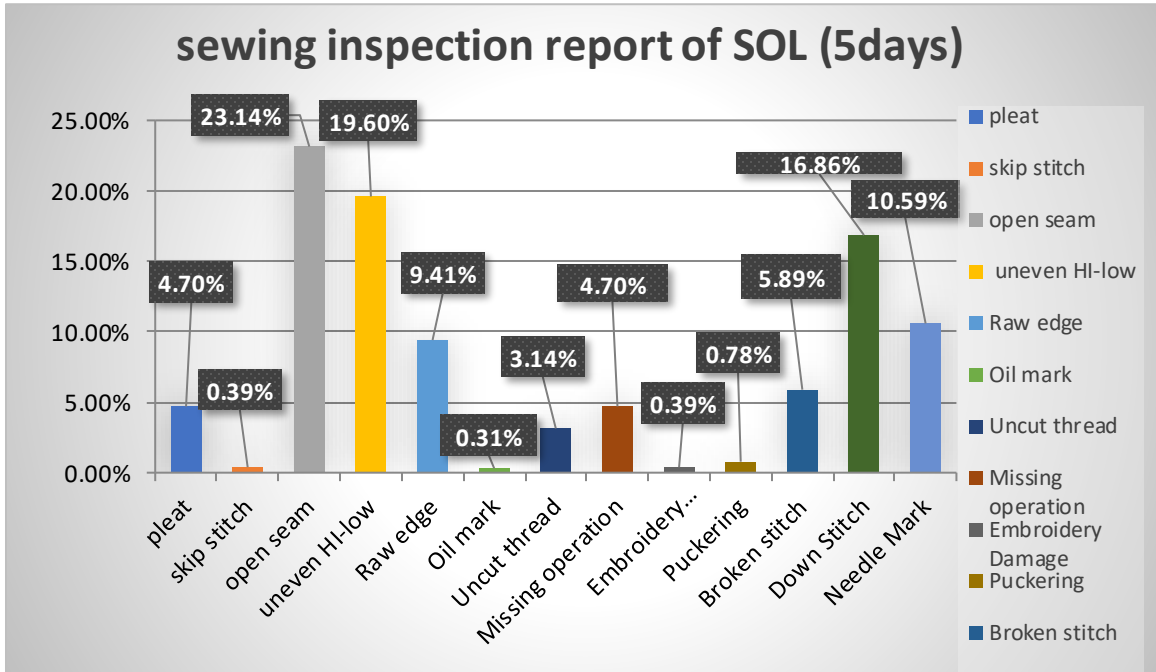


Figure: 4.2 sewing inspection report of SOL (5days)

This the Summary of End Line Inspection report which is collected by us from SNOWTEX outwear ltd. We have collected 5 days report from different production line. And the result is visible in the pie chart. Where 23% Open Seam, 16.86% Down Stitch, 20% uneven HI Low, 10.59% Needle Mark, 5.89% broken Stitch, 4.70% Missing Operation, 0.39% Skip Stitch, 4.70% pleat. From the report we can see that the highest amount of fault is Open Seam which is 23.14% and the Lowest occurring fault is skip stitch in SNOWTEX outwear ltd.



### 4.3 Comparison of Sewing Defects Percentage between 2 factories:

SL	Defects	Magpie composite Textile Ltd.	Snowtex Outwear Ltd.
1	Skip stitch	19.41%	0.39%
2	Uneven stitch	9.70%	0%
3	Raw-edge	5%	9.41%
4	Dirty Mark	2.94%	0%
5	Oil Stain	6.76%	0.39%
6	Over stitch	9.41%	0%
7	Pleat	1.17%	4.70%
8	Label Join	12.05%	0%
9	Puckering	1.18%	0.78%
10	Open Seam	8.24%	23.14%
11	Down Stitch	0%	16.86%
12	Size mistake	2.64%	0%
13	Uncut thread	0%	3.14%
14	Missing operation	0%	4.70%
15	Uneven hi-low	0%	19.6%
16	Needle mark	0%	10.59%
17	Broken stitch	0%	5.89%

**Table: 4.1 Comparison of Sewing Defects Percentage between 2 factories**

This is the comparison Table of sewing Defects in percentage between 2 factories those factories are Magpie composite textile Ltd (MCTL) and Snowtex Outwear Ltd (SOL). From the table we can see that defects are varied for different factories. Skip stitch is 19.41% in MCTL but 0.39% in SOL, uneven stitch is 9.70% in MCTL & 0% in SOL, Raw-edge is 5% in MCTL and 9.41% in SOL, Dirty Mark is 2.94 in MCTL & 0% in SOL, oil stain is 6.76% in MCTL & 0.39% in SOL, over stitch is 9.41% in MCTL & 0% in SOL, pleat is 1.17% in MCTL & 4.70% in SOL , Label join is 12.05% in MCTL & 0% in SOL, puckering is 1.18% in MCTL & 0.78% in

SOL, Down Stitch is 16.86% in SOL but 0% in MCTL, size mistake is 2.64% in MCTL and 0% in SOL, uncut thread is 0% in MCTL & 3.14% in SOL missing operation is 5 in MCTL and 4.70% in SOL, uneven hi- Low is 0% in MCTL but 19.6% in SOL, Needle Mark is 0% in MCTL but 10.59% in SOL . here defect percentage are different for different factories. From upper information found some defects which are common in both Factories those are Skip stitch, Open seam, Uneven stitch, Raw edge, Down stitch.

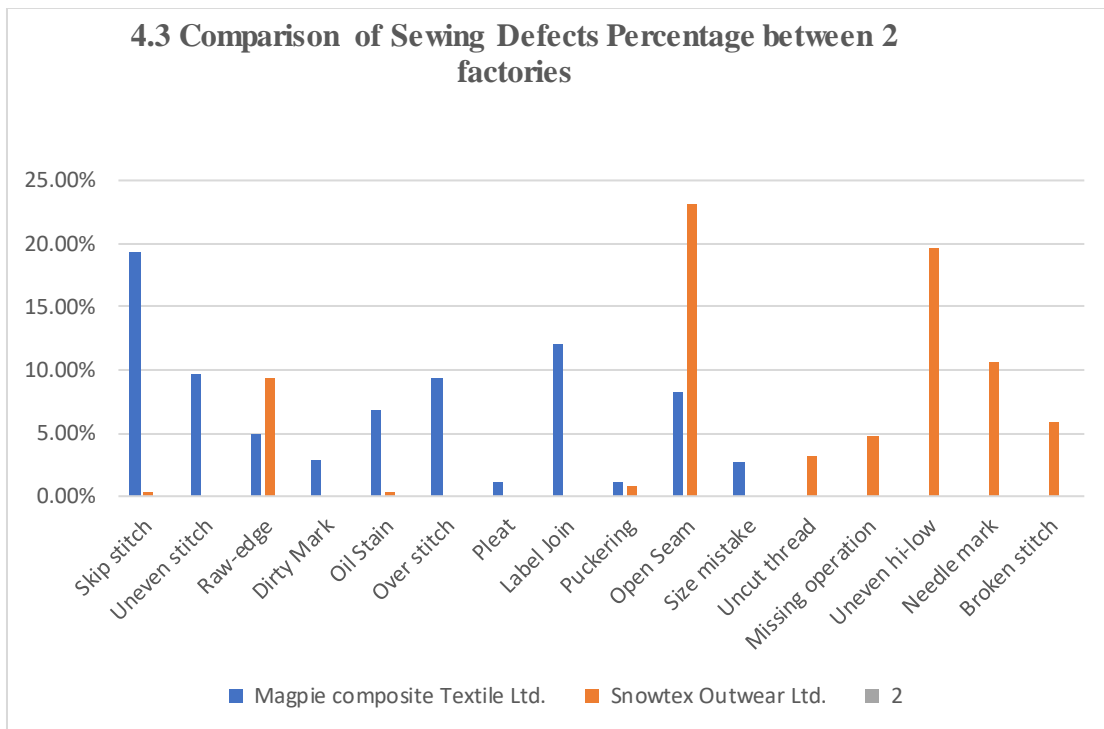


Figure: 4.3 Comparison of Sewing Defects Percentage between 2 factories

#### **4.4 Major 5 Defect found from two factories:**

- Skip stitch.
- Open seam.
- Uneven stitch.
- Raw edge.
- Down stitch

#### **Discussion:**

##### **4.4.1 Skip stitch:**

This is a sewing fault Occurred for machine defect.



**Figure: 4.4.1 SkipStitch.**

#### **Causes:**

- Shorts needle loop.
- Hight tension in needle thread.
- Wrong needle size.

#### **Remedies:**

- Thread tension should be perfect.
- Accurate size needle must be used.
- Machine should be service timely.

#### **4.4.2 Open seam:**

This is the sewing problem where two edge of fabric not attached completely after sewing.



Figure: 4.4.2 Open Seam

#### **Causes:**

- Needle and looper timing mismatch.
- Improper parts handling of garments.

#### **Remedies:**

- Machine Service for needle and looper.
- Start Operators training.
- Proper thread tension should be used.

### 4.4.3 Uneven stitch:

The stitch line is not even or not straight is called uneven stitch.



Figure: 4.4.3 Uneven Stitch

#### Cause:

- Operators poor sewing skill.
- Too much pulling garments during sewing.
- For poor quality thread.
- For soft Fabric

#### Remedies:

- By Avoiding excess pulling garments during sewing.
- By using good quality thread.
- By operators training.
- By using right Needles according to fabric types.

**4.4.4 Downstitch:** Down stitch can be defined as a fault where stitch line did not place in the right path.



Figure: 4.4.4 Down stitch

**Causes:**

- For unskilled operator.
- Carelessness in work.
- Improper machine speed.

**Remedies:**

- By setting proper guide.
- By using skilled operators.
- By maintain machine speed.

**4.4.5 Row-edge:** Excess fabric is shown in sewing line after sewing is raw-edge.



Figure: 4.4.5 Raw- edge.

**Causes:**

- For unskilled operator.
- Improper panels cutting.

**Remedies:**

- By proper panels cutting in cutting section.
- By using skilled operators.

## CHAPTER -5

### 5.1 Conclusion:

The project is all about sewing fault and its remedies. We have completed our project using two factories information, those are Magpie composite textile ltd another one is SNOWTEX outwear ltd. For the project we have collected many ends line table quality inspection report. After analysis those report we found some major faults which Remedies we found from factories. SNOWTEX outwear ltd 5day DHU= 18.07% and Magpie composite textile ltd 7day DHU=3.69%. sewing should be controlled to improve production. Most common 3 Faults in SNOWTEX outwear ltd is open seam, uneven HI Low, Down stitch and for Magpie composite textile ltd skip stitch, uneven stitch, and label join. We choose 3 faults from all faults and found those remedies in this project and this will be very helpful to reduce those problem.





Reference: GARMENTS & TECHNOLOGY by prof. M A kashem, granthanir  
prokashoni.

## Sewing Faults

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