Faculty of Engineering
Department of Textile Engineering

REPORT ON

"Investigation of faults of sample garments"

Course Title: Thesis (Project)
Course Code: TE4214

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This Report Presented in Partial Fulfilment of the Requirements for the Degree of Bachelor of Science in Textile Engineering.

Advance in Apparel Manufacturing Technology
February, 2023

LETTER OF APPROVAL

To

The Head

Department of Textile Engineering

Daffodil International University

Ashulia 1341, Dhaka 1207

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

Dear Sir,

I am just writing to let you know that this project report titled as **"Investigation of faults of sample garments"** has been prepared by the student bearing ID 191- 23-5634, ID 191-23-5628, ID 191-23-5592 is completed for final evaluation. The whole report is prepared based on the proper investigation and interruption through different types of faults of sample garments & their remedies. The students were directly involved in their project activities and the report became vital to spark much valuable information for the readers.

Therefore, it will highly be appreciated if you kindly accept this project report and consider it for final evaluation.

Yours Sincerely

M Rahman
25.02.2023

Mr. Md. Mominur Rahman

Assistant Professor

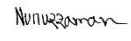
Department of Textile Engineering

Daffodil international university

DECLARATION

We hereby declare that the work presented in this thesis investigation performed by us. We also declare that all the materials of this topic are not copied anywhere. We further declare that this thesis paper or any part thereof has not been or is not being submitted anywhere. All the materials attached in this paper are full of practical and technical knowledge about this topic.

Submitted by:

Name	**Id**	Signature
Nuruzzaman	191-23-5534	
Khandakar Abdullah Nur	191-23-5628	
Salah Pru Marma	191-23-5592	

ACKNOWLEDGEMENT

First of all, we like to thank the almighty Allah for helping us complete this Report on time. We also like to thank the number of people who helped us complete this report. Without the help and guidance from numerous instances it would not have been possible to prepare this report in its present form. We wish to express our sincere appreciation to all those individuals and organizations who have directly or indirectly contributed towards the preparation of this project report. We particularly express our gratitude to the following:

Honorable **Mr. Md. Mominur Rahman** assistant professor of the department of Textile Engineering for his broad-minded, generous and active assistance continually and in all phases of working on this report

We also want to thank the management of **Mosharaf Apparel Studio Ltd.** for helping us with valuable information to complete this report.

Our special thanks go to **Md. Murad Hossain** merchandise manager **Mosharaf Apparel Studio Ltd.** We also like to thank our parents for being able to complete this report with sound health.

ABSTRACT

In the sample section, there are different types of sampling faults. So, various faults arise usually during manufacturing a sample in the industry. In industries, generally most of the employees are not educated and technically trained up. Therefore, during troubleshooting of any fault, they fail to find the root cause of the fault and take severe steps as trial error methods to solve the problem. Buyers who buy garments from an industry ensure the quality of the garments by different types of samples which must fulfil all requirements of the buyer. But there are different types of faults in the complete sample garments. It must be removed from the garments. From this point of view, we became intended to perform a project namely- “Investigation of faults of sample garments.” We conducted the project work and practically observed the sample garments manufacturing faults during my (2 months long) industrial training in Mosharaf Apparel Studio Ltd. Based on practical experience, theory from text books and through discussion with our supervisor, finally we prepared the project. The project paper contains details of sample garments, literature of the sample, sampling process, analytical data about the faults of sample garments, and discussion of the results and their remedies & reference of the information in the project.

Contents

CHAPTER 1

INTRODUCTION

Introduction

Sample is one of the most important parts of the ready-made Garment industry. A good quality sample can provide good business and invites good buyers to the factory as buyers check the quality of the sample to give a larger order. It also gives manufacturers the opportunities to look for the options to source fabric trims and other accessories for the design at a cheaper price but a better quality which later helps in costing also. Sampling is important for manufacturers because it gives information about cost, timing labor and production of garments. At the same time manufacturers have to be careful that the sample attracts or satisfies the buyers to proceed further into the order. Hence, Sampling is an important parameter for manufacturers as well as for buyers to serve an ideal product to the customers.

Figure 1: Garments section

CHAPTER 2

LITERATURE REVIEW

2.1 Definition of sample

Sample is a product which represents a large amount of product or a group of products. By assessing the sample one can check its quality, style design or any kind of characteristics. Sampling basically includes details like product code/reference number, specifications, kind of fabric, composition, quality, details of button, zippers or any kind of accessories. In the textile industry buyers usually ask for samples to check its quality and different parameters to be sure that they can give an order or not. Sample can be of many types. Sample can be taken from the start of the production or in the middle or from the finished goods. For all order different samples are to be made. Samples are made in each stage to check the quality of every stage and the workmanship of the manufacturers. A good sample can build a good quality First impression to the buyers which is largely important in the textile sector. So, a manufacturer should use his best workers and best efforts to produce samples.

Figure 2 : Sample section

2.2 Sequence Flow chart of sampling

Received tech pack from the buyer
↓
Pattern making
↓
Cutting
↓
Print /Embroidery (if required)
↓
Sewing
↓
Finishing
↓
QC
↓
Send for approval

2.3 Types of sampling required for completing a garments order

There are mainly eight types of samples required for completing a garments order. Those are –

- Development sample
- Fit sample
- Size set sample
- Counter sample
- Salesman sample (SMS)
- Pre-production sample (PPS)
- Top over production sample (TOP)
- Shipment sample

2.3.1 Development sample

Development sample can also be known as first sample. It is a proto type sample by which manufacturers just made a structure of a cloth with the raw materials which are available to him. It is more of a trial sample. The main purpose of the Development sample is to see the design work and to test the fitting. Quantity of development sample should be 2. One for buyers and other one for self-keeping.

2.3.2 Fit sample

Once the development sample gets approved than buyers asks for fitting sample. Fit sample is made and sent to the buyers to confirm the fit of the garments on live models or dummy and for approval of construction details. The purpose of buyers to ask fit sample Is to be sure that factory understand the construction and quality details and standards. For producing fit sample manufacturing uses its available materials just like the development sample. Quantity for fit sample is also should be 2 one for the buyers and one for self-keeping.

2.3.3 Size set sample

After approving the fitting sample buyers ask for the size set sample. Main purpose of the size set sample is to check the factories capabilities of producing garments of all sizes. For size set sample buyers ask samples for each size and size color. Buyers may skip some size if the number of sizes is more. This is known as jump size set. This sample can be made in a sample room or in the actual floor recommended by the buyer. Material that is used for this sample may be actual. Cutting should not be start for bulk production without the approval of size set sample

2.3.4 Counter sample

Suppliers have to develop a sample given by a buyer. Main purpose of the Counter sample is to check the workmanship and test the factory skill. Usually, quantity is 2. One for buyers and one for the self-keeping.

2.3.5 Salesman sample

Salesman sample is used by sales team of buyers to increase the sales. Buyers held meeting with the customers to check on the response to each size and color. Here the cost of the sample production is given by the buyer. The main purpose of the SMS sample is to make sales meetings with retailers, knowing market response order forecasts etc. Materials should be actual for this sample. Quantity of this sample showed be one for each color and each size. The price of the order is confirmed through this sample. It is very close to order confirmation. One thing manufacturer need to notice is it is very important to meet the delivery date of salesman sample.

2.3.6 Pre-production sample

When all the item / Material for bulk production arrives, the factory makes a sample with the actual material in the bulk line and sends it to the buyers for approval. This sample is very

important as the approval of this sample gives manufacturers the permission to start the bulk production. Pre-production samples are sent in only one 1-2 samples or specified by the buyer.

2.3.7 Top of production sample

Top of production sample is the sample which is sent to the buyers during the production. This sample is sent to the buyers as soon as the initial pieces come out of the sewing line. The purpose of the top of production sample is to check out that factory producing the right design and right quality production.

2.3.8 Shipment sample

A sample is sent to the buyers as soon as the final inspection is done; this sample is known as shipment sample. By getting this sample buyers find out what types of products they may receive. It also helps the buyer to settle the Customs procedure earlier. Manufacturer kept one piece of the sample so that he may refer in case of any claim.

2.4 Purpose of sample

- Reducing the cost of the manufacturer
- Getting clarifications about style details from the merchandiser
- Checking pattern working ability
- Preparation of making different types of samples and getting buyers approval
- Reducing consumption of fabric
- Reduction of operation
- Finding quality related problem

2.5 Explanation of sample and their uses

2.5.1 First sample

Synonyms: dummy, mock-up, drape, Development sample.

Explanation: This is a concept sample, often a rough rendition of a drape sewn together. Used primarily by designers who prefer to convey design ideas in actual fabric as part of their creation process instead of drawing a sketch. Or, they have an idea but can’t articulate it so they put fabric on a mannequin instead.

Uses: To convert the pattern into actual garments

2.5.2 Fit sample

Synonyms: Original sample, sample test garment, development sample, design sample, white seal sample.
Explanation: This is a sample made from the first (or production quality) pattern (which was made from the and intended to test the designer’s idea or concept in the chosen fabrication. If design, fabrication and fit of this sample come out as planned and doesn’t n When we work with some buyers continuously, we will have to keep on sending samples to them very often. Whenever they have enquiries, buyer may need samples. Buyers may like to see the garments in a new fabric. For one enquiry, they may need samples in different fabrics to choose from. If they want to develop new style in new fabric, then also we will have to send these samples. We may have to spend too much on these samples. But these samples are inevitably important to develop business. Sometimes, even the buyer is not so confident of some inquiries, if our samples are good and attractive at reasonable prices, they will bring orders to us. Also, we will have to send samples to the newly contacted buyers to show our workmanship, product range, quality standards and price level. These samples should be sent so that they would attract the buyers. So, it is better for a company to have a separate sampling department so that they can create new styles in new fabrics to impress the buyers.

Uses: To check the fitting of the garments.

2.5.3 Style sample

Synonyms: style reference, parent pattern.

Explanation: [In addition to the context above in that fit and first sample are the same thing] In some companies, a fit sample can refer to an earlier proven style that fits well and is used as a point of reference for design iterations, providing the basis of new style development and fit. In such cases, this preceding fit sample would be called a style reference and its pattern would be a sort of “parent” pattern or block.

Uses: To check the style of the garments.

2.5.4 Prototype sample

Synonyms: Proto.

Explanation: This sample is the result of previous iterations, the version that meets the designer’s test for execution. The fit should also be as expected so it would also be a fit sample for companies that use a separate designation. Ideally, a proto sample is also a sew by as described below. If you sew in house, the prototype should be used for costing and become the production sew-by.

2.5.5 Pre-production sample

Synonyms: Pre-pro, P/P, costing sample, Counter sample, Salesman’s sample, Sales sample, Duplicates.
Explanation: This sampling stage is to prove the pattern, test cost effectiveness and consistency in production whether it is done in house or outsourced to a contractor. If the (counter) sample is approved, it would become the production sew by. Ideally, pre-production samples (salesman’s samples) are used to pre-sell the product.

Uses: To grain approval before the bulk production.

2.5.6 Photo sample

Synonyms: Model sizes, Flat samples, Editorial samples.

Explanation: These samples are made in smaller sizes for photo shoots intended for editorial and marketing, previously a size 4 but these days maybe a size 0. This may not be necessary if you can pin a garment strategically on the model. If you intend to shoot flats, you may need to cut the smaller size because it’s hard to get close enough to fit garment attributes in the frame. Some people know they will need smaller sizes for photography so they use this as their base size. Please don’t do that.

Uses: Buyers use this sample for marketing propose.

2.5.7 Salesman’s sample

Synonyms: Duplicates, Sales samples, Selling sample.

Explanation: Ideally the pre-production can be used for sales and marketing. You would have duplicates of the approved pre-production or production sample made for each party. Domestic producers should priorities the making of the sales samples as the test production runs.

Uses: Use to confirmation of the order quantity.

2.5.8 Show sample

Synonyms: Showroom sample, Merchandising sample, Salesman’s sample.

Explanation: Primarily intended for showrooms (but not exclusively) that market directly to editorial (fashion editors etc.), you may need to have photo samples as above and for the same reasons. You may also need the mid-range size for retail buyers who stop by. Confer with your showroom as to their preferences.

Uses: Use for marketing propose in showroom.

2.5.9 Size set sample

Synonyms: Size run, Size set.

Explanation: Sample lot production of a style in all the intended sizes. Ideally you design sizes to target your customer profile early on in product development. This may not be possible if your silhouettes vary greatly between styles, meaning you will need to test sizes of various styles.

Uses: To identify factory has the capability to produce all sizes garments.

2.5.10 Production sample

Synonyms: Counter sample, Spec sample.

Explanation: This is the final approved version of a style produced by whomever is doing production. Often a production test run is done and the output is gauged for quality and the samples ideally used for marketing, promotion, pre-sales and perhaps trunk sales. The quantity of units produced will vary from one to a percentage of the intended production lot size. This can be very expensive if the run includes all colorways and sizes.

Uses: To check the production is going ok or not.

2.5.11 Ship sample

Synonyms: Shipment sample, Fulfilment sample.

Explanation: A sample that reflects what buyers will receive down to QC, folding, tagging, bagging, pre-packs (if applicable), labelling and final packaging included.

Uses: To know what kind of final product buyers will receive.

2.6 Sample making procedure flowchart

Tech pack given by merchant
↓
Marker & pattern making
↓
Cutting (Fabric arrange by merchant)
↓
Print+ embroidery + washing (If required)
↓
Recheck
↓
Input
↓

"Investigation of faults of sample garments"

Arrange accessories from merchant

↓

Tech pack analysis and advised to sample man

↓

Sample make flow up

↓

All sewing process insure than output

↓

Initial checking of finishing, QC

↓

Garments Ironing

↓

Final check with Tech pack with buyers given comment

↓

Adding accessories

↓

Folding & packing

↓

Sending for buyer's approval.

2.7 Miscellaneous

2.7.1 Final sample

There should always be a final sample to the manufacturer to keep. This sample is known as the final sample. If any kind of problem arises after delivering final goods, the manufacturer may come up with this sample.

2.7.2 Revised sample

Revised sample is any kind of sample that comes up with any kind of change recommended by buyers for a specific type of sample. Reverse samples are basically the changes made based on buyers' comments for a specific sample.

2.7.3 Responsibilities of sample department

- Getting clarification from merchandisers about style details.
- Checking pattern working ability.
- Preparation of different samples and getting buyers approval.
- Informing quality related problems during sample preparation.
- Minimizing operation and consumption.

2.7.4 Sample planning

Sampling systems and sampling plans allow an assessment of the risk to both the producer and the consumer in accepting or rejecting a lot of products and these risks need to be quantified, discussed and agreed. Planning helps both manufacturers and buyers to save cost and also save time and minimize operation. So, sample Planning is an important factor in the garment industry.

2.7.5 Summary

Sampling is costly if not managed properly. For any factory to grow properly, samples have to be made with better quality because this is what will attract buyers to the factory and by this factory will get larger orders. So basically, sample is the heart of a factory to grow up financially. So proper care should be taken to Produce sample garments.

CHAPTER 3

METHODOLOGY

We have done our internship in Mosharraf apparel studio and we have the advantage to look into the different buyer’s comments and their different technical package, measurement sheet etc. We try to add different buyer’s documents in this report to find and what are the faults that generally happens in an order. Some of the documents are given bellow –

3.1 Buyer – Hangten

Technical package is a document where buyers provide information about the clothes they want from the factories. The documents contain information about how to make, construct and assemble garments.

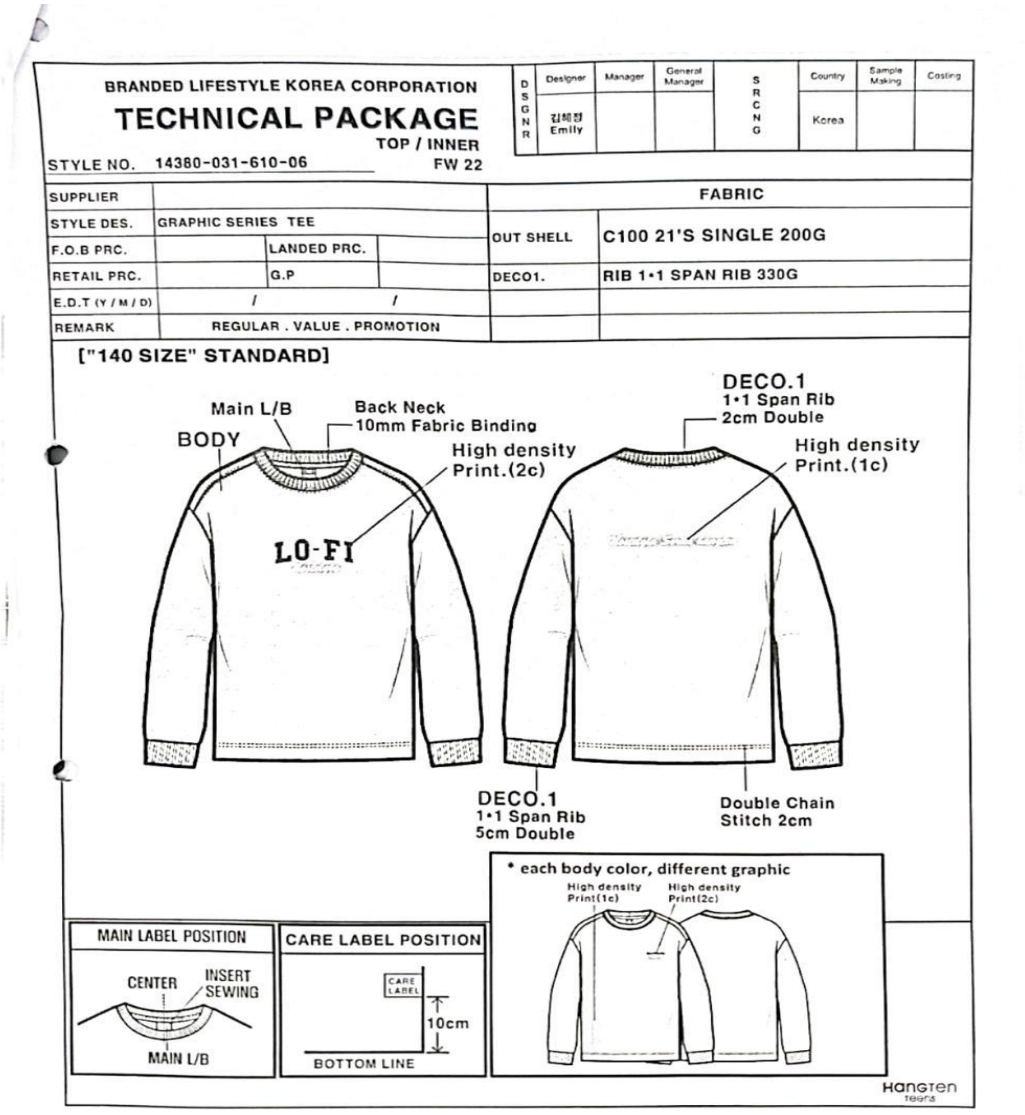
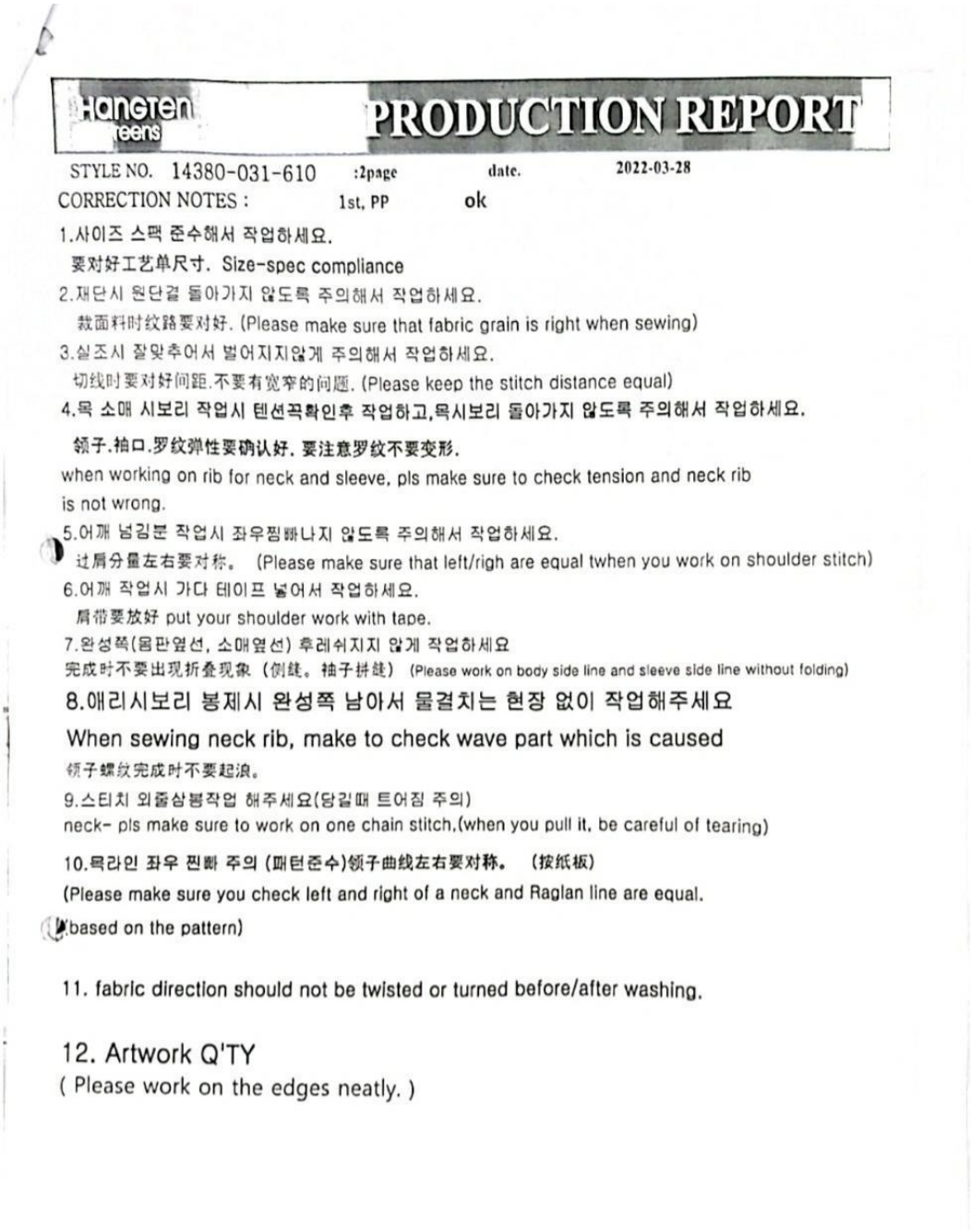


Figure 3 : Techpack

Here buyers give correction about different defects in the production line like measurements problem, artwork problem, fabric construction problem etc.



Hanesten teens

PRODUCTION REPORT

STYLE NO. 14380-031-610 :2page date. 2022-03-28

CORRECTION NOTES : 1st, PP ok

1.사이즈 스팩 준수해서 작업하세요.

要对好工艺单尺寸. Size-spec compliance

2.재단시 원단결 돌아가지 않도록 주의해서 작업하세요.

裁面料时纹路要对好. (Please make sure that fabric grain is right when sewing)

3.실조시 잘맞추어서 벌어지지않게 주의해서 작업하세요.

切线时要对好间距.不要有宽窄的问题. (Please keep the stitch distance equal)

4.목 소매 시보리 작업시 텐션꼭확인후 작업하고,목시보리 돌아가지 않도록 주의해서 작업하세요.

领子.袖口.罗纹弹性要确认好. 要注意罗纹不要变形.

when working on rib for neck and sleeve, pls make sure to check tension and neck rib is not wrong.

5.어깨 넘김분 작업시 좌우찜빼나지 않도록 주의해서 작업하세요.

过肩分量左右要对称。 (Please make sure that left/righ are equal twhen you work on shoulder stitch)

6.어깨 작업시 가다 테이프 넣어서 작업하세요.

肩带要放好 put your shoulder work with tape.

7.완성쪽(몸판옆선, 소매옆선) 휴레쉬지지 않게 작업하세요

完成时不要出现折叠现象 (侧缝。袖子拼缝) (Please work on body side line and sleeve side line without folding)

8.애리시보리 봉제시 완성쪽 남아서 물결치는 현장 없이 작업해주세요

When sewing neck rib, make to check wave part which is caused

领子螺纹完成时不要起浪。

9.스티치 외줄삼봉작업 해주세요(당길때 트어짐 주의)

neck- pls make sure to work on one chain stitch.(when you pull it, be careful of tearing)

10.목라인 좌우 찐빠 주의 (패턴준수)领子曲线左右要对称。 (按纸板)

(Please make sure you check left and right of a neck and Raglan line are equal. based on the pattern)

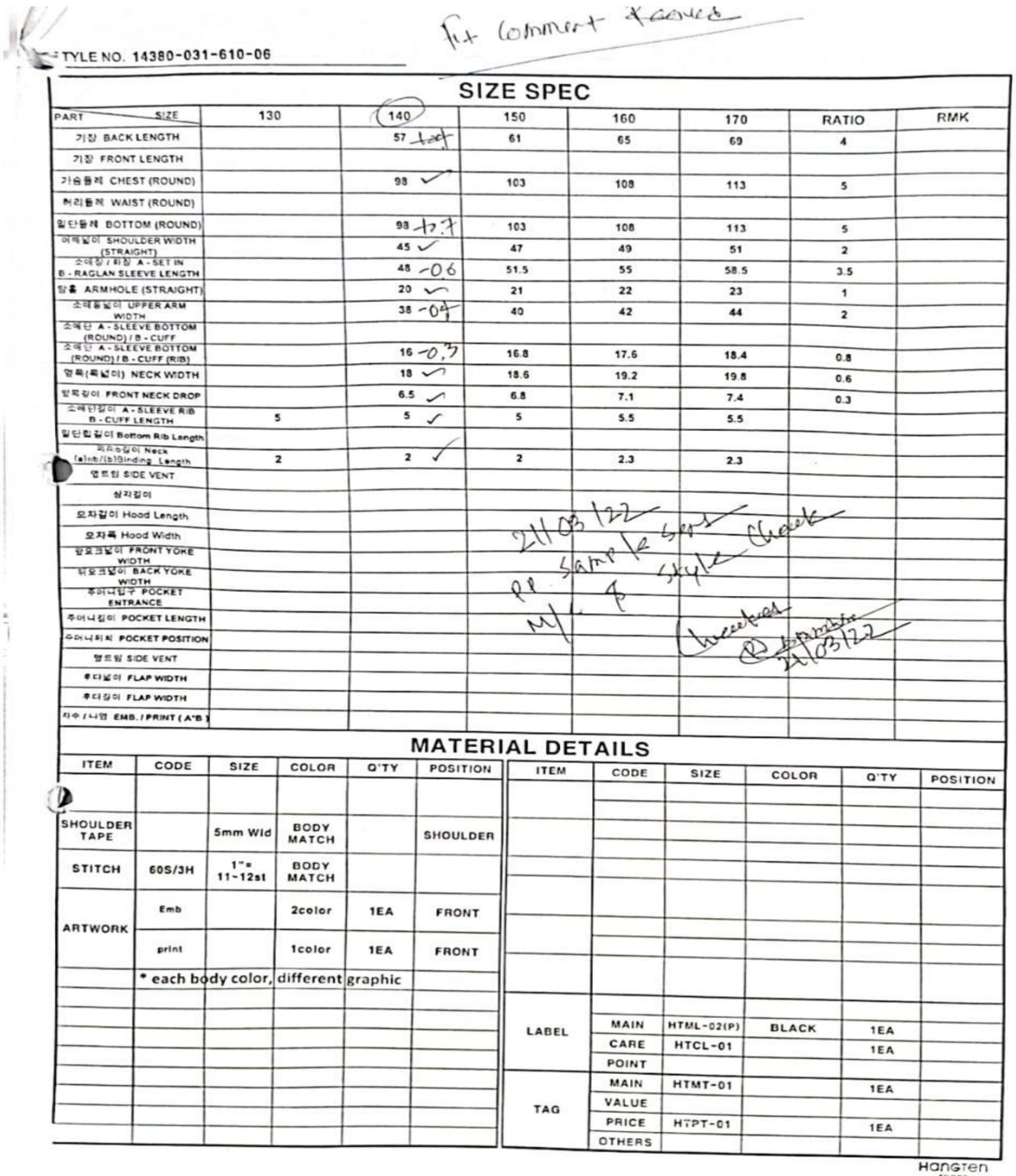
11. fabric direction should not be twisted or turned before/after washing.

12. Artwork Q'TY

(Please work on the edges neatly.)

Figure 4: Buyers comments

Here buyers give different sizes information. Factory have to follow the size specification to avoid measurement issues.



STYLE NO. 14380-031-610-06

SIZE SPEC

PART \ SIZE	130	140	150	160	170	RATIO	RMK
기장 BACK LENGTH		57	61	65	69	4	
기장 FRONT LENGTH							
가슴둘레 CHEST (ROUND)		98	103	108	113	5	
허리둘레 WAIST (ROUND)							
밑단둘레 BOTTOM (ROUND)		98	103	108	113	5	
어깨넓이 SHOULDER WIDTH (STRAIGHT)		45	47	49	51	2	
소매장 / 화장 A - SET IN B - RAGLAN SLEEVE LENGTH		48	51.5	55	58.5	3.5	
암홀 ARMHOLE (STRAIGHT)		20	21	22	23	1	
소매통넓이 UPPER ARM WIDTH		38	40	42	44	2	
소매단 A - SLEEVE BOTTOM (ROUND) / B - CUFF							
소매단 A - SLEEVE BOTTOM (ROUND) / B - CUFF (RIB)		16	16.8	17.6	18.4	0.8	
목폭(목넓이) NECK WIDTH		18	18.6	19.2	19.8	0.6	
앞목깊이 FRONT NECK DROP		6.5	6.8	7.1	7.4	0.3	
소매단길이 A - SLEEVE RIB B - CUFF LENGTH	5	5	5	5.5	5.5		
밑단립길이 Bottom Rib Length							
목립길이 Neck (a)rib/(b)Binding Length	2	2	2	2.3	2.3		
옆트임 SIDE VENT							
삼각길이							
모자길이 Hood Length							
모자폭 Hood Width							
앞요크넓이 FRONT YOKE WIDTH							
뒤요크넓이 BACK YOKE WIDTH							
주머니입구 POCKET ENTRANCE							
주머니길이 POCKET LENGTH							
주머니위치 POCKET POSITION							
[illegible] SIDE VENT							
후다넓이 FLAP WIDTH							
후다길이 FLAP WIDTH							
자수 / 나염 EMB. / PRINT (A*B)							

MATERIAL DETAILS

ITEM	CODE	SIZE	COLOR	Q'TY	POSITION
SHOULDER TAPE		5mm Wid	BODY MATCH		SHOULDER
STITCH	60S/3H	1"= 11~12st	BODY MATCH		
ARTWORK	Emb		2color	1EA	FRONT
	print		1color	1EA	FRONT
	* each body color, different graphic				

ITEM	CODE	SIZE	COLOR	Q'TY	POSITION
LABEL	MAIN	HTML-02(P)	BLACK	1EA	
	CARE	HTCL-01		1EA	
	POINT				
TAG	MAIN	HTMT-01		1EA	
	VALUE				
	PRICE	HTPT-01		1EA	
	OTHERS				

HangTen teens

Figure 5: Measurement sheet

HANGTEN teens

PRODUCTION REPORT

Approval Sample ☐
Preproduction Sample ☐

STYLE NO. 14380-031-610
FACTORY. PEAK
DESIGNER. Emily :1page
DATE. 2022-03-15 1st, QC ok

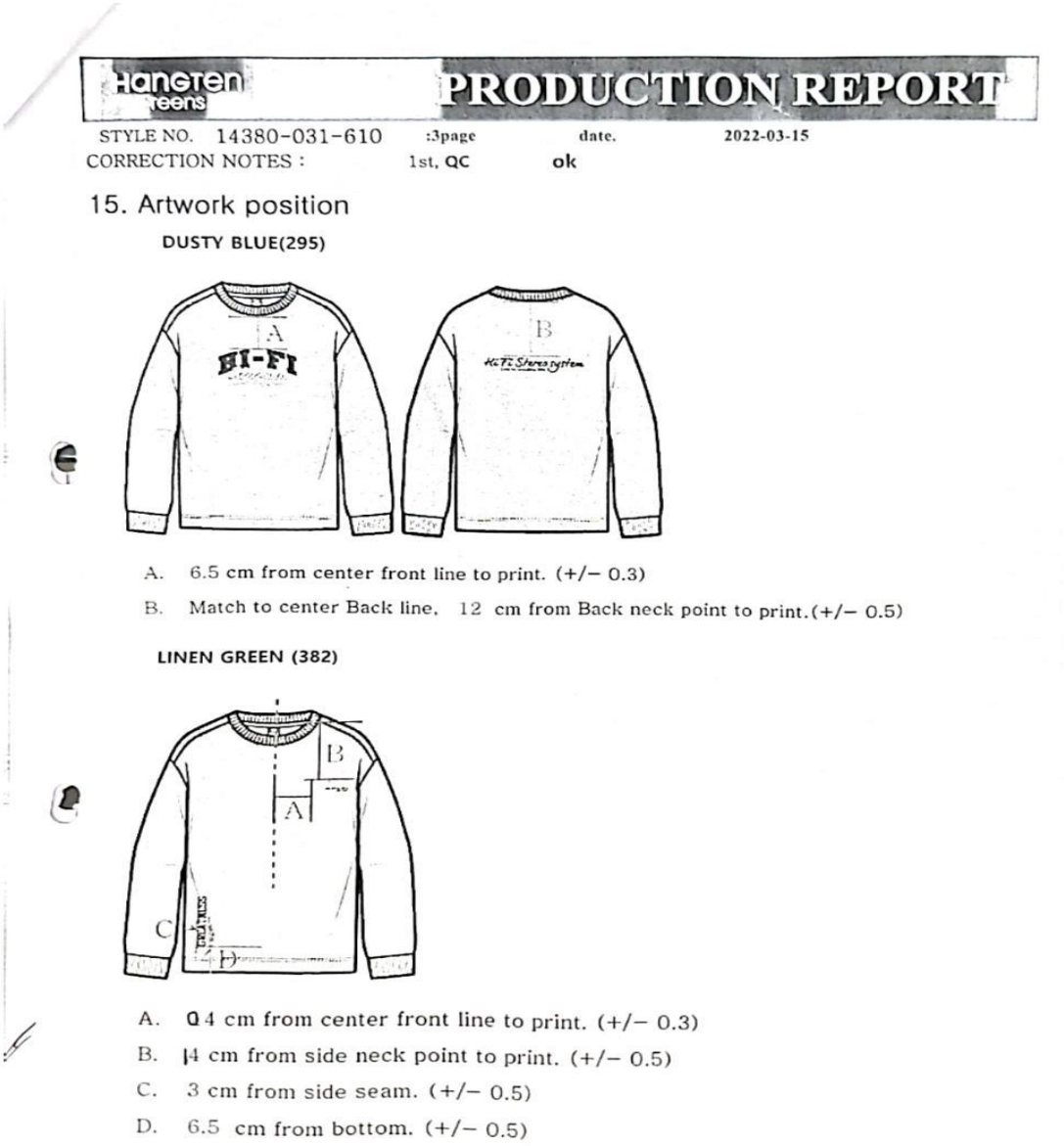
Designer.	Chief des.	COO
김혜정 Emily		
Pattern	**QC**	**Supplier**
JSW		

cm

SIZE SPEC	SIZE 11			SIZE 15			REMARK
	OR	QC	ER	OR	QC	ER	
기장 BACK LENGTH	57	57	0				
기장 FRONT LENGTH							
가슴둘레 CHEST (ROUND)	98	98	0				
허리둘레 WAIST (ROUND)							
밑단둘레 BOTTOM (ROUND)	98	98	0				
어깨넓이 SHOULDER WIDTH (STRAIGHT)	45	45.5	0.5				
소매장 / 화장 A - SET IN B - RAGLAN SLEEVE LENGTH	48	48	0				
암홀 ARMHOLE (STRAIGHT)	20	20.5	0.5				
소매통둘레 UPPER ARM (ROUND)	38	38	0				
소매단 A - SLEEVE BOTTOM (ROUND) / B - CUFF	16	16	0				
앞목(목넓이) NECK WIDTH	18	18	0				
목둘레 NECK CIRCUMFERENCE							
앞목깊이 FRONT NECK DROP	6.5	6	-0.5				
소매단깊이 A - SLEEVE RIB B - CUFF LENGTH	5	5.3	0.3				
밑단립깊이 Bottom Rib Length							
목Rib깊이 Neck (a)rib/(b)Binding Length	2	2	0				
삼각넓이							
삼각깊이							
모자깊이 Hood Length							
모자폭 Hood Width							
앞요크넓이 FRONT YOKE WIDTH							
뒤요크넓이 BACK YOKE WIDTH							
주머니입구폭 POCKET ENTRANCE WIDTH							
주머니깊이 POCKET LENGTH							
주머니위치 POCKET POSITION							
옆트임 SIDE SLIT							

Figure 6: Measurement sheet

This is the latest production correction sheet where buyers add few more production defects through their comments.



Haneten
reens

PRODUCTION REPORT

STYLE NO. 14380-031-610 :3page date. 2022-03-15

CORRECTION NOTES : 1st, QC ok

15. Artwork position

DUSTY BLUE(295)

A. 6.5 cm from center front line to print. (+/− 0.3)

B. Match to center Back line, 12 cm from Back neck point to print.(+/− 0.5)

LINEN GREEN (382)

A. 04 cm from center front line to print. (+/− 0.3)

B. 14 cm from side neck point to print. (+/− 0.5)

C. 3 cm from side seam. (+/− 0.5)

D. 6.5 cm from bottom. (+/− 0.5)

Figure 7: Buyers comments

This is the final size specification sheet to check out final product.

STYLE NO. 14380-031-610-06

SIZE SPEC

PART \ SIZE	130	140	150	160	170	RATIO	RMK
기장 BACK LENGTH		57	61	65	69	4	
기장 FRONT LENGTH							
가슴둘레 CHEST (ROUND)		98	103	108	113	5	
허리둘레 WAIST (ROUND)							
밑단둘레 BOTTOM (ROUND)		98	103	108	113	5	
어깨넓이 SHOULDER WIDTH (STRAIGHT)		45	47	49	51	2	
소매통 / 진동 A - SET IN B - RAGLAN SLEEVE LENGTH		48	51.5	55	58.5	3.5	
진동 ARMHOLE (STRAIGHT)		20	21	22	23	1	
소매통넓이 UPPER ARM WIDTH		38	40	42	44	2	
소매단 A - SLEEVE BOTTOM (ROUND) / B - CUFF							
소매단 A - SLEEVE BOTTOM (ROUND) / B - CUFF (RIB)		16	16.8	17.6	18.4	0.8	
앞목(목넓이) NECK WIDTH		18	18.6	19.2	19.8	0.6	
앞목깊이 FRONT NECK DROP		6.5	6.8	7.1	7.4	0.3	
소매단깊이 A - SLEEVE RIB B - CUFF LENGTH	5	5	5	5.5	5.5		
밑단단깊이 Bottom Rib Length							
목Rib깊이 Neck (a)rib/(b)Binding Length	2	2	2	2.3	2.3		
옆트임 SIDE VENT							
심작깊이							
모자깊이 Hood Length							
모자폭 Hood Width							
앞요크넓이 FRONT YOKE WIDTH							
뒤요크넓이 BACK YOKE WIDTH							
주머니입구 POCKET ENTRANCE							
주머니깊이 POCKET LENGTH							
주머니위치 POCKET POSITION							
옆트임 SIDE VENT							
후다넓이 FLAP WIDTH							
후다깊이 FLAP WIDTH							
자수 / 나염 EMB. / PRINT (A~B)							

15/03/22

MATERIAL DETAILS

ITEM	CODE	SIZE	COLOR	Q'TY	POSITION
SHOULDER TAPE		5mm Wid	BODY MATCH		SHOULDER
STITCH	60S/3H	1"= 11~12st	BODY MATCH		
ARTWORK	Emb		2color	1EA	FRONT
	print		1color	1EA	FRONT
	* each body color, different graphic				

ITEM	CODE	SIZE	COLOR	Q'TY	POSITION
LABEL	MAIN	HTML-02(P)	BLACK	1EA	
	CARE	HTCL-01		1EA	
	POINT				
TAG	MAIN	HTMT-01		1EA	
	VALUE				
	PRICE	HTPT-01		1EA	
	OTHERS				

Hangten

Figure 8: Final measurement sheet

This is technical package figure to check out all the information buyers given is okay with the final product or not.

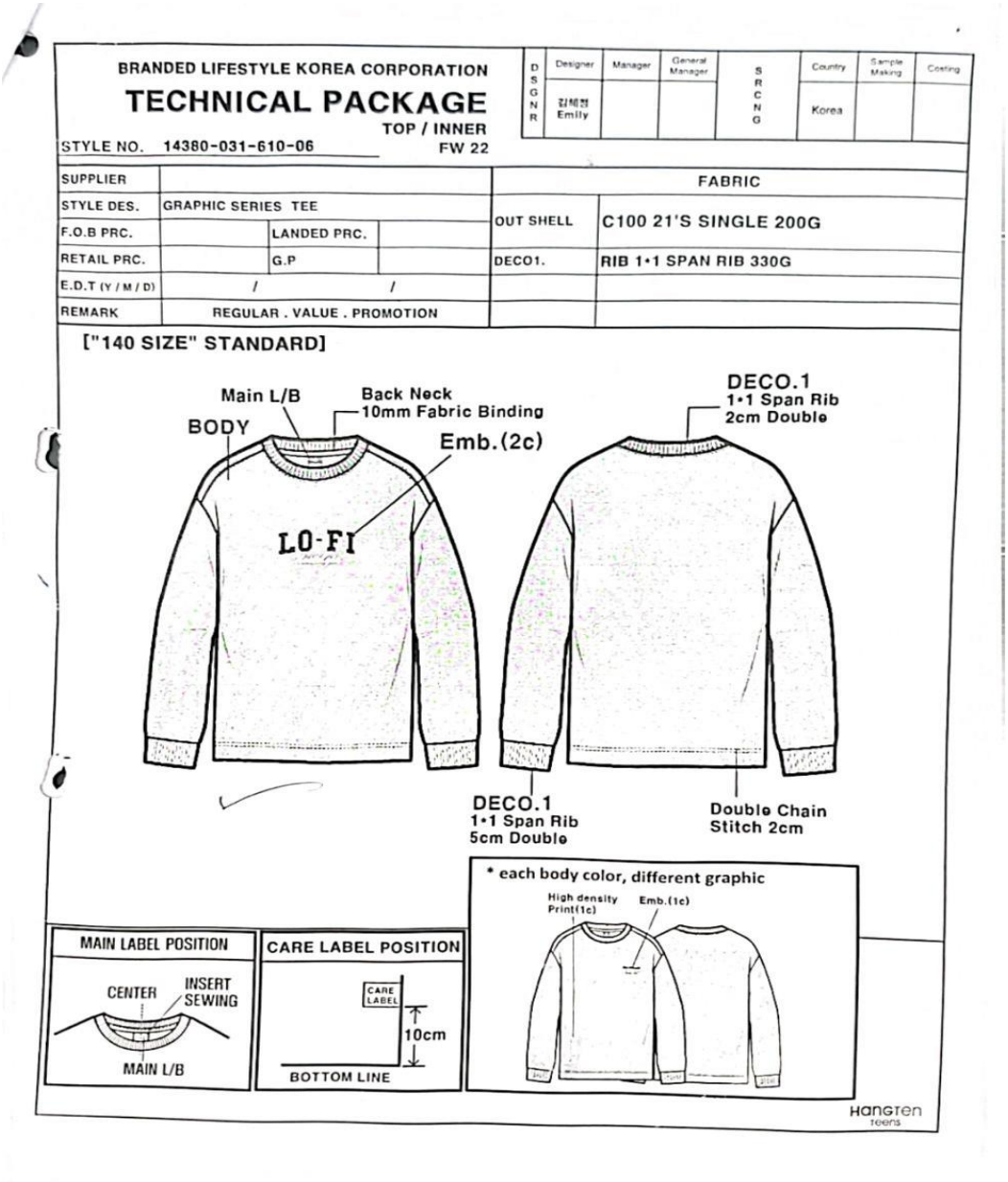
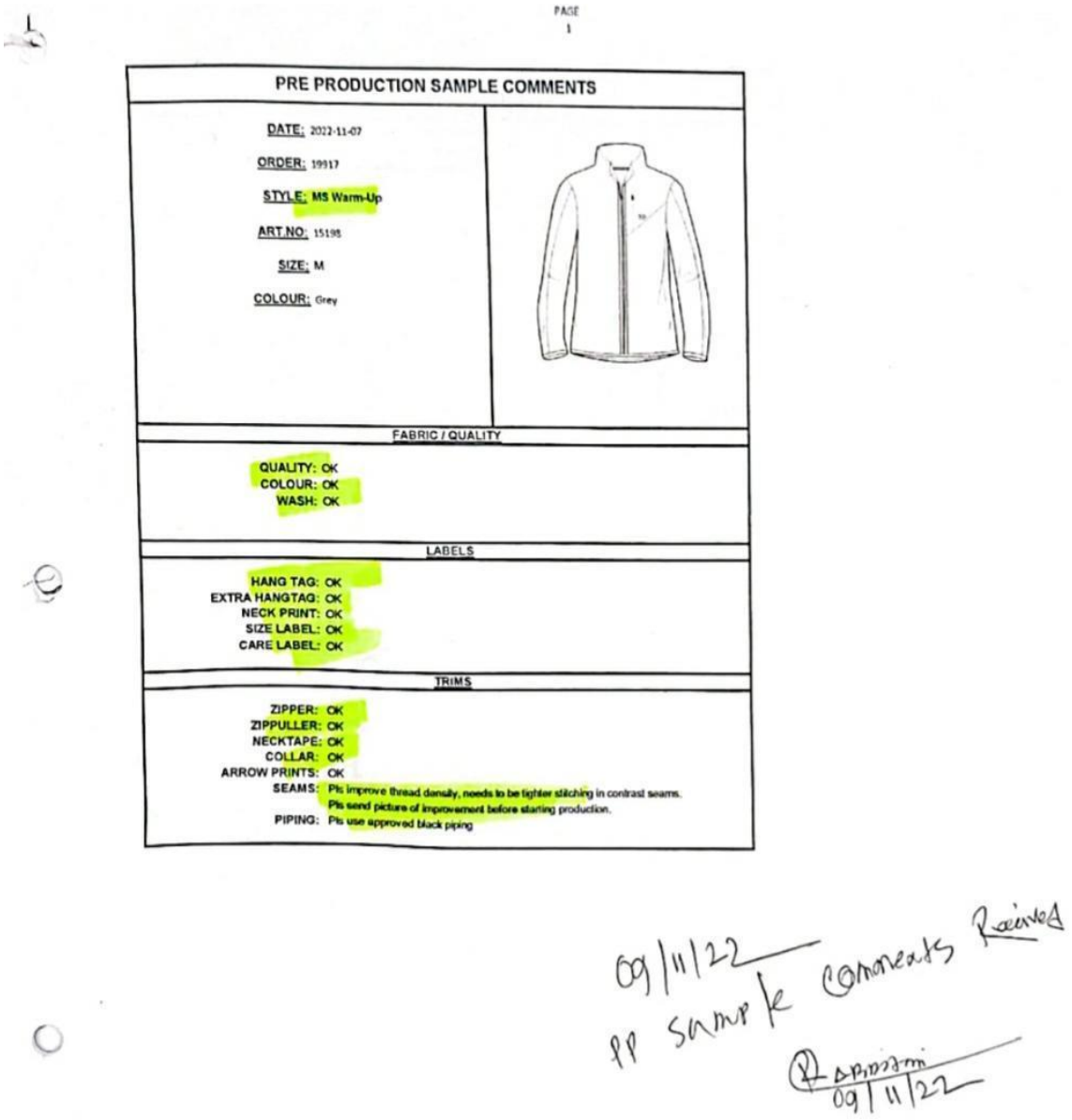


Figure 9: Techpack

3.2 Buyer – Aim Global

This figure is shows the pp comments of the buyers. Which shows that fabric quality and levels are okay of the garments but there are problems in trims like - seam and piping.



PAGE
1

PRE PRODUCTION SAMPLE COMMENTS

DATE: 2022-11-07
ORDER: 19917
STYLE: MS Warm-Up
ART.NO: 15198
SIZE: M
COLOUR: Grey

FABRIC / QUALITY

QUALITY: OK
COLOUR: OK
WASH: OK

LABELS

HANG TAG: OK
EXTRA HANGTAG: OK
NECK PRINT: OK
SIZE LABEL: OK
CARE LABEL: OK

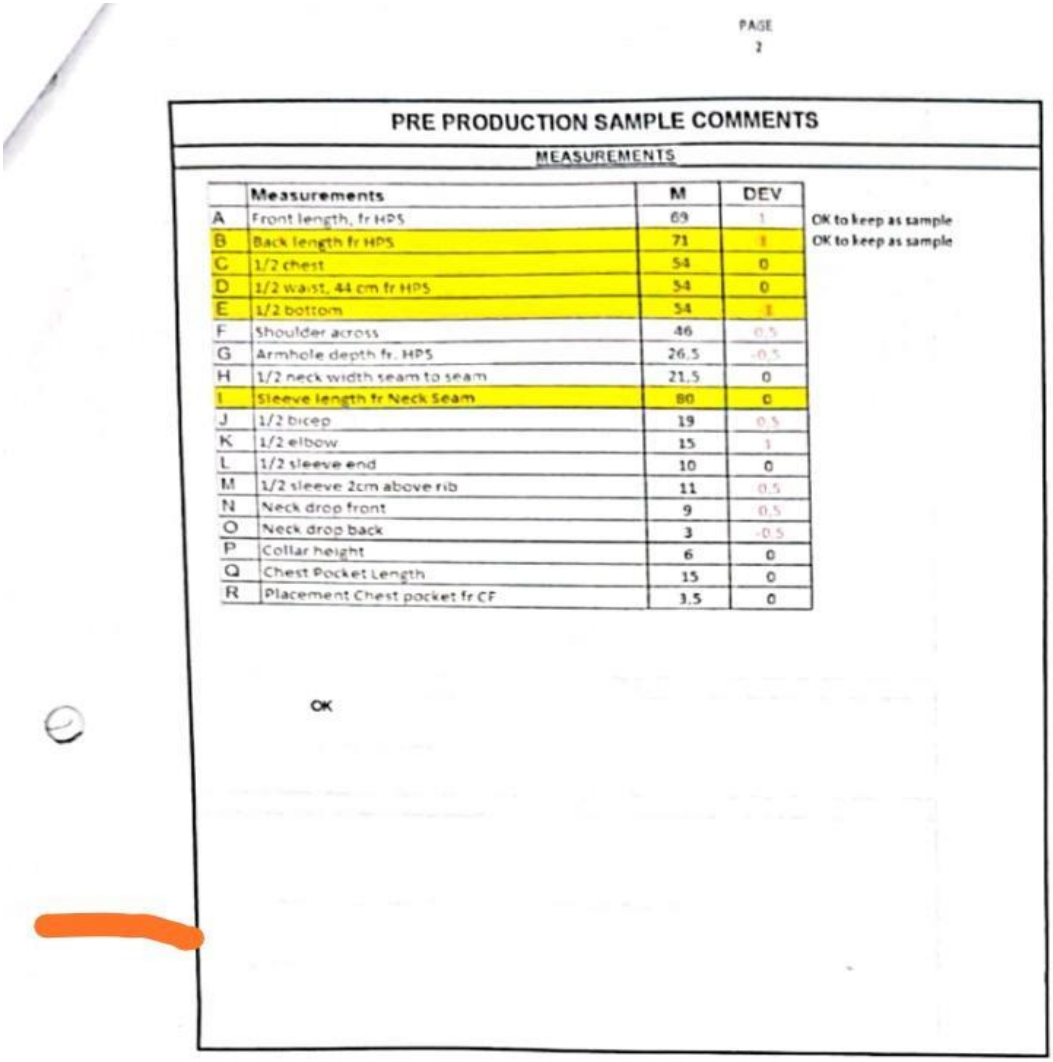
TRIMS

ZIPPER: OK
ZIPPULLER: OK
NECKTAPE: OK
COLLAR: OK
ARROW PRINTS: OK
SEAMS: Pls improve thread density, needs to be tighter stitching in contrast seams.
Pls send picture of improvement before starting production.
PIPING: Pls use approved black piping

09/11/22
PP Sample Comments Received
09/11/22

Figure 10: Buyers comments

This figure shows the measurement sheet comments which is okay according to buyer.



PAGE
2

PRE PRODUCTION SAMPLE COMMENTS

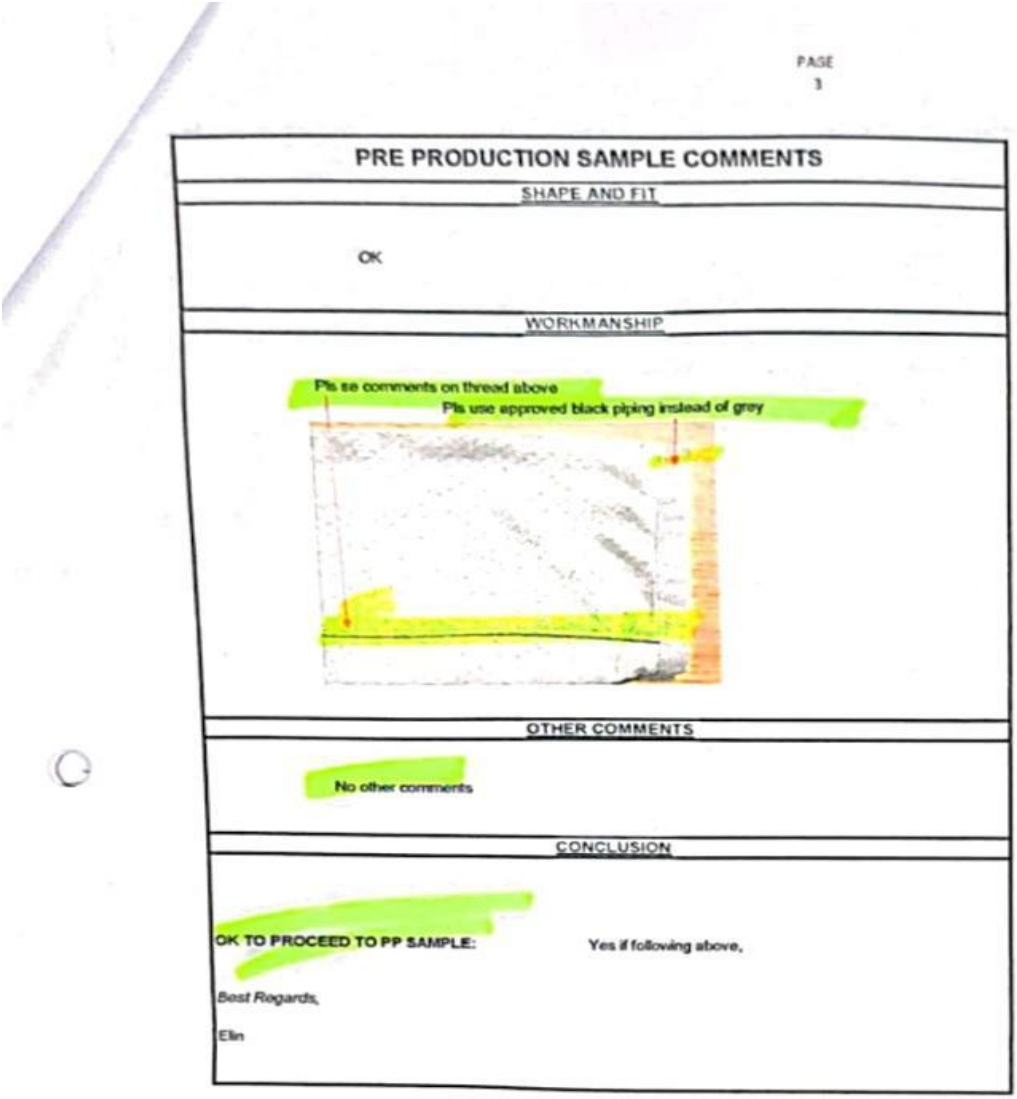
MEASUREMENTS

	Measurements	M	DEV	
A	Front length, fr HPS	69	1	OK to keep as sample
B	Back length fr HPS	71	1	OK to keep as sample
C	1/2 chest	54	0	
D	1/2 waist, 44 cm fr HPS	54	0	
E	1/2 bottom	54	1	
F	Shoulder across	46	-0.5	
G	Armhole depth fr. HPS	26.5	-0.5	
H	1/2 neck width seam to seam	21.5	0	
I	Sleeve length fr Neck Seam	80	0	
J	1/2 bicep	19	0.5	
K	1/2 elbow	15	1	
L	1/2 sleeve end	10	0	
M	1/2 sleeve 2cm above rib	11	0.5	
N	Neck drop front	9	0.5	
O	Neck drop back	3	-0.5	
P	Collar height	6	0	
Q	Chest Pocket Length	15	0	
R	Placement Chest pocket fr CF	3.5	0	

OK

Figure 11: Measurement sheet

This figure also shows buyers pp comments. Here buyers find some problems in workmanship but gives green signal for proceeding.



PAGE
1

PRE PRODUCTION SAMPLE COMMENTS

SHAPE AND FIT

OK

WORKMANSHIP

Pls se comments on thread above
Pls use approved black piping instead of grey

OTHER COMMENTS

No other comments

CONCLUSION

OK TO PROCEED TO PP SAMPLE: Yes if following above,

Best Regards,

Elin

Figure 12: Pp comments

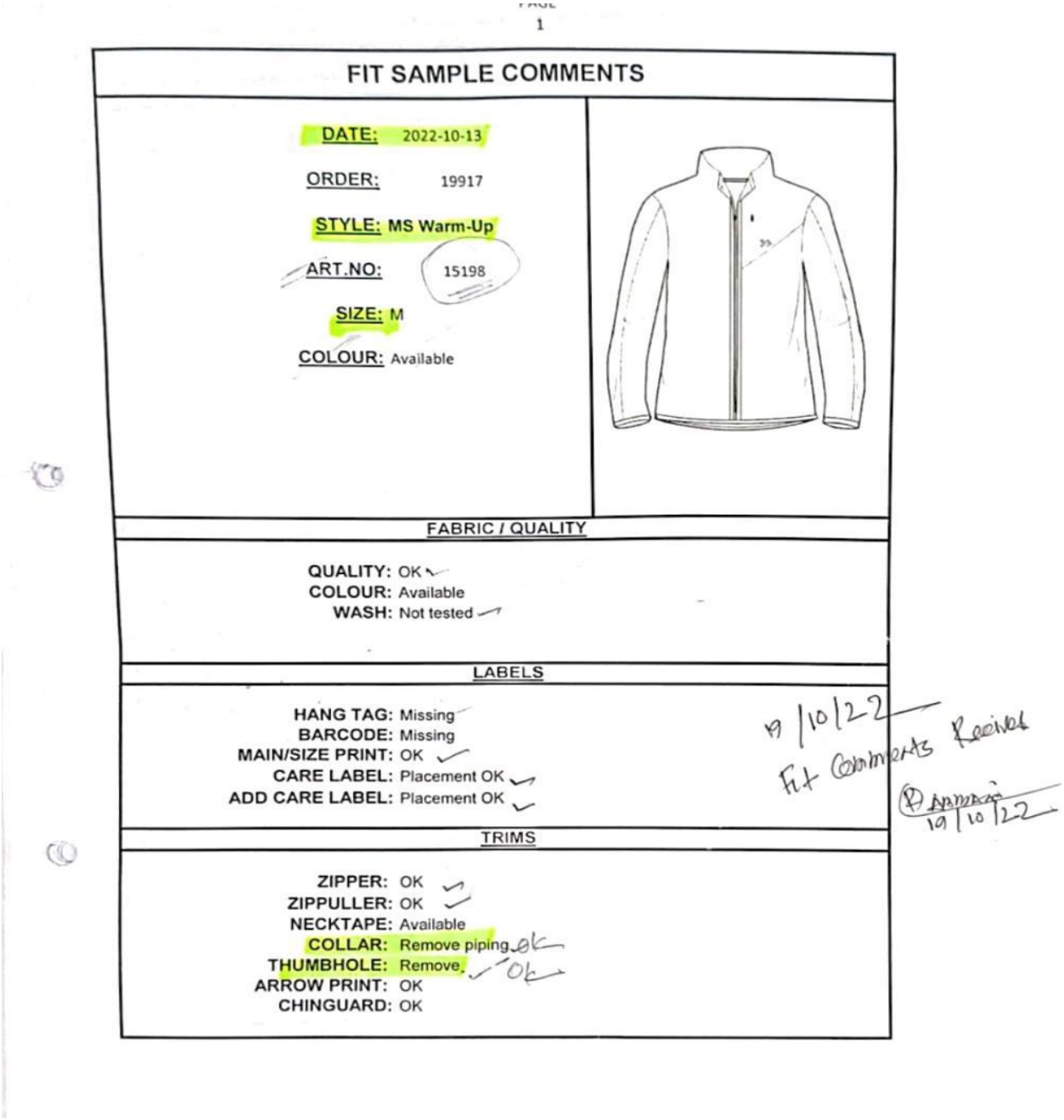
This figure shows the updated measurement sheet buyers sent it to the factory.

PP Sample

MS WARM UP JACKET							
Measurements	S	M	L	XL	XXL		Comments
Front length fr HPS	67	69	71	73	75		
Back length fr HPS	69	71	73	75	77		Upd 221017
1/2 chest	51	54	57	60	63		Upd 221017
1/2 waist, 44 cm fr HPS	51	54	57	60	63		Upd 221017
1/2 bottom	51	54	57	60	63		Upd 221017
Shoulder across	44	46	48	50	52		
Armhole depth fr HPS	25.5	26.5	27.5	28.5	29.5		
1/2 neck width seam to seam	21	21.5	22	22.5	23		
Sleeve length fr neck seam	78	80	82	84	86		Upd 221017
1/2 bicep	18	19	20	21	22		
1/2 elbow	14.25	15	15.75	16.5	17.25		
1/2 sleeve end	9.5	10	10.5	11	11.5		
1/2 sleeve 2 cm above rib	10.5	11	11.5	12	12.5		
Neck drop front	8.5	9	9.5	10	10.5		
Neck drop back	3	3	3	3	3		
Collar height	6	6	6	6	6		
Collar length at top	42	43.5	45	46.5	48		Removed 221017
Chest pocket length	15	15	15	15	15		
Placement chest pocket fr CF	3.5	3.5	3.5	3.5	3.5		

Figure 13: Measurement sheet

Here buyers add some others comment to remove others faults of sampling.



1

FIT SAMPLE COMMENTS

DATE: 2022-10-13

ORDER: 19917

STYLE: MS Warm-Up

ART.NO: 15198

SIZE: M

COLOUR: Available

FABRIC / QUALITY

QUALITY: OK
COLOUR: Available
WASH: Not tested

LABELS

HANG TAG: Missing
BARCODE: Missing
MAIN/SIZE PRINT: OK
CARE LABEL: Placement OK
ADD CARE LABEL: Placement OK

19/10/22
Fit Comments Received
19/10/22

TRIMS

ZIPPER: OK
ZIPPULLER: OK
NECKTAPE: Available
COLLAR: Remove piping ok
THUMBHOLE: Remove. Ok
ARROW PRINT: OK
CHINGUARD: OK

Figure 14: Buyers comments

Here we can see another comment to remove a specific design of the garments.

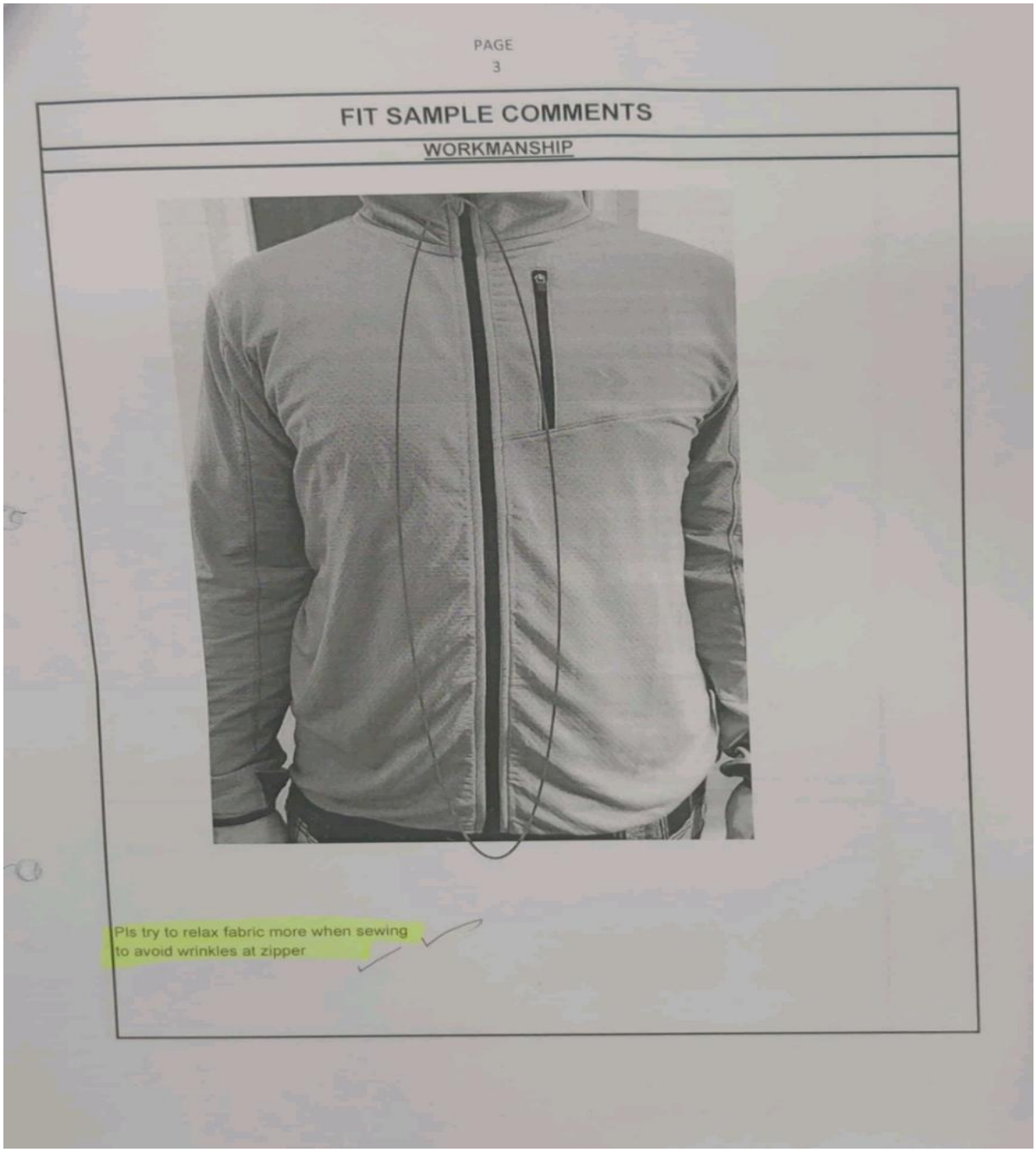


Figure 15: Buyers comments

This figure also shows some specific defects buyers identified and want to be removed from final product.

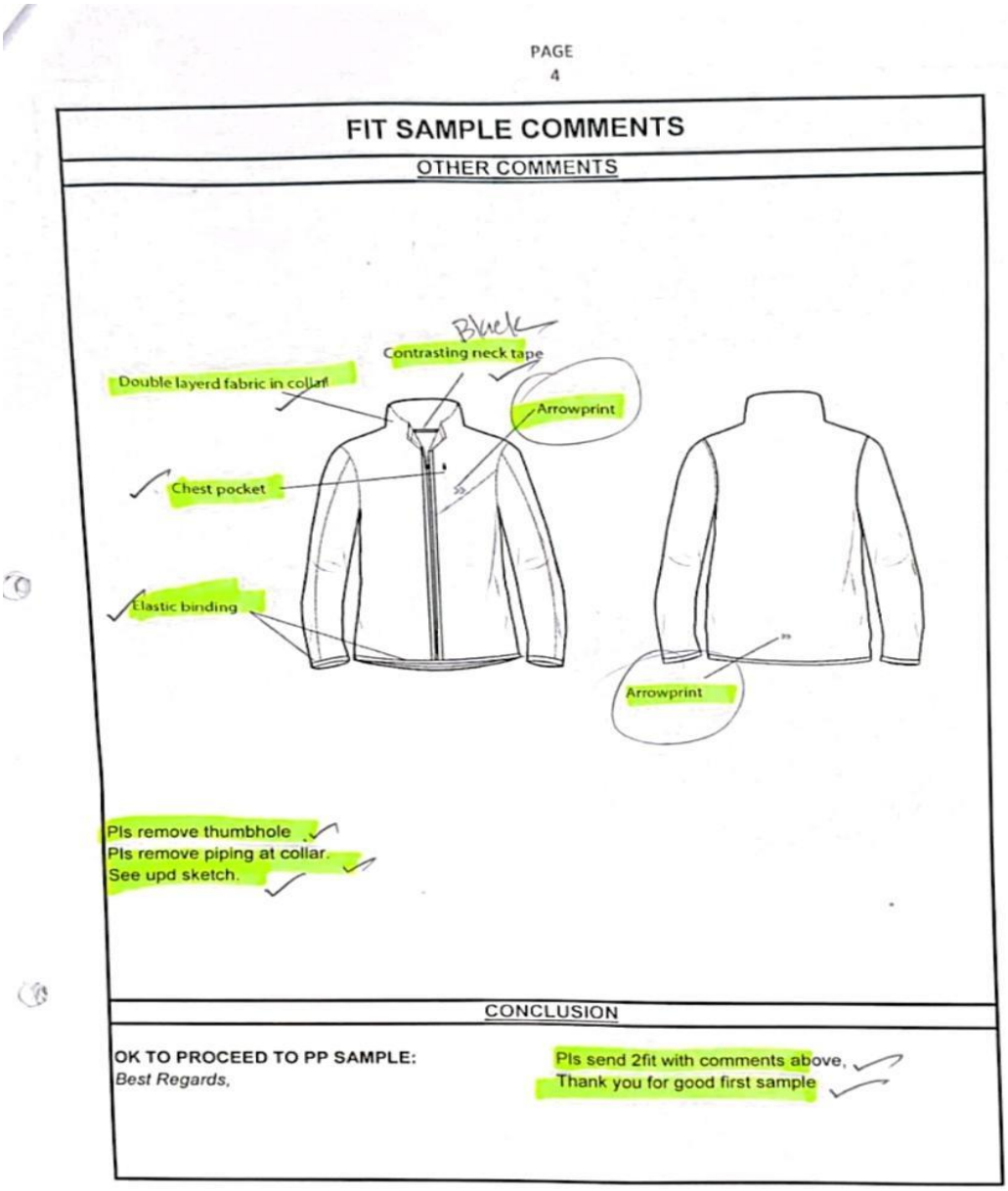


Figure 16: Buyers comment

Figure 17: Specific defects

This is the final measurement sheet by which the factory will match the final product.

MS WARM-UP JACKET

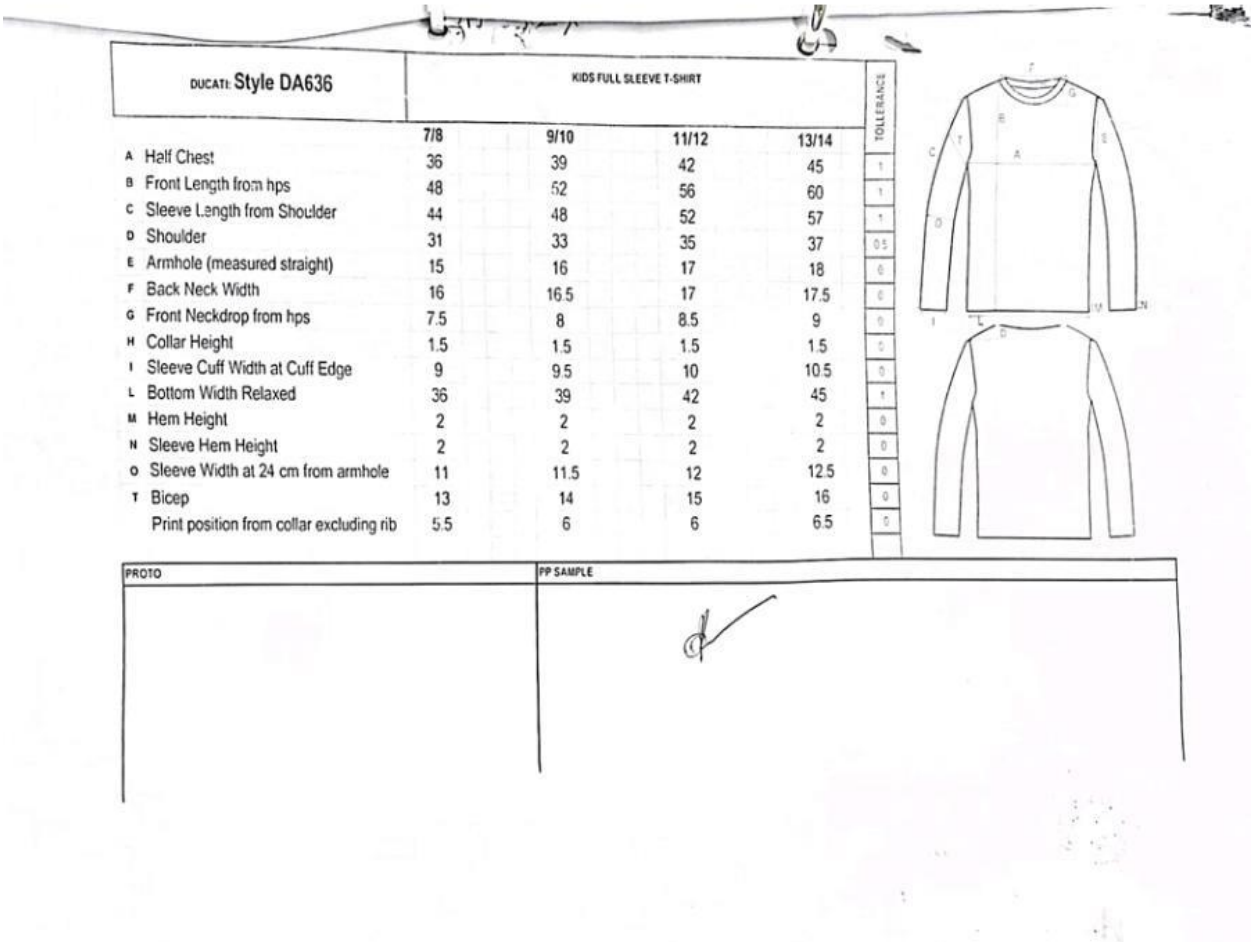
	Measurements	S	M	L	XL	XXL	Comments
A	Front length, fr HPS	67	69	71	73	75	
B	Back length fr HPS	72	74	76	78	80	
C	1/2 chest	52	55	55	55	55	
D	1/2 waist, 44 cm fr HPS	52	55	55	55	55	
E	1/2 bottom	52	55	58	61	64	
F	Shoulder across	44	46	48	50	52	NEW
G	Armhole depth fr. HPS	25,5	26,5	27,5	28,5	29,5	
H	1/2 neck width seam to seam	21	21,5	22	22,5	23	
I	Sleeve length fr Neck Seam	80	82	84	86	88	
J	1/2 bicep	18	19	20	21	22	
K	1/2 elbow	14,25	15	15,75	16,5	17,25	
L	1/2 sleeve end	9,5	10	10,5	11	11,5	
M	1/2 sleeve 2cm above rib	10,5	11	11,5	12	12,5	
N	Neck drop front	8,5	9	9,5	10	10,5	
O	Neck drop back	3	3	3	3	3	
P	Collar height	6	6	6	6	6	
Q	Chest Pocket Length	15	15	15	15	15	
R	Placement Chest pocket fr CF	3,5	3,5	3,5	3,5	3,5	

157.

Figure 18: Measurement sheet

3.3 Buyer – Ducati

This figure shows the measurement sheet of the buyers. Where different styles and size specifications are given.



DUCATI Style DA636 — KIDS FULL SLEEVE T-SHIRT

		7/8	9/10	11/12	13/14	TOLLERANCE
A	Half Chest	36	39	42	45	1
B	Front Length from hps	48	52	56	60	1
C	Sleeve Length from Shoulder	44	48	52	57	1
D	Shoulder	31	33	35	37	0.5
E	Armhole (measured straight)	15	16	17	18	0
F	Back Neck Width	16	16.5	17	17.5	0
G	Front Neckdrop from hps	7.5	8	8.5	9	0
H	Collar Height	1.5	1.5	1.5	1.5	0
I	Sleeve Cuff Width at Cuff Edge	9	9.5	10	10.5	0
L	Bottom Width Relaxed	36	39	42	45	1
M	Hem Height	2	2	2	2	0
N	Sleeve Hem Height	2	2	2	2	0
O	Sleeve Width at 24 cm from armhole	11	11.5	12	12.5	0
T	Bicep	13	14	15	16	0
	Print position from collar excluding rib	5.5	6	6	6.5	0

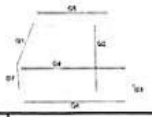
PROTO | PP SAMPLE

Figure 19: Measurement sheet

UPDATE ON 27.09.22

DUCATI KIDS ZIP JACKET SPEC

STYLE DA639



Boy's Full Zip Hoody				S	M	L	XL	
MA	MEASURMENTS	Tol. +/-	GRADE RULES	7/8	9/10	11/12	13/14	
A	FRONT LENGHT FROM HPS	1	4/5/4/2	52	57	62	66	
B	1/2 CHEST	1	2/3/4/3	40	43	46	49	
D1	1/2 BOTTOM WIDTH BEFORE RIB	1	2/3/4/3	38	41	44	47	
D2	1/2 BOTTOM WIDTH RIB RELAX	1	2/3	33	36	39	42	
D3	BOTTOM HEIGHT	0	/	6	6	6	6	
E	SHOULDER TO SHOULDER	1	2.5	33.5	36	38.5	41	
F1	SLEEVE LENGTH FROM NECK POINT	1	4/5/3	57.0	62.0	67.0	72.0	
G	1/2 ARMHOLE	0.5	1.5/1/2	17.5	18.5	19.5	20.5	
H	1/2 BICEPS	0.5	1	15.5	16.5	17.5	18.5	
J	1/2 SLEEVE OPENNING	0.5	/	8	8	9	9	
J3	SLEEVE HEIGHT	0	/	6	6	6	6	
X1	HOOD HEIGHT FROM HPS	0.5	/	31	31	32	32	
X2	HOOD WIDTH	0.5	0.5	24	24.5	25	25.5	
Y1	NECK OPENNING	0.5	0.5	18	18.5	19	19.5	
Y2	FRONT NECK DROP FROM HPS	0.5	/	6.5	6.5	7.5	7.5	
Y3	BACK NECK DROP FROM HPS	0	0	1.5	1.5	1.5	1.5	
Q1	POCKET OPENING	0.5	0.5	12.5	13	13.5	14	
Q2	POCKET HEIGHT	0	1	17	18	19	20	
Q3	POCKET HEM HEIGHT	0	0	2	2	2	2	
Q4	MAXIMUM POCKET WIDTH	0.5	1	26.5	27.5	28.5	29.5	
Q5	UPPER POCKET WIDTH	0.5	1	17.5	18.5	19.5	20.5	+2c
Q6	LOWER POCKET WIDTH	0.5	1	23	24	25	26	+2c
Q7	SIDE POCKET HEIGHT	0.5	0.5	5.5	6	6.5	7	
	Collar Height			5.5	5.5	5.5	5.5	

25/10/22

CS Cam

Figure 20: Measurement sheet

This figure shows the product package of buyers which gives details information about the product.

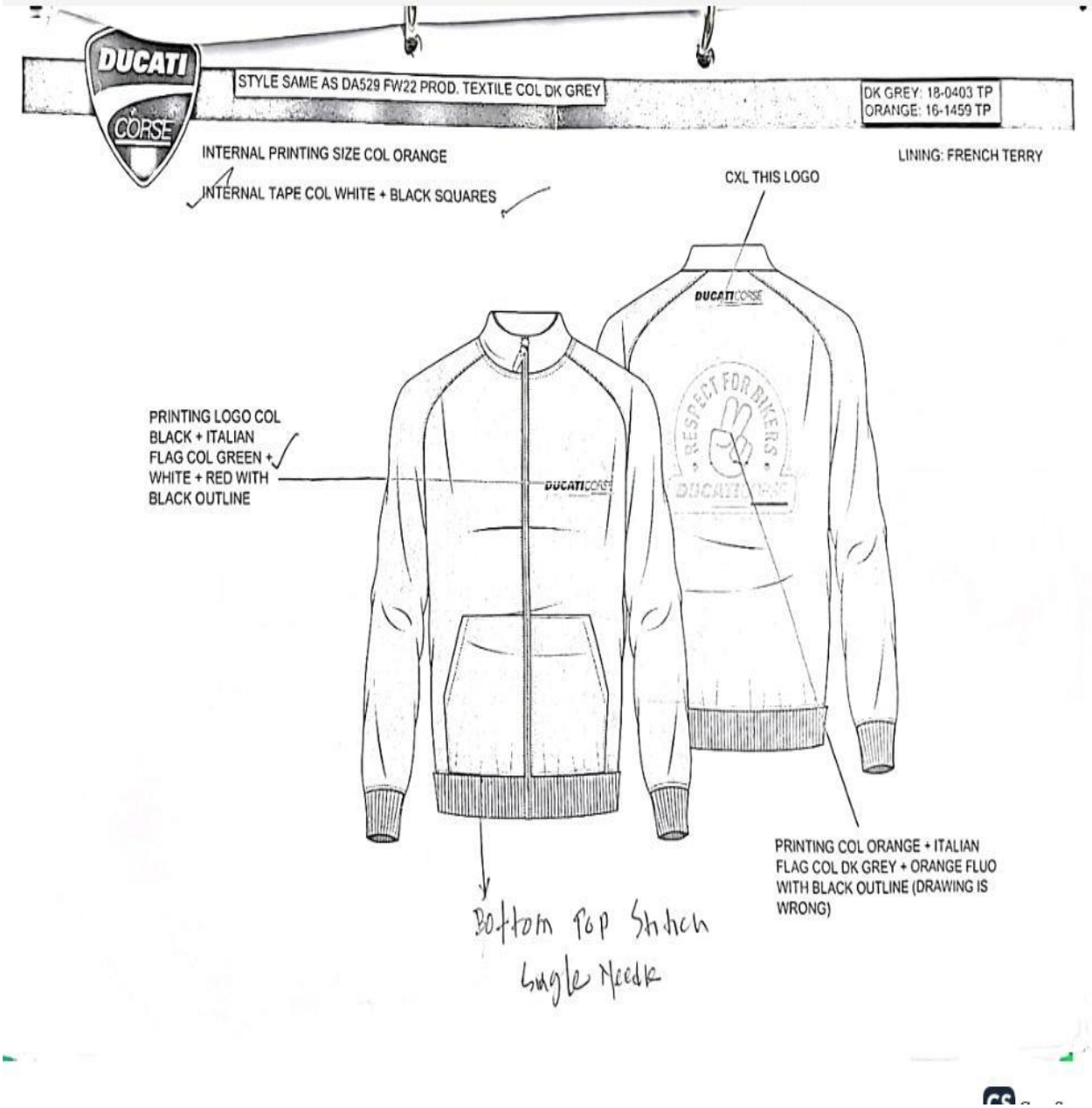


Figure 21: Techpack

This is the final measurement sheet. Where we can see "m" size is given as master size.

MENS HOODIE REGULAR
STYLE: DA408

MARKS	MEASUREMENTS	GRADE RULE	S	M	L	XL	2XL
A	LENGTH	2	70	72	74	76	78.0
B	CHEST	3/2	52	55	58	61	64.0
F	BOTTOM	3/2	48	51	54	57	60.0
D	BOTTOM RIB	2	41	43	45	47	49.0
E	SHOULDER TO SHOULDER	3/2	42	45	48	51	54.0
J	SLEEVE LENGTH	3/2	84	87	90	93	96.0
I	ARMHOLE	1	23	24	25	26	27.0
P	NECK OPENING	0.5	21	21.5	22	22.5	23.0
V	BOTTOM SLEEVE	1	11	12	13	14	15.0
M	FRONT NECK DROP FROM HPS	0.5	9	9.5	10	10.5	11.0
K	CUFF OPENING	0.5	9	9.5	10	10.5	11.0
O	CUFF HEIGHT	0	6	6	6	6	6.0
L	BOTTOM HEIGHT	0	6	6	6	6	6.0
J1	BICEPS	1	20	21	22	23	24.0
J2	ELBOW	1	15	16	17	18	19.0
MARKS	HOOD & POCKET MEASUREMENTS	GRADE RULE	S	M	L	XL	2XL
M1	HOOD HEIGHT	0.5	36	36.5	37	37.5	38.0
M2	HOOD WIDTH	0.5	25	25.5	26	26.5	27.0
Q2	POCKET HEIGHT	1	22	23	24	25	26.0
Q1	POCKET OPENING	0.5	14	14.5	15	15.5	16.0
G3	POCKET HEM HEIGHT	0	2	2	2	2	2.0
Q4	UPPER POCKET WIDTH	1	20	21	22	23	24.0
Q5	MAXIMUM POCKET WIDTH	1	31	2	33	34	35.0
Q6	LOWER POCKET WIDTH	1	26	27	28	29	30.0
**	DRAWCORD LENTH VISIBLE	0	20	20	20	20	20.0

Figure 22: Measurement sheet

This figure shows buyers pp comments in which buyers reflects the faults in pre-production sample.

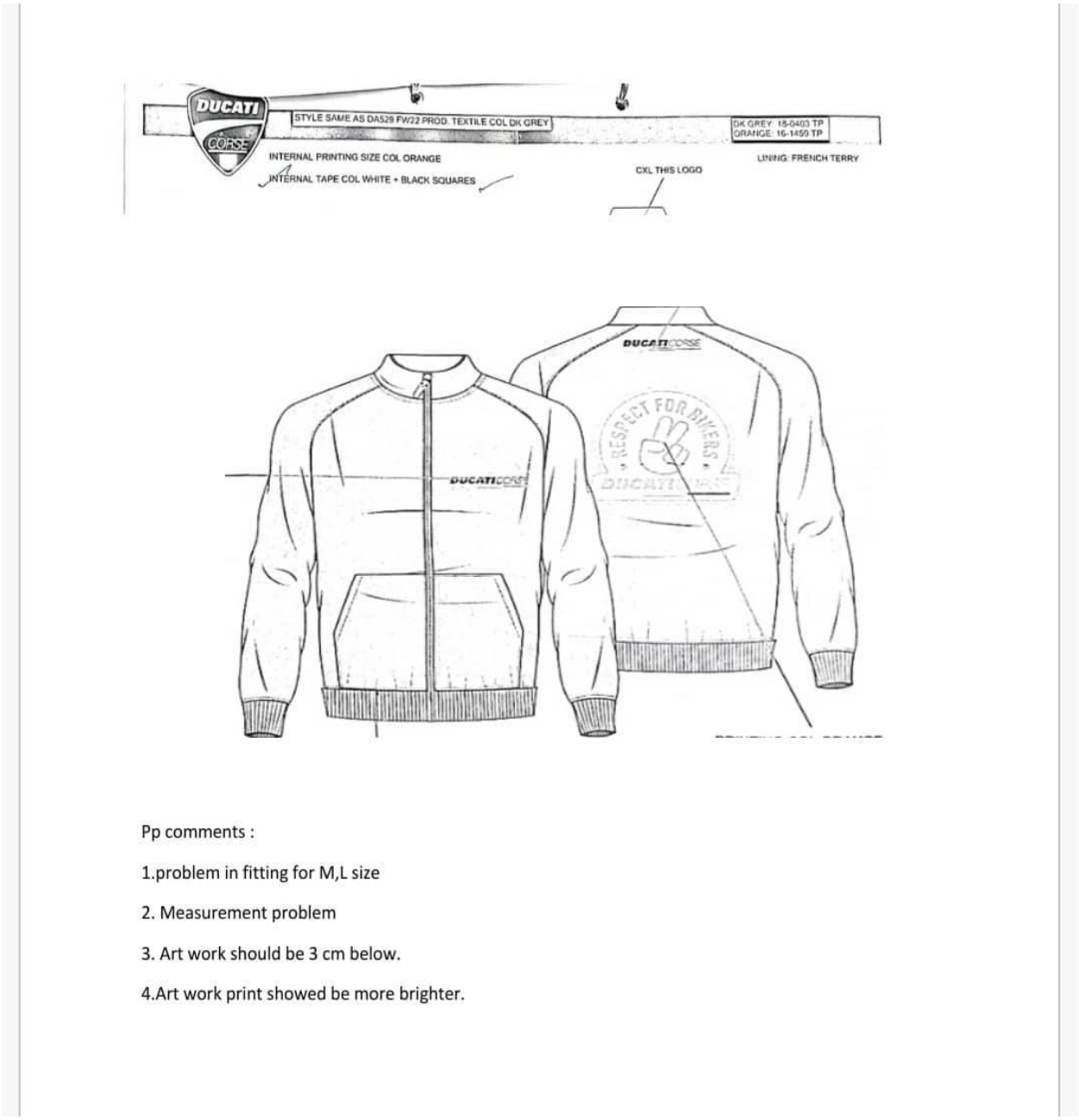


Figure 23: Buyers comments

This is also the final measurement sheet by which factory will match the final product.

T- SHIRT DA402, DA502, DA600, DA602, DA604, DA605, DA606, DA608, SC602, SC604, SC606, SC608

Sourcing Size TOP	XS	S	M	L	XL	2XL
A Body width	50.0	52.0	54.0	56.0	58.0	60.0
B Body lenght	68.0	70.0	72.0	74.0	77.0	80.0
C Armhole	20.5	21.5	22.5	23.5	24.5	25.5
C1 Muscle	16.5	17.5	18.5	19.5	20.5	21.5
C2 Muscle position from under armhole	1.5	1.5	1.5	1.5	1.5	1.5
*F Total shoulder width	42.5	44.0	45.5	47.0	48.5	50.0
F1 Shoulder drop	2.0	2.0	2.0	2.0	2.0	2.0
G3 Only short sleeve length	19.5	20.5	21.5	22.5	23.5	24.5
H Sleeve opening	14.5	15.5	16.5	17.5	18.5	19.5
J Bottom width	48.0	50.0	52.0	54.0	56.0	58.0
K1 Min meas of stretched neck opening	31.0	31.0	31.0	31.0	31.0	31.0
K Neck opening	17.5	18.0	18.5	19.0	20.0	20.5
L Front neck depth	9.0	9.0	9.5	9.5	10.5	10.5
L1 Back neck depth	1.8	1.8	1.8	1.8	1.8	1.8
N Neck height	2.0	2.0	2.0	2.0	2.0	2.0

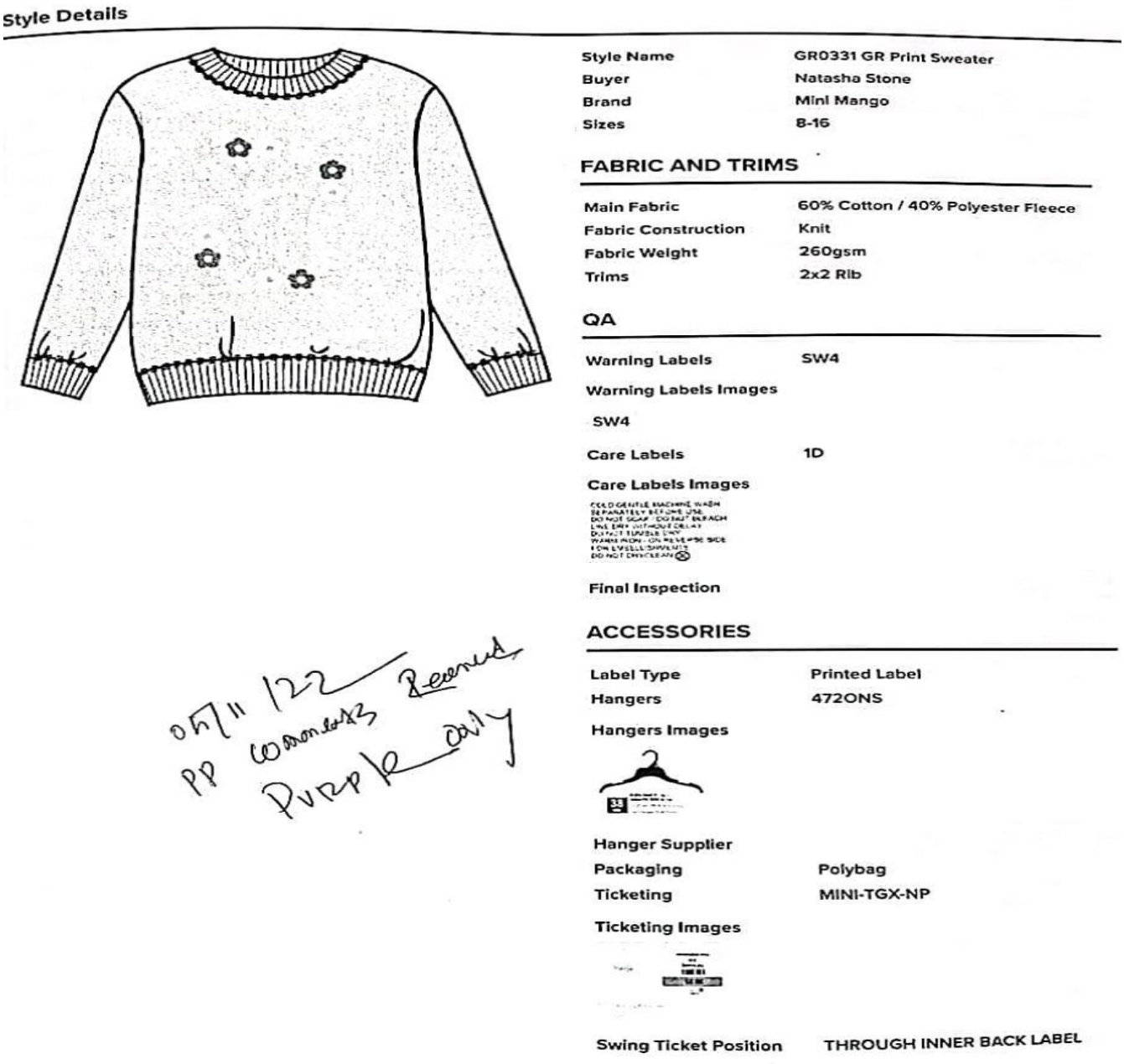
DUCATI MENS LS SWEAT SHIRT. Style = DA616, DA670.

Sourcing Size TOP	XS	S	M	L	XL	2XL
A Body width	49.0	52.0	55.0	58.0	61.0	64.0
B Body lenght	66.0	68.0	70.0	72.0	75.0	78.0
C Armhole	21.5	22.5	23.5	24.5	25.5	26.5
C1 Muscle	18.5	19.5	20.5	21.5	22.5	23.5
*F Total shoulder width	42.3	44.2	46.1	48.0	49.9	51.8
F1 Shoulder drop	2	2	2	2.0	2	2.0
G2 Only sleeve length	62.5	64.0	65.5	67.0	68.5	70.0
H1 Cuff opening	9.0	9.0	10.0	10.0	11.0	12.0
I Cuff height	6.0	6.0	6.0	6.0	6.0	6.0
IA Forearm position	15.0	15.0	15.0	15.0	15.0	15.0
I1 Forearm	14.0	14.0	15.0	16.0	17.0	18.0
J Bottom rib width	37.0	40.0	43.0	46.0	49.0	52.0
J Bottom width	44.0	47.0	50.0	53.0	56.0	59.0
J1 Bottom rib height	6.0	6.0	6.0	6.0	6.0	6.0
K Neck opening	16.5	17	17.5	18.0	18.5	19.0
K1 Min meas of stretched neck opening	31.0	31.0	31.0	31.0	31.0	31.0
L Front neck depth	9.0	9.0	9.5	9.5	10.0	10.5
L1 Back neck depth	1.8	1.8	1.8	1.8	1.8	1.8
N Neck height	2.0	2.0	2.0	2.0	2.0	2.0

Figure 24: Measurement sheet

3.4 Buyer – Best & Less

Here in this figure, we can see the buyers given product package where buyers give information about fabric, trims and accessories.



Style Details

Style Name	GR0331 GR Print Sweater
Buyer	Natasha Stone
Brand	Mini Mango
Sizes	8-16

FABRIC AND TRIMS

Main Fabric	60% Cotton / 40% Polyester Fleece
Fabric Construction	Knit
Fabric Weight	260gsm
Trims	2x2 Rib

QA

Warning Labels	SW4
Warning Labels Images	
SW4	
Care Labels	1D
Care Labels Images	
Final Inspection	

ACCESSORIES

Label Type	Printed Label
Hangers	472ONS
Hangers Images	
Hanger Supplier	
Packaging	Polybag
Ticketing	MINI-TGX-NP
Ticketing Images	
Swing Ticket Position	THROUGH INNER BACK LABEL

Figure 25: Techpack

This is the measurement sheet which gives information about different sizes.

Best & Less GR0331 GR Print Sweater GR0331 - Size spec Draft-Sample 04-11-2022, 11:39

POMs

PP Sample

POM	Description	Tol (-)	Tol (+)	8	9	10	12	14	16	Comment
A06	Chest Circ. - 3cm below U/Arm	0.00	0.00	90.00	92.50	95.00	100.00	105.00	110.00	
B01	Waist Circ.	-2.00	2.00	85.00	87.50	90.00	95.00	100.00	105.00	
D26	Hem Circ. 3 cm above Basque seam	-1.00	1.00	85.00	87.50	90.00	95.00	100.00	105.00	
D11	Hem Circ. - at Rib edge	-0.50	0.50	71.00	73.50	76.00	81.00	86.00	91.00	
E120	Top Length - HSP to hem	-1.00	1.00	52.00	54.00	56.00	59.00	62.00	64.00	
F05	Across Shoulder (Extended)	-1.00	1.00	47.50	48.75	50.00	52.50	55.00	57.50	
G01	Shoulder Drop	-0.50	0.50	4.00	4.00	4.00	4.00	4.00	4.00	
H01	Underarm Level - from HSP	-1.00	1.00	23.00	23.50	24.00	25.00	26.00	27.00	
I33	Across Front - Mid Armhole (Extended)	-0.50	0.50	45.50	46.75	48.00	50.50	53.00	55.50	
J23	Neck Width - seam to seam	-0.50	0.50	18.00	18.50	18.50	19.00	19.50	20.00	
J24	Front Neck Drop - HSP to seam	0.00	0.00	7.50	8.00	8.00	8.50	9.00	9.50	
J25	Back Neck Drop - HSP to seam	0.00	0.00	2.50	2.50	2.50	2.50	2.50	2.50	
J30	Neck Band Width	-0.50	0.50	2.00	2.00	2.00	2.00	2.00	2.00	
JMIN	Neck Circ. - MIN Stretched	-0.50	0.50	58.00	58.00	58.00	58.00	60.00	60.00	
K11	Sleeve Length - from Shoulder Point - Long (Extended)	-0.50	0.50	40.00	41.00	42.00	45.00	48.00	49.00	
L01	Upper Arm Circ. - at U/Arm	-1.00	1.00	38.00	39.00	40.00	42.00	44.00	46.00	
M06	Undersleeve Length (Extended) - Long	-0.50	0.50	38.00	39.00	40.00	43.00	46.00	47.00	
N23	Sleeve Circ. 3 cm above cuff seam	-0.50	0.50	20.00	20.50	21.00	22.00	23.00	24.00	
N04	Sleeve Opening Circ. - Long	-1.00	1.00	17.00	17.50	18.00	19.00	20.00	21.00	
N24	Sleeve Cuff Depth	-0.50	0.50	7.00	7.00	7.00	7.00	7.00	7.00	
N38	Basque Depth	-0.50	0.50	7.00	7.00	7.00	7.00	7.00	7.00	

Displaying 21 results Units: CM Grade Rule Display: Absolute

14/11/22
PP Sample sent
Pink Sample size 10+16

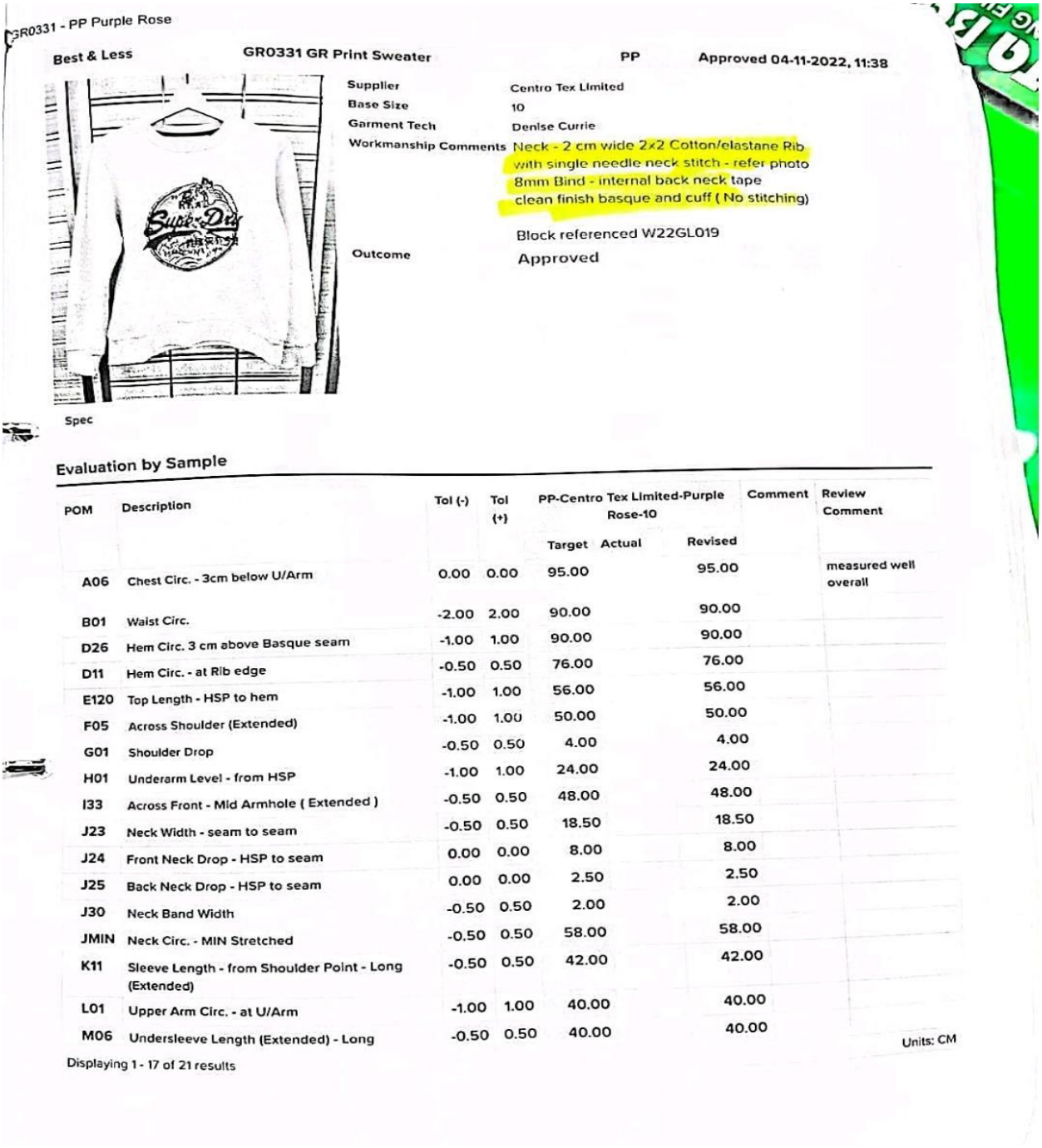
14/11/22

29/12/22
PP Sample sent
(Henderson Hems + F (Pink))

29/12/22

Figure 26: Measurement sheet

This figure shows the workmanship defects though buyer's comment. Also shows this style pp sample is approved.



GR0331 - PP Purple Rose

Best & Less — GR0331 GR Print Sweater — PP — Approved 04-11-2022, 11:38

Supplier: Centro Tex Limited
Base Size: 10
Garment Tech: Denise Currie
Workmanship Comments: Neck - 2 cm wide 2x2 Cotton/elastane Rib with single needle neck stitch - refer photo
8mm Bind - internal back neck tape
clean finish basque and cuff (No stitching)

Block referenced W22GL019

Outcome: Approved

Spec

Evaluation by Sample

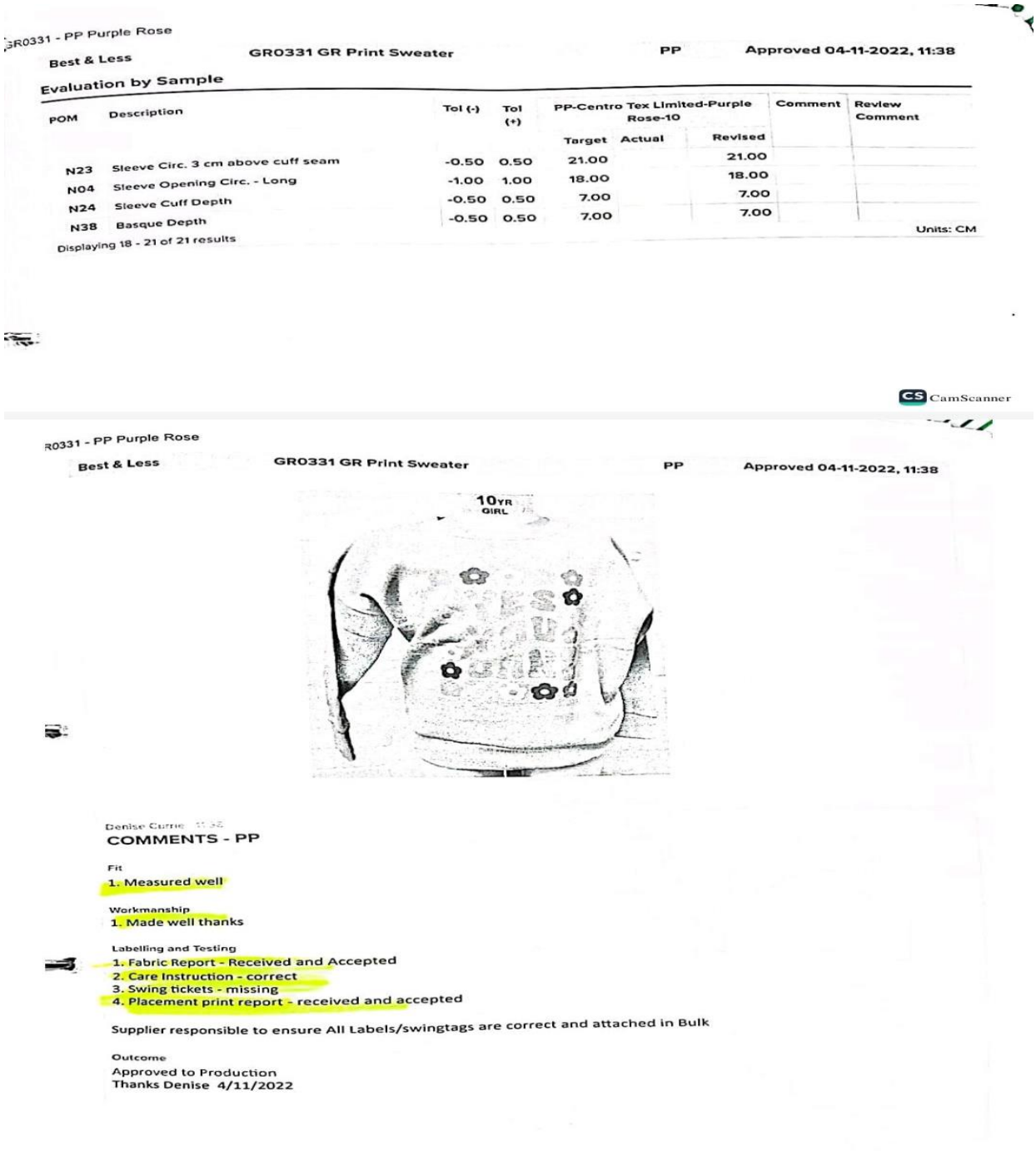
POM	Description	Tol (-)	Tol (+)	PP-Centro Tex Limited-Purple Rose-10 Target	Actual	Revised	Comment	Review Comment
A06	Chest Circ. - 3cm below U/Arm	0.00	0.00	95.00		95.00		measured well overall
B01	Waist Circ.	-2.00	2.00	90.00		90.00		
D26	Hem Circ. 3 cm above Basque seam	-1.00	1.00	90.00		90.00		
D11	Hem Circ. - at Rib edge	-0.50	0.50	76.00		76.00		
E120	Top Length - HSP to hem	-1.00	1.00	56.00		56.00		
F05	Across Shoulder (Extended)	-1.00	1.00	50.00		50.00		
G01	Shoulder Drop	-0.50	0.50	4.00		4.00		
H01	Underarm Level - from HSP	-1.00	1.00	24.00		24.00		
I33	Across Front - Mid Armhole (Extended)	-0.50	0.50	48.00		48.00		
J23	Neck Width - seam to seam	-0.50	0.50	18.50		18.50		
J24	Front Neck Drop - HSP to seam	0.00	0.00	8.00		8.00		
J25	Back Neck Drop - HSP to seam	0.00	0.00	2.50		2.50		
J30	Neck Band Width	-0.50	0.50	2.00		2.00		
JMIN	Neck Circ. - MIN Stretched	-0.50	0.50	58.00		58.00		
K11	Sleeve Length - from Shoulder Point - Long (Extended)	-0.50	0.50	42.00		42.00		
L01	Upper Arm Circ. - at U/Arm	-1.00	1.00	40.00		40.00		
M06	Undersleeve Length (Extended) - Long	-0.50	0.50	40.00		40.00		

Displaying 1 - 17 of 21 results

Units: CM

*Figure 27: **Buyers comments***

This figure shows measurement sheet and different pp comments of buyers where different defects are found underlined by buyer.



GR0331 - PP Purple Rose

Best & Less | GR0331 GR Print Sweater | PP | Approved 04-11-2022, 11:38

Evaluation by Sample

POM	Description	Tol (-)	Tol (+)	PP-Centro Tex Limited-Purple Rose-10 Target	Actual	Revised	Comment	Review Comment
N23	Sleeve Circ. 3 cm above cuff seam	-0.50	0.50	21.00		21.00		
N04	Sleeve Opening Circ. - Long	-1.00	1.00	18.00		18.00		
N24	Sleeve Cuff Depth	-0.50	0.50	7.00		7.00		
N38	Basque Depth	-0.50	0.50	7.00		7.00		

Displaying 18 - 21 of 21 results

Units: CM

CamScanner

R0331 - PP Purple Rose

Best & Less | GR0331 GR Print Sweater | PP | Approved 04-11-2022, 11:38

Denise Currie

COMMENTS - PP

Fit
1. Measured well

Workmanship
1. Made well thanks

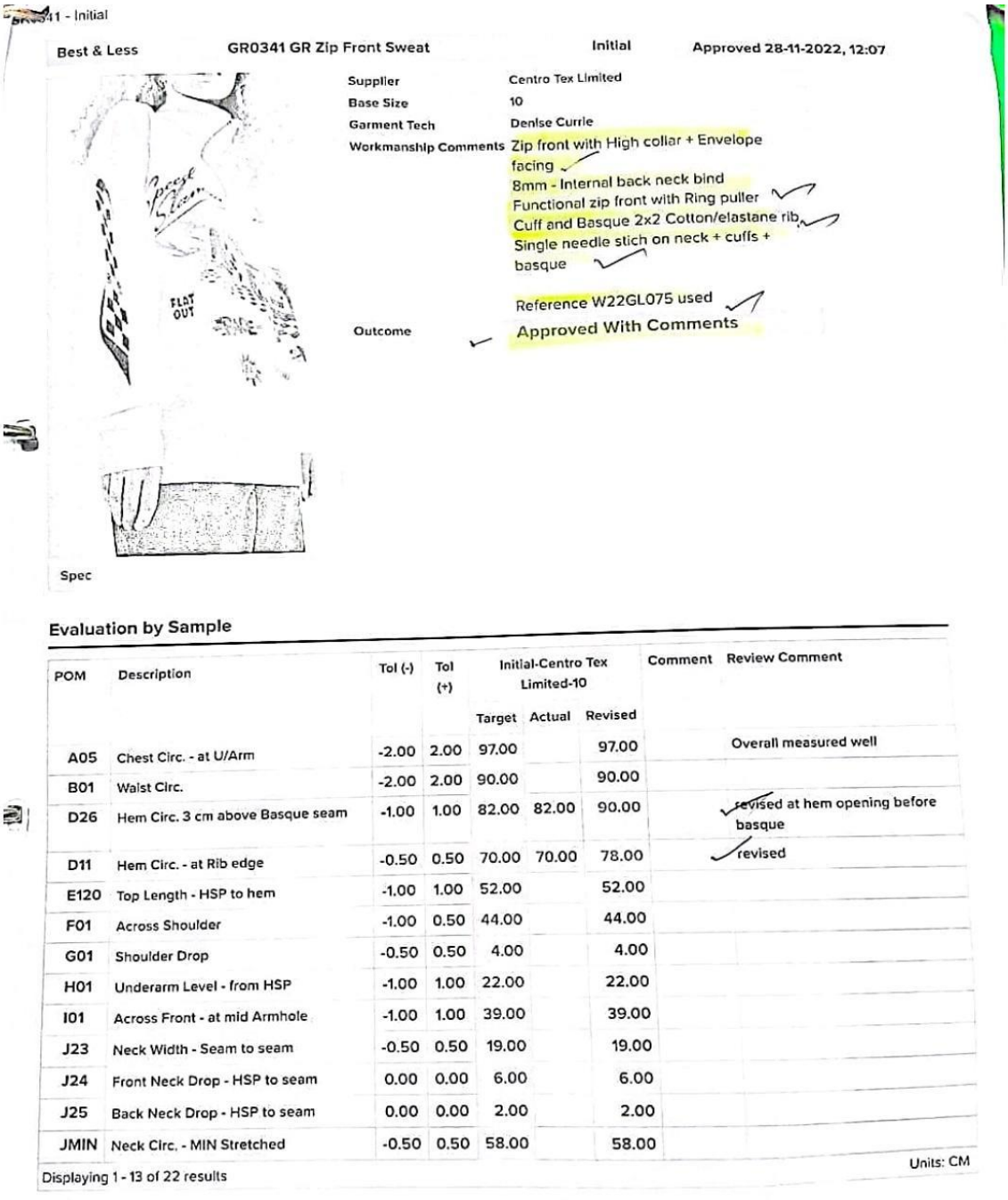
Labelling and Testing
1. Fabric Report - Received and Accepted
2. Care Instruction - correct
3. Swing tickets - missing
4. Placement print report - received and accepted

Supplier responsible to ensure All Labels/swingtags are correct and attached in Bulk

Outcome
Approved to Production
Thanks Denise 4/11/2022

Figure 28: Buyers comments

This figure shows workmanship defects and measurement sheet.



1 - Initial

Best & Less | GR0341 GR Zip Front Sweat | Initial | Approved 28-11-2022, 12:07

Supplier: Centro Tex Limited
Base Size: 10
Garment Tech: Denise Currie
Workmanship Comments: Zip front with High collar + Envelope facing
8mm - Internal back neck bind
Functional zip front with Ring puller
Cuff and Basque 2x2 Cotton/elastane rib
Single needle stich on neck + cuffs + basque
Reference W22GL075 used
Outcome: Approved With Comments

Spec

Evaluation by Sample

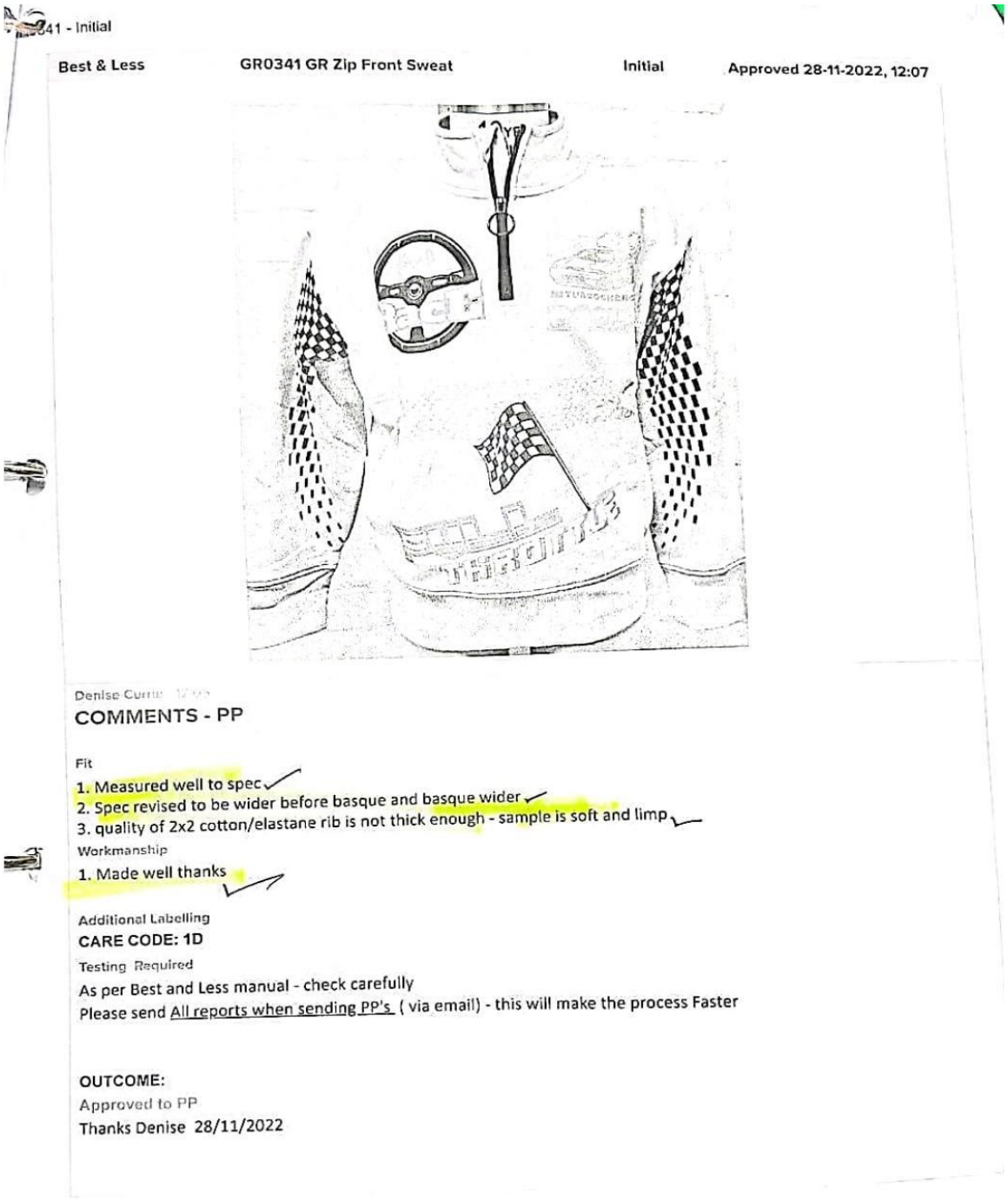
POM	Description	Tol (-)	Tol (+)	Initial-Centro Tex Limited-10 Target	Actual	Revised	Comment	Review Comment
A05	Chest Circ. - at U/Arm	-2.00	2.00	97.00		97.00		Overall measured well
B01	Waist Circ.	-2.00	2.00	90.00		90.00		
D26	Hem Circ. 3 cm above Basque seam	-1.00	1.00	82.00	82.00	90.00		revised at hem opening before basque
D11	Hem Circ. - at Rib edge	-0.50	0.50	70.00	70.00	78.00		revised
E120	Top Length - HSP to hem	-1.00	1.00	52.00		52.00		
F01	Across Shoulder	-1.00	0.50	44.00		44.00		
G01	Shoulder Drop	-0.50	0.50	4.00		4.00		
H01	Underarm Level - from HSP	-1.00	1.00	22.00		22.00		
I01	Across Front - at mid Armhole	-1.00	1.00	39.00		39.00		
J23	Neck Width - Seam to seam	-0.50	0.50	19.00		19.00		
J24	Front Neck Drop - HSP to seam	0.00	0.00	6.00		6.00		
J25	Back Neck Drop - HSP to seam	0.00	0.00	2.00		2.00		
JMIN	Neck Circ. - MIN Stretched	-0.50	0.50	58.00		58.00		

Displaying 1 - 13 of 22 results

Units: CM

Figure 29: Defects & measurements

This figure shows buyers different pp comments and problem found in the production. It also gives the buyers approval green signal to the factory.



341 - Initial

Best & Less GR0341 GR Zip Front Sweat Initial Approved 28-11-2022, 12:07

Denise Curtis

COMMENTS - PP

Fit

1. Measured well to spec
2. Spec revised to be wider before basque and basque wider
3. quality of 2x2 cotton/elastane rib is not thick enough - sample is soft and limp

Workmanship

1. Made well thanks

Additional Labelling

CARE CODE: 1D

Testing Required

As per Best and Less manual - check carefully

Please send All reports when sending PP's (via email) - this will make the process Faster

OUTCOME:

Approved to PP

Thanks Denise 28/11/2022

Figure 30: Buyers comments

3.5 Buyer – Medicine

This figure shows different sample comments like fit sample and pp sample.

MOSHARAF APPERALS STUDIO LTD.

(SAMPLE SACTION)

BUYER- CHANGED COMMENTS ON SAMPLES SUBMISSION- LOG SHEET

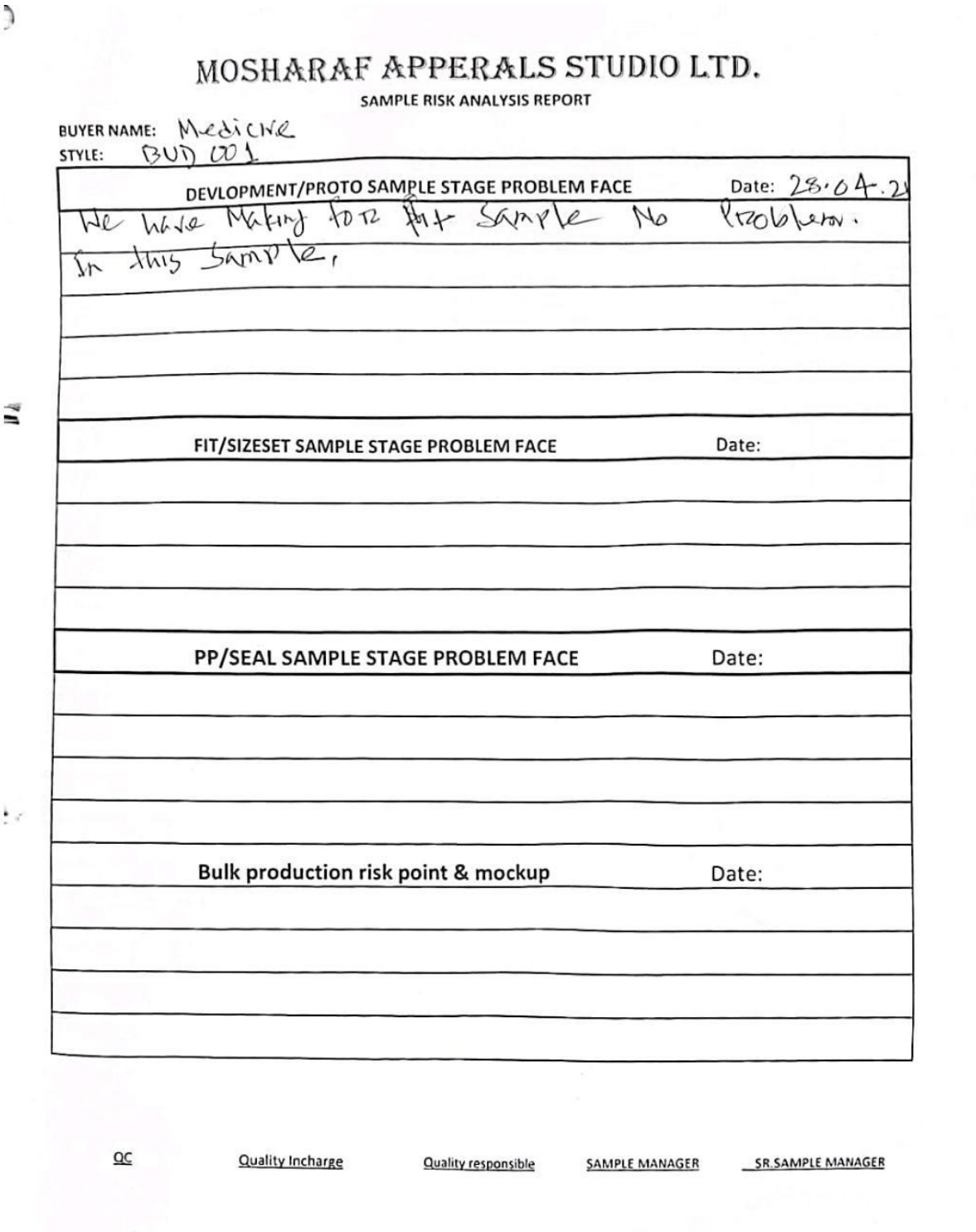
BUYER	Medicine
STYLE	BUD 001

SL.NO	SAMPLE TYPE	COMMENTS & CHANGES
1	DEVOLOPMENT/PROTO SAMPLE	
2	FIT SAMPLE	Buyer some points M/C Different Sec a (Shoulder + Neck + Length) we have Improve In this points then Making
3	PP / SMS SAMPLE	for a PP Sample Buyer PP sample Accepted Go for Bulk Production.
4	SHIPPING SAMPLE	
5	TEST SAMPLE	

SAMPLE SECTION SIZE SET QUALITY PRO: GPQ

Figure 31: Buyers comments

This figure shows buyers comments on development sample.



MOSHARAF APPERALS STUDIO LTD.

SAMPLE RISK ANALYSIS REPORT

BUYER NAME: Medicine

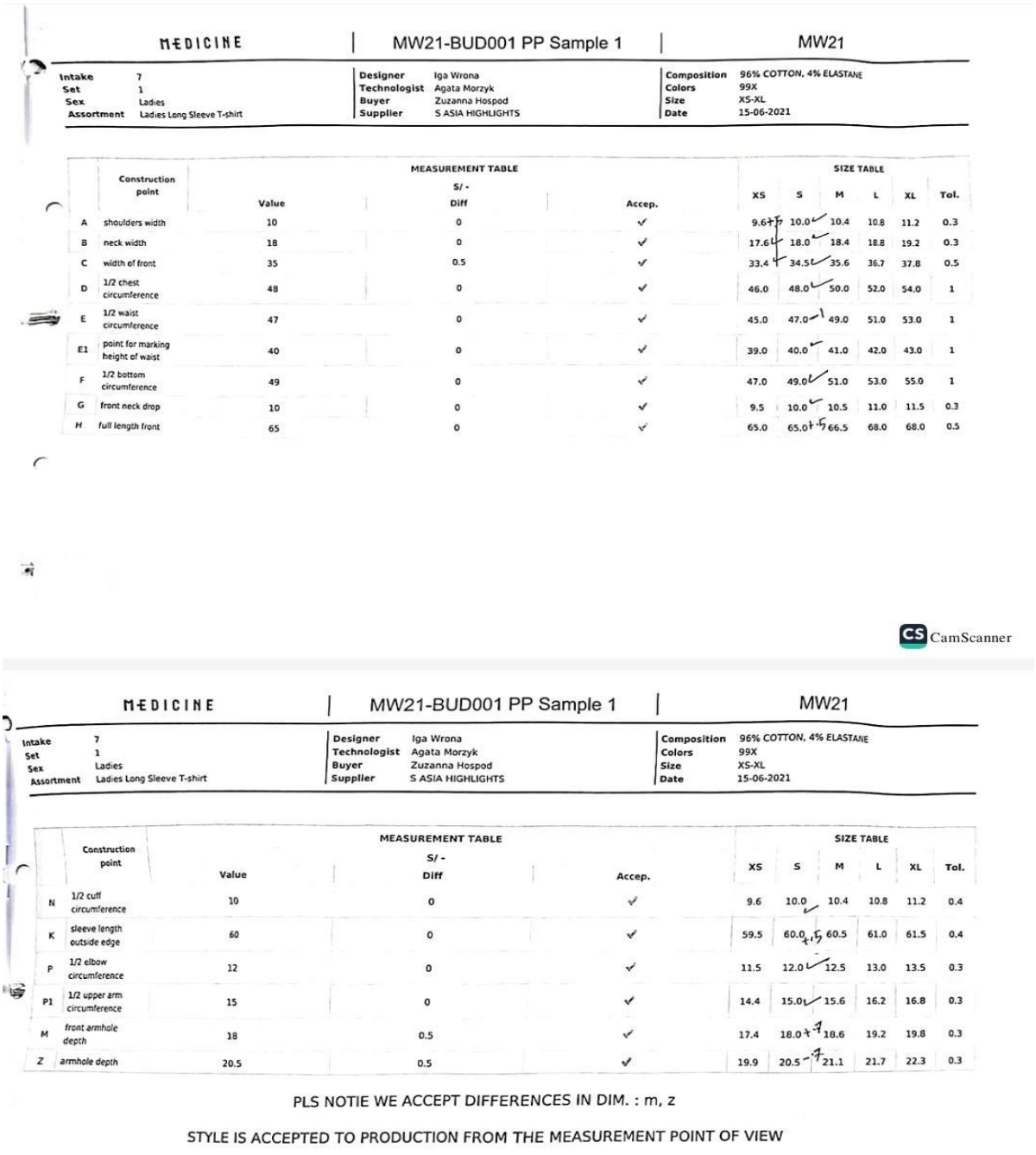
STYLE: BUD 001

DEVLOPMENT/PROTO SAMPLE STAGE PROBLEM FACE	Date: 28.04.21
We have Making for Fit Sample No Problem. In this Sample.	
FIT/SIZESET SAMPLE STAGE PROBLEM FACE	**Date:**
PP/SEAL SAMPLE STAGE PROBLEM FACE	**Date:**
Bulk production risk point & mockup	**Date:**

QC Quality Incharge Quality responsible SAMPLE MANAGER SR.SAMPLE MANAGER

Figure 32: buyers comments

This figure shows the buyers given size specification.



MEDICINE | MW21-BUD001 PP Sample 1 | MW21

Intake	7	Designer	Iga Wrona	Composition	96% COTTON, 4% ELASTANE
Set	1	Technologist	Agata Morzyk	Colors	99X
Sex	Ladies	Buyer	Zuzanna Hospod	Size	XS-XL
Assortment	Ladies Long Sleeve T-shirt	Supplier	S ASIA HIGHLIGHTS	Date	15-06-2021

	Construction point	MEASUREMENT TABLE Value	S/ - Diff	Accep.	SIZE TABLE XS	S	M	L	XL	Tol.
A	shoulders width	10	0	✓	9.6	10.0	10.4	10.8	11.2	0.3
B	neck width	18	0	✓	17.6	18.0	18.4	18.8	19.2	0.3
C	width of front	35	0.5	✓	33.4	34.5	35.6	36.7	37.8	0.5
D	1/2 chest circumference	48	0	✓	46.0	48.0	50.0	52.0	54.0	1
E	1/2 waist circumference	47	0	✓	45.0	47.0	49.0	51.0	53.0	1
E1	point for marking height of waist	40	0	✓	39.0	40.0	41.0	42.0	43.0	1
F	1/2 bottom circumference	49	0	✓	47.0	49.0	51.0	53.0	55.0	1
G	front neck drop	10	0	✓	9.5	10.0	10.5	11.0	11.5	0.3
H	full length front	65	0	✓	65.0	65.0	66.5	68.0	68.0	0.5

CamScanner

MEDICINE | MW21-BUD001 PP Sample 1 | MW21

Intake	7	Designer	Iga Wrona	Composition	96% COTTON, 4% ELASTANE
Set	1	Technologist	Agata Morzyk	Colors	99X
Sex	Ladies	Buyer	Zuzanna Hospod	Size	XS-XL
Assortment	Ladies Long Sleeve T-shirt	Supplier	S ASIA HIGHLIGHTS	Date	15-06-2021

	Construction point	MEASUREMENT TABLE Value	S/ - Diff	Accep.	SIZE TABLE XS	S	M	L	XL	Tol.
N	1/2 cuff circumference	10	0	✓	9.6	10.0	10.4	10.8	11.2	0.4
K	sleeve length outside edge	60	0	✓	59.5	60.0	60.5	61.0	61.5	0.4
P	1/2 elbow circumference	12	0	✓	11.5	12.0	12.5	13.0	13.5	0.3
P1	1/2 upper arm circumference	15	0	✓	14.4	15.0	15.6	16.2	16.8	0.3
M	front armhole depth	18	0.5	✓	17.4	18.0	18.6	19.2	19.8	0.3
Z	armhole depth	20.5	0.5	✓	19.9	20.5	21.1	21.7	22.3	0.3

PLS NOTIE WE ACCEPT DIFFERENCES IN DIM. : m, z

STYLE IS ACCEPTED TO PRODUCTION FROM THE MEASUREMENT POINT OF VIEW

Figure 33: Measurement sheet

Here buyers given comments on fit sample and SMS sample are shown.

MOSHARAF APPERALS STUDIO LTD.

(SAMPLE SACTION)

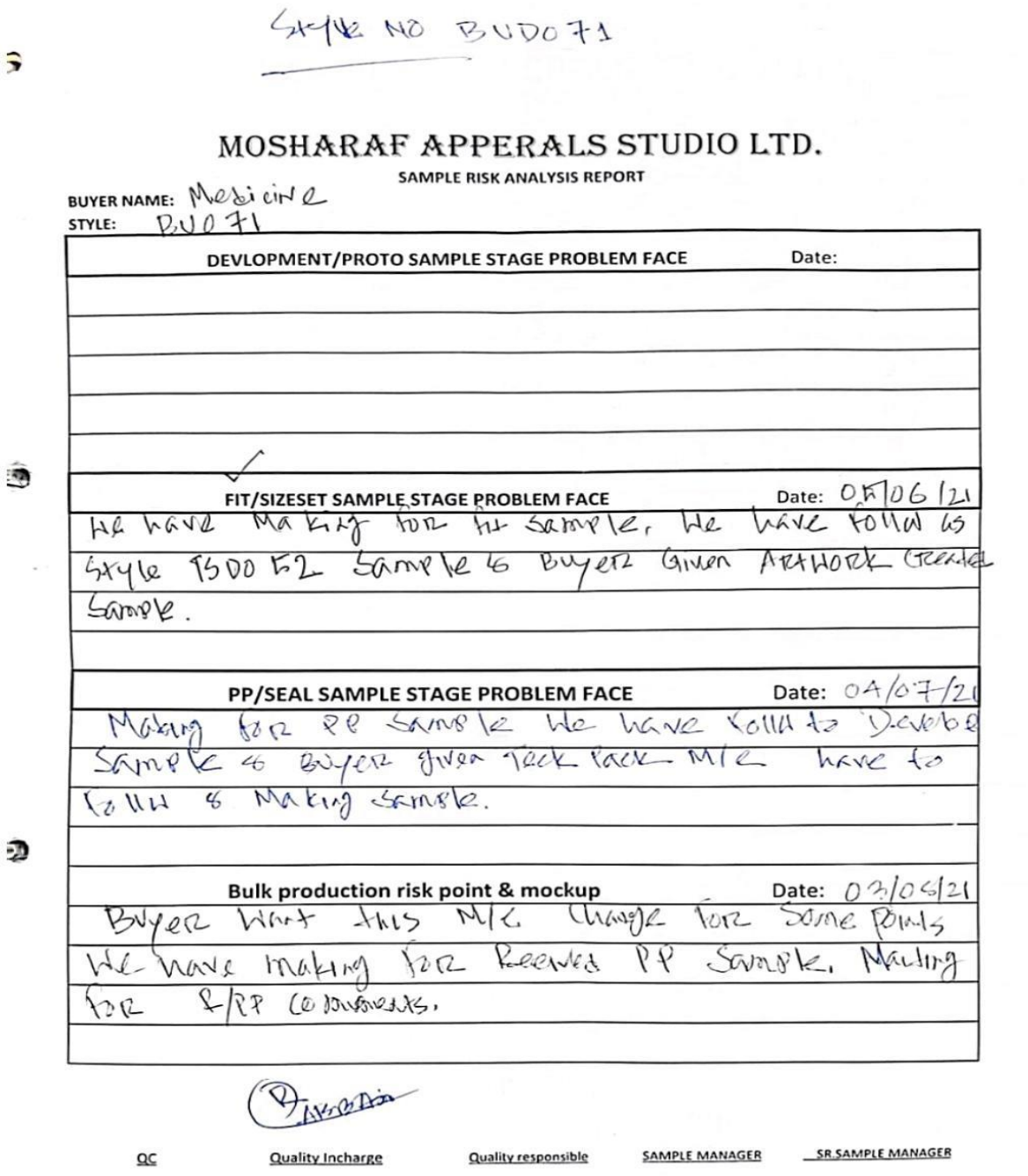
BUYER- CHANGED COMMENTS ON SAMPLES SUBMISSION- LOG SHEET

	BUYER	Medicine
	STYLE	BUM001
SL.NO	**SAMPLE TYPE**	**COMMENTS & CHANGES**
1	DEVOLOPMENT/PROTO SAMPLE	
2	FIT SAMPLE	Buyer given fit comments below, (Black color Not ok + Discharge print missing + Accessories) Missing some M/C point Differents Pls improve & we have follow & making next sample
3	PP / SMS SAMPLE	Buyer given PP comment Accepted But print improve to bulk production
4	SHIPPING SAMPLE	
5	TEST SAMPLE	

SAMPLE SECTION   SIZE SET QUALITY PRO: GPQ

Figure 34: Buyers comments

This figure shows buyers comments on fit sample and seal sample also it analyses bulk production risks and mockup.



STYLE NO BUD071

MOSHARAF APPERALS STUDIO LTD.

SAMPLE RISK ANALYSIS REPORT

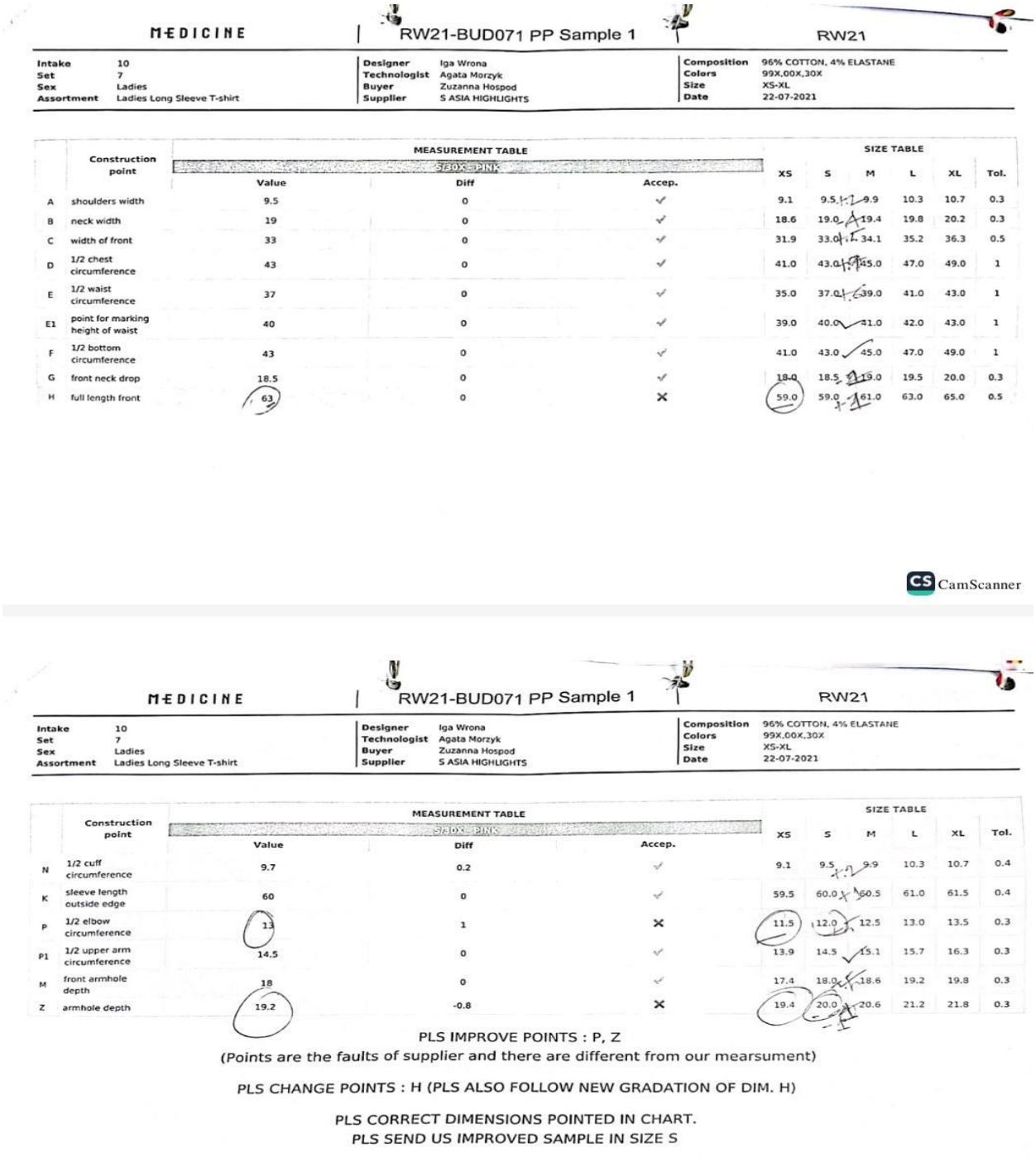
BUYER NAME: Medicine

STYLE: BUD71

DEVLOPMENT/PROTO SAMPLE STAGE PROBLEM FACE	Date:
FIT/SIZESET SAMPLE STAGE PROBLEM FACE	Date: 05/06/21
We have Making for fit sample. We have follow us Style TSDD52 Sample & Buyer Given ARTWORK Created Sample.	
PP/SEAL SAMPLE STAGE PROBLEM FACE	Date: 04/07/21
Making for PP Sample We have follow to Develop Sample & Buyer given Tick Pack M/C have to follow & Making Sample.	
Bulk production risk point & mockup	Date: 03/05/21
Buyer Want this M/C Change for Some Points We have making for Revised PP Sample. Making for F/PP Comments.	

QC Quality Incharge Quality responsible SAMPLE MANAGER SR.SAMPLE MANAGER

Figure 35: Buyers comments



MEDICINE | RW21-BUD071 PP Sample 1 | RW21

Intake	10	Designer	Iga Wrona	Composition	96% COTTON, 4% ELASTANE
Set	7	Technologist	Agata Morzyk	Colors	99X,00X,30X
Sex	Ladies	Buyer	Zuzanna Hospod	Size	XS-XL
Assortment	Ladies Long Sleeve T-shirt	Supplier	S ASIA HIGHLIGHTS	Date	22-07-2021

	Construction point	MEASUREMENT TABLE SB0X - PINK Value	Diff	Accep.	SIZE TABLE XS	S	M	L	XL	Tol.
A	shoulders width	9.5	0	✓	9.1	9.5	9.9	10.3	10.7	0.3
B	neck width	19	0	✓	18.6	19.0	19.4	19.8	20.2	0.3
C	width of front	33	0	✓	31.9	33.0	34.1	35.2	36.3	0.5
D	1/2 chest circumference	43	0	✓	41.0	43.0	45.0	47.0	49.0	1
E	1/2 waist circumference	37	0	✓	35.0	37.0	39.0	41.0	43.0	1
E1	point for marking height of waist	40	0	✓	39.0	40.0	41.0	42.0	43.0	1
F	1/2 bottom circumference	43	0	✓	41.0	43.0	45.0	47.0	49.0	1
G	front neck drop	18.5	0	✓	18.0	18.5	19.0	19.5	20.0	0.3
H	full length front	63	0	✗	59.0	59.0	61.0	63.0	65.0	0.5

CamScanner

MEDICINE | RW21-BUD071 PP Sample 1 | RW21

Intake	10	Designer	Iga Wrona	Composition	96% COTTON, 4% ELASTANE
Set	7	Technologist	Agata Morzyk	Colors	99X,00X,30X
Sex	Ladies	Buyer	Zuzanna Hospod	Size	XS-XL
Assortment	Ladies Long Sleeve T-shirt	Supplier	S ASIA HIGHLIGHTS	Date	22-07-2021

	Construction point	MEASUREMENT TABLE SB0X - PINK Value	Diff	Accep.	SIZE TABLE XS	S	M	L	XL	Tol.
N	1/2 cuff circumference	9.7	0.2	✓	9.1	9.5	9.9	10.3	10.7	0.4
K	sleeve length outside edge	60	0	✓	59.5	60.0	60.5	61.0	61.5	0.4
P	1/2 elbow circumference	13	1	✗	11.5	12.0	12.5	13.0	13.5	0.3
P1	1/2 upper arm circumference	14.5	0	✓	13.9	14.5	15.1	15.7	16.3	0.3
M	front armhole depth	18	0	✓	17.4	18.0	18.6	19.2	19.8	0.3
Z	armhole depth	19.2	-0.8	✗	19.4	20.0	20.6	21.2	21.8	0.3

PLS IMPROVE POINTS : P, Z
(Points are the faults of supplier and there are different from our mearsument)

PLS CHANGE POINTS : H (PLS ALSO FOLLOW NEW GRADATION OF DIM. H)

PLS CORRECT DIMENSIONS POINTED IN CHART.
PLS SEND US IMPROVED SAMPLE IN SIZE S

Figure 36: Measurement sheet

Buyers given comments on proto sample is shown here.

MOSHARAF APPERALS STUDIO LTD.

SAMPLE RISK ANALYSIS REPORT

BUYER NAME: Medicine
STYLE: TSDA06

DEVLOPMENT/PROTO SAMPLE STAGE PROBLEM FACE	Date: 10.04.21
We have Greated a Develop Sample. We have face some Problem. before Attach a Stone, cutting then Making For Sample. very Crutial Issue of Point Setting For Body Press the Body Machine fit hole & Rejection. Neck Press s/b Looks Not Well, but M/B follw.	
FIT/SIZESET SAMPLE STAGE PROBLEM FACE	**Date:**
PP/SEAL SAMPLE STAGE PROBLEM FACE	**Date:**
Bulk production risk point & mockup	**Date:**

10/04/21

QC | Quality Incharge | Quality responsible | SAMPLE MANAGER | SR.SAMPLE MANAGER

Figure 37: Buyers comments

This shows seal sample comments and bulk production risks and mock up.

MOSHARAF APPERALS STUDIO LTD.

SAMPLE RISK ANALYSIS REPORT

BUYER NAME: Medline

STYLE: PO M-403

DEVLOPMENT/PROTO SAMPLE STAGE PROBLEM FACE	Date:
FIT/SIZESET SAMPLE STAGE PROBLEM FACE	Date:
PP/SEAL SAMPLE STAGE PROBLEM FACE	Date: 01.03.21
We have created PP sample. We have face some problem in this sample. Collar ban & snap button are uneven. Length -2cm. Follow the master sample & buyer techpack.	
Bulk production risk point & mockup	Date:
S/b Interfacing Duble Use Collar band. Cuff Not visible Seam Point M/c be Carefully.	

QC | Quality Incharge 01.03.21 | Quality responsible | SAMPLE MANAGER | SR.SAMPLE MANAGER

Figure 38: Buyers comments

This figure summarizes the different defects found on this order.

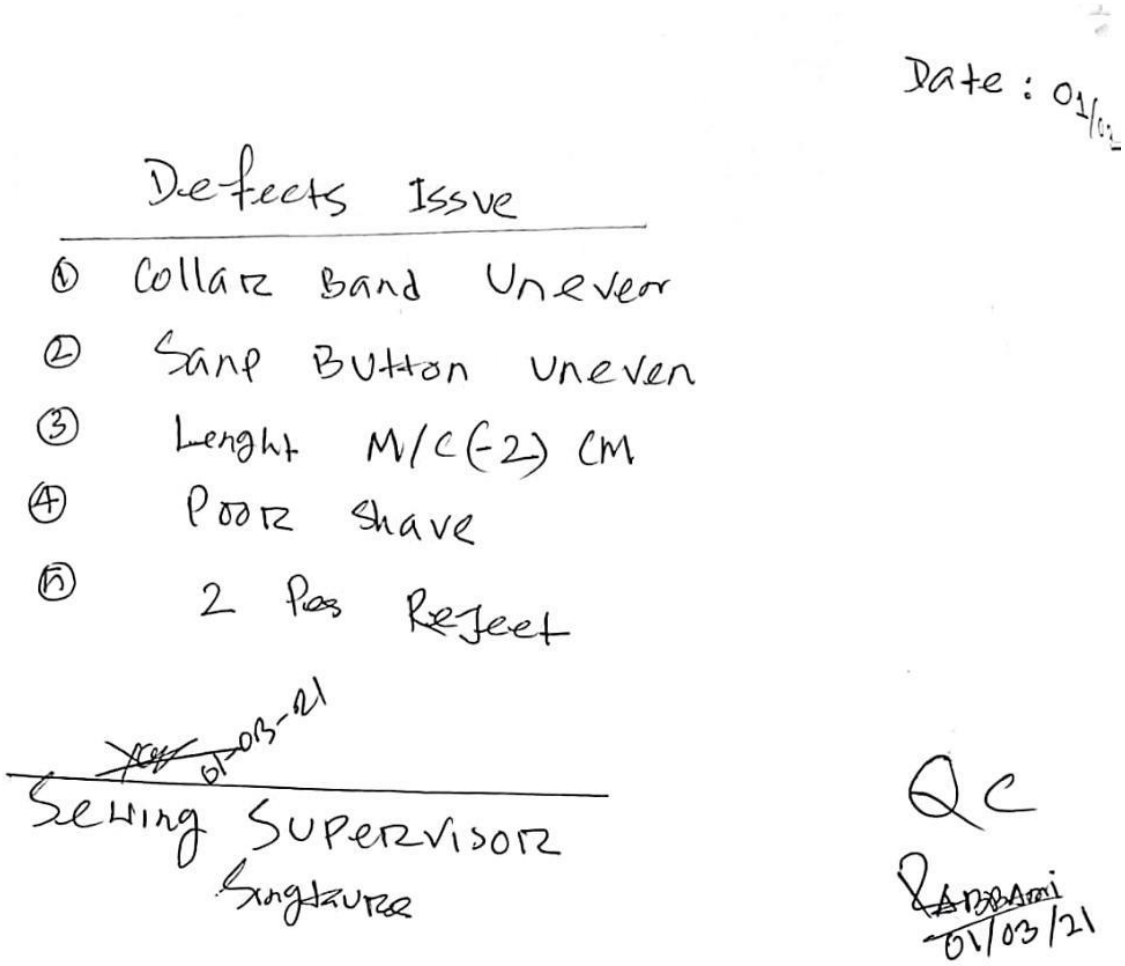
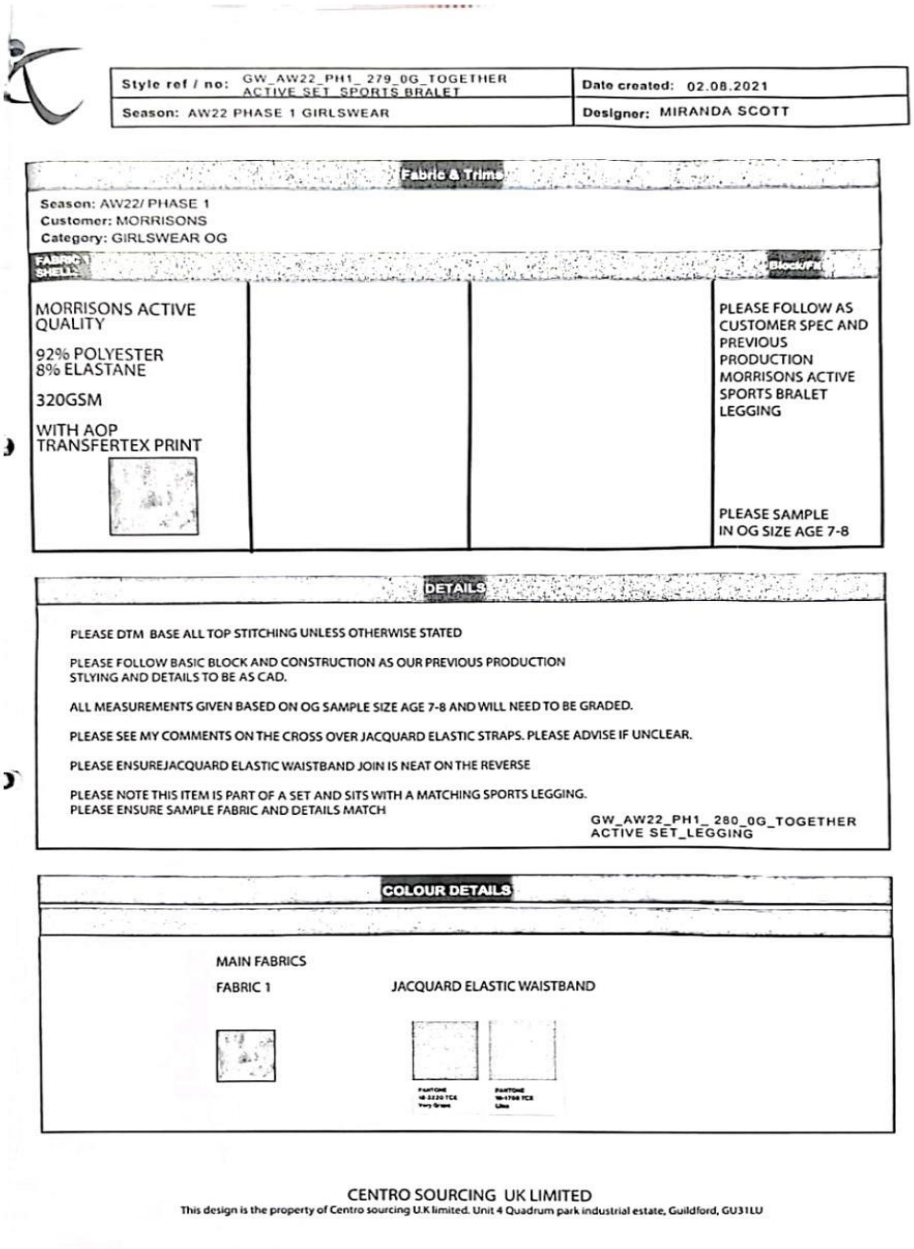


Figure 39: Defects

3.6 Buyer – Nutmeg

This figure shows Produce package. Which holds different information about order.



Style ref / no: GW_AW22_PH1_ 279_0G_TOGETHER ACTIVE SET_SPORTS BRALET	Date created: 02.08.2021
Season: AW22 PHASE 1 GIRLSWEAR	Designer: MIRANDA SCOTT

Fabric & Trims

Season: AW22/ PHASE 1
Customer: MORRISONS
Category: GIRLSWEAR OG

Fabric Sheet			Block/Pat
MORRISONS ACTIVE QUALITY 92% POLYESTER 8% ELASTANE 320GSM WITH AOP TRANSFERTEX PRINT			PLEASE FOLLOW AS CUSTOMER SPEC AND PREVIOUS PRODUCTION MORRISONS ACTIVE SPORTS BRALET LEGGING PLEASE SAMPLE IN OG SIZE AGE 7-8

DETAILS

PLEASE DTM BASE ALL TOP STITCHING UNLESS OTHERWISE STATED

PLEASE FOLLOW BASIC BLOCK AND CONSTRUCTION AS OUR PREVIOUS PRODUCTION STLYING AND DETAILS TO BE AS CAD.

ALL MEASUREMENTS GIVEN BASED ON OG SAMPLE SIZE AGE 7-8 AND WILL NEED TO BE GRADED.

PLEASE SEE MY COMMENTS ON THE CROSS OVER JACQUARD ELASTIC STRAPS. PLEASE ADVISE IF UNCLEAR.

PLEASE ENSUREJACQUARD ELASTIC WAISTBAND JOIN IS NEAT ON THE REVERSE

PLEASE NOTE THIS ITEM IS PART OF A SET AND SITS WITH A MATCHING SPORTS LEGGING.
PLEASE ENSURE SAMPLE FABRIC AND DETAILS MATCH

GW_AW22_PH1_ 280_0G_TOGETHER ACTIVE SET_LEGGING

COLOUR DETAILS

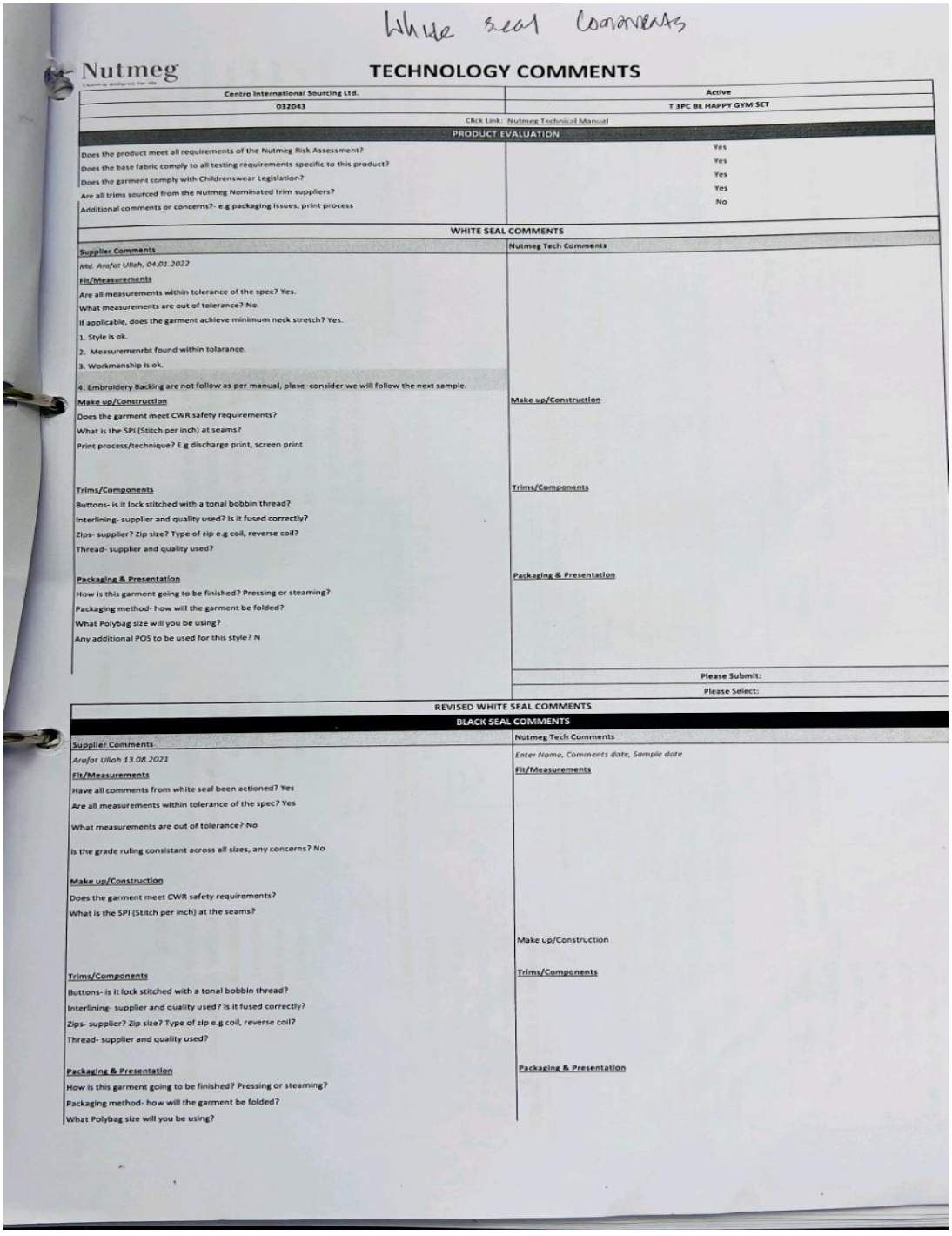
MAIN FABRICS

FABRIC 1 — JACQUARD ELASTIC WAISTBAND

CENTRO SOURCING UK LIMITED
This design is the property of Centro sourcing U.K limited. Unit 4 Quadrum park industrial estate, Guildford, GU31LU

Figure 40: Techpack

This figure shows buyers comments on different problem of the order.



White seal Comments

Nutmeg

TECHNOLOGY COMMENTS

Centro International Sourcing Ltd.	Active
032043	T 3PC BE HAPPY GYM SET

Click Link: Nutmeg Technical Manual

PRODUCT EVALUATION

Does the product meet all requirements of the Nutmeg Risk Assessment?	Yes
Does the base fabric comply to all testing requirements specific to this product?	Yes
Does the garment comply with Childrenswear Legislation?	Yes
Are all trims sourced from the Nutmeg Nominated trim suppliers?	Yes
Additional comments or concerns?- e.g packaging issues, print process	No

WHITE SEAL COMMENTS

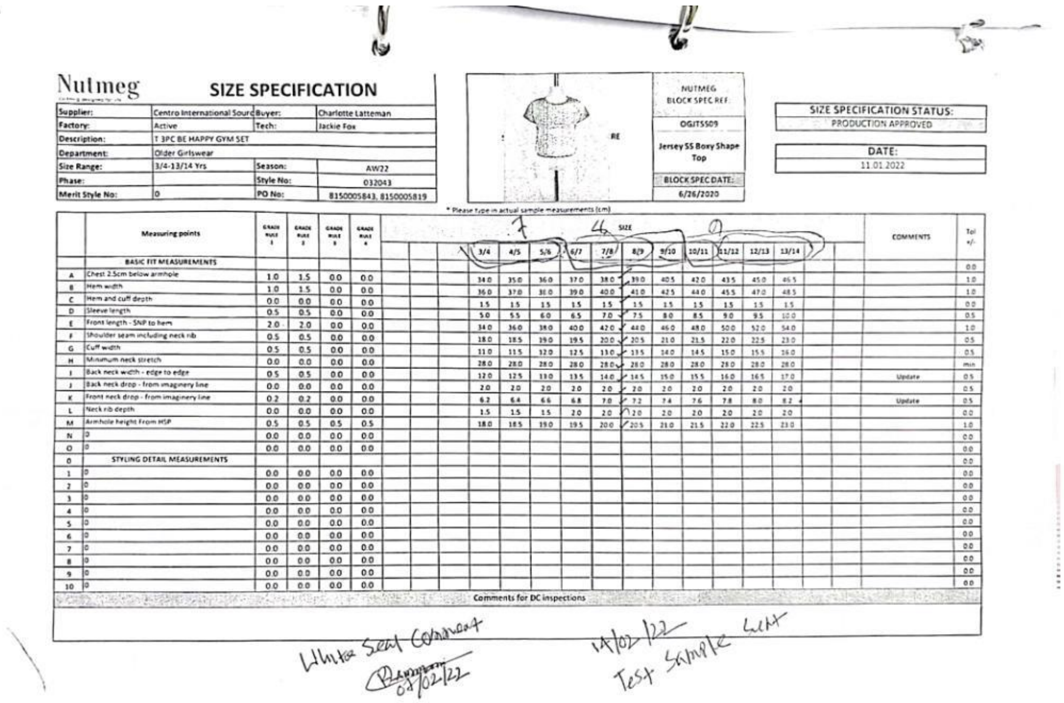
Supplier Comments	Nutmeg Tech Comments
Md. Arafat Ullah, 04.01.2022	
Fit/Measurements	
Are all measurements within tolerance of the spec? Yes.	
What measurements are out of tolerance? No.	
If applicable, does the garment achieve minimum neck stretch? Yes.	
1. Style is ok.	
2. Measuremenrbt found within tolarance.	
3. Workmanship is ok.	
4. Embroidery Backing are not follow as per manual, plase consider we will follow the next sample.	
Make up/Construction	**Make up/Construction**
Does the garment meet CWR safety requirements?	
What is the SPI (Stitch per inch) at seams?	
Print process/technique? E.g discharge print, screen print	
Trims/Components	**Trims/Components**
Buttons- is it lock stitched with a tonal bobbin thread?	
Interlining- supplier and quality used? Is it fused correctly?	
Zips- supplier? Zip size? Type of zip e.g coil, reverse coil?	
Thread- supplier and quality used?	
Packaging & Presentation	**Packaging & Presentation**
How is this garment going to be finished? Pressing or steaming?	
Packaging method- how will the garment be folded?	
What Polybag size will you be using?	
Any additional POS to be used for this style? N	
	Please Submit:
	Please Select:

REVISED WHITE SEAL COMMENTS

BLACK SEAL COMMENTS

Supplier Comments	Nutmeg Tech Comments
Arafat Ullah 13.08.2021	*Enter Name, Comments date, Sample date*
Fit/Measurements	**Fit/Measurements**
Have all comments from white seal been actioned? Yes	
Are all measurements within tolerance of the spec? Yes	
What measurements are out of tolerance? No	
Is the grade ruling consistant across all sizes, any concerns? No	
Make up/Construction	
Does the garment meet CWR safety requirements?	
What is the SPI (Stitch per inch) at the seams?	
	Make up/Construction
Trims/Components	**Trims/Components**
Buttons- is it lock stitched with a tonal bobbin thread?	
Interlining- supplier and quality used? Is it fused correctly?	
Zips- supplier? Zip size? Type of zip e.g coil, reverse coil?	
Thread- supplier and quality used?	
Packaging & Presentation	**Packaging & Presentation**
How is this garment going to be finished? Pressing or steaming?	
Packaging method- how will the garment be folded?	
What Polybag size will you be using?	

Figure 41: Buyers comments



Nutmeg

SIZE SPECIFICATION

Supplier:	Centro International Sourc	Buyer:	Charlotte Latteman
Factory:	Active	Tech:	Jackie Fox
Description:	T 3PC BE HAPPY GYM SET		
Department:	Older Girlswear		
Size Range:	3/4-13/14 Yrs	Season:	AW22
Phase:		Style No:	032043
Merit Style No:	0	PO No:	8150005843, 8150005819

NUTMEG BLOCK SPEC REF: OGJTS509

Jersey SS Boxy Shape Top

BLOCK SPEC DATE: 6/26/2020

SIZE SPECIFICATION STATUS: PRODUCTION APPROVED

DATE: 11.01.2022

* Please type in actual sample measurements (cm)

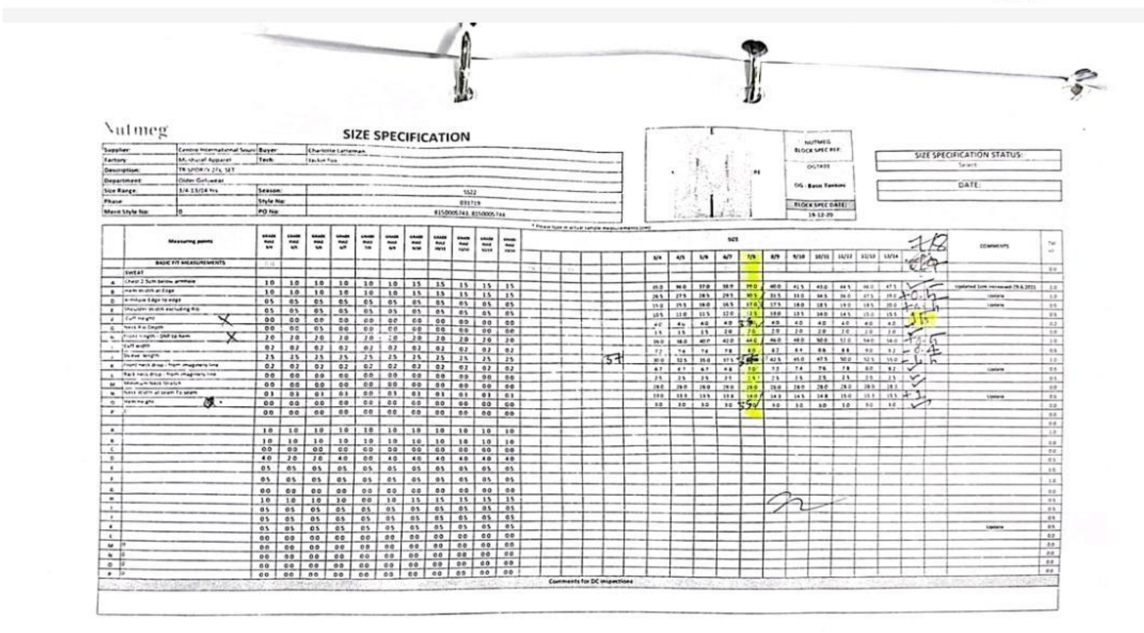
	Measuring points	Grade rule 1	Grade rule 2	Grade rule 3	Grade rule 4	3/4	4/5	5/6	6/7	7/8	8/9	9/10	10/11	11/12	12/13	13/14	Comments	Tol +/-
	BASIC FIT MEASUREMENTS																	0.0
A	Chest 2.5cm below armhole	1.0	1.5	0.0	0.0	34.0	35.0	36.0	37.0	38.0	39.0	40.5	42.0	43.5	45.0	46.5		1.0
B	Hem width	1.0	1.5	0.0	0.0	36.0	37.0	38.0	39.0	40.0	41.0	42.5	44.0	45.5	47.0	48.5		1.0
C	Hem and cuff depth	0.0	0.0	0.0	0.0	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5		0.0
D	Sleeve length	0.5	0.5	0.0	0.0	5.0	5.5	6.0	6.5	7.0	7.5	8.0	8.5	9.0	9.5	10.0		0.5
E	Front length - SNP to hem	2.0	2.0	0.0	0.0	34.0	36.0	38.0	40.0	42.0	44.0	46.0	48.0	50.0	52.0	54.0		1.0
F	Shoulder seam including neck rib	0.5	0.5	0.0	0.0	18.0	18.5	19.0	19.5	20.0	20.5	21.0	21.5	22.0	22.5	23.0		0.5
G	Cuff width	0.5	0.5	0.0	0.0	11.0	11.5	12.0	12.5	13.0	13.5	14.0	14.5	15.0	15.5	16.0		0.5
H	Minimum neck stretch	0.0	0.0	0.0	0.0	28.0	28.0	28.0	28.0	28.0	28.0	28.0	28.0	28.0	28.0	28.0		min
I	Back neck width - edge to edge	0.5	0.5	0.0	0.0	12.0	12.5	13.0	13.5	14.0	14.5	15.0	15.5	16.0	16.5	17.0	Update	0.5
J	Back neck drop - from imaginery line	0.0	0.0	0.0	0.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0		0.5
K	Front neck drop - from imaginery line	0.2	0.2	0.0	0.0	6.2	6.4	6.6	6.8	7.0	7.2	7.4	7.6	7.8	8.0	8.2	Update	0.5
L	Neck rib depth	0.0	0.0	0.0	0.0	1.5	1.5	1.5	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0		0.0
M	Armhole height From HSP	0.5	0.5	0.5	0.5	18.0	18.5	19.0	19.5	20.0	20.5	21.0	21.5	22.0	22.5	23.0		1.0
N	0	0.0	0.0	0.0	0.0													0.0
O	0	0.0	0.0	0.0	0.0													0.0
0	STYLING DETAIL MEASUREMENTS																	0.0
1	0	0.0	0.0	0.0	0.0													0.0
2	0	0.0	0.0	0.0	0.0													0.0
3	0	0.0	0.0	0.0	0.0													0.0
4	0	0.0	0.0	0.0	0.0													0.0
5	0	0.0	0.0	0.0	0.0													0.0
6	0	0.0	0.0	0.0	0.0													0.0
7	0	0.0	0.0	0.0	0.0													0.0
8	0	0.0	0.0	0.0	0.0													0.0
9	0	0.0	0.0	0.0	0.0													0.0
10	0	0.0	0.0	0.0	0.0													0.0

Comments for DC inspections

White Seal Comment 07/02/22

14/02/22 Test Sample Lint

CamScanner



Nutmeg

SIZE SPECIFICATION

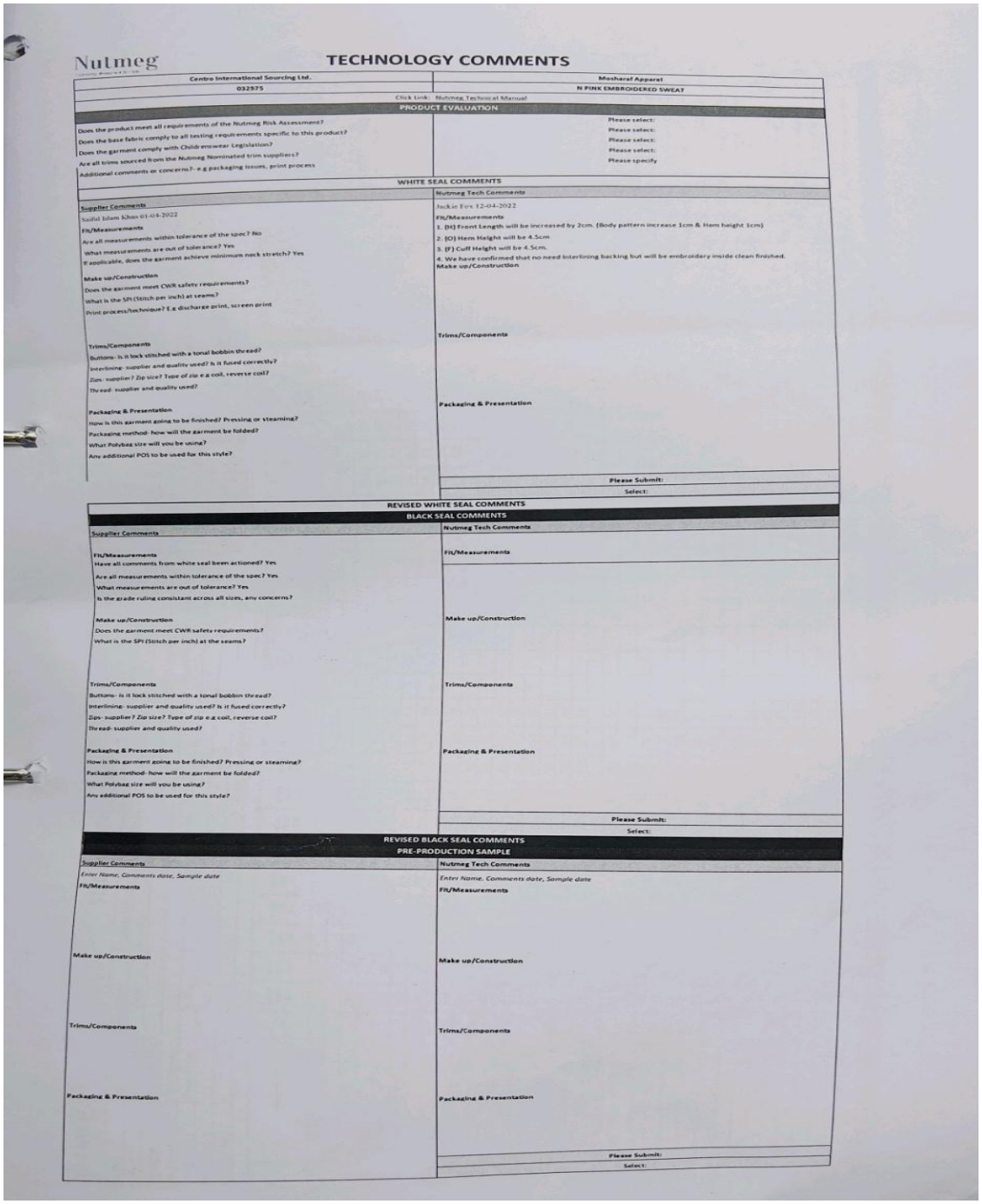
SIZE SPECIFICATION STATUS:

DATE:

Comments for DC inspections

Figure 42: Measurement sheet

This figure shows different technological comments of buyers which mainly found defects on measurements related problem.



Nutmeg

TECHNOLOGY COMMENTS

Centre International Sourcing Ltd.	Mosharaf Apparel
032975	N PINK EMBRODERED SWEAT
Click Link: Nutmeg Technical Manual	

PRODUCT EVALUATION

Does the product meet all requirements of the Nutmeg Risk Assessment?	Please select:
Does the base fabric comply to all testing requirements specific to this product?	Please select:
Does the garment comply with Childrenswear Legislation?	Please select:
Are all trims sourced from the Nutmeg Nominated trim suppliers?	Please select:
Additional comments or concerns? - e.g packaging issues, print process	Please specify

WHITE SEAL COMMENTS

Supplier Comments	Nutmeg Tech Comments
Saiful Islam Khan 01-04-2022	Jackie Fox 12-04-2022
Fit/Measurements	Fit/Measurements
Are all measurements within tolerance of the spec? No	1. (H) Front Length will be increased by 2cm. (Body pattern increase 1cm & Hem height 1cm)
What measurements are out of tolerance? Yes	2. (O) Hem Height will be 4.5cm
If applicable, does the garment achieve minimum neck stretch? Yes	3. (F) Cuff Height will be 4.5cm.
	4. We have confirmed that no need interlining backing but will be embroidary inside clean finished.
Make up/Construction	Make up/Construction
Does the garment meet CWR safety requirements?	
What is the SPI (Stitch per inch) at seams?	
Print process/technique? E.g discharge print, screen print	
	Trims/Components
Trims/Components	
Buttons- Is it lock stitched with a tonal bobbin thread?	
Interlining- supplier and quality used? Is it fused correctly?	
Zips- supplier? Zip size? Type of zip e.g coil, reverse coil?	
Thread- supplier and quality used?	
	Packaging & Presentation
Packaging & Presentation	
How is this garment going to be finished? Pressing or steaming?	
Packaging method- how will the garment be folded?	
What Polybag size will you be using?	
Any additional POS to be used for this style?	
	Please Submit:
	Select:

REVISED WHITE SEAL COMMENTS

BLACK SEAL COMMENTS

Supplier Comments	Nutmeg Tech Comments
	Fit/Measurements
Fit/Measurements	
Have all comments from white seal been actioned? Yes	
Are all measurements within tolerance of the spec? Yes	
What measurements are out of tolerance? Yes	
Is the grade ruling consistant across all sizes, any concerns?	
	Make up/Construction
Make up/Construction	
Does the garment meet CWR safety requirements?	
What is the SPI (Stitch per inch) at the seams?	
	Trims/Components
Trims/Components	
Buttons- Is it lock stitched with a tonal bobbin thread?	
Interlining- supplier and quality used? Is it fused correctly?	
Zips- supplier? Zip size? Type of zip e.g coil, reverse coil?	
Thread- supplier and quality used?	
	Packaging & Presentation
Packaging & Presentation	
How is this garment going to be finished? Pressing or steaming?	
Packaging method- how will the garment be folded?	
What Polybag size will you be using?	
Any additional POS to be used for this style?	
	Please Submit:
	Select:

REVISED BLACK SEAL COMMENTS

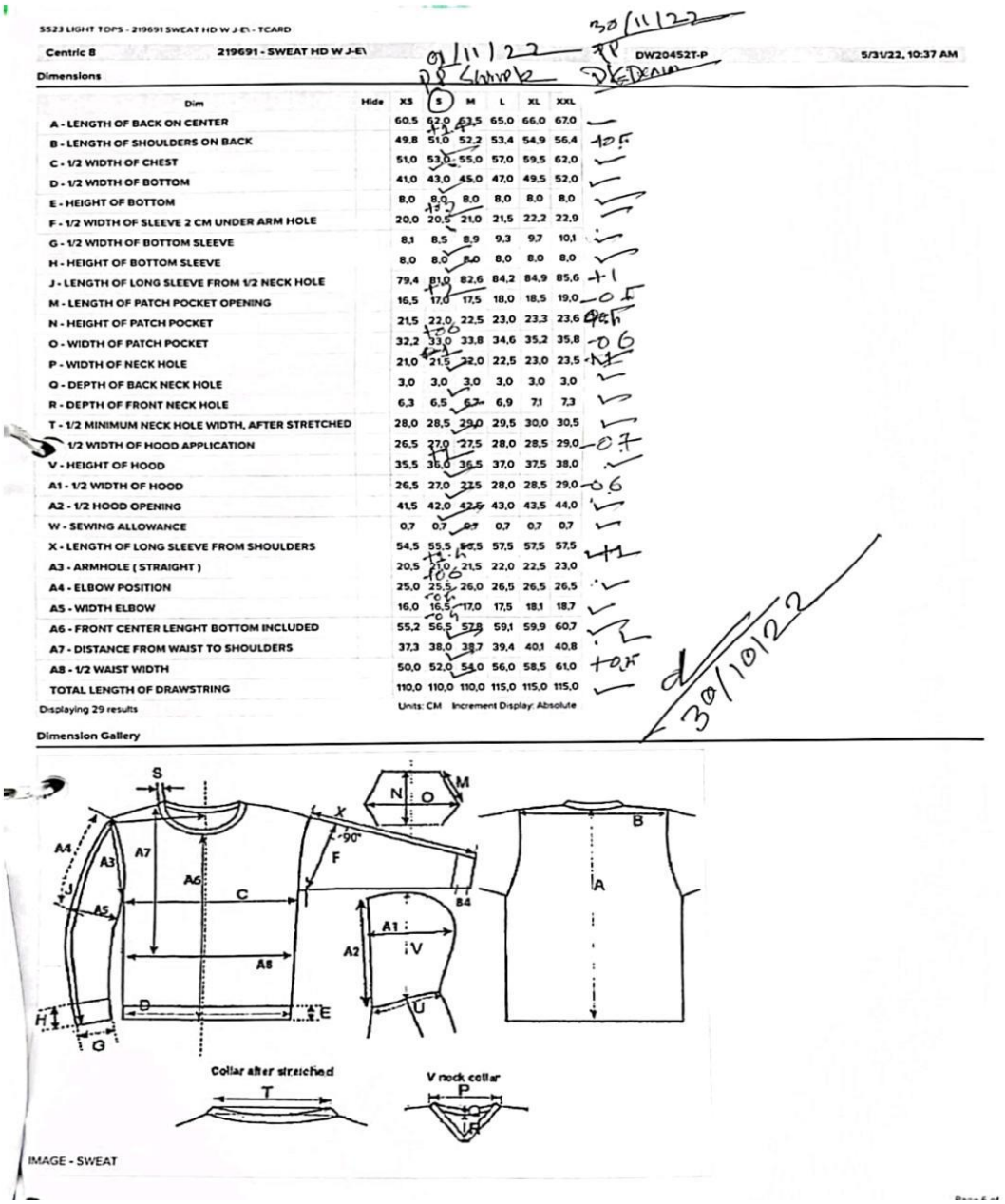
PRE-PRODUCTION SAMPLE

Supplier Comments	Nutmeg Tech Comments
Enter Name, Comments date, Sample date	*Enter Name, Comments date, Sample date*
Fit/Measurements	Fit/Measurements
Make up/Construction	Make up/Construction
Trims/Components	Trims/Components
Packaging & Presentation	Packaging & Presentation
	Please Submit:
	Select:

Figure 43: Buyers comments

3.7 Buyer – Lotto

This figure shows buyers measurement sheet specifications and buyers artworks which helps factory understand the order better.



5523 LIGHT TOPS - 219691 SWEAT HD W J-E\ - TCARD

Centric 8 | 219691 - SWEAT HD W J-E\ | DW20452T-P | 5/31/22, 10:37 AM

Dimensions

Dim	Hide	XS	S	M	L	XL	XXL
A - LENGTH OF BACK ON CENTER		60,5	62,0	63,5	65,0	66,0	67,0
B - LENGTH OF SHOULDERS ON BACK		49,8	51,0	52,2	53,4	54,9	56,4
C - 1/2 WIDTH OF CHEST		51,0	53,0	55,0	57,0	59,5	62,0
D - 1/2 WIDTH OF BOTTOM		41,0	43,0	45,0	47,0	49,5	52,0
E - HEIGHT OF BOTTOM		8,0	8,0	8,0	8,0	8,0	8,0
F - 1/2 WIDTH OF SLEEVE 2 CM UNDER ARM HOLE		20,0	20,5	21,0	21,5	22,2	22,9
G - 1/2 WIDTH OF BOTTOM SLEEVE		8,1	8,5	8,9	9,3	9,7	10,1
H - HEIGHT OF BOTTOM SLEEVE		8,0	8,0	8,0	8,0	8,0	8,0
J - LENGTH OF LONG SLEEVE FROM 1/2 NECK HOLE		79,4	81,0	82,6	84,2	84,9	85,6
M - LENGTH OF PATCH POCKET OPENING		16,5	17,0	17,5	18,0	18,5	19,0
N - HEIGHT OF PATCH POCKET		21,5	22,0	22,5	23,0	23,3	23,6
O - WIDTH OF PATCH POCKET		32,2	33,0	33,8	34,6	35,2	35,8
P - WIDTH OF NECK HOLE		21,0	21,5	22,0	22,5	23,0	23,5
Q - DEPTH OF BACK NECK HOLE		3,0	3,0	3,0	3,0	3,0	3,0
R - DEPTH OF FRONT NECK HOLE		6,3	6,5	6,7	6,9	7,1	7,3
T - 1/2 MINIMUM NECK HOLE WIDTH, AFTER STRETCHED		28,0	28,5	29,0	29,5	30,0	30,5
U - 1/2 WIDTH OF HOOD APPLICATION		26,5	27,0	27,5	28,0	28,5	29,0
V - HEIGHT OF HOOD		35,5	36,0	36,5	37,0	37,5	38,0
A1 - 1/2 WIDTH OF HOOD		26,5	27,0	27,5	28,0	28,5	29,0
A2 - 1/2 HOOD OPENING		41,5	42,0	42,5	43,0	43,5	44,0
W - SEWING ALLOWANCE		0,7	0,7	0,7	0,7	0,7	0,7
X - LENGTH OF LONG SLEEVE FROM SHOULDERS		54,5	55,5	56,5	57,5	57,5	57,5
A3 - ARMHOLE (STRAIGHT)		20,5	21,0	21,5	22,0	22,5	23,0
A4 - ELBOW POSITION		25,0	25,5	26,0	26,5	26,5	26,5
A5 - WIDTH ELBOW		16,0	16,5	17,0	17,5	18,1	18,7
A6 - FRONT CENTER LENGHT BOTTOM INCLUDED		55,2	56,5	57,8	59,1	59,9	60,7
A7 - DISTANCE FROM WAIST TO SHOULDERS		37,3	38,0	38,7	39,4	40,1	40,8
A8 - 1/2 WAIST WIDTH		50,0	52,0	54,0	56,0	58,5	61,0
TOTAL LENGTH OF DRAWSTRING		110,0	110,0	110,0	115,0	115,0	115,0

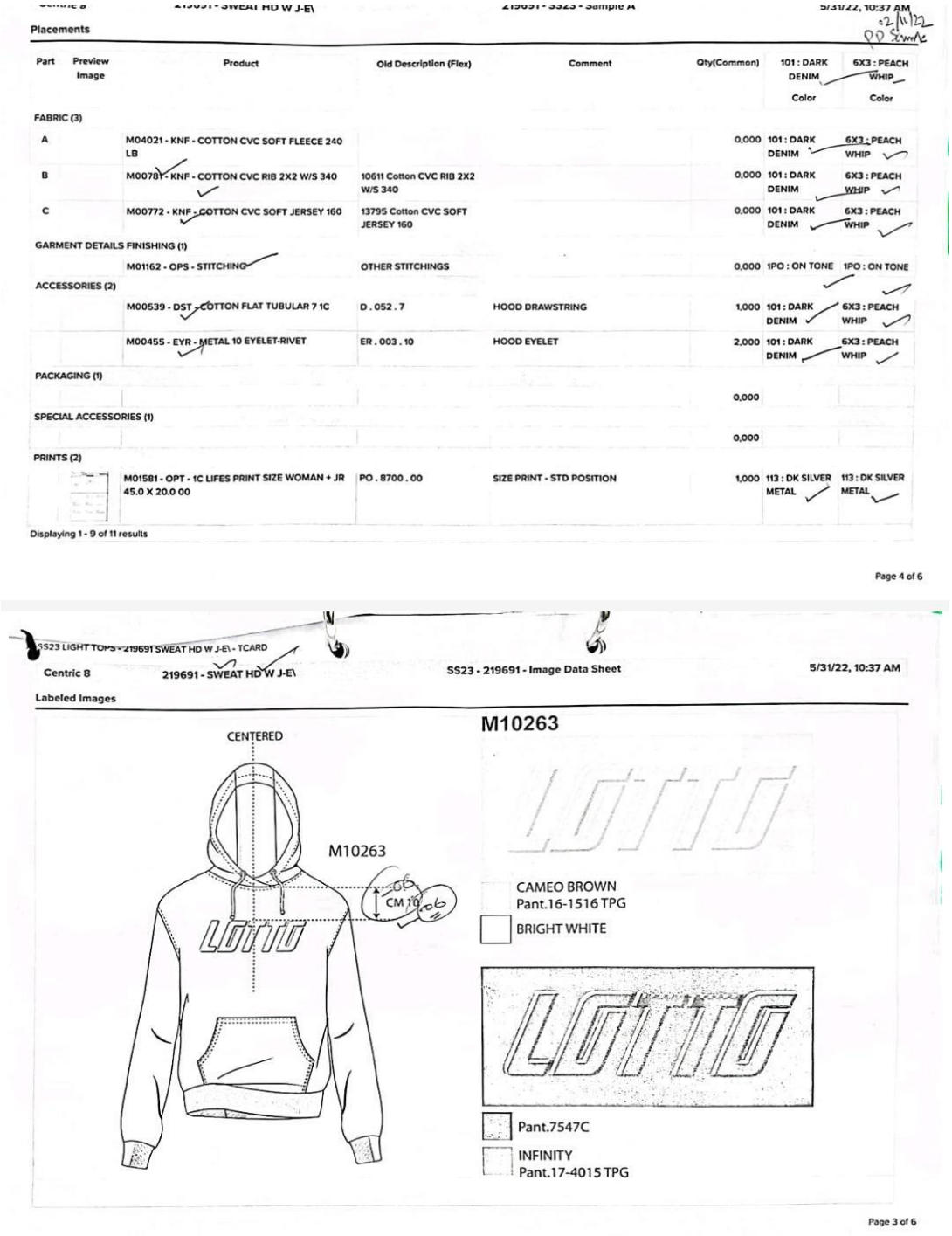
Displaying 29 results | Units: CM | Increment Display: Absolute

Dimension Gallery

IMAGE - SWEAT

Figure 44: Measurement sheet

This figure shows buyers art work information and also the printing information that the print showed be bright white.



Placements

Part	Preview Image	Product	Old Description (Flex)	Comment	Qty(Common)	101 : DARK DENIM Color	6X3 : PEACH WHIP Color
FABRIC (3)							
A		M04021 - KNF - COTTON CVC SOFT FLEECE 240 LB			0,000	101 : DARK DENIM	6X3 : PEACH WHIP
B		M00781 - KNF - COTTON CVC RIB 2X2 W/S 340	10611 Cotton CVC RIB 2X2 W/S 340		0,000	101 : DARK DENIM	6X3 : PEACH WHIP
C		M00772 - KNF - COTTON CVC SOFT JERSEY 160	13795 Cotton CVC SOFT JERSEY 160		0,000	101 : DARK DENIM	6X3 : PEACH WHIP
GARMENT DETAILS FINISHING (1)							
		M01162 - OPS - STITCHING	OTHER STITCHINGS		0,000	1PO : ON TONE	1PO : ON TONE
ACCESSORIES (2)							
		M00539 - DST - COTTON FLAT TUBULAR 7 1C	D . 052 . 7	HOOD DRAWSTRING	1,000	101 : DARK DENIM	6X3 : PEACH WHIP
		M00455 - EYR - METAL 10 EYELET-RIVET	ER . 003 . 10	HOOD EYELET	2,000	101 : DARK DENIM	6X3 : PEACH WHIP
PACKAGING (1)							
					0,000		
SPECIAL ACCESSORIES (1)							
					0,000		
PRINTS (2)							
		M01581 - OPT - 1C LIFES PRINT SIZE WOMAN + JR 45.0 X 20.0 00	PO . 8700 . 00	SIZE PRINT - STD POSITION	1,000	113 : DK SILVER METAL	113 : DK SILVER METAL

Displaying 1 - 9 of 11 results

Page 4 of 6

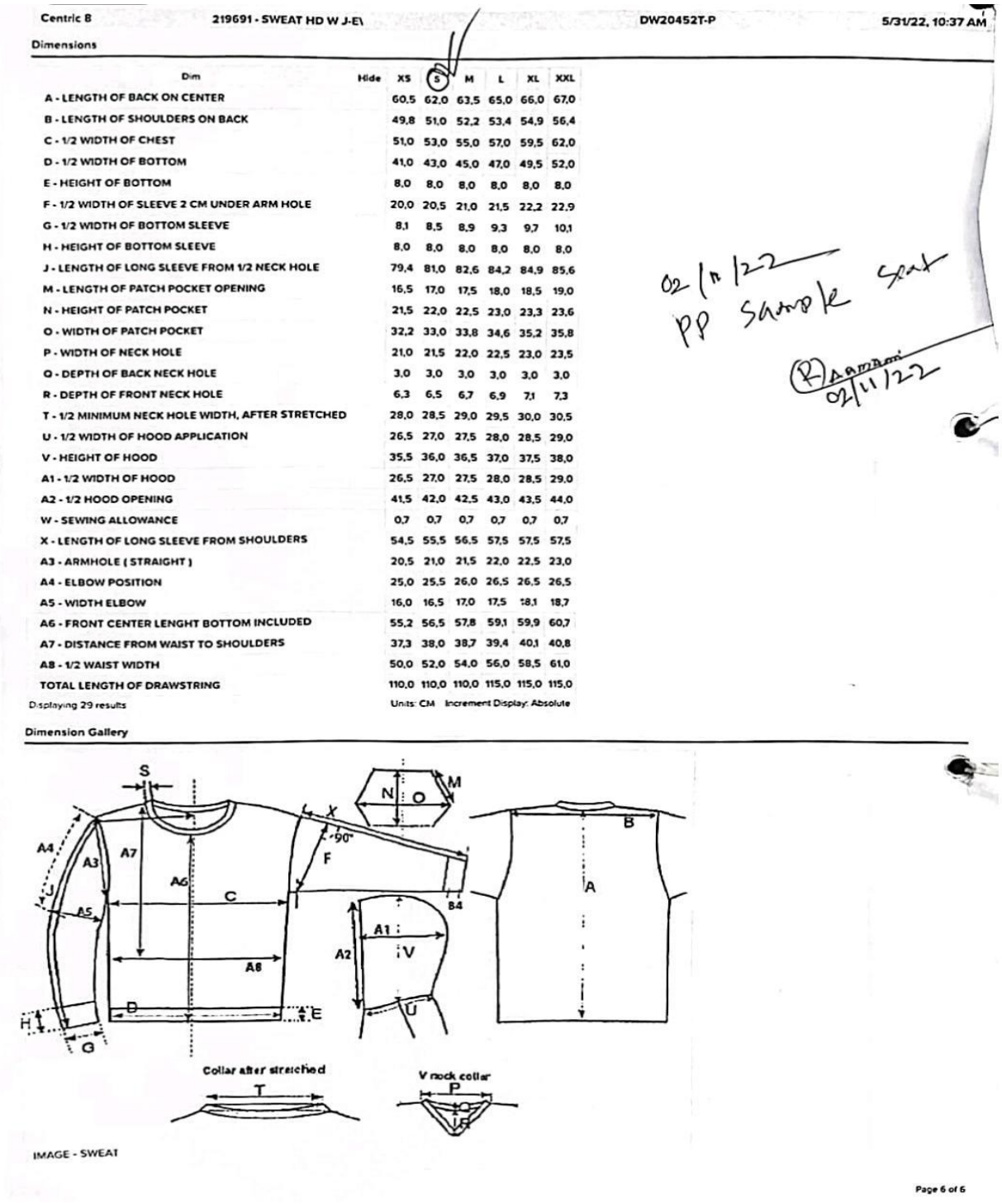
Centric 8 | 219691 - SWEAT HD W J-E\ | SS23 - 219691 - Image Data Sheet | 5/31/22, 10:37 AM

Labeled Images

Page 3 of 6

Figure 45: Techpack

This figure also shows buyers size specification and artwork.



Centric 8 | 219691 - SWEAT HD W J-E\ | DW20452T-P | 5/31/22, 10:37 AM

Dimensions

Dim	Hide	XS	S	M	L	XL	XXL
A - LENGTH OF BACK ON CENTER		60,5	62,0	63,5	65,0	66,0	67,0
B - LENGTH OF SHOULDERS ON BACK		49,8	51,0	52,2	53,4	54,9	56,4
C - 1/2 WIDTH OF CHEST		51,0	53,0	55,0	57,0	59,5	62,0
D - 1/2 WIDTH OF BOTTOM		41,0	43,0	45,0	47,0	49,5	52,0
E - HEIGHT OF BOTTOM		8,0	8,0	8,0	8,0	8,0	8,0
F - 1/2 WIDTH OF SLEEVE 2 CM UNDER ARM HOLE		20,0	20,5	21,0	21,5	22,2	22,9
G - 1/2 WIDTH OF BOTTOM SLEEVE		8,1	8,5	8,9	9,3	9,7	10,1
H - HEIGHT OF BOTTOM SLEEVE		8,0	8,0	8,0	8,0	8,0	8,0
J - LENGTH OF LONG SLEEVE FROM 1/2 NECK HOLE		79,4	81,0	82,6	84,2	84,9	85,6
M - LENGTH OF PATCH POCKET OPENING		16,5	17,0	17,5	18,0	18,5	19,0
N - HEIGHT OF PATCH POCKET		21,5	22,0	22,5	23,0	23,3	23,6
O - WIDTH OF PATCH POCKET		32,2	33,0	33,8	34,6	35,2	35,8
P - WIDTH OF NECK HOLE		21,0	21,5	22,0	22,5	23,0	23,5
Q - DEPTH OF BACK NECK HOLE		3,0	3,0	3,0	3,0	3,0	3,0
R - DEPTH OF FRONT NECK HOLE		6,3	6,5	6,7	6,9	7,1	7,3
T - 1/2 MINIMUM NECK HOLE WIDTH, AFTER STRETCHED		28,0	28,5	29,0	29,5	30,0	30,5
U - 1/2 WIDTH OF HOOD APPLICATION		26,5	27,0	27,5	28,0	28,5	29,0
V - HEIGHT OF HOOD		35,5	36,0	36,5	37,0	37,5	38,0
A1 - 1/2 WIDTH OF HOOD		26,5	27,0	27,5	28,0	28,5	29,0
A2 - 1/2 HOOD OPENING		41,5	42,0	42,5	43,0	43,5	44,0
W - SEWING ALLOWANCE		0,7	0,7	0,7	0,7	0,7	0,7
X - LENGTH OF LONG SLEEVE FROM SHOULDERS		54,5	55,5	56,5	57,5	57,5	57,5
A3 - ARMHOLE (STRAIGHT)		20,5	21,0	21,5	22,0	22,5	23,0
A4 - ELBOW POSITION		25,0	25,5	26,0	26,5	26,5	26,5
A5 - WIDTH ELBOW		16,0	16,5	17,0	17,5	18,1	18,7
A6 - FRONT CENTER LENGHT BOTTOM INCLUDED		55,2	56,5	57,8	59,1	59,9	60,7
A7 - DISTANCE FROM WAIST TO SHOULDERS		37,3	38,0	38,7	39,4	40,1	40,8
A8 - 1/2 WAIST WIDTH		50,0	52,0	54,0	56,0	58,5	61,0
TOTAL LENGTH OF DRAWSTRING		110,0	110,0	110,0	115,0	115,0	115,0

Displaying 29 results — Units: CM — Increment Display: Absolute

02/11/22 PP Sample Sent

Approved 02/11/22

Dimension Gallery

IMAGE - SWEAT

Page 6 of 6

Figure 46: Measurement sheet

Here in this picture, we can see that buyers commented the different defects he found on the pp sample and how he wants them to be removed.

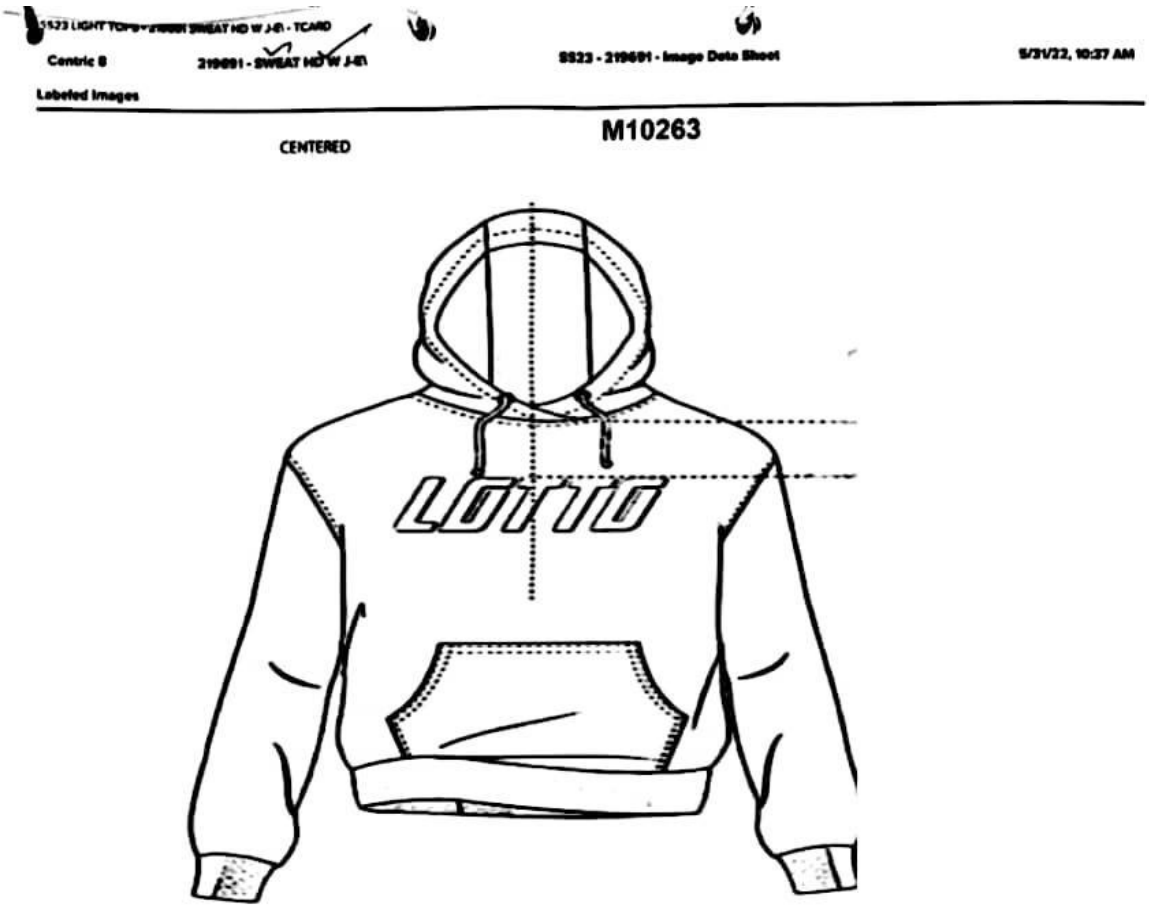
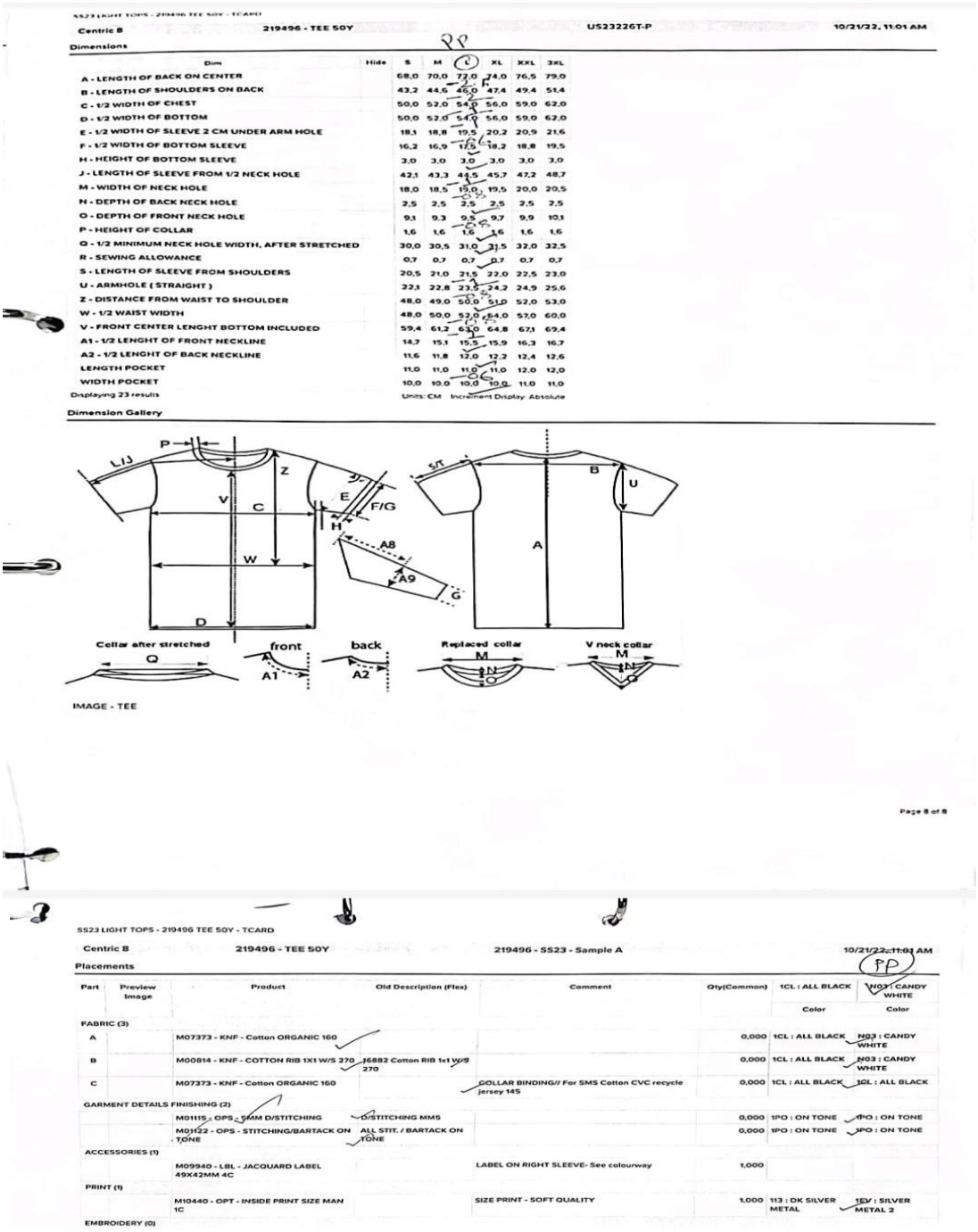


Figure 47: Buyers comments

This figure shows the final measurement sheet and artwork according which factory will submit their final product.



Centric 8 — 219496 - TEE SOY — US23226T-P — 10/21/22, 11:01 AM

Dimensions

Dim	Hide	S	M	L	XL	XXL	3XL
A - LENGTH OF BACK ON CENTER		68,0	70,0	72,0	74,0	76,5	79,0
B - LENGTH OF SHOULDERS ON BACK		43,2	44,6	46,0	47,4	49,4	51,4
C - 1/2 WIDTH OF CHEST		50,0	52,0	54,0	56,0	59,0	62,0
D - 1/2 WIDTH OF BOTTOM		50,0	52,0	54,0	56,0	59,0	62,0
E - 1/2 WIDTH OF SLEEVE 2 CM UNDER ARM HOLE		18,1	18,8	19,5	20,2	20,9	21,6
F - 1/2 WIDTH OF BOTTOM SLEEVE		16,2	16,9	17,5	18,2	18,8	19,5
H - HEIGHT OF BOTTOM SLEEVE		3,0	3,0	3,0	3,0	3,0	3,0
J - LENGTH OF SLEEVE FROM 1/2 NECK HOLE		42,1	43,3	44,5	45,7	47,2	48,7
M - WIDTH OF NECK HOLE		18,0	18,5	19,0	19,5	20,0	20,5
N - DEPTH OF BACK NECK HOLE		2,5	2,5	2,5	2,5	2,5	2,5
O - DEPTH OF FRONT NECK HOLE		9,1	9,3	9,5	9,7	9,9	10,1
P - HEIGHT OF COLLAR		1,6	1,6	1,6	1,6	1,6	1,6
Q - 1/2 MINIMUM NECK HOLE WIDTH, AFTER STRETCHED		30,0	30,5	31,0	31,5	32,0	32,5
R - SEWING ALLOWANCE		0,7	0,7	0,7	0,7	0,7	0,7
S - LENGTH OF SLEEVE FROM SHOULDERS		20,5	21,0	21,5	22,0	22,5	23,0
U - ARMHOLE (STRAIGHT)		22,1	22,8	23,5	24,2	24,9	25,6
Z - DISTANCE FROM WAIST TO SHOULDER		48,0	49,0	50,0	51,0	52,0	53,0
W - 1/2 WAIST WIDTH		48,0	50,0	52,0	54,0	57,0	60,0
V - FRONT CENTER LENGHT BOTTOM INCLUDED		59,4	61,2	63,0	64,8	67,1	69,4
A1 - 1/2 LENGHT OF FRONT NECKLINE		14,7	15,1	15,5	15,9	16,3	16,7
A2 - 1/2 LENGHT OF BACK NECKLINE		11,6	11,8	12,0	12,2	12,4	12,6
LENGTH POCKET		11,0	11,0	11,0	11,0	12,0	12,0
WIDTH POCKET		10,0	10,0	10,0	10,0	11,0	11,0

Displaying 23 results — Units: CM — Increment Display: Absolute

Dimension Gallery

IMAGE - TEE

Page 8 of 8

SS23 LIGHT TOPS - 219496 TEE SOY - TCARD

Centric 8 — 219496 - TEE SOY — 219496 - SS23 - Sample A — 10/21/22, 11:01 AM

Placements

Part	Preview Image	Product	Old Description (Flex)	Comment	Qty(Common)	1CL : ALL BLACK Color	N03 : CANDY WHITE Color
FABRIC (3)							
A		M07373 - KNF - Cotton ORGANIC 160			0,000	1CL : ALL BLACK	N03 : CANDY WHITE
B		M00814 - KNF - COTTON RIB 1X1 W/S 270	J6882 Cotton RIB 1x1 W/S 270		0,000	1CL : ALL BLACK	N03 : CANDY WHITE
C		M07373 - KNF - Cotton ORGANIC 160		COLLAR BINDING// For SMS Cotton CVC recycle jersey 145	0,000	1CL : ALL BLACK	1CL : ALL BLACK
GARMENT DETAILS FINISHING (2)							
		M01115 - OPS - 5MM D/STITCHING	D/STITCHING MM5		0,000	1PO : ON TONE	1PO : ON TONE
		M01122 - OPS - STITCHING/BARTACK ON TONE	ALL STIT. / BARTACK ON TONE		0,000	1PO : ON TONE	1PO : ON TONE
ACCESSORIES (1)							
		M09940 - LBL - JACQUARD LABEL 49X42MM 4C		LABEL ON RIGHT SLEEVE- See colourway	1,000		
PRINT (1)							
		M10440 - OPT - INSIDE PRINT SIZE MAN 1C		SIZE PRINT - SOFT QUALITY	1,000	113 : DK SILVER METAL	1EV : SILVER METAL 2
EMBROIDERY (0)							

Figure 48: Measurement sheet

CHAPTER 4

RESULT AND DISCUSSION

4.1 Results of Hangten

From the above given documents of hang ten we found out that there were problem or defect related to sewing and workmanship in the pre-production sample.

Workmanship faults: workmanship defect is known as the degree of skill of which a product is made. Generally, this kind of problem occurs when workers do not work with professionalism and make silly mistakes. Some of the workmanship defects that are found on hang ten documents are- Extra tension given during neck rib sewing, folding was done while working on body side line, grain line was not right when sewing. This problem can be overcome by regular training and counselling the workers.

Sewing fault: Generally, when sewing of different parts of a sample is done sewing problem may arise. Some of the sewing problem that were occurs during hang ten production are stitch distance of sewing was not found equal, also found problem related to shoulder stitch and neck rib. This kind of problem occurs there is seam puckering or bobbin or looper thread breakage so these matters need to be handled carefully to overcome this problem.

4.2 Results of Aim Global

From the documents of aim global we have found out that there were lots of defects in the sampling. These defects were related to measurement, sewing, workmanship and accessories. **Measurement faults:** Measurement problem is one of major problem that happens during the sample making procedure. When factory can't meet the measurement given by the buyers this problem arises. This problem mainly arises when pattern making is not done properly, also excessive trimming during sewing leads to measurement defect there some others reason as well which will we describe below in this report.

Sewing fault: Sewing problem as we discuss above this problem arises when buyer doesn't like the sewing of different parts of sample garments.

Workmanship fault: Workmanship defects is generally found in almost every buyer document but it can be overcome easily. Some of the workmanship defects found in aim global are relaxation of fabric time should be more. Piping should be removed from collar etc.

Accessories faults: This problem generally occurs when factory do not provide same quality accessories as given in Swatch. Also, sometimes workers forget to attach accessories which lead to this problem. Some of the accessory's problem found in aim global documents are hang tag missing, barcode was missing, thumbhole should not be attached.

4.3 Results of Ducati

From the documents of Ducati, we have found that there were lots of faults related to measurement, fitting, Artwork and printing. These faults were removed to complete the Order.

Measurement faults: Measurements problems were found in Ducati because of Shrinkage problem of the fabric; this problem basically arises because of the low quality of the fabric.

Fitting fault: Fitting problem is another major fault of the sample garments which leads to many orders rejection. when different parts of the sample not adjusted properly this problem arises. Here in Ducati, there were problem related to shoulder fitting and armhole fitting in M and L size. Fitting problem may be overcome if measurement is taken carefully, sewing is done with experience workers.

Art work fault: Art work problem arise when the positioning of the artwork is not done properly. This problem basically arises when measurement sheet is not followed by the workers carefully. And also final inspection is not done strictly.

Printing faults: This arise when there is print required for sample. It mainly occurs when printing is not done to the exact place where buyers wanted. Also, if the shade of the print doesn’t match the buyer’s requirements. Here in Ducati buyers wants the art work to be brighter. These faults may be overcome by using more bright print paste.

4.4 Result of Best & Less

From the documents of best and less we have found out that there was fault related to the workmanship and accessories defects.

Workmanship faults: There was problem at neck stitch which was considered as workmanship defects.

Accessories faults: Sewing ticket was also missing in this style of order which is considered as accessories faults.

4.5 Results of Medicine

From the documents of Medicine, we have notice that there were some faults while completing the sample. Those faults are – Measurement faults, Sewing faults, Workmanship faults.

Measurement fault: Here in this order buyers accepted the measurement to be up and done 1cm from the measurement sheet but for M size measurement was found +2 cm up which was consider as faults.

Sewing fault: Three were some problems related to sewing for this order which was considered as sewing fault.

Workmanship faults: This order was not. Perfectly done by the workers they made a lot of silly mistakes which lead as workmanship defects. Some of the workmanship defects found in this order are poor shape in the garments, snap button was uneven, Collar band was uneven. Leading to all this problem 2 pieces of sample garments were rejected by buyer.

4.6 Results of Nutmeg

From the documents of Nutmeg, we have found that there was only measurements problem while completing the sample garments for buyer.

Measurement faults: when factory cannot complete garments with the same measurement as buyer gives in the measurement sheet these faults arise. For nutmeg order measurement fault arise because of the cutting defects. Which lead to the shortness of the fabric while sewing so ultimate result was measurement fault. This problem can be overcome by ironing the garments with extra stream.

4.7 Result of Lotto

From the documents of Lotto, we have gathered information about different kind of faults of the factory that appears while completing their sampling. Some of the faults that appears are- Fitting faults, accessories faults, fabric construction problem, shade variations and printing problem

Fitting faults: when different parts of sample do not match with the others part this problem arises. Because if this problem quality of the sample reduced highly. In most of the case full order may get cancel because of these faults. Here in this case fitting of XXL size was not up to the mark so buyers recommended the changes.

Accessories problem: When accessories of final product do not match with the accessories of the buyer's given data than this problem will arise. Here in case of lotto hang tag and care level was missing fir some size. Which may be considered as major faults. Shade variations faults: when the shade of the different parts of a garments or shade of the complete garments does not match with buyers data then this problem is known as shade variations problem. In case of lotto buyers could not find the development sample shade and pp sample shade matching so this remains as shade variations faults.

Fabric construction faults: When the construction of the fabric buyers recommends does not match with the final product this problem arises. If the GSM of the fabric is not up to the mark than this problem mainly arises but if the stitch per inch is less or more than construction problem may arise. In case of lotto buyers wants stitch per inch to increase.

Printing faults: If there is printing required for sample and printing positioning or printing quality is not up to the mark than it is considered as printing faults. In case of lotto buyers want the artwork print to be brighter which can be achieved by using more brighter print paste.

Brief discussion after all:

In sample section factory makes sample to get buyers approval. But if the sample is not up to buyer's mark than buyers find different kinds of faults and give feedback though comments to factory. Factory than works on those comments to remove those faults they made first time to get buyers approval this time around. There are different kinds of faults we found while studying different buyer's comments. We found that factory received most comments from lotto about different faults. Which is five in number like- fitting, accessories, fabric construction, shade variations, printing. After that Ducati and aim global given four comments about different faults. After that medicine responds with three faults and then hang ten and best and less submitted two faults each. Nutmeg also submitted one fault by analyzing their sample. After receiving all those

comments, factory immediately start working to remove those faults and submit revised sample to get buyers approval.

4.8 Summary of the results

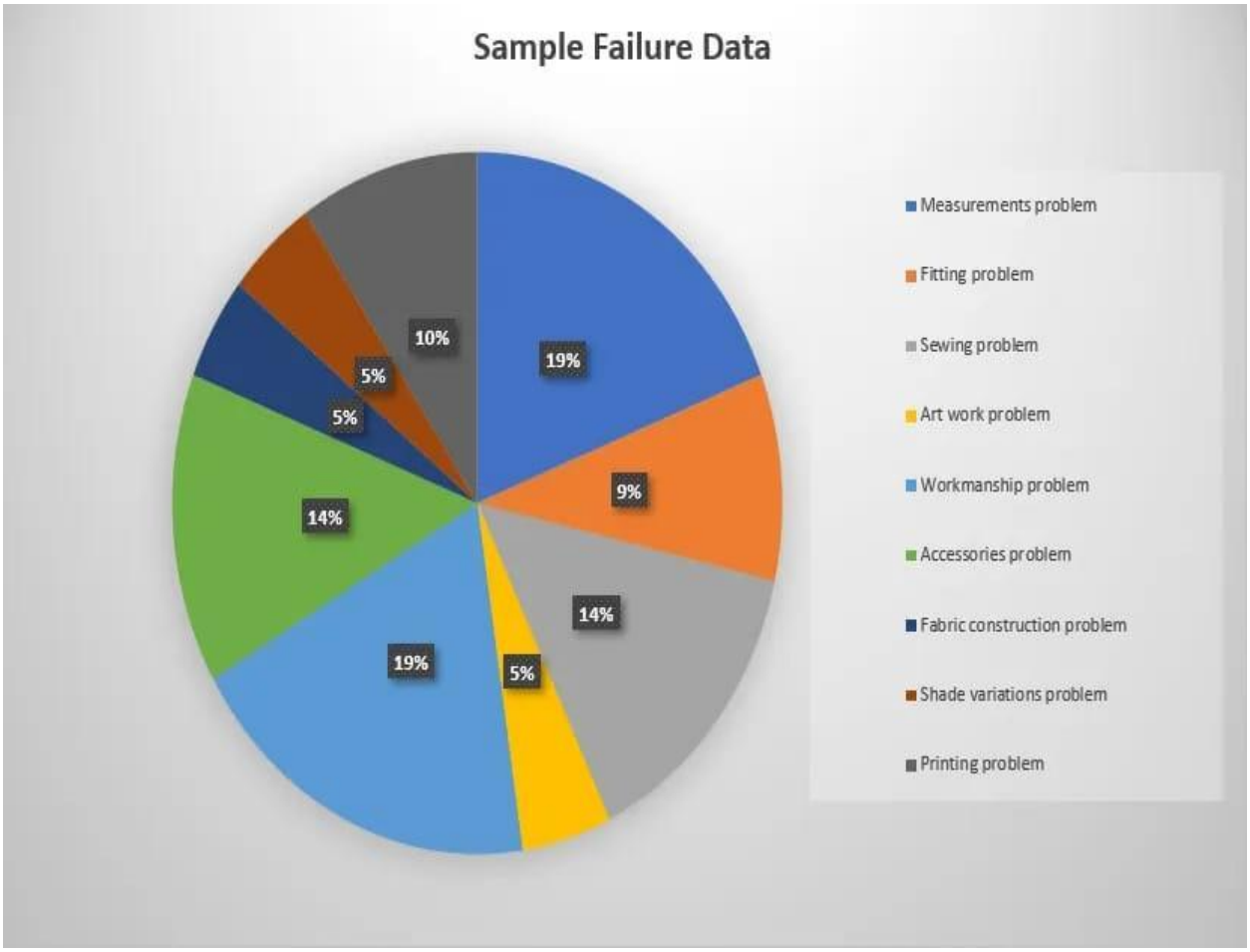
Name of the problem/Name of buyers	Measurements Problem	Fitting Problem	Sewing Problem	Art work Problem	Workmanship Problem	Accessories problem	Fabric construction problem	Shade variations problem	Printing problem
Hang Tang			Yes		Yes				
Aim global	Yes		Yes		Yes	Yes			
Ducati	Yes	Yes		Yes					Yes
Best and Less					Yes	Yes			
Medicine	Yes		Yes		Yes				
Nutmeg	Yes								
Lotto		Yes				Yes	Yes	Yes	Yes
Total	4	2	3	1	4	3	1	1	2
Percentage	19.05	9.53	14.29	4.76	19.05	14.29	4.76	4.76	9.53

Calculation of sample result fault:

Total no. Of defects found 21.

Percentage of fault = (No. Of faults ×100)/total no. Of faults.

Graphical view of data



Discussion

In the sample section we saw how a sample was made and how buyers make comments on it. we saw various kinds of comments of buyers and how the problem accrued during sampling. There are many kinds of problem or faults accrued during sampling. Here we can see that measurement problem and workmanship problem accrues mostly (19.05%) in sample garments. After that we can see sewing problem and accessories problem accrued mostly (14.29%). There are some other problems like shade variations, fitting, printing, art work and fabric construction problems as well that may occur in the sampling section.

Reason of sample garments faults -

Buyers assess the sample and gives feedback to factory within 5-7 days. Feedback from the buyers may be three types.

- Accepted
- Accepted with comments
- Rejected

Sample may reject or accepted with comments because of some major reasons. These reasons are-

- Measurement’s problem
- Fitting problem
- Sewing problem
- Artwork problem
- Workmanship problem
- Accessories problem
- Fabric construction problem
- Shade variations problem
- Printing problem

Reason behind this problem and their remedies is given below-

Measurement’s problem and their remedies (19.05%)

When the workers can't meet the measurement of the buyer according to their desire it is categorized as a measurement problem. In the garment industry measurement fault is considered as one of the major faults as the garments or sample may get rejected easily because of this problem.

Figure 49: Checking measurement

There are some major reasons behind the measurement problem. These are-

- Lack of idea about measurement Sheet.
- Wrong pattern making
- Shrinkage may cause measurement problem
- Improper sewing
- Lack of sufficient fabric relaxation
- Excessive trimming during sewing.
- Problem in fabric quality
- Improper machine setting.

Remedies of the measurement problem:

- Workers need to have a good idea about the measurement sheet.
- Patterns should be made accordingly.
- Fabric quality should be checked carefully so that shrinkage may not occur lately.
- Sewing operator should have good experience so that he may not run the machine improperly or produce improper sewing.
- Trimming showed an acceptable level during sewing.

Fitting problem and their remedies (9.53%)

When different parts of the garments are not adjusted properly then this problem may occur when it is worn on a dummy or by a person. Fitting problem is another major problem or reason behind garments rejection. Problems like shoulder Fitting problem, neckline problems, and armhole problems are known as fitting problems.

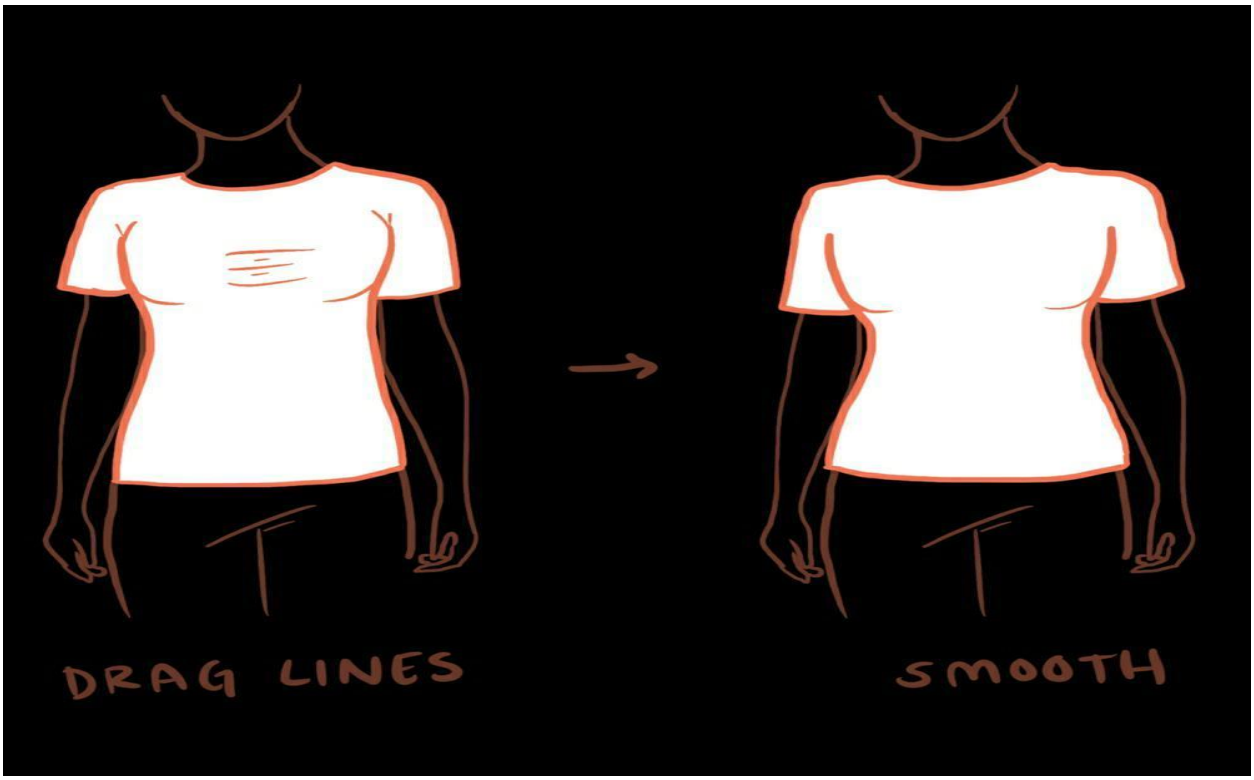


Figure 50: Garments Fitting

Reason behind garments fitting problem:

- Can happen because of improper measurement
- Because of fabrics shrinkage
- If lay out is not followed carefully
- Improper seam line.

Remedies of fitting problem:

- Measurement showed be taken carefully
- Shrinkage should be tested before fabric cutting.
- Lay out should be followed accordingly while sewing different parts.
- Experienced workers should be selected to produce garments samples.

Sewing problem and their remedies (14.29%)

During the sewing of the garments this problem arises. Some of the sewing defects are open seam, wrong stitching of garments, different color thread is used in same color garments. Missing stitch. Creasing mark. These all are sewing defects.

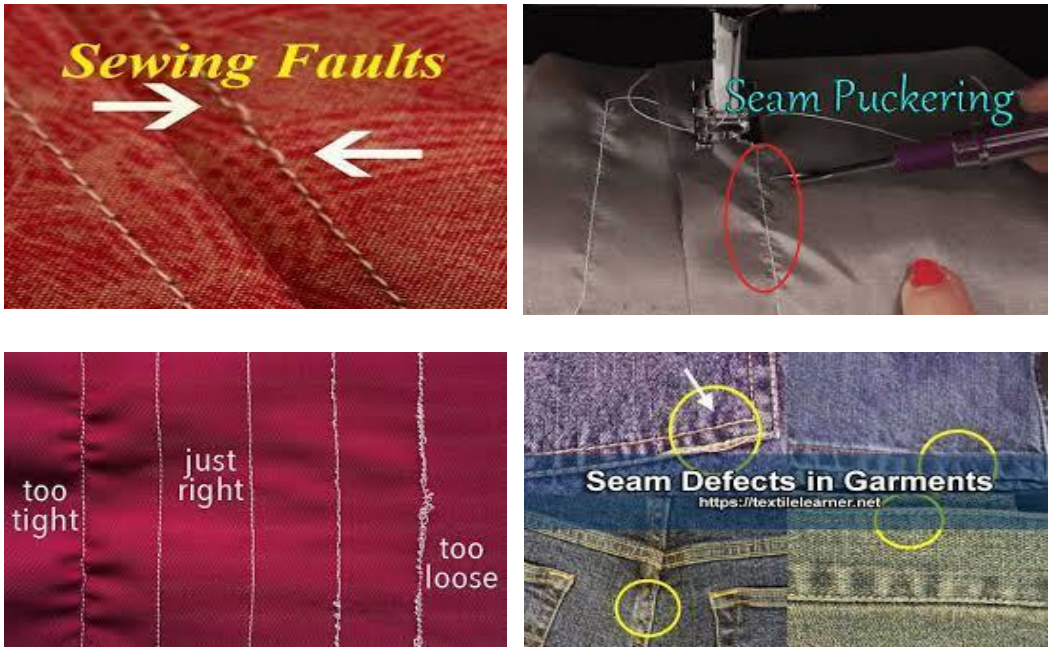


Figure 51: Sewing defect

Causes of sewing defects:

- Seam puckering
- Needle thread breakage
- Bobbin or looper thread breakage
- Skipped stitch
- Uneven stitch

Remedies of sewing defects:

- Proper placement of looper
- Seam faults should be checked.
- Experienced worker showed be selected
- Setting of proper tension to sewing thread

Artwork problem and its remedies (4.76%)

When there is art work in the garments then this problem may arise. Mainly positioning of the art work is the problem that happens in sampling.

Causes of Artwork problem:

- Because not flowing the Tech pack correctly.
- Not understanding the positioning of art work.

Remedies of artwork problem:

- Art work positioning should be followed carefully.
- Experience worker should be selected.

Workmanship problem and their remedies (19.05%)

The degree of skill of which a product is made or a job is done is known as workmanship. In garments sampling workmanship plays a vital role to produce good quality samples. Because these are silly problems made by the workers which may lead to the garment's sample rejections.

Figure 52: Workmanship problem

Causes of workmanship defects:

- Due to lack of experience of the workers.
- Lack of concentration while working.
- Working environment if not up to the mark.
- Checking of the finished sample if not done properly.
- If the workers are not well trained.

Remedies of workmanship defects:

- Experienced workers should be selected for sample making.
- Working conditions for worker showed be standard.
- Workers should be given proper training.
- Proper motivation should be given to workers.
- Supervisor showed inspect the finished sample.

Accessories problem and their remedies (14.29%)

The material which is used to make the garments attractive other than fabric and trims is known as accessories. Buyers usually asked for different types of Accessories with their sample. But sometimes factory workers make mistakes while attaching accessories or they miss accessories. These are Basically known as accessories problems.

Figure 53: Accessories Problem

Causes of accessories problem:

- When the quality of accessories does not match with the trim card.
- When the care level or size level is missing or does not attach at the right position.
- When the packing is not done with the desired poly bag.
- Missing hang tag.
- If the elastic is not latex free.

Remedies of accessories problem:

- Accessories quality should be inspected rightly to match with the trim card.
- Have to be careful so there are no missing accessories.
- Elastic use was latex free.
- Size level or care level should be attached at the right place.

Fabric construction problem (4.76%)

When fabric GSM is not up to the mark this problem mainly arises. Also, there are other reasons behind fabric construction problems like stitch per inch is more or less or patta, lycra etc.

Figure 54: Construction problem

Causes of fabric construction problem:

- High yarn tension.
- Count variation.
- Mixing of the yarn lot.
- Lack of inspection.

Remedies of fabric construction problem:

- Ensure uniform yarn tension to all the feeder.
- Have to be careful so a lot of yarn may not get mixed.
- Inspection should be done carefully.

Shade variations problem and their remedies (4.76%)

When the shades of different samples or shade of the body and sleeve of the same sample do not match with each other this problem may occur. This is one of the major problems of sample rejection. Shade variations reduce the quality of a product.

Figure 55: Shade Variation

Causes of shade variations problem:

- Miss handling of the fabric roll during cutting.
- If the numbering of the cutting not done properly.
- Dyeing process not done properly.
- Workers mistakes during sewing.

Remedies of shade variations:

- Handling of the fabric roll should be done properly during cutting.
- Numbering of the cutting showed be done properly.
- Right chemical showed be used during cutting.
- Workers showed be careful during sewing.

Printing problem and their remedies (9.53%)

Defects that occur during the operation of printing is known as printing defect. Sample garments are sent into the printing section if there is a need of printing after cutting. There are lots of printing defect some of them are - fussing, bleeding, misfit, stick in, double printing, pattern bending etc.

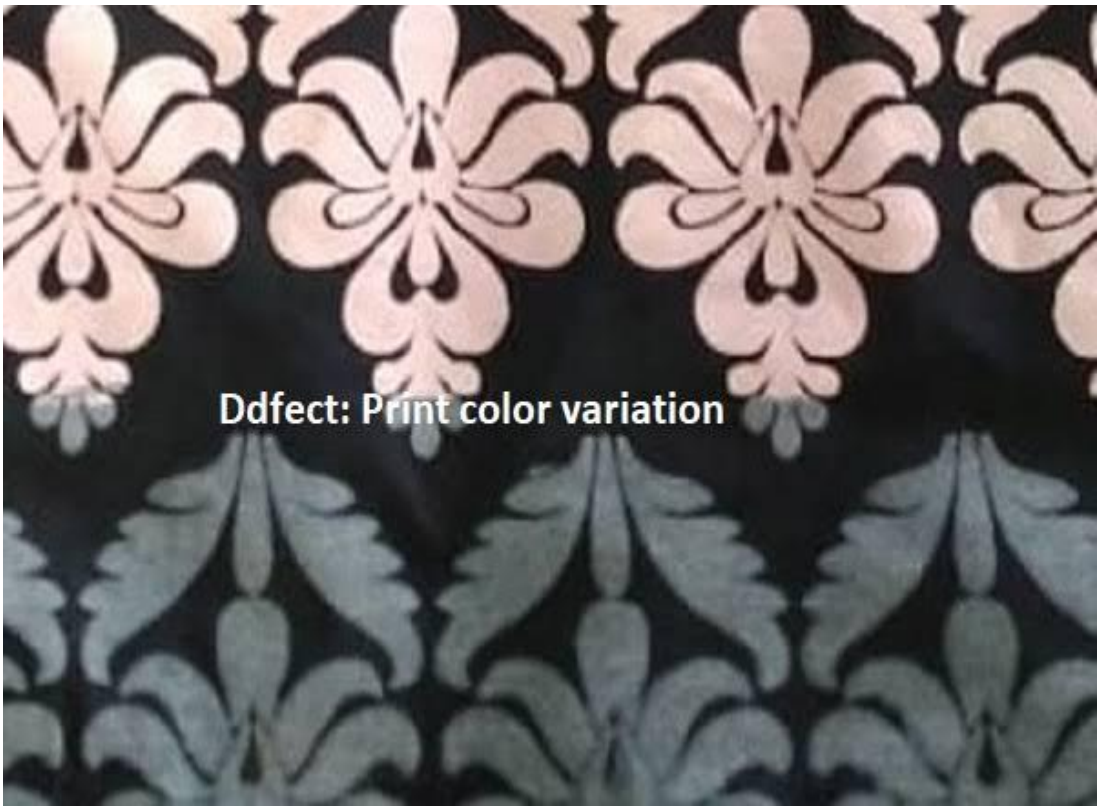


Figure 56: Printing Problem

Causes of printing defect:

- When the screen is not fit properly then misfit may arise.
- When small fiber gets stuck in screen then problems accrue.
- Low viscosity of print paste may cause bleeding in printing.
- Improper setting of the machine may cause misprint.
- During printing if the print paste runs out low then printing defect may arise.

Remedies of printing defect:

- Screen showed be set up properly.
- Print paste should have high viscosity as desired to produce exact print.
- Machine setting should be proper.
- Workers have to monitor the complete process so that printing paste may not runs Out.

Other's reason of quality failure:

Shrinkage problem

During the washing fabric may extend or shorten which is known as shrinkage. Because of Shrinkage there may be problems in garments measurement.

Figure 57: Shrinkage Problem

Delayed of raw materials

If the raw materials which are required to produce a sample are not arrived on time, then quality of the garments Won't be up to the mark. Supplier and buyers prefixed a time before the sample will be delivered but because of the arrival of fabric in-house work will not be started on time. Also, if the accessories do not arrive on time, then also this problem may arise. So the sample section then needs to produce samples quicker than its normal capabilities which lead to the quality failure.

Quality of the raw materials

If the quality of the fabric is not good enough then there will be quality failure in the final product. Without the good quality raw materials all the above defects we learn in this study about samples will arise.

Overload of order

If there is order overload in the sample department then there may be quality failure because workers efficiency will reduce with working overtime. So, overload creates workmanship defects. Eventually the quality of the sample was reduced.

CHAPTER 5

PROFESSIONAL RESPONSIBILITIES

5.1 Codes & standards used

ILO- International labor organization is a United national agency who works to provide social and economic justice for workers by setting international labor standards. Mosharaf Apparel Studio Ltd. provides this certificate

BSCI- Business social compliance initiative is a supply chain management code of conduct which provides company with a social auditing methodology. Mosharaf Apparel Studio Ltd. applies all the code of conduct of BSCI.

SEDEX- Supplier ethical data exchange enables to business to work together to better manage their social and environmental performance.

WRAP- World responsible accredited production is the biggest certification for manufacturing clothing for factories. Mosharaf Apparel Studio Ltd. achieved wrap certificate.

HIGG- This is an apparel industry self-assessment standard to rate environmental and social sustainability throughout the Supply chain. This standard is used by Mosharraf Apparel Studio Ltd.

RSC- The RSC (RMG Sustainability Council) conducts structural, electrical, fire and boiler safety inspections, supports and monitors remediation, conducts safety training and operates an independent safety & health complaints mechanism available to workers in RMG factories in Bangladesh.

These are the code and standards maintained by Mosharaf Apparel Studio Ltd.

5.2 Ethical principles & professional commitments

The textile sector is becoming more and more competitive which also raises the question of following ethical principles in industry. Ensuring professional commitment is the basic goal of every workplace. This section aims to focus how industries like Mosharaf Group maintains professional commitment and follows ethical norms of textile industry. Between HIGG index and ISO (International Organization for Standardization), Mosharaf Group is HIGG certified. The group ensures the safety of their workers by following the international standards. They also ensure that their structural safety is maintained and provide healthcare for emergency treatment for the officers and workers. They do auditorial assessment to make sure every party associated with them gets the full priority and service from them. They maintain security measures to ensure the workplace is safe by following proper standards and having the license for trading, HIGG, and RSC from local authority, BGMEA and international authority.

5.3 Impact on society, health, culture, legal and safety issues

The textile industry has had a significant impact on Bangladesh’s economy, as well as its culture, health, safety, and legal issues. This essay will analyze the economic impact of the factory on society, the impact on cultural values, and assess health, safety, and legal issues related to the factory. By examining these topics, it will be possible to gain a better understanding of the effects of the textile industry as a whole.

This factory had a positive effect on the local economy and society in general. Specifically, this factory provided economic opportunities for the local community, with employment opportunities for both men and women. Furthermore, the factory enabled the local community to benefit from improved infrastructure and access to basic services such as electricity, water and sanitation. Moreover, this factory helped to bring about an increase in income and wealth, as well as an improvement in the quality of life for the workers. In addition, the factory was seen to have a positive effect on the environment, with reduced emissions and pollution levels. Though it has a lot of socio-economic positive aspects there is a slight cultural aspect is noticed as well. The factory had a major impact on the traditional gender roles within the community. Men were given preference when it came to high-level positions in the factory, while women were given low-level positions such as sorting and packing. This shift in traditional roles caused women to become more independent, as they were the main breadwinners in many families. This change had a positive impact on the empowerment of women in the community, as they became more educated, more financially independent, and more able to make decisions for themselves.

In case of safety and health issues the scenery is different from other Bangladeshi textile factories. Most textile factories in Bangladesh are exposed to variety of hazards such as heat and noise and lacking of health and safety equipment. But this factory is cleared of all these issues and workers of the factory been registered maintain all legal compliance.

5.4 Impact on Environment

The factory has been maintaining sustainability since its establishment. The factory is HIGG certified and working for becoming ISO certified in recent future. HIGG certification is a sustainability assessment tool that standardizes how facilities measure and evaluate their environmental performance, year over year. It is developed by Sustainable Apparel coalition which has been helping consumers ensure that the textile products they are purchasing is not hampering the environment in any way. Being a HIGG certified factory the firm has been one of the most preferred factories for many foreign clients. Also, the factory has been maintaining corporate social responsibility by ensuring sustainability in the nature which is praiseworthy.

CHAPTER 6

CONCLUSION

Conclusion

As the garments sample section is the most important section in the garments industry. Everything in a garment depends on a good quality sample. Here in this study, we work on the different comments of buyers and understand the defects which are produced during making samples. From the total analysis we found -

- Workmanship and sewing faults were found by hang ten which mainly arise because of workers irresponsibility’s.
- Along with workmanship and sewing, measurement and accessories faults was also found in Aim global. Measurement’s fault was because of pattern problem and accessories was missing by workers.
- Along with measurements fitting fault, artwork fault and printing fault was also found in Ducati fitting and artwork positioning fault was found because of measurement sheet was not followed carefully.
- Workmanship and accessories faults were found by best and less which was due to workers irresponsibility’s.
- Workmanship, sewing and measurement faults was found by medicine which was also found mostly because of inexperience workers.
- Only measurement’s fault was found by Nutmeg which was found because of cutting defects and excessive trimming during sewing
- Along with fitting, accessories and printing, fabric construction fault was also found by lotto. Printing defect was found because of not using brighter print paste.

We have worked with these different buyers in this study in a very short time to investigate different sample faults if anyone further work with this topic, we would like to recommend them to give more time to follow complete order of the buyer to achieve and analyze better result of the study.

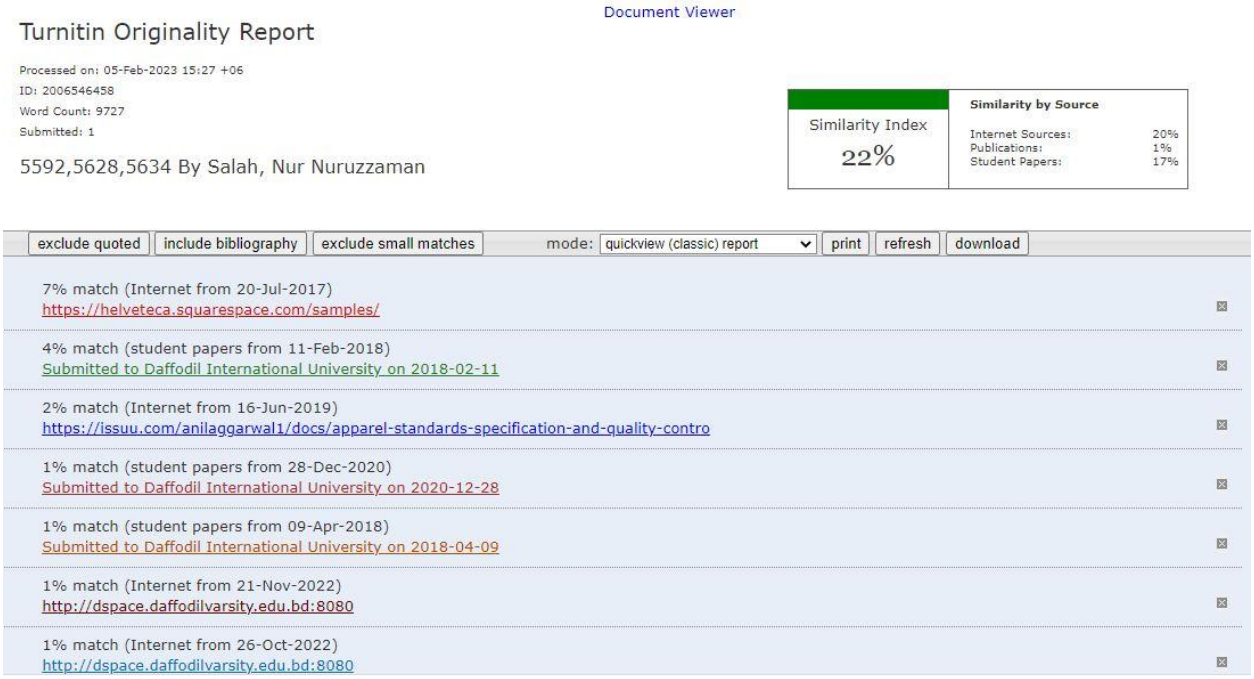


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Figure 58: Turnitin Report