



Faculty of Engineering

Department of Textile Engineering

Study on Development Sample of Home Textile Industry

Course code: TE- 4214 Course title: Project (Thesis)

Submitted by:

Habibur Rahman	182-23-5368
----------------	-------------

Supervised by:

Mominur Rahman

Assistant Professor & Head
Department of Textile Engineering

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

Bachelor of Science in Textile Engineering

Advance in Apparel Manufacturing Technology

LETTER OF APPROVAL

08-01-2023

To

The Head

Daffodil International University

Department of Textile Engineering

102, Shukrabad, Mirpur Road, Dhaka-1207

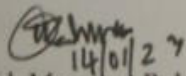
Subject: Approval of Project Report of B.Sc. In TE Program

Dear Sir,

I am simply writing to tell you that this task report titled as, "Study on Development Sample of Home Textile Industry" has been set up by the under study bearing ID: 183-23-5368 is finished for definite assessment. The entire report is readied in light of the best possible examination at ACS Textile Bangladesh Ltd. Furthermore, intrusion through basic examination of observational information with required possessions. The under study were straight forwardly associated with their undertaking exercises.

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

Yours Sincerely,




Md. Momtazur Rahman

Assistant Professor & Head
Department of Textile Engineering
Faculty of Engineering
Daffodil International University

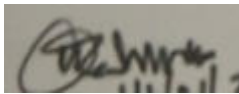
DECLARATION

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

Name	ID & SIGNATURE
Habibur Rahman	182-23-5368 

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

Supervisor:



Md. Mominur Rahman

Assistant Professor

Department,

TE, FE, DIU

ACKNOWLEDGEMENT

First of all, i would like to pay our special regards to Allah. By the grace of Allah I am going to conclude the work of thesis paper. I would like to extend our deepest and warm gratitude to those people, who allow us to walk in a long way with lots of knowledge by embracing the right direction. By all means, they made significant contribution in this long journey of use for having a good result with experience in Thesis report. The first step in getting help is from our department (Textile Engineering). Undoubtedly, the help of our supervisor is incomparable. Our respected Sir Mr. Md. Mominur Rahman, (Department Head of Textile Engineering) gives us the way of having a good experience with a lot's of positive vibes. I cannot begin to express thanks to our Sir. I would like to express our heartiest gratitude to Our respected Supervisor. I am able to end my journey beautifully by walking on the path shown by him. All the guidelines, having a good impression, being confident, maintain every rule as well as I have received a lot of information related to the subject from our respected supervisor.

The employee of office and workers helped us a lot. Their contribution, advices and suggestion created a wise and long effect of our journey.

The management team of ACS TEXTILE (BD) LTD. is awesome. I am grateful. I would like to thank Mr.Ovais Akbani (DMD) at ACS TEXTILE (BD) LTD. And also thank to Mr.Rubel Ahammed (Senior Merchandiser).I am very beholden to him, his help has benefited us a lot

In the end, Acknowledge with due respect the constant support and patience of our parents. I am grateful to them for trusting me.

ABSTRACT

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

Table of Content

LETTER OF APPROVAL.....	ii
DECLARATION.....	iii
ACKNOWLEDGEMENT.....	iv
ABSTRACT.....	v
CHAPTER- 1	
INTRODUCTION.....	1
1.1 Background of the Study.....	2
1.2 Objectives of the Study.....	2
1.3 Importance of the Study.....	2-3
1.4 Limitations of the Study.....	3
CHAPTER- 2	
LITERATURE REVIEW.....	4
2.1 Sample.....	5
2.2 Introduction of development sample of Home Textile.....	5
2.3 Home Textile.....	5-6
2.4 Home Textile Market Segmentation.....	6
2.5 Global Market of Home Textile.....	6-7
2.6 Home Textile in Bangladesh.....	8
2.7 Sample Development of Home Textile coordinate with Merchandiser.....	9
2.8 Duties and Responsibilities of a Merchandiser.....	10-11
2.9 Sample Section.....	11-14

Study on Development Sample of Home Textile Industry

2.10 Sample Development.....	14
2.11 Purpose of Sample Development.....	15
2.12 The Details attached to the Garments Sample.....	15
2.13 Sampling Process	16
2.14 Process Flow Chart After Receiving New Style in Development Stage.....	17-18
2.15 Buyer Mascot HØIE	19
2.16 Mascot Hoie Buyer SOP.....	20
2.17 Sampling process flow chart.....	21

CHAPTER- 3

EXPERIMENTAL DATA.....	22
3.1 Development Sample for Duvet cover.....	23
3.1.1 Design File Details	23
3.1.2 Design Information.....	24-25
3.1.3 Design File Details	25-27
3.1.4 Design File Details	27-29
3.1.5 Stitching DTM.....	30-33
3.2 ORDER SHEET.....	33-34
3.2.1 GREY DEMAND.....	34-35
3.2.2 DIRECTION SETTING.....	35-36
3.2.3 PRINTING PROGRAMME.....	36-37
3.2.4 STITCHING PROGRAMME.....	37-38
3.2.5 TRIMMING & ACCESSORIES.....	39-41
3.3 MEASUREMENT CHART.....	42

Study on Development Sample of Home Textile Industry

3.4	LOT OR PACKING LIST.....	43
CHAPTER- 4		
	RESULT AND DISCUSSION.....	44
4.1	Analysis of development Sample for Duvet set (Hakan).....	45
4.1.1	Analyzing various Characteristics of Duvet set & Pillowcase.....	45-46
4.1.2	Challenges for Duvet set & Pillowcase: Hakan.....	46
4.1.3	Overall View for the development sample of Duvet set and pillowcase.....	46
4.1.4	Rejection and Comments for Duvet & pillowcase.....	46
4.2	Analysis of Development Sample for Flat sheet (Fina).....	47
4.2.1	Analyzing various characteristics of Flat sheet (Fina).....	48
4.2.2	Challenges for Flat sheet (Fina).....	48
4.2.3	Overall View for the development sample of Flat sheet.....	49
4.2.4	Rejection and Comments for Flat sheet.....	49
4.3	Analysis of Development Sample for Fitted sheet (Helmer).....	49
4.3.1	Analyzing various characteristics of Fitted sheet (Helmer).....	50
4.3.2	Challenges for Fitted sheet.....	50
4.3.3	Overall View for the development sample for Fitted sheet.....	51
4.3.4	Rejection and Comments for Fitted sheet.....	51
4.3.5	Analysis of types of comments of buyer Mascot Hoie for Duvet cover and Pillowcase.....	52-53
4.3.6	Analysis of types of comments of buyer Mascot Hoie for Flat and Fitted sheet.....	54-55
4.4	Difference between 3 products of this report.....	56

CHAPTER- 5

Conclusion.....	57
5.1 Conclusion.....	58
References.....	59

List of Figure

Fig 2.5 Major Product Categories of Home Textile Product.....	7
Fig 2.5.1 Global Market of Home Textile.....	7
Fig 2.7 Role of Merchandiser.....	9
Fig 2.9 Strike Off Sample.....	12
Fig 2.9.1 Size set Sample.....	12
Fig 2.9.2 P.P Sample.....	13
Fig 2.9.3 Gold Seal Sample.....	13
Fig 2.9.4 Production Sample.....	14
Fig 2.17 Sampling Process Flow Chart.....	21
Fig 3.2.2 Direction Setting.....	36

List of Table

4.1.1 Analyzing various Characteristics of Duvet set & Pillowcase.....	45-46
4.1.3 Overall View for the development sample of Duvet set and pillowcase.....	46
4.1.4 Rejection and Comments for Duvet & pillowcase.....	46
4.2.1 Analyzing various characteristics of Flat sheet (Fina).....	48
4.2.3 Overall View for the development sample of Flat sheet.....	49
4.2.4 Rejection and Comments for Flat sheet.....	49
4.3.1 Analyzing various characteristics of Fitted sheet (Helmer).....	50
4.3.3 Overall View for the development sample for Fitted sheet.....	51
4.3.4 Rejection and Comments for Fitted sheet.....	51
4.3.5 Analysis of types of comments of buyer Mascot Hoie for Duvet cover and Pillowcase.....	52
4.3.6 Analysis of types of comments of buyer Mascot Hoie for Flat and Fitted sheet.....	54
4.4 Difference between 3 products of this report.....	56

CHAPTER- 1
INTRODUCTION

1.1 Background of the Study

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

Merchandiser could help the sample coordinators by informing about the product style. The sampling department's development samples should be prepared.

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

1.2 Objectives of the Study

- To show the different types of sample and their development process at home textile.
- To find out the limitations of samples.
- To identify the challenges of getting approval of a sample before beginning bulk manufacturing.

1.3 Importance of the Study

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

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

1.4 Limitations of the Study

We encountered the following issues while working on our thesis:

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

CHAPTER- 2
LITERATURE REVIEW

2.1 Sample

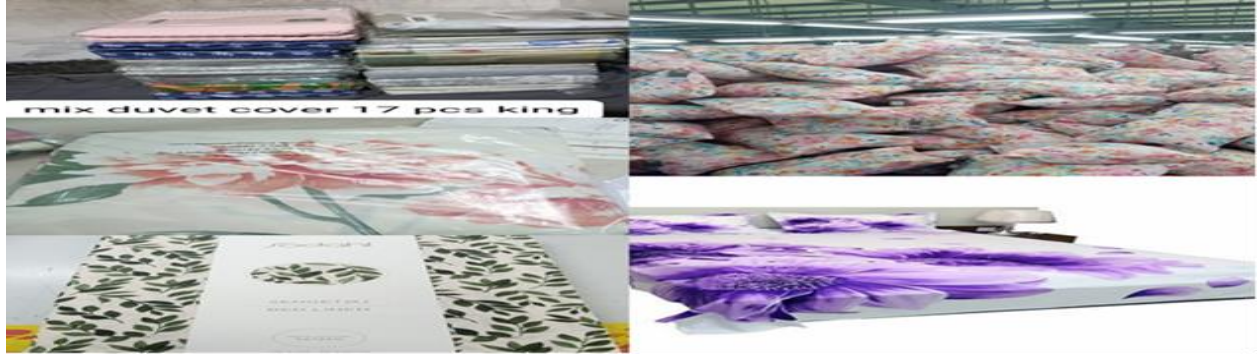
The buyer can determine how and if to confirm the order based on the sample, which is the garment's prototype or model. On the other hand, Sample is a product which represent a group of product or lot or batch, in order to assess their quality, style or design or any characteristic of the product. Depend on the sample the customer will give Approval or Comments for any modification in design or style or quality. Now we can easily explain that the product which we need to develop as buyer requirement for buyer approval before bulk production is called the Sample.

2.2 Introduction of development sample of Home Textile

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

2.3 Home Textile

Home textile is one of the growing branches of technical textile. It can be defined as textiles used for home & office decoration, called Home Textiles. In addition to embellishments, demands & appetite has also been added to this home textile. More important than home decor, maintenance work or comfort is keeping our minds fresh and well. It provides mental relaxation to people. The Bangladesh home textiles market has a strong growth due to rising the consumers demand. Home textile is now one of the vital export sectors in Bangladesh also known as domestic textiles. There are Duvet cover, pillowcase, Spread sheets, fabric bag Curtains, Bed sheets, Blankets, Cushion covers, Sofa covers, Upholstery fabrics, various furniture covers, Wall mats etc. help in beautifying the house.



2.4 Home Textile Market Segmentation

Product Segmentation:

- ◆ Bed linen
- ◆ Bath linen
- ◆ Kitchen linen
- ◆ Upholstery
- ◆ Carpets & floor coverings
- ◆ Others

Distribution Channel Segmentation:

- ◆ Retail Outlets
- ◆ Online Market Place

Geographical Segmentation:

- ◆ Asia Pacific
- ◆ Europe
- ◆ North America
- ◆ South America
- ◆ Middle East Africa

2.5 Global Market of Home Textile

In the present situation, Home textile Make a huge market in the world. The world home textiles market size is predicted to success at \$133.4 billion by 2025 registering a CAGR (Compound annual growth rate) of 5.01%. Additionally, quickly Real Estate market is expected to improve the home textile market growth from 2019 to 2025.

Study on Development Sample of Home Textile Industry



Fig 2.5: Major Product Categories of Home Textile Product

In this figure, terms of revenue bathroom linen is predicted to register a CAGR of 3.4% growth same as kitchen, upholstery, flooring product revenue rapidly growth day by day.



Fig 2.5.1: Global Market of Home Textile

2.6 Home Textile in Bangladesh

Even a decade ago, Bangladesh did not have a name in the world market in the home textile sector. At present, the name of Bangladesh has been associated with China, India and Pakistan. The home textile product has high demand, especially in the European market. Exports of home textiles are also increasing due to demand. According to the Bangladesh “Terry Towel and Linen Manufacturers and Exporters Association” and the “Export Promotion Bureau”, the home textile export revenue in 2004-05 FY was only 150 million USD. In the 2010-11 FY, it increased to about 790 million USD. In the 2016-17 FY, the home textile export income came to 79 core 91 lakh 40 thousand US dollars. In 2018-19 FY, exports of home textiles goods worth 850 million USD were made in this sector. However, due to the outbreak of Corona in the outgoing fiscal year (2019-20), the export income of this sector decreased to 75 core 89 lakh USD. But, in the first three months of the current fiscal year (2020-21), home textile exports have been 25 crore 23 lakh USD, an increase of 40.74 percent.

The number of home textile factories in Bangladesh is much less than that of garment manufacturers. But now home textile is one of the first line export sectors in Bangladesh. There are 25-30 home textile factories in Bangladesh, big and small, which are exporting almost 234 products abroad to meet the demand of the country. There are some famous home textile industry like as Zaber & Zubair group, ACS Textile Bangladesh Ltd, All tex, Mom Textile etc.



2.7 Sample Development of Home Textile coordinate with Merchandiser

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

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

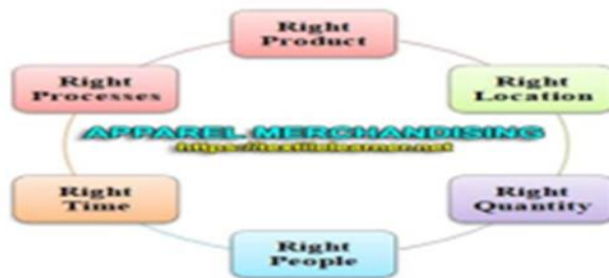


Fig 2.7: Role of Merchandiser

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

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

2.8 Duties and Responsibilities of a Merchandiser

A Merchandisers Key Responsibility is as follows:

- ◆ Product Development
- ◆ Market and product Exploration
- ◆ Selling the concept
- ◆ Booking orders
- ◆ Confirming Deliveries
- ◆ Designing and Sampling follow up
- ◆ Costing
- ◆ Raw Material
- ◆ Flow Monitoring
- ◆ Production Follow Ups
- ◆ Payments Follows
- ◆ Internal and external communication with buyers
- ◆ Sampling
- ◆ Lab dips

Study on Development Sample of Home Textile Industry

- ◆ Accessories and trims
- ◆ Preparing internal order sheets
- ◆ Preparing purchase orders
- ◆ Advising and assisting production,
- ◆ Advising quality department about quality level
- ◆ Mediating production and quality departments
- ◆ Giving shipping instructions and following shipping mark.
- ◆ Helping documentation department.
- ◆ Taking responsibility for inspections and
- ◆ Following up the shipment.

2.9 Sample Section

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

- ❖ **Strike Off Sample:** Strike off samples are known as the first sample. At least three sample should be made – 2 samples to send to the buyer for approval. Out of these 2 sample, buyer keeps one sample and send back to the second sample to the factory. Third sample should be made as a factory's counter sample of strike off sample.



Fig 2.9: Strike Off Sample

- ❖ **Size set sample:** The determination of the size set sample is checking the product with bed fit of more sizes. The size set samples are normally made for common sizes. Like Norway size, Swedish size, Denmark size, Germany size etc. A number of samples required for size set depend on the customer's requirement. If the merchandiser team found some sizes are not giving accurate with Bed Mapping, they do correction on the pattern until they get the accurate fit. After the size set approval, the supplier can develop the PP sample.

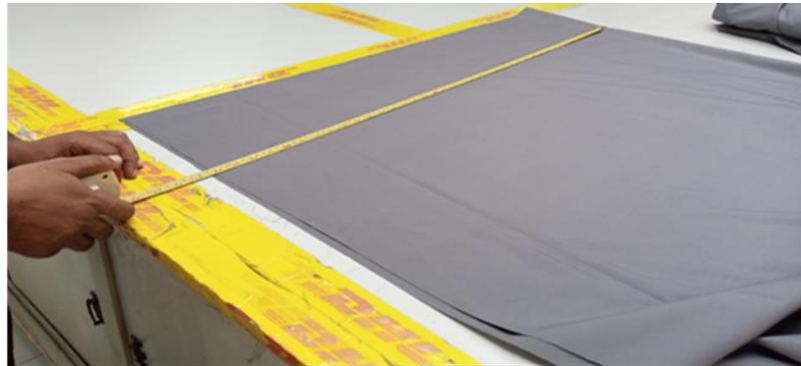


Fig 2.9.1: Size set sample

- ❖ **Salesman sample:** Buyer want salesman sample or SMS sample after approve the strike off sample to see their market assessment. In salesman sample we sent 90 pieces of sample and 80 pcs Swatch.
- ❖ **P.P sample:** Before bulk production we sent the pre-production sample to the buyer.



Fig 2.9.2: P.P sample

- ❖ **Gold Seal sample:** Once the PP sample is approved by the brand, they are sealed to prevent tampering from the factory and now become the standard for bulk production. They are also known as gold-seal samples or red-seal samples, depending on the approval, or disapproval of the brand.



Fig 2.9.3: Gold Seal sample

- ❖ **Production Sample:** After Bulk production and before shipment we send the production sample to the buyer.

2.11 Purpose of Sample Development

- To allow the buyer to evaluate the production abilities of the producer.
- To deliver a means for making adjustments in the bulk production process.
- To let the manufacturer evaluation the thread and fabric consumption, and develop cost quotations.
- To let the buyer know the potential of an exporter.

2.12 The Details attached to the Garments Sample

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

- Article Name
- Article Number
- EAN code
- Fabrication
- Quality
- Composition
- Description
- Quantity
- Size
- Price

2.13 Sampling Process

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

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

The second stage covers the process after getting approval of the first strike off sample and matching the color shade of this sample with buyer requirements after getting approval then carry out the functions of sourcing and ordering component, testing the product and carry out trails once the approved sample specifications has been pinched up.

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

Samples that are made in development stage are as following:

- Develop sample
- Photo sample
- Size set sample
- Sales sample
- Pre-production sample

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

- Production sample according to gold seal.
- Shipment sample (Before final shipment)

2.14 Process Flow Chart After Receiving New Style in Development Stage

First of all Merchandiser receive the sample request according to design file from customer. Then they start their work on it. They analysis and sent it to the Computer Aided Design (CAD) section. In CAD, the designer follow the design file and develop the design with a standard direction which is help to make the sample fabric printing. For home textile product there have two direction length for length (LxL) & width for length (WxL) for flat bed or rotary & digital printing machine. After that merchandiser sent the Sample Grey demand (SGD) of the fabric and also sent requisition to store for arrange the required accessories for the Product. After the fabric weaving, the mending section sent it into the processing section. The develop merchandiser sent processing program to the processing section. In processing the fabric get pre-treatment before printing .After printing, fabric sent to the finishing, then it sent to the folding. After Folding the develop merchandiser sent it in to the sample room for cutting, sewing and finishing. To complete the all Process the product has made.

Tech pack Received From Buyer

Make File and analysis thus file

Need to check Lab dip for color Standard

Make a Plan for easy work

Create Fabric Grey Demand and send file to Weaving & Mending section

Create Accessories Requisition for Strike off Sample and Developed Sample

Need to make Processing Program for Printing

Need to make a requisition for testing the Sample

After Fabric finishing need to sample requisition for sample section

Follow up Pattern master to cutting sample according to buyer layout.

Follow up R&D section for Photo sample fabric

Need to check Photo Sample Accessories

Study on Development Sample of Home Textile Industry

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

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

Must be note down every step in summary.

After photo sample send need to work for size set Sample.

After sent size set sample need to GSS/Seal sample for buyer approval just before bulk production.

There are many customers in a industry, such as

- Kid. Hemtex 24 H, Mascot hoie. Kesko, sodhal (Scandic)
- Casino, Descamps- (France)
- Pillow talk,Adiars(Australia)
- M&S(USA)
- H&M(Sweden)

From those buyers I worked and made MY report with Kid – Mascot Hoie which is a buyer from Scandic region.

2.15 Buyer Mascot HØIE



Mascot høie is the mother buyer of the organization. The company MASCOT HØIE AS, is a Manufacturer/ Producer, founded in 1996, which operates in the Linen industry. It also operates in the Blankets, bedspreads, duvets and eiderdowns, and wool blanket industries. It is based in Brekstad, Norway We have worked on høie buyer develop stages. Mascot høie buyers order quantity is huge. Mascot Høie is the Scandinavian (Norway, Sweden, Denmark, Finland, Iceland) buyer. Mascot høie is the leading value trader among the clothing discounters and delivers its consumers with a varied product range of current seasonal fashion for the whole family, as well as home textiles and home accessories. This clothing discounter with around 6,000 employees is one of the leading clothing retailers in scandic specially Norway. All the brands have running work. Here all the stages are discussed below.

2.16 Mascot Hoie Buyer SOP

Hoie required sampling stages are-

- Develop lab dip sample
- Photo sample
- Testing sample
- Washing Sample
- P.P sample
- Gold Seal Sample
- Production Sample.

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

2.17 Sampling Process Flow Chart

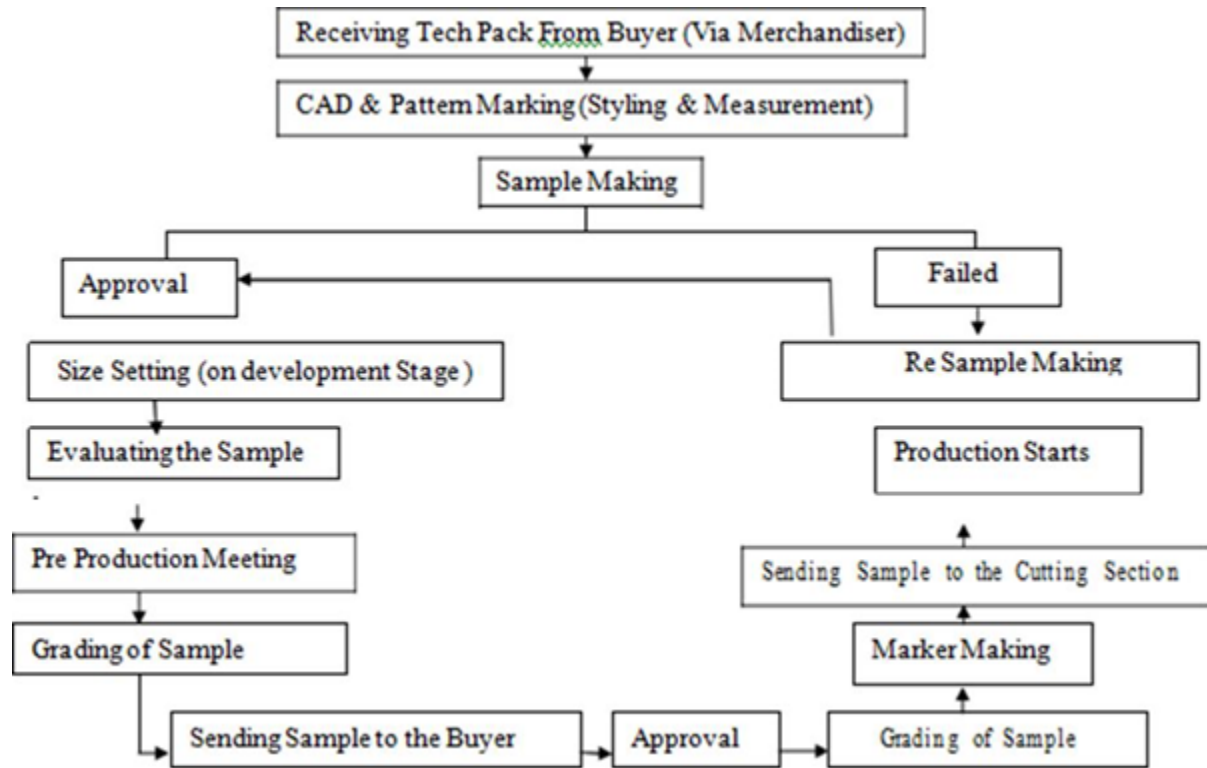


Fig 2.17: Sampling Process Flow Chart

CHAPTER- 3
EXPERIMENTAL DATA


3.1 Development Sample for Duvet Cover

3.1.1 Design File Details

- Development (Strike off) Sample.
- Style-No:809(Fina)
- Buyer:Mascot Hoie
- Designer: Trine varysied.
- Style Description: Duvet cover set.
- Order received date: 1st December, 2022.

Study on Development Sample of Home Textile Industry

3.1.2 Design Information

hoie <small>OF SCANDINAVIA</small>		New design									
Sample order no	809	Design no	design: 2794								
Grey cloth art.	100% cotton 30x30 / 76x68	Producer	ACS								
Name of design	FINA	Date:	4/26/2022								
Art. specification	SWAN - As fabric spec.										
Finishing:	Easy care + soft finish										
Product:	Duvet set										
Design repeat	See downloaded designfile										
Collection:	Høie AW 2023										
NOTES: Send strike-off / handloom per colourway for colour and print approval before you start making the samples. <i>Pls. Note this design is the property of Høie and may only be used in accordance with the instructions of Høie.</i>											
PRINT: Reactive colour: X Pigment colour:											
Col.	col name	1	2	3	4	5	6	7	8	9	10
1	Beige	See enclosed downloaded files for colour ref.				25.11.2022: Beige is approved.					
5	Pink	See enclosed downloaded files for colour ref.				25.11.2022: Make revised pink.					
8	Pistachio	See enclosed downloaded files for colour ref.				Cancel.					
6	Aqua	See enclosed downloaded files for colour ref.				25.11.2022: Make new colourway					

ITEM SAMPLES:		
Sewing model PC / DC	Size:	Comments:
PC:	* Duvet set 140x200/50x70	* Make both sizes for photo samples
DC:		
PC:	* Duvet set 100x140 / 40x60	* Make both sizes for photo samples
DC: 01		
PC:		
PC:		

Details:	Design no + colourway no:			
	Col.: Beige	Col.: Pink	Col.: Aqua	Col.:
Frontside PC	Single faced	Single faced	Single faced	
Backside PC				
Frontside DC				
Backside DC				
Thread colour	Matching ground	Matching ground	Matching ground	
Jeans stitching				
Piping				
If zipper - YKK	Matching ground	Matching ground	Matching ground	
If buttons				

Study on Development Sample of Home Textile Industry

LOGO LABEL:



121 B)
Offwhite w/ black

I kindly remind you that all photo samples
are requested to have logo label

Only on PC

CONTACT PERSON / DELIVERY ADDRESS STRIKE-OFF AND PHOTO-SAMPLES:

Trine Varøystrand Designer Manager @: trinev@hoie.no Office +47 73 88 09 51 Mobile: +47 91 81 34 88

DETAILS ONLY FOR PRODUCTION:


Folding model:

To be informed by Marte

3.1.3 Design File Details

- Development (Strike off) Sample.
- Style-No:822(Helmer)
- Buyer:Mascot Hoie
- Designer: Trine varøysied.
- Style Description: Duvet cover set.
- Order received date: 1st December, 2022.

Study on Development Sample of Home Textile Industry


høie <small>OF SCANDINAVIA</small>	New design		
Sample order no	822	Design no	design: 2801
Grey cloth art.	100% cotton flannel 20x10 / 52x44	Producer	ACS
Name of design	HELMER	Date:	11/15/2022
Art. specification	Flannel		
Finishing:	As spec.		
Product:	Duvet set		
Design repeat	See downloaded designfile		
Collection:	Høie AW 2023		
NOTES: Send strike-off / handloom per colourway for colour and print approval before you start making the samples.			
<i>Pls. Note this design is the property of Høie and may only be used in accordance with the instructions of Høie.</i>			
PRINT: Reactive colour:		Pigment colour: X	

Col.	col name	1	2	3	4	5	6	7	8	9	10
4	Red	Creme our standard	19-1543 TCX	17-0000 TCX	Opt 1.						
4	Red	Creme our standard	As paper	17-0000 TCX	Opt 2						
4	Red	Creme our standard	As paper	As paper	Opt 3						

ITEM SAMPLES:

Sewing model PC / DC	Size:	Comments:
PC: 28	Duvet set 140x200 / 50x70	
DC: 01		
PC: 04		
DC:		
PC:		
DC:		
PC:		
PC:		

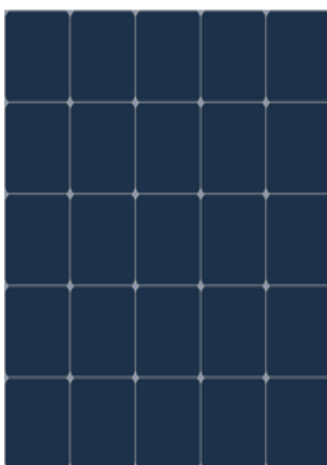
Study on Development Sample of Home Textile Industry

Design no + colourway no:	
Details:	Col.: Red
Front piece PC	Single faced
Back piece PC	
Front piece DC	
Back piece DC	
Thread colour	Matching
Jeans stitching	
Piping	
If zipper - YKK	Creme
If buttons - on PC	PC: 4 pcs.
Buttons: 18mm Covered with self fabric	
LOGO LABEL:	
	<p style="color: red;">Kindly note that all photo samples are requested to have Logo label</p> <p>121 B offwhite with black logo Only on PC</p>
CONTACT PERSON / DELIVERY ADDRESS STRIKE-OFF AND PHOTO-SAMPLES:	

3.1.4 Design File Details

- Development (Strike off) Sample.
- Style-No:829(Hakan)
- Buyer:Mascot Hoie
- Designer: Trine variesied.
- Style Description: Duvet cover set.
- Order received date: 1st December, 2022.



Study on Development Sample of Home Textile Industry

høie <small>OF SCANDINAVIA</small>	New design		
Sample order no	829	Design no	design: 2793
Grey cloth art.	Sateen 40x40 / 135x80	Producer	ACS
Name of design	HÅKAN	Date:	11/24/2022
Art. specification	As fabric spec.		
Finishing:	As fabric spec		
Product:	Duvet set		
Design repeat	See details on colourpalette data fi		
Collection:	Høie AW 2023		
<p>NOTES: Send strike-off / handloom per colourway for colour and print approval before you start making the samples.</p> <p><i>Pls. Note this design is the property of Høie and may only be used in accordance with the instructions of Høie.</i></p>			
PRINT: Reactive colour: X		Pigment colour:	

Col.	col name	1	2	3	4	5	6	7	8	9	10
g	Anthracite	19-0201	16-1102	18-1242							
	e	TCX	TCX	TCX							

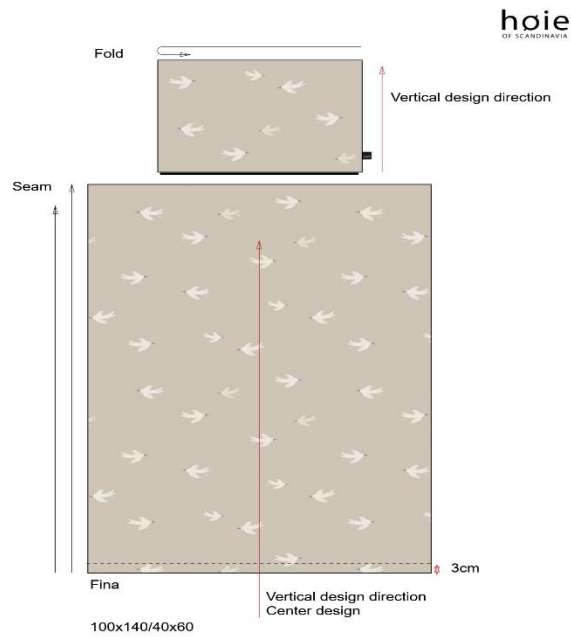
ITEM SAMPLES:											
Sewing model PC / DC		Size:				Comments:					
PC: 04		Duvet set 140x200 / 50x70									
DC: 01											
Details:		Design no + colourway no:									
		Col.: Anthracite									
Frontside PC		Single faced									
Backside PC											
Frontside DC											
Backside DC											
Thread colour		Matching									
If zipper - YKK		19-0201 TCX									
Logo colour		Black w/ gold 120 B									

Study on Development Sample of Home Textile Industry

LOGO LABEL:	
	120 B) Black w/ gold
I kindly remind you that all photo samples need to have logo label. Only on PC.	
CONTACT PERSON STRIKE-OFF AND PHOTO-SAMPLES:	
Trine Varøystrand Designer Manager @: trinev@hoie.no Office +47 73 88 09 51 Mobile: +47 91 81 34 88	
DETAILS ONLY FOR PRODUCTION:	
Folding model:	
Single faced = 1	
	

3.1.5 Stitching DTM

Design: Fina



hoie
OF SCANDINAVIA

Design No: 2794 Fina
Single faced

PC Model no 04

Pillowcase with folded envelope-opening in bottom long side.

Size: 50x70cm = 25cm flap inside.

Size 40x60 / 35x40cm = 15cm flap inside

Logo placement: Version no 12.

Duved cover: Model No: 01

With full opening in bottom shortside with zipper.

Logo colour:

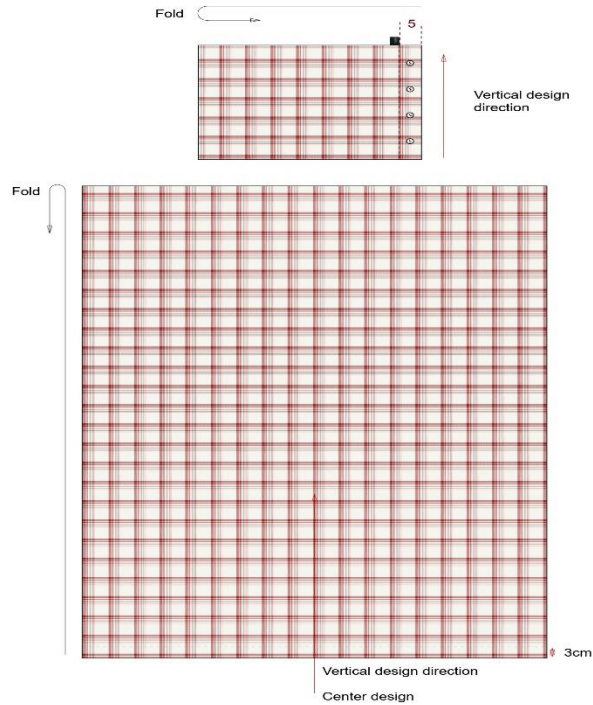


121 B)
Offhite
w/black

FOLDING MODEL NO:
Instructions to be given by Marte



Design: Helmer



Design No: 2801 Helmer

PC Model no 28

Pillowcase with opening in short side.
Closing: 4 pcs. buttons.
5cm hem/fold in opening

Logo placement: Version no 5.

Duved cover: Model No: 01

With full opening in bottom shortside with zipper.



Ref. for buttons:
Covered with self fabric 18mm
2pcs silverholes.

Logo colour:

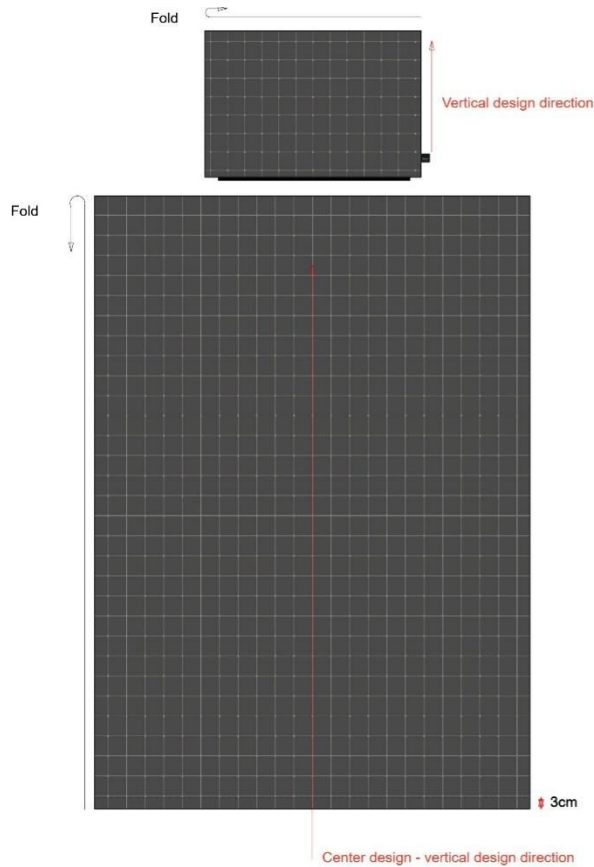


121 B)
Offwhite with
black logo

FOLDING MODEL NO: 5



Design: Hakan



Design No: 2793 Håkan

PC Model no 04

Pillowcase with folded envelope-opening in bottom long side. 25cm flap inside.

Logo placement: Version no 12.

Duved cover: Model No: 01

With full opening in bottom shortside with zipper.

Logo colour:



120 B)
Black
w/gold

FOLDING MODEL NO: 1 Single faced



There have lot of designs are sent from buyer. First step we develop the strike off sample and send to the buyer then the buyer look carefully specially color & size. If the color or printing match with buyer requirement then they given approval and finally we get order sheet from buyer. In the above design the buyer approved the design "Hakan". We got a order sheet from buyer. After getting order sheet we start to planning about bulk production. But before bulk production & after bulk we have sent many sample to the buyer:

Before Bulk:

- Photo Sample
- Size set Sample
- Gold seal Sample
- Pre production Sample

After Bulk:

- Testing Sample
- Washing Sample
- Pre Shipment Sample

3.2 ORDER SHEET

Study on Development Sample of Home Textile Industry

Purchase Order PO19024

Page 1



Supplier 52050
ACS Textiles (Bangladesh) Ltd.
Mehedi Hasan
Tetlabo, Ward-3, Parabo,
Rupganj,
Narayanganj
Bangladesh

Ship to Address
Mascot Høie AS
Tverrvæien 29
7130 Brekstad
Norway

Order Date 10. June 2022
Purchaser Maria T. Strand
Direct Phone +47 72 51 33 92
Direct E-Mail maria.strand@hoie.no

VAT Registration No.

ETD

15.10.2022

Your Reference

Payment Terms Payment in advance

ETA

15.12.2022

Terms of Delivery

FOB

Item No.	Description	Volume	ETD	Expected Receipt	Qty.	UoM	Units per Parcel	Direct Unit Cost	Amount	HS Code	EAN Code	Supplier Item No.	Customer Item No.
7006731	Håkan sett krem DK 10x200/60x63 cm	0,41	15.10.22	15.12.22	102	PCS	6	11,17	1 119,34	6302 2100	234 157067313		
7006732	Håkan sett krem DK XL 10x220/60x63 cm	0,20	15.10.22	15.12.22	50	PCS	4	10,05	402,50	6302 2100	234 157067320		
7006724	Håkan sett marine DK 10x200/60x63 cm	0,48	15.10.22	15.12.22	120	PCS	6	11,17	1 340,40	6302 2100	234 157067245		
7006725	Håkan sett marine DK XL 10x220/60x63 cm	0,31	15.10.22	15.12.22	80	PCS	4	12,05	964,00	6302 2100	234 157067252		
7006733	Håkan sett krem SE 10x210/50x60 cm	0,31	15.10.22	15.12.22	78	PCS	6	11,88	96,64	6302 2100	234 157067337		
7006734	Håkan sett krem SE dbf 20x220/215x60 cm	0,12	15.10.22	15.12.22	20	PCS	2	16,61	372,20	6302 2100	234 157067344		
7006726	Håkan sett marine SE 10x210/50x60 cm	0,31	15.10.22	15.12.22	78	PCS	6	11,88	96,64	6302 2100	234 157067269		
7006727	Håkan sett marine SE dbf 20x220/215x60 cm	0,12	15.10.22	15.12.22	20	PCS	2	16,61	372,20	6302 2100	234 157067276		

Mascot Høie AS
Tverrvæien 29
7130 BREKSTAD
Norway

Phone No.
Home Page
The Registry of Business Enterprises

+4772 51 33 60
www.hoie.no
976 031 636 MVA

Bank
Account No.
SWIFT Code
IBAN

Danske Bank
USD - 8601258834
DABANK22
N0968601258834

Purchase Order PO19024

Page 2



Supplier 52050
ACS Textiles (Bangladesh) Ltd.
Mehedi Hasan
Tetlabo, Ward-3, Parabo,
Rupganj,
Narayanganj
Bangladesh

Ship to Address
Mascot Høie AS
Tverrvæien 29
7130 Brekstad
Norway

Order Date 10. June 2022
Purchaser Maria T. Strand
Direct Phone +47 72 51 33 92
Direct E-Mail maria.strand@hoie.no

VAT Registration No.

ETD

15.10.2022

Your Reference

Payment Terms Payment in advance

ETA

15.12.2022

Terms of Delivery

FOB

Item No.	Description	Volume	ETD	Expected Receipt	Qty.	UoM	Units per Parcel	Direct Unit Cost	Amount	HS Code	EAN Code	Supplier Item No.	Customer Item No.
7006728	Håkan sett krem N 10x200/50x70 cm	1,68	15.10.22	15.12.22	432	PCS	4	11,02	4 760,64	6302 2100	234 157067283		
7006730	Håkan sett krem N dbf 20x220/215x70 cm	0,50	15.10.22	15.12.22	90	PCS	2	17,62	1 585,80	6302 2100	234 157067306		
7006729	Håkan sett krem N XL 10x220/50x70 cm	1,68	15.10.22	15.12.22	432	PCS	4	11,88	5 112,16	6302 2100	234 157067290		
7006721	Håkan sett marine N 10x200/50x70 cm	1,95	15.10.22	15.12.22	500	PCS	4	11,02	5 510,00	6302 2100	234 157067214		
7006723	Håkan sett marine N dbf 20x220/215x70 cm	0,62	15.10.22	15.12.22	110	PCS	2	17,62	1 988,20	6302 2100	234 157067238		
7006722	Håkan sett marine N XL 10x220/50x70 cm	1,95	15.10.22	15.12.22	500	PCS	4	11,88	5 940,00	6302 2100	234 157067221		
7006738	Milano sett 10tblå DK 10x200/60x63 cm	1,61	15.10.22	15.12.22	402	PCS	6	10,52	4 229,04	6302 2100	234 157067382		
7006739	Milano sett 10tblå DK XL 10x220/60x63 cm	0,78	15.10.22	15.12.22	300	PCS	4	11,35	2 270,00	6302 2100	234 157067399		
7006740	Milano sett 10tblå SE		15.10.22	15.12.22	48	PCS	6	11,20	57,60	6302 2100	234 157067405		

Mascot Høie AS
Tverrvæien 29
7130 BREKSTAD
Norway

Phone No.
Home Page
The Registry of Business Enterprises

+4772 51 33 60
www.hoie.no
976 031 636 MVA

Bank
Account No.
SWIFT Code
IBAN

Danske Bank
USD - 8601258834
DABANK22
N0968601258834

3.2.1 GREY DEMAND

After receiving the order sheet merchndiser create a grey demand for weaving .The grey demand have quantity of fabric(Meter) ,Yarn rate, costing, total order value, total yarn required, yarn required date & shipment date etc. After creating the grey demand then it send to weaving process.

Study on Development Sample of Home Textile Industry

OS TEXTILES (Bangladesh) LTD.
 1/ETLABO, RUPGANJ, NARAYANGANJ.

Grey Demand ID : 223592	Shipment Date : 05-Oct-2022	Construction : 40/40/135*80 (Settle)	Yarn Shrinkage : 1.76
Grey Demand No : 26318	Buyer Name : Masood Hossain	Yarn Wastage : 4.153C	Wet Yn Rate : 1.25
Issue Date : 13-Jun-2022	Style Desc : Hakan	Order No : 19924	Wet Yn Rate : 1.25
Grey Require Date : 25-Sep-2022	Style No : Hakan		Bend : 130%
Byer. Pref. Dept. : Buyer Design			

Grey Fabric Requirement

Item Size	Item Name	Part	Color	Order Qty	Fab Cons	Color Wise Yarn Required	61	65	66	68
140X214 CM	DUVET COVER	All	Crème	504	4.16	496.5565	2332.21	3.00	4.00	1.00
			Navy	900	4.16	578.2844	2708.95	3.00	4.00	1.00
140X224 CM	DUVET COVER	All	Crème	402	4.56	491.1012	2307.82	3.00	4.00	1.00
			Navy	500	4.56	590.8545	2777.04	3.00	4.00	1.00
160X214 CM	DUVET COVER	All	Crème	78	4.36	30.8847	0.00	397.08	4.00	1.00
			Navy	78	4.36	30.8847	0.00	397.08	4.00	1.00
200X224 CM	DUVET COVER	All	Crème	90	4.56	129.2790	0.00	3.00	436.91	1.00
			Navy	910	4.56	158.0040	0.00	3.00	528.81	1.00
220X224 CM	DUVET COVER	All	Crème	10	4.56	31.7348	0.00	3.00	0.00	91.75
			Navy	10	4.56	31.7348	0.00	3.00	0.00	91.75
10X83 CM	PILLOWCASE	All	Crème	918	0.45	16.7285	0.00	3.00	81.75	1.00
			Navy	918	0.45	16.7285	0.00	3.00	81.75	1.00
50X70 CM	PILLOWCASE	All	Crème	1,264	0.45	183.4793	0.00	3.00	3.00	491.29
			Navy	1,200	0.45	181.0516	0.00	3.00	3.00	179.41
80X80	PILLOWCASE	All	Crème	152	0.52	24.8916	0.00	0.00	82.98	0.00
			Navy	230	0.52	32.7800	0.00	0.00	103.20	0.00
Total							12,125.53	714.17	1,281.20	1,201.25

Total Fabric Required : 13,362.26 - Stock Use : 0.90 = 13,362.26

Total Order Qty : 5,484

Remarks:

3.2.2 DIRECTION SETTING

After grey demand it's the most important to direction the setting for printing rotary. If mistakenly changed the direction of printing screen then the repeat size of design or totally changend the design. When the fabric cutting we could not cut the fabric according to buyer required then the fabric has been rejected.

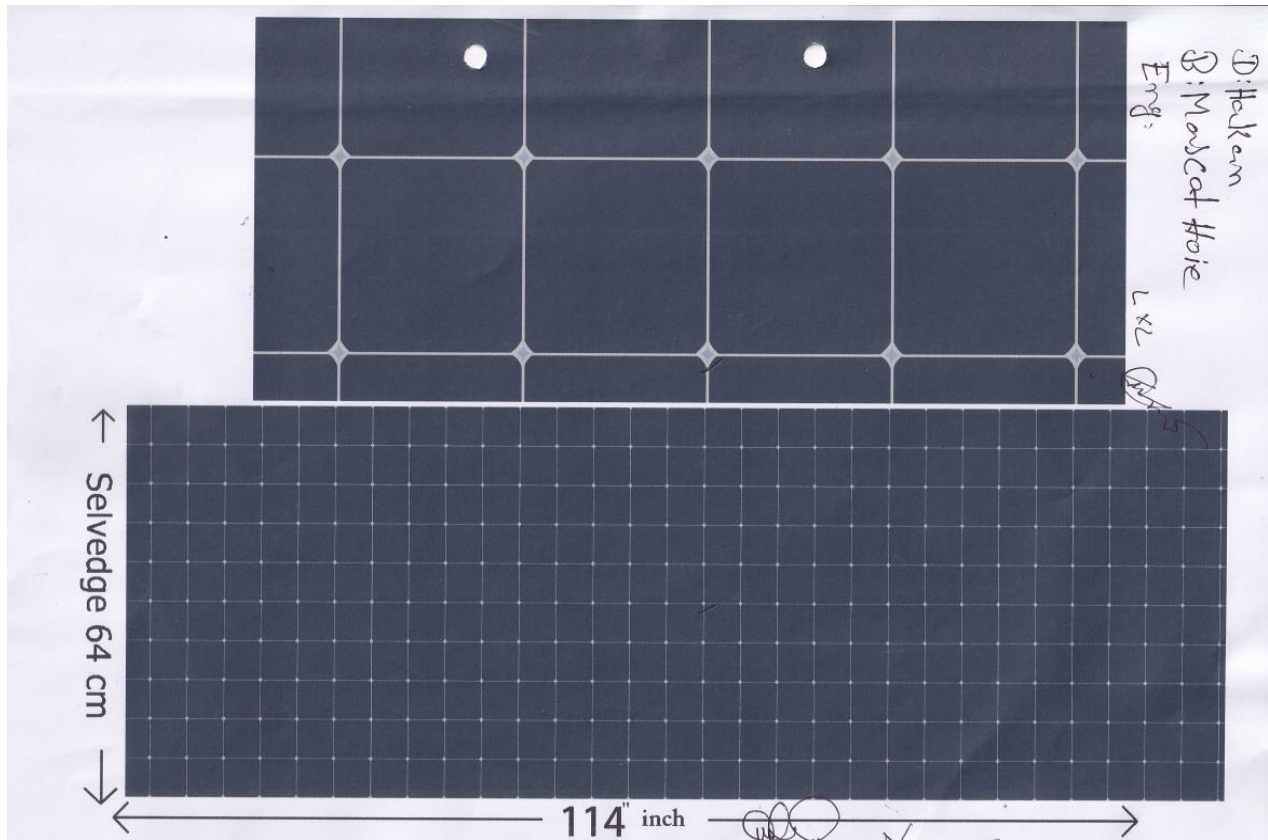


Fig 3.2.2: DIRECTION SETTING

3.2.3 PRINTING PROGRAMME

After setting the direction of printing then we sent it to cad .The cad confirm it the setting is right & then they set the direction which is LxL or WxL.The design of hakan is length for length and it's a reactive print.Cad sent the all printing information to he processing section.Precessing section means pre treatment like as bleaching,scouring,signing etc,printing,finishing.The merchandiser sent a printing programme to the processing then the processing start:

Study on Development Sample of Home Textile Industry

TEXTILES (Bangladesh) LTD.
TETLAPO, RUPGANJ, NARAYANGA...

Printing Production Program

Printing Prog ID : PPP/22/992
 User Given No. : 28318
 Issue Date : 31-Sep-2022
 Buyer : Mascot Hole As
 Design : Hakan

Construction : 4040(1355)
 Blend : 100% COTTON SATEEN
 Order : 19024
 Shipment Date : 05-Oct-2022

Plan Start Date :
 Plan Finish Date :
 Prepared By : 013254


Fabric Printing Quantity in Mtr:

Process	Machine	Color Way	Part	Grey Width	F. F. Width	DUVET COVER	PILLOW CASE	Total
Reactive Print	Printing Rotary	Creme	All	61	57	4 640.33	0.00	4,640.33
				65	61	357.08	0.00	357.08
				88	81	430.92	158.73	589.65
				95	90	95.76	463.29	559.05
		Navy	All	61	57	5,485.20	3.00	5,488.20
				65	61	357.08	0.00	357.08
				88	81	526.68	164.98	691.66
				95	90	95.76	576.45	672.21
Printing Rotary Total						11,918.81	1,373.45	13,292.26
Reactive Print: Total						11,918.81	1,373.45	13,292.26
Grand Total						11,918.81	1,373.45	13,292.26

Grey Width Wise Summary:

Grey Width	Mtr
61	10,126.53
65	714.16
88	1,291.31
95	1,261.26
Total	13,393.26

Remarks :
 Prepare By : C13254



3.2.4 STITCHING PROGRAMME

When the fabric printing, finishing completed then the processing section sent it into the folding section.

The folding section check the fabric quality if the fabric have holes or defect then the fabric is rejected and all good fabric sent to the stitching unit.

Study on Development Sample of Home Textile Industry

Stitching Programme

Date: 9/5/2022
 Customer: Mascot hole
 Design: Hakan
 Color: Cream, Navy
 Quality: 43,40/135.80
 process : 100% COTTON SATIN
 Shipment date: 5-Oct

GP NO: 28318

Please make all article 2 cm over size than actual size

Single face design

Design	Colour	Order no	Article no	EAN No	Description	Sets	Retail	FW	Delivery			
Hakan	Crème	19024	70006731	7034187067313	140x200/60x63 cm	102	6	57"/81"	10/5/2022			
			70006732	7034187067320	140x220/60x63 cm	50	4	57"/81"				
			70006733	7034187067337	150x210/50x60 cm	78	6	61"/81"				
			70006734	7034187067344	220x220/2x50x60 cm	20	2	90"/81"				
			70006728	7034187067283	140x200/50x70 cm	432	4	57"/90"				
			70006729	7034187067290	140x220/50x70 cm	432	4	57"/90"				
	70006730		7034187067306	200x220/2x50x70 cm	90	2	81"/90"					
	70006724		7034187067245	140x200/60x63 cm	120	6	57"/81"					
	70006725		7034187067252	140x220/60x63 cm	80	4	57"/81"					
	70006726		7034187067269	150x210/50x60 cm	78	6	61"/81"					
	70006727		7034187067276	220x220/2x50x60 cm	20	2	90"/81"					
	70006721		7034187067214	140x200/50x70 cm	500	4	57"/90"					
	70006723		7034187067238	200x220/2x50x70 cm	110	2	81"/90"					
	70006722		7034187067221	140x220/50x70 cm	500	4	57"/90"					
	Total						2612					

Handwritten signature

Handwritten signature

Design No: 2793 Hakan

PC Model no 04
 Pillowcase with folded envelope-opening in bottom long side.
 25cm flap inside.

Logo placement: Version no 12.

Duved cover: Model No: 01
 With full opening in bottom shortside with zipper.

IN B. Follow approved samples from Mr. Mustafa J

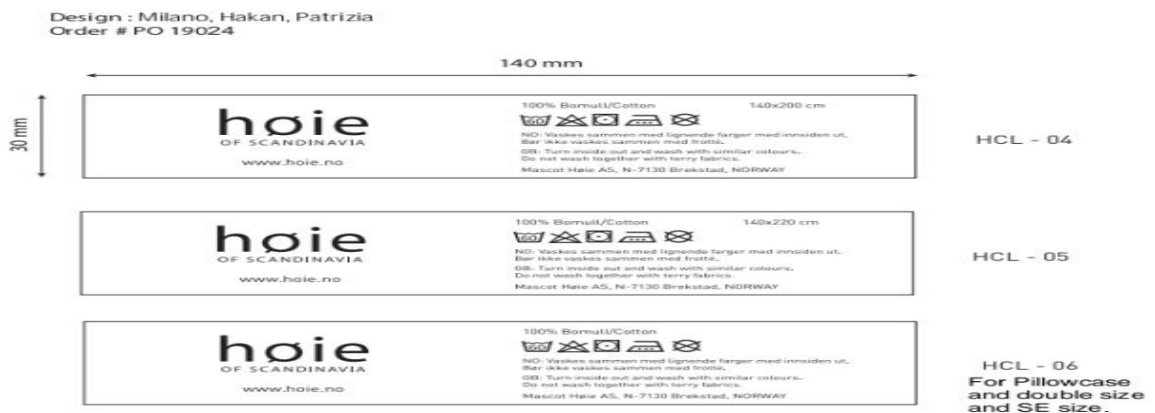
3.2.5 TRIMMINGS & ACCESSORIES

In home textile item duvet cover, flat sheet & pillowcase have simple trim and accessories needed.

The design of hakan we use some accessories:

- ✓ Care label
- ✓ Wash care label
- ✓ Inlay card(Back part+Front part)
- ✓ Back sticker
- ✓ Oeko-tex label

Care label & Wash care label:



Inlay Card:



Oeko tex label:



Sticker:



Size Label:

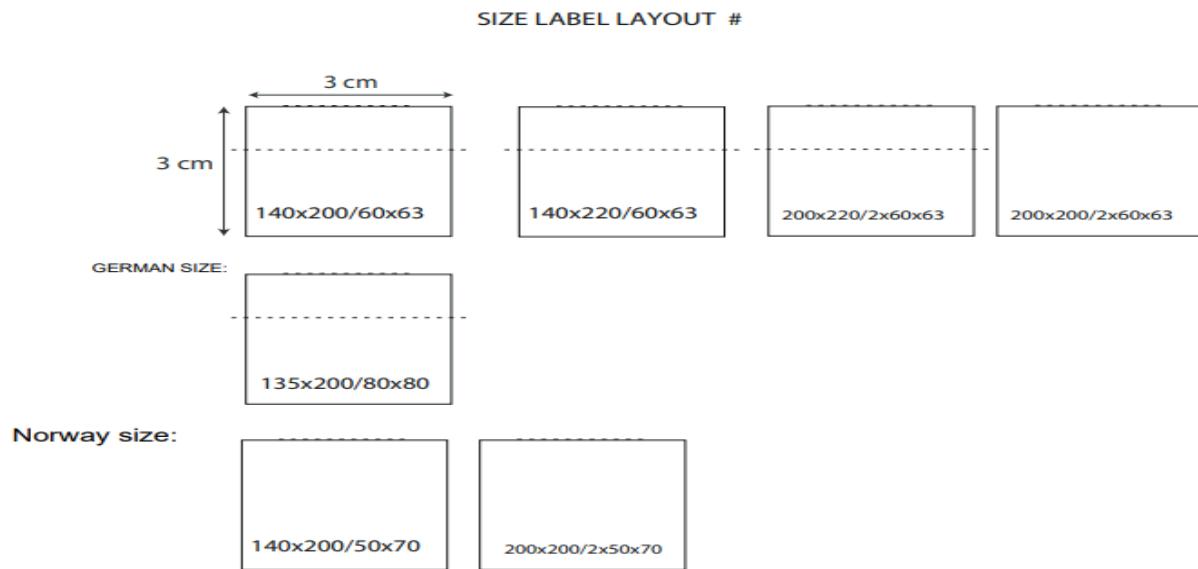


Fig 3.2.5: TRIMMINGS & ACCESSORIES

3.3 Measurement Chart

Measurement Chart:

US Size Chart (inch)					
Bed size	Flat sheet	Fitted sheet	Dovet/Quilt cover	Pillow	Pillow case
Twin 39" x 76"	66" x 115"	39" x 76" x 12"	68" x 86"	18" x 29"	21" x 32"
Full 54" x 76"	81" x 115"	54" x 76" x 12"	83" x 86"	18" x 29"	21" x 32"
Queen 60" x 80"	90" x 115"	60" x 80" x 12"	90 x 92"	18" x 29"	21" x 32"
King 76" x 80"	108" x 115"	76" x 80" x 12"	106" x 92"	18" x 39"	21" x 42"
UK/AU Size Chart (cm)					
Bed size	Flat sheet	Fitted sheet	Dovet/Quilt cover	Pillow	Pillow case
Single 90 x 190	180 x 280	90 x 190 x 35	140 x 210	45 x 70	52 x 76
Double 137 x 190	225 x 280	137 x 190 x 35	180 x 210	45 x 70	52 x 76
Queen 152 x 203	250 x 280	152 x 203 x 35	210 x 210	45 x 70	52 x 76
King 183 x 203	285 x 280	183 x 203 x 35	240 x 210	50 x 90	60 x 100
Dubai Size Chart (cm)					
Bed size	Flat sheet	Fitted sheet	Dovet/Quilt cover	Pillow	Pillow case
Single 100 x 200	180 x 280	100 x 200 x 35	160 x 235	45 x 75	50 x 80
Double 120x 200	200 x 280	120x 200 x 35	180 x 235	45 x 75	50 x 80
Queen 160 x 200	240 x 280	160 x 200 x 35	220 x 235	45 x 75	50 x 80
King 180 x 200	260 x 280	180 x 200 x 35	240 x 235	55 x 85	60 x 90

Study on Development Sample of Home Textile Industry

3.4 Lot or Packing list

Lot or Packing list:

Lot number & Packing list:																	
SHIPPER:																	
ACS TEXTILES (BANGLADESH) LTD. TETLABO, RUPGANJ NARAYANGONJ, BANGLADESH.																	
Invoice no: ACS/EXP/22/0201				DATE: 06.02.2022				2111 cartons containing: 57380.00 PCS 100% COTTON									
Order No: Vendor Number 1068497 HOME TEXTILE AND BEDLINEN FLAT SHEET,PILLOWCASE AS PER ORDER NO. 19024 100% BCI COTTON HS CODE: 630231																	
Consignee: KESKO CORPORATION K-CITYMARKET PL 1 FI-00016 KESKO FINLAND				DELIVERY ADDRESS / V907 : KV1 HAKKILA CM TIKKURILANTIE 3 FI-01380 VANTAA FINLAND				UP NO.049/2022 GP NO.27102,27101				DATE OF SHIPPING :					
Marks and																	
Carton No.	Product GTIN No.	Outer carton GTIN no.	ORDER NO.	DESIGN NAME.	Color No.	Total CTNS	Pcs per CTN	TOTAL SETS/PCS	GR WT KGS per CTN	TOTAL GR. WT IN KGS	NT WT KGS per CTN	TOTAL NET. WT IN KGS	MEAS.	TOTAL CBM			
1	200	6438544770549	6438544770532	19024	HAKAN	DARK BLUE	200	10 PCS 2 PACK	4000	12.10	2420.00	11.70	2340.00	45	24	2	7.31
201	401	6438544770563	6438544770556	19024	HAKAN	BERRY	201	10 PCS 2 PACK	4020	12.10	2432.10	11.70	2351.70	45	24	2	7.34
402	552	6438544770587	6438544770570	19024	HAKAN	SIENNA	151	10 PCS 2 PACK	3020	12.10	1827.10	11.70	1766.70	45	24	2	5.52
553	612	6438544770600	6438544770594	19024	HAKAN	DARK BLUE	60	10 PCS 2 PACK	1200	14.10	846.00	13.70	822.00	45	24	3	2.51
613	672	6438544770624	6438544770617	19024	HAKAN	BERRY	60	10 PCS 2 PACK	1200	14.10	846.00	13.70	822.00	45	24	3	2.51
673	717	6438544770648	6438544770631	19024	HAKAN	SIENNA	45	10 PCS 2 PACK	900	14.10	634.50	13.70	616.50	45	24	3	1.88
718	1093	6438544770662	6438544770655	19024	HAKAN	DARK BLUE	376	4 PCS 4 PACK	6016	14.80	5564.80	14.40	5414.40	45	24	3	18.16
1094	1470	6438544770686	6438544770679	19024	HAKAN	BERRY	377	4 PCS 4 PACK	6032	14.80	5579.60	14.40	5428.80	45	24	3	18.20
1471	1787	6438544770709	6438544770693	19024	HAKAN	SIENNA	317	4 PCS 4 PACK	5072	14.80	4691.60	14.40	4564.80	45	24	3	15.31
1788	1888	6438544770907	6438544770891	19024	HAKAN	DARK BLUE	101	20 PCS 4 PACK	8080	11.80	1191.80	11.40	1151.40	45	24	2	3.56
1889	1989	6438544770921	6438544770914	19024	HAKAN	BERRY	101	20 PCS 4 PACK	8080	11.80	1191.80	11.40	1151.40	45	24	2	3.56
1990	2065	6438544770945	6438544770938	19024	HAKAN	SIENNA	76	20 PCS 4 PACK	6080	11.80	896.80	11.40	866.40	45	24	2	2.68
2066	2081	6438544770969	6438544770952	19024	HAKAN	DARK BLUE	16	10 PCS 8 PACK	1280	13.90	222.40	13.50	216.00	45	24	3	0.79
2082	2096	6438544770983	6438544770976	19024	HAKAN	BERRY	15	10 PCS 8 PACK	1200	13.90	208.50	13.50	202.50	45	24	3	0.74
2097	2111	6438544771003	6438544770990	19024	HAKAN	SIENNA	15	10 PCS 8 PACK	1200	13.90	208.50	13.50	202.50	45	24	3	0.74
TOTAL:						2111	SET/PCS	57380		28761.50		27917.10					90.794
							TOTAL PCS	57,380									

TOTAL GROSS WEIGHT: 28761.50 KGS
 TOTAL NET WEIGHT: 27917.10 KGS
 TOTAL MEAS: 90.794 CBM
 TOTAL CARTON: 2111 CTN
 TOTAL QUANTITY: 57380.00 PCS

STATEMENT OF ORIGIN
 The Exporter ACS Textiles (Bangladesh) Ltd. **REX NO. BDREX00056** Date of Registration **05.08.2019** of the products covered by this document declares that, except where otherwise clearly indicated, these products are of Bangladesh preferential origin according to rules of origin of the Generalized System of Preferences of the European Union and that the origin criterion met is W 63.02



CHAPTER- 4
RESULT AND DISCUSSION

4.1 Analysis of Development Sample for Duvet Set (Hakan)

Received an order of buyer Mascot Hoie for the style: 829 At first here the strike off sample had developed.

Strike off sample sent to the buyer for color matching then the color is ok but buyer given a comment for quality this quality didn't matching with previous production shipped, they give a mail and we confirm that we will remake the new sample and sent it asap. After a week we sent the sample.

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

4.1.1 Analyzing various Characteristics of Duvet set & Pillowcase

Types	Description	Style number
Fabrication	Generally Fabric used 100% cotton sateen fabric, GSM 220 Rotary Reactive Print Used. Construction:40.40/120.80	829 Design: Hakan
Comment	Mainly buyer do comments on measurement, shade matching issues.	
Sample Stage	1. Lab dip 2. Fabric swatch for quality. 3. Size set sample 4. Final random inspection 5. Production sample	

Study on Development Sample of Home Textile Industry

Trims & Accessories	All types of trim and accessories are used in home textile product like as logo label Hang tag, inlay card, care label, size-label, hidden zipper, glass button, fabric button etc.	
--------------------------------	---	--

4.1.2 Challenges for Duvet set & Pillowcase: Hakan

- Buyers reject that product for 2 times as the color didn't match as desire.
- The accessories whose are used in the product wasn't appropriate as buyers demand.
- To obtain the buyer quality and GSM.
- To maintain the luster with matte color was also a challenge.
- The zipper dyeing is very difficult cause its match with the ground color of the product.
- Side seam, style line maintenance.

4.1.3 Overall View for the development sample of Duvet set & Pillowcase

Products	Sample given	Fault %	Approval time	Matching with Buyer requirements
Duvet set & Pillowcase	15	20%	3rd	96%

4.1.4 Rejection and Comments for Duvet set & Pillowcase

Time	Approval	Comments
1st	Reject	Colors aren't match. Match with pantone book
2nd	Reject	Size are not ok for shrinkage of Fabric, about 6 cm short, but Buyer allow +-5.
3rd	Approved	The sample fulfill the buyer Requirements, sample approved.

4.2 Analysis of Development Sample for Flat sheet (Fina)

Received an order of buyer Mascot Hoie for the style: 809.

At first here develop the Strike off sample.

For 1st strike off sample Comments type:

Changes in measurement: Flat sheet have size 240x260 cm but its too short and there have one part folding, the pack size is big. After correction of the strike off sample we resend the new sample then the sample also rejected for bowing issues, the panel design is not correct for bowing. So next we sent the fit sample and size, color all are ok then the buyer want to pp sample. Start work for PP Sample and send to the buyer. Buyer confirmed the PP sample then start bulk production.

4.2.1 Analyzing various characteristics of Flat sheet (Fina)

Types	Description	Style number
Fabrication	Generally Fabric used 100% cotton fabric, GSM 140 Rotary Pigment Print Used. Construction:30.30\76.68	809 Design: Fina
Comment	Mainly buyer do comments on measurement, shade matching issues.	
Sample Stage	<ol style="list-style-type: none"> 1. Lab dip 2. Fabric swatch for quality. 3. Size set sample 4. Final random inspection 5. Production sample 	
Trims & Accessories	All types of trim and accessories are used in home textile product like as logo label Hang tag, inlay card, care label, size label, hidden zipper, glass button, fabric button etc.	

4.2.2 Challenges for Flat sheet (Fina)

There faced a problem in stitching at top seam.

Firstly there was 3 sides oxford or top seam in pillowcase but fabric bag has no oxford and also need two needle.

Print with thin yarn stitching was a problem.

Problem in flap with the front part.

Here the piping design maintenance.

4.2.3 Overall View for the Development Sample of Flat sheet

Products	Sample given	Fault %	Approval time	Matching with Buyer requirements
Flat sheet	10	10%	2nd	97%

4.2.4 Rejection and Comments for Flat sheet

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

4.3 Analysis of Development Sample for Fitted sheet (Helmer)

Received an order of buyer for the style:822
At first here develop the strike off sample.

2nd strike off sample Comments.

- Changes in measurement: In this sample there have standard measurement is 180x200+25 cm .
- Fit Comments: Approved. Buyer said overall fit is acceptable on stand. But improve as well the requirements.
- Workmanship: Little folded at top of the fitted sheet s/b improve, Top hem little uneven s/b improve in bulk Production.
- Constructions: Same as the Tech Pack

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

4.3.1 Analyzing various characteristics of Fitted sheet (Helmer)

Types	Description	Style number
Fabrication	Generally Fabric used 100% cotton flannel fabric, GSM 181 Rotary Pigment Print Used. Construction:20.10/52.44	822 Design: Helmer
Comment	Mainly buyer do comments on measurement, shade matching issues.	
Sample Stage	1. Lab dip 2. Fabric swatch for quality. 3. Size set sample 4. Final random inspection 5. Production sample	
Trims & Accessories	All types of trim and accessories are used in home textile product like as logo label Hang tag, inlay card, care label, size label, hidden zipper, glass button, fabric button etc.	

4.3.2 Challenges for Fitted Sheet

This product got rejection for uneven brushing.

The color of printing didn't match with the requirement

Products tends to shrink for bowing

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

Measurement issues.

4.3.3 Overall View of Development sample for Fitted sheet

Products	Sample given	Fault %	Approval time	Matching with Buyer requirements
Fitted sheet	08	15	3rd	96%

4.3.4 Rejection and Comments for Fitted sheet

Time	Approval	Comments
1st	Reject	The fitted sheet have four side Box pannel with double elastic But buyer found one Elastic.
2nd	Reject	Non ability of actual trims and fabrics.
3rd	Approved	Ok to proceed on bulk

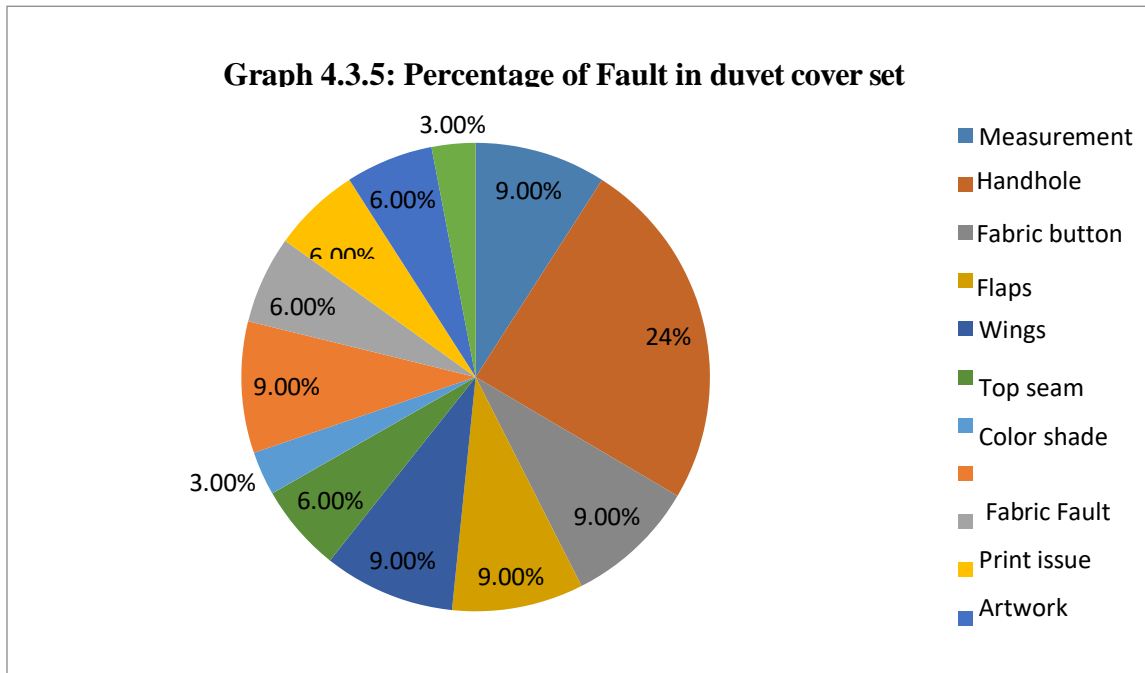
Study on Development Sample of Home Textile Industry

4.3.5 Analysis of types of comments of buyer Mascot Hoie:

Analysis of fault percentage of buyer for Duvet Cover & Pillowcases:

Fault Percentage Report on Design Hakan (Duvet cover & Pillowcase)									
Comments on	First time			Second time		Third Time			
Style	Option:1	Option:2	Option:3	Option:1	Option:2	Option:1	Option:2	Total	Percentage%
Measurement	0	1	0	1	0	0	1	3	9.0%
Hand holes	2	1	1	0	0	2	2	8	24.2%
Fabric Button	0	1	0	1	0	0	1	3	9.0%
Flap	1	0	0	0	1	1	0	3	9.0%
Wings	0	1	0	1	0	0	1	3	9.0%
Top seam	1	0	0	0	0	1	0	2	6.0%
Logo label placement	0	0	1	0	0	0	0	1	3.0%
Fabric Fault	0	1	0	1	0	0	1	3	9.0%
Printing fault	1	0	0	0	0	1	0	2	6.0%
Artwork	1	0	1	0	0	0	0	2	6.0%
Color Shade	1	0	0	0	0	1	0	2	6.0%
Ironing	0	0	1	0	0	0	0	1	3.0%
Total								33	

A graph based on the table:



Graph 4.3.5 shows the percentage of fault of sample of design hakan of Mascot Hoie. Here fault percentage as buyer comments in measurement is not much (9%). Fault percentage in hand holes (24%). Buyer comments on matching fabric button (9.0%), Fault percentage in flaps (9.0%), In wings or oxford fault percentage 9.0%, percentages of top seam is 6.0%, In logo label placement fault percentage 3.0%. And fabric fault percentage (9.0%), Fault in print (6.0%), Artwork Fault (6.0%), Color shade defects 6.0%.

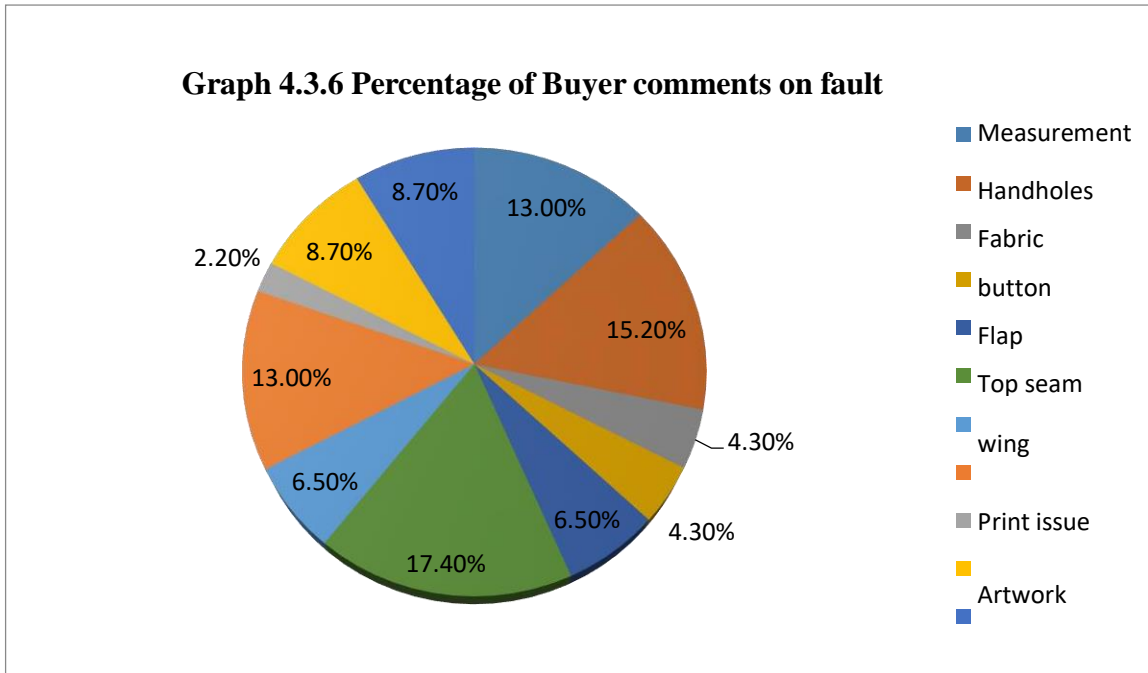
Study on Development Sample of Home Textile Industry

4.3.6 Analysis of types of comments of buyer Mascot Hoie:

Analysis of fault percentage of buyer for Flat Sheet & Fitted Sheet:

Fault Percentage Report on Design Hakan (Flat sheet and Flitted sheet)									
Comments on	First time			Second time		Third Time			
Style	Option:1	Option:2	Option:3	Option:1	Option:2	Option:1	Option:2	Total	Percentage%
Measurement	0	1	0	1	0	3	1	6	13.0%
Hand holes	1	1	1	0	0	2	2	7	15.2%
Fabric Button	0	1	0	0	0	0	1	2	4.3%
Flap	0	0	0	0	1	1	0	2	4.3%
Wings	0	1	0	1	0	0	1	3	6.5%
Top seam	1	1	2	0	2	1	1	8	17.4%
Logo label placement	1	0	1	0	1	0	0	3	6.5%
Fabric Fault	0	1	1	1	2	0	1	6	13.0%
Printing fault	1	0	0	0	0	1	0	1	2.2%
Artwork	1	0	1	0	0	2	0	4	8.7%
Color Shade	1	0	0	2	0	1	0	4	8.7%
Total								46	

A Graph based on the table:



Graph 4.3.6 shows the percentage of fault of sample of Flat sheet & fitted sheet. Here fault percentage as buyer comments in measurement is (13.0%). Fault percentage in hand holes (15.20%). Buyer comments on Fabric button (4.3%), Fault percentage in Wing (4.3%), In Flap fault percentage 6.5%, top seam fault percentages 17.40%, In button fabric fault percentage 6.5%. And fabric fault percentage (13.0%), Fault in print (2.20%), Artwork Fault (8.70%), Color shade defects 8.70%.

I observe the develop sample activity of several styles likes duvet cover, pillowcase, flat sheet, fitted sheet of buyer Mascot Hoie & I have found different types of activities of this buyers.

4.4 Differences between 3 products of this report

Fabrication	Product 1 (Duvet cover) 829	Product 2 (flat sheet) 809	Product 3 Fitted sheet) 822
	100% Cotton satin Cons:40x40/120.80	100% cotton Fabric Cons:30x30/76x68	100% cotton Flannel fab. Cons:20x10\52.44
GSM	220 GSM	140 GSM.	181 GSM
Comments	Measurements, Fitting issue	Artwork, fabrication, print, design.	Measurement issue, accessories, Fabrication, Bowing box,
Sample Stage	Five sample stage are done Lab dip Quality swatch Size set, Photo sample FRI	Lab dip Quality swatch Initial Approval sample, size, pp, photo sample FRI	Lab dip Quality swatch Size set sample FRI Photo sample
Accessories	Woven label, Care label, Size label, Hangtag, Country label all are used.	Woven label, Care label, Size label, Hangtag, Country label all are used.	Woven label, Care label, Size label, Hangtag, Country label all are used.
Approval	Product approved in 4 th observation by buyers	Product approved in 2nd observation by buyers.	Product approved in 2nd observation by buyers.

CHAPTER- 5
CONCLUSION

5.1 Conclusion

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

- In Duvet cover of design Hakan has been observe that, after 3 rejection the product got the approval from the buyer. In Flat sheet of design Fina has been found that this product got approval in 2nd time with 97% matching of buyer requirements.
- For Fitted Sheet, after 2nd observation by buyer, the sample gets approval. Match with buyers demand 96%
- The Duvet set & Pillowcase matches 96% with the buyer requirements, Flat sheet 97% and fitted sheet 96% for starting bulk production.
- Fault % of Duvet set & Pillowcase, Flat sheet & fitted sheet are 20%, 10% and 15% (Gradually).
- For getting approval, samples have been given 15, 10, 08 for Duvet set & Pillowcase, Flat sheet & fitted sheet.
- Most common reason of rejections are Measurement and stitching issue as well as print of front, alienation of color, accessories, pattern etc.
- Heavy construction, Glass or fabric button quality, Top seam and style miss were also the reason of rejection for Duvet set.
- By this report the observation found that, in every product the most common comments of buyers were about measurement issue. Until find at least 95% matching with the requirements the order got rejections. Fabrication, accessories requirements, sampling stages and comments variations all are different for 3 products Duvet set & Pillowcase, Flat sheet & fitted sheet.

References:

- <https://www.google.com/url?q=https://textilelearner.net/home-textile-types-classification/&sa=U&ved=2ahUKEwiO6tbr3Ln8AhWiUGwGHeWPCnEQFnoECAkQAg&usg=AOvVaw0VVbfxcNRsZDRnAiWeJeeg>
- <https://www.textileebook.com/2021/01/apparel-merchandising-by-r-rathinamoorthy-and-r-surjit.html>
- <https://www.hometextilestoday.com/>
- <https://www.goldnfiber.com/2019/01/textile-engineering-garments-merchandising-fashion-designing-designing-ebooks-free-download.html>
- https://www.google.com/url?q=https://www.mordorintelligence.com/industry-reports/bangladesh-home-textile-market&sa=U&ved=2ahUKEwjW-Kyd3bn8AhVoR2wGHaBXAWgQFnoECAkQAg&usg=AOvVaw0jmfM8NZxr-XV97f4va_Pi
- https://www.researchgate.net/publication/326508042_Home_Textiles-A_Review_Home_Textiles-A_Review
- <https://www.goodreads.com/en/book/show/13723850-textiles>
- <https://www.bloomsbury.com/us/textile-technology-and-design-9781472523754/>
- https://books.google.com.bd/books/about/Textiles.html?id=Ong5jwEACAAJ&redir_esc=y

Study on Development Sample of Home Textile Industry

Document Viewer

Turnitin Originality Report

Processed on: 10-Jan-2023 14:47 +06

ID: 1990647893

Word Count: 8254

Submitted: 1

5368 By Habibur Rahman

Similarity by Source	
Similarity Index	
30%	
Internet Sources:	29%
Publications:	0%
Student Papers:	15%

exclude quoted	include bibliography	exclude small matches	mode: quickview (classic) report	print	refresh	download
12% match (Internet from 15-Mar-2022) http://dspace.daffodilvarsity.edu.bd:8080 ✕						
3% match (student papers from 17-Apr-2018) Submitted to Daffodil International University on 2018-04-17 ✕						
2% match (Internet from 22-Aug-2021) https://textilelearner.net/merchandising-department-in-garment-industry/ ✕						
2% match (Internet from 04-Dec-2022) https://textilefocus.com/bangladeshs-home-textile-export-status-global-market-share/ ✕						
1% match (Internet from 21-Nov-2022) http://dspace.daffodilvarsity.edu.bd:8080 ✕						
1% match (Internet from 26-Oct-2022) http://dspace.daffodilvarsity.edu.bd:8080 ✕						
1% match (student papers from 10-Apr-2018) Submitted to Daffodil International University on 2018-04-10 ✕						