



Faculty of Engineering

Department of Textile Engineering

Project (Thesis) on

Study on Different Types of Sewing Defects on Knit Garments

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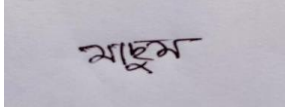
**This Report Presented in Partial Fulfillment of the Requirements for the
Degree of Bachelor of Science in Textile Engineering.**

Advance in Apparel Manufacturing Technology

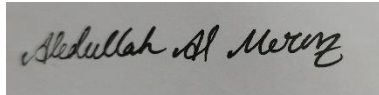
Fall-2022

DECLARATION

This project was carried out by us, we hereby declare, under the guidance of **Mr. Abdullah Al Mamun, Associate Professor**, Department of Textile Engineering, Faculty of Engineering, and Daffodil International University. Additionally, we hereby swear that neither this project nor any of its components have ever been submitted elsewhere for the purpose of receiving a degree.



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LETTER OF APPROVAL

January 5, 2023

To

The Head

Department of Textile Engineering

Daffodil Smart City (DSC)

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 Study on **Different Types of Sewing Defects on Knit Garments in Apparel** has been prepared by the students **Md. Masum (ID:191-23-5521)**, **Abdullah Al Meraz (ID: 191-23-5544)** and **Md. Sherajul Islam Shovon (ID: 172-23-5022)** are completed for final evaluation. The whole report is prepared based on the proper investigation and information in Knit Concern Group and JM Fabrics. The students were directly involved in their project report activities.

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

Yours Sincerely



Mr. Abdullah Al Mamun

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ACKNOWLEDGEMENT

First of all, we would want to thank the Almighty for giving me the opportunity to complete this project with his heavenly grace.

we appreciate the guidance we received from **Mr. Abdullah Al Mamun, Associate Professor** the Department of Textile Engineering, Faculty of Engineering at the Daffodil International University faculty of engineering. Our supervisor's extensive experience and deep interest in the subject of textile and Garments motivated me to complete the job. This endeavor was made possible by his never-ending patience, academic leadership, constant encouragement, active supervision, constructive criticism, insightful counsel, reading numerous subpar drafts and rectifying these at all levels.

We would like to express our thanks to **Mr. Md. Mominur Rahman, Assistant Professor & Head (In- Charge)**, Department of Textile Engineering, Faculty of Engineering, Daffodil international University for his kind help to finish our project report.

Finally, we want to thank our cherished parents and friends for their encouragement, perseverance, and help with the project report.

ABSTRACT

Bangladesh, a highlighted name in Ready Made Garments sector. Behind of this, there are so many reasons such as huge number of manpower, cheap labor, skilled workers etc. Though we cannot produce much value-added products but we are showing our expertise in conventional garments making. Sewing is undoubtedly major part of garments making. When we are providing garments to our buyers, we must maintain some qualities or standards. Sewing quality is a mentionable among these. This quality is hampered by sewing defects. We do sewing with machine operated by human, it's not hundred percent defect less. So, it's a common affair about defects. That's why we look for solution. First of all, find out and named the defects then cause of defects and remedies of these defects. This study was about find out what types of defects are so common in our apparel industry. All of these reports are collected from Knit Concern Group and JM Fabrics Ltd. At Knit concern Group we have found Uncut Thread as most occurred defects about 27.75%, followed by Broken Stitch 10.45% Joint Stitch 8.22%, Raw Edge 7.85%, Skip Stitch 7.59% ,Dirty Spot 6.95%, Others 5.84% ,Pleat 5.57% , Open Seam5.41%, Reject4.83%, Uneven Stitch3.93%,Oil Mark 3.61%, Point Up down 0.955%, Puckering0.74% and Needle Hole 0.32%

This scenery is little bit different in JM fabrics Ltd. There we have found Skip Stitch 19.76% Broken Stitch 19.45%, Oil Mark 13.37%, Uncut Thread 11.85%, Pleat 7.90% , Open Seam 7.29%, Reject 6.08%, Dirty Spot 4.86%, Poor Joining 4.56% and Uneven Stitch 1.22%.

We tried to highlight some observed defects. This will let us be careful on production and make us conscious about defects those are going to be happened.

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CHAPTER 01

INTRODUCTION

1.1 Background of the Study

Without the sewing procedure, the ready-made item of clothing is completely disassembled. Even without Sewing section buyer do not place order in factory. Sewing section is mother of a factory. A factory gets how much profit that's depending capacity of sewing section. In any case, sometimes there are a variety of issues, and the ultimate result is sewing concessions. It is caused by the lack of adequate competence, the unsettling effects of the machine, and incorrect machine modification. These obscurities led to shortcomings, which have an effect on proficiency, profitability, and quality. Therefore, item improvement, assembly planning, and quality guidelines are all parts of an organization's normal operating technique. The organization's standards reflect the standard level of naturally brilliant performance. Providing consistency across products and product lines is the crucial justification for using quality standards. By maintaining the standard or character of the item, it is necessary to recognize the flaw and find a pleasant solution to decrease the error. Item control outline has been used in the inspection among the system control list.

The advancement of the relationship between excellent quality and efficiency depends greatly on the quick detection of a sewing defect. Imperfections discovered after sewing have a negative effect on the item's cost. There is more than just spotting a defect before moving on to other procedures that avoid resewing and removing creases. The administrator serves as the primary line of execution for value control in the modern framework, which serves as the fundamental foundation for this discourse. Additionally, there is no administrator working in the principal line quality control job at the unique sewing stations. At that point, the final deformity evaluation procedures were completed, and a favorable suggestion was found.

The association between productivity and quality in the sewing area is very strong. If further flaws are discovered after the product is sewn, the expenses will increase. There are various benefits of spotting a flaw before additional procedures obstruct seam removal and resewing. The operator serves as the first line of implementation for quality control in the existing system, which forms the basis for this observation. Additionally, the first line quality control post at other sewing stations is vacant. Finally, a defect assessment process was carried out to determine the optimum solution.

1.2 Objective of the study

General Objectives

- To know the different types of sewing defect of knit garments in Apparel.

Specific Objectives

- To learn about sewing process in knit composite factory.
- To learn the line layout of sewing section.
- To learn different types of sewing faults.
- To learn cause and remedies of sewing faults.
- To way to reduce fabric faults.
- To learn how many times required to alter these faults.

1.3 Importance of the Study

We can save our seashore in this unit. This article explains the causes of stitching errors in fast-fashion garments. Clothing manufacturers frequently consider sewing flaws as a problem. Despite the fact that it is a very simple problem, it is really difficult to solve completely. This article discusses a few components of the sewing fault arrangement, its causes, assurance, and treatments. The author realized that eliminating errors completely is really difficult. The type of clothes, location of the crease, and appearance all play a significant role in the questions of whether the level of blame is appropriate or not. Quality issues that arise throughout this process have a negative impact on the item's quality and effectiveness and also increase the cost of production. The goal of the investigation is to learn how to improve quality control when producing apparel and to offer suggestions for doing so. By looking at each quality control step in detail, we were able to demonstrate how important it is to produce high-quality apparel and prepare for more appealing change designs.

1.4 Limitations

We encountered various issues while working on our thesis. Here are several examples:

- Due to several limitations, we can't collect all the data.
- We are not permitted to present certain required paperwork without the consent of a higher authority.
- There was also the issue of time.
- There is no special training department for study.
- The task of gathering information while working was challenging.

CHAPTER 2
LITERATURE REVIEW

2.1 Sewing process

The art of sewing involves creating stitches using a needle and thread to fasten or attach items. One of the earliest textile arts is sewing, which dates back to the Paleolithic. Archaeologists believe that Stone Age humans in Europe and Asia sewed fur and skin clothes using bone, antler, or ivory needles and "thread" formed of various animal body parts like sinew, catgut, and veins before the creation of spinning yarn or weaving fabric. With the aid of a needle and strings, textures, calfskin, skins, or other distinctively adaptable materials are attached using the simple sewing technique. Clothing and home décor are frequently made with sewing. Sewing is undoubtedly one of the most important dressmaking techniques. Modern sewing machines perform a substantial percentage of such mechanical sewing. At the very beginning, the chopped pieces of an article of clothing are typically attached or accidentally sewn. At that time, the machine's disorganized parts pierce the fabric layers with string and then coil it around themselves.

2.2 Sewing Machine

A sewing machine is a mechanical or electromechanical device that has one or more needles that are threaded at the point end and periodically puncture the fabric as it passes underneath the needles. As the thread sews the fabric together, it loops around on itself to form a chain stitch or locks around a second strand of thread to form a lock stitch. Although they are used in both the home and the workplace, sewing machines are designed differently for each environment. Those for the home will typically be more adaptable in terms of the quantity and types of fasteners they can handle, but they operate more slowly than modern machines and have a shorter lifespan. Modern machinery can be designed for specialized tasks and is often heavier, has a longer lifespan, and can accommodate several fasteners per inch.

2.3 History of Sewing Machine

Sewing has been regarded as an art form for almost 20.000 years. The first needles were created in the XIV century, and sewing by hand was abandoned in favor of sewing machines in 1790. The sewing machine is a sophisticated tool that joins two or more pieces of fabric together by sewing them together. It is typically employed in the production of clothes.

Although Thomas Saint, a British inventor, is credited with creating the idea for the sewing machine, it is unclear whether he was also responsible for creating the machine's initial prototype. His work appeared to be nothing more than an unsuccessful attempt to create it.

The French tailor Barthelemy Thionine invented the first sewing machine, but the achievement didn't make him famous since a group of other tailors set fire to the factory. They believed that the sewing machine would render them unemployed and stop customers from visiting their tailor shops.

Because of the established notion that machines lead to unemployment in the wholesale garment industry, Walter Hunt, who invented the first sewing machine in the United States in 1834, likewise had no success.

When Isaac Singer unearthed an old sewing machine and restored it in just 11 days, the first sewing machine that was acknowledged commercially was created, bringing forth the first sewing machine that was actually successful. Singer substituted a pedal for the wheel and pedestal in his machine, setting it apart from the others. The Singer brand began selling 3.000 pieces annually in 1858, and by 1863, sales had reached over 20.000 units. The first production line in Canada was established in 1873, and sales reached 500,000 units in 1889. 23 years later, in 1903, they were reporting sales of 1.305.000 units annually.

2.4 Types of Sewing Machine

There are two types of sewing machines accessible in the clothing business, depending on the operating system. Here are several examples:

- Manually Sewing Machine
- Electrically Sewing Machine

The basic Sewing machine are:

1. Plain Sewing Machine
2. Flat lock Sewing Machine
3. Overlock Sewing Machine

Those machines have both manual and automatic system. But in recent time all factory wants to use automatic machine. When manual machines are use than helper need more. That's why all factory want to reduce cost and use automatic machine.

Plain Machine are Two types:

1. Single Needle Plain Machine
2. Double Needle Plain Machine



Fig: Single Needle Plain Machine



Fig: Single Needle Plain Machine

Flat Lock Machine are three types:

1. Cylinder bed lock machine
2. Flat Bed lock machine
3. Compressor lock machine



Fig: Cylinder Bed Lock Machine



Fig: Compressor Lock Machine

Overlock Machine are two types:

1. 4 threads overlock machine (for knit garments)
2. 5 threads overlock machine (for Woven garments)



Fig: 4 threads overlock Machine

Some special machine also uses in factory. They are:

- Feed of the arm (double chain stitch m/c, 3-needle)
- Picot sewing machine
- Cocot sewing machine

- Zig-zag machine
- Multi needle machine
- Smoke machine
- Button attaching machine
- Button hole m/c (for woven fabric)
- Button hole sewing m/c (for knit fabric)
- Collar and cuff turning and blocking machine
- Label/elastic inserting machine
- Interlock m/c
- Lap seaming m/c
- Bar tack sewing m/c
- Pin tucking machine
- Shoulder pad-attaching machine
- Automatic multi-needle shirring machine
- Top & bottom cover stitch flat lock machine
- QQ loop making m/c
- Bias tape cutting m/c
- Blind stitch sewing machine
- Button covering stitch belt loop making m/c
- Double chain stitch m/c
- Double chain stitch sewing m/c
- Double chain stitch sewing machine
- Hemstitch machine for pant
- Linking machine



Fig: Picot Machine



Fig: Snap button attaching



Fig: Button Attaching Machine



Fig: Button Hole Machine



Fig: Rib Cutter Machine



Fig: Multi needle Machine (3 needle)

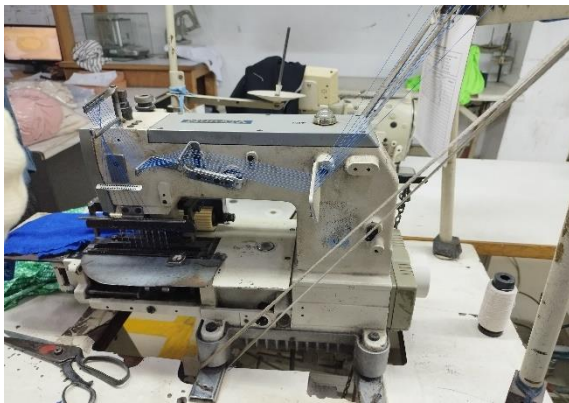


Fig: Multi Needle Machine (8 needle)



Fig: Flat Bed Machine



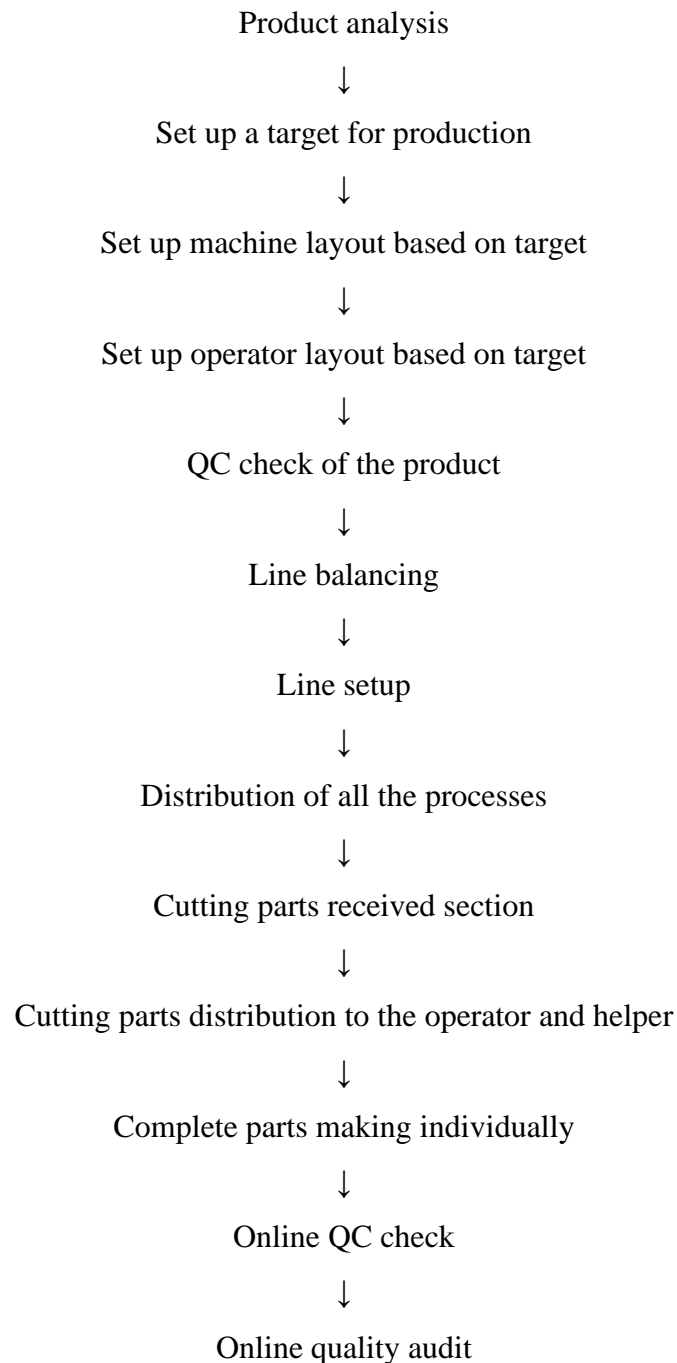
Fig: Draw sting Hole Machine

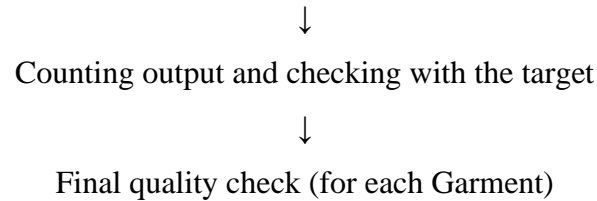
2.6 Machine Layout Plan

Production in the apparel sector refers to the chain-based procedure used to create a ready-made garment. The number of sewing machines varies depending on how many steps go into making a garment. Planned machine arrangement is the first priority for increasing output. In the clothing sector, the production manager will always build up a machine layout plan for a particular garment item. The machine layout plan varies depending on the type of garment being produced. It primarily consists of a sewing machine layout that can produce the most number of clothes in the quickest amount of time with the fewest errors.

2.7 Process Flow Chart of Garments Sewing

Sewing is an important department in the garments manufacturing industry. All the parts of a garment are joined here by making stitches with the help of a needle and thread. Where the sewing process flow chart helps to make a complete garment easily. By maintaining the sewing process flow chart, an order can be completed in a timely.





2.8 Defect in Garments

The final stage of production is clothing manufacture, which comes before marketing. Consumers are more likely to accept products with fewer flaws. For this reason, the manufacturer needs to be informed of any product flaws. Throughout this entire production process, a variety of errors may arise. The absence of desired qualities or the presence of undesirable features in products is referred to as an apparel defect. Products with flaws become less valuable on the market. A product could have a variety of flaws. Reject is a word that is similar to defects. When a product loses its marketability, it is considered a reject. Rejecting clothing hurts the businesses that make it. A garment may be rejected if it has a single flaw in the most noticeable part of it.

2.9 Types of defects

According to the garments workmanship and appearance garments defects are divided in the three ways

- a. Critical defects
- b. Major defects
- c. Minor defects

Causes of defects:

There are two main causes of defects

- a. Non sewing defects
- b. Sewing defects

Here sewing is an important part of garments. So must be known about sewing defects.

2.10 Non-Sewing Defect:

Deformities may happen in Clothing industry created on mass scale.

The wellsprings of deformities are notice underneath:

- Defects causes because of cutting of textures, lining, interlining by wrong pattern.
- Defect happens due flawed crude material.
- Defects happens because of wrong stamping, incorrectly spreading of texture etc.
- Defects causes because of oil checks in garments.
- Defects happen because of wrong pressing, collapsing, pressing, bundling and so on.

2.11 Sewing Defect

By employing stitches created with a needle and thread, two fabric pieces are joined through the process of sewing. One of the fundamental steps in making clothes is sewing. Aside from that, the ready-made clothing industry's sewing segment is its most important one. For the sewing department to continue producing clothing of the acceptable caliber, a variety of faults or defects should be eliminated. This article's significance is that it displays every flaw made in the sewing section of the factory that makes clothes.

Sewing defect can be classified as three groups:

- Problem of stitch formation.
- Seam pucker.
- Fabric damage along the seam line/stitch

2.12 Problems of stitch formation:

2.12.1 Sewing Defects:

1. Skip Stitch
2. Thread Breakage
3. Joint stitch
4. Uneven stitch
5. Broken stitch
6. Open seam
7. Oil spot
8. Seam puckering
9. Joint uneven
10. Raw edge problem
11. Needle mark

2.12.2 Seaming Defects:

1. Uneven width.
2. Uneven seam line.
3. Not secured by backstitch.
4. Twisting.
5. No matching of check or stripe.
6. No matching of the seam.
7. Unexpected materials are attached to the sewing.
8. Not sewn by matching face side or back side of fabrics.
9. Use of wrong stitch type.
10. Wrong shade matching of sewing thread.

2.12.3 Assembly Defects:

1. Defected finished components by size, like imperfect size and shape of finished components.
2. Imperfect garments size.
3. Use of the wrong ticket.
4. Missing of any parts or predetermined design of garments.
5. Imperfect alignment of components, like button, hook, in the proper place.
6. Wrong placing or creasing of interlining.
7. Looseness or tightness of interlining.
8. Folding of any parts of garments that are seen to bad appearance.
9. Shade variation of garments.
10. The false direction of fabric parts in the garments.
11. Imperfect matching of trimmings in the garments.

2.12.4 Stitch Defects

There are various kinds of stitch defects like:

1. Boardy: The knitted fabric becomes boardy (a stiff or harsh hand) when the stitches have been knit very tightly.
2. Cockled or puckered: If the knitted fabric is cockled or puckered, it is due to uneven stitches or uneven yarn size.
3. Dropped Stitch: This is an un knitted stitch caused either by the yarn carrier not having been set properly or the stitch having been knitted too loosely.
4. Run or ladder: A run or ladder indicates a row of dropped stitches in the wale.
5. Hole: A large hole or a press off is the result of a broken yarn at a specific needle feed so that knitting cannot occur.
6. Tucking: This is the result of an unintentional tucking in the knitted fabric. This is also called the bird's eye defect.
7. Float: This is caused by a miss stitch which is the result of failure of one or more needles to have been raised to catch the yarn.

CHAPTER 3

METHODOLOGY


3.1 Data Collection

In this report, all data are collected from Knit Concern Group and JM Fabrics. We all of our team member collected those data. We collected DHU report of those factory. Those reports are collected from different line and different date. Mainly H&M, Pepko, Okaidi, AS Color buyer's data are collected.

3.2 Attachment of sewing report

3.2.1 Line inspection report 1:

This report is the property of KC Group (Knit Concern Group) and collected from KCL floor.

 KC PRINT LIMITED 57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH. DEFECTS PER HUNDRED UNIT (DHU) SEWING													F/Q.C./SEW/07 Revision No : 00
PROD. FLOOR: <u>K.C.P.</u>	LINE: <u>D</u>	BUYER: <u>OSADI</u>	ORDER #: <u>4/005</u>	STYLE: <u>POLO SHIRT</u>	DATE: <u>01.07.2022</u>	CHECKER: <u>FARIM/LSC</u>							
DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM		1	1			1		1					5
BROKEN STITCH	11	11	1	1			11						11
SKIP STITCH	1		1			1		1					4
UNEVEN STITCH				11	1		1	1					5
JOINT STITCH		1	1	11									4
PLEET		1				1							2
MEASUR. DAVIATION													
NEEDLE HOLE							1						1
SIZE MISTAKE													1
DIRTY SPOT		1	1	1									3
OIL MARK		1	11		1111	1	1	111					12
UNCUT THREAD	1	11	1111	111	1111	111	11	111					28
REJECT				1	1	1		1					4
EMB./PRINT MISTAKE													1
LABEL DISPLACE			1										1
Reverse	1	1	1	1	1	11	1	1					8
TUCK			11	1		11	11	1					8
Print up-down	1	1			1								3
DOWN STITCH				1		11		1					3
PLACED POSITION				1	1								2
PUCKERING			1	1									2
TOTAL PASS/CHECK:	20/20	125/147	175/189	125/166	120/133	120/140	115/123	120/130					920/1122
TOTAL DEFECTIVE GARMENTS	5	12	14	10	13	15	8	10					87
TOTAL DEFECTS:	7	14	17	19	15	17	16	13					108
TOTAL DEFECTS %	28%	9.52%	8.99%	9.62%	11.28%	12.14%	8.15%	10%					9.26%
LQC SIGNATURE													

DHU FORMULA: Total defects found x 100 ÷ Total garments inspected

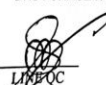


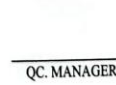

 LQC
 SNR. QC
 SEWING IN-CHARGE
 QC. MANAGER
 PROD. MANAGER

Fig: Line Inspection Report 1

Sewing inspection report of 01-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.2.2 Data Table 1

Knit Concern Group

Hourly DHU REPORT

Date: 01-01-2023

Order: 4/00P

Style: 214486

Buyer: Okaidi

Sewing Line: D

Floor: KCP

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam		2	1			1		1			5
Broken Stitch	3	4	1	1			2				11
Skip Stitch	1		1			1		1			4
Uneven Stitch				2	1		1	1			5
Joint Stitch		1	1	2							4
Pleet		1				1					2
Measure Deviation											
Needle Hole											
Size Mistake							1				1
Dirty Spot		1	1	1							3
Oil Mark		1	2		4	1	1	3			12
Uncut Thread	1	2	6	3	6	5	2	3			28
Reject				1	1	1		1			4

Emb/Print Mistake											
Label Displace			1								1
Rawedge	1	1		1	1	2	1	1			8
Tuck			2	1		2	2	1			8
Point up down	1	1			1						3
Down Stitch				1		3		1			5
Puckering			1	1							2
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total pass/ Check	20/25	135/147	175/189	125/125	120/133	125/140	115/123	120/130			935/1122
Total Defective Garments	5	12	14	10	13	15	8	10			87
Total Defect	7	14	17	13	15	17	10	13			108
Total Defect %	28%	9.52%	8.99%	9.63%	11.28%	12.14%	8.13%	10%			9.62%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (108/1122) *100$$

$$=9.62\%$$

1st Highest Defects =Uncut threat 28 pcs

2nd Highest Defects = Oil Mark 12 pcs

3rd Highest Defects = Broken Stitch 11 pcs

Total Pieces checked =1122

Total Defects =108

3.3 Attachment of sewing report

3.3.1 Line inspection report 2:

This report is the property of KC Group (Knit Concern Group) and collected from KCL 2 floor.

F/QC/SW/05
 REVISION 01

KC PRINT LID.
 57/1, Water Works Road, Godnail Narayanan
Hourly DHU Report (At Sewing QC Table)

DHU % = Till defects qty x 100
 Till check qty
 Date: 01-01-23
 DHU AVG %

Order No.: MF2138MFL	Style Name: 5004	Color: NATURAL
Floor No.: K.C.P-2	Line No.: 11	Table Quality Name: MASUMI ANAND

Defects Name	Hour										Total
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	
Broken stitch											1
Button											
Button Hole											
Fabric fault											
Drop stitch											
Needle hole											
Improper shape											
Joint stitch	1		11	11	11	1	11	11	11		12
Label fault			111	11	1	1	11	1	1		11
Measurement											
Needle mark											
Open seam		1		1						11	1
Print fault											
Embroidery											
Puckering					1	11	1	11	11	11	12
Pleat	11	11		111	1	1	111	1	1		12
Rawedge	11	11		111	1	1	111	1	1		12
Slanted											
Skip stitch	1		1	11	1	11	11	11	11	1	15
Shading											
Thread Mistake											
Twisting											
Thread tension											
Up-down	1	1	11		11	11	111	1	11		14
Up-even											
Uncut thread	111	1111	1111	1111	1111	1111	11	1111	111	111	157
Wavyness											
Wrong SPI											
Size Mistake											
Oil spot											
Dirty spot	11	111	1111	111	1111	1111	1111	1	111	11111	154
Rejects											
Others	11	11	111	111	111	111	1111	111	111	1111	121
Total check gmts	110	133	190	190	200	200	220	220	152	188	186
Total Pass gmts	100	120	170	174	180	182	200	200	210	170	186
Total defective gmts	10	13	20	16	20	18	22	20	22	18	18
Total defect qty	12	13	22	18	22	30	22	22	25	20	187
DHU %	10.90%	12.77%	11.57%	9.47%	11%						9.89%
Defect rectified Qty	0	10	13	20	16	20	18	22	20	22	187
Defect Balance qty	10	13	20	16	20	18	22	20	22	18	18
Rectify Defects check & pass	0	10	13	20	16	20	18	22	20	22	187
Rejects qty											
LQC / Super. Signature	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
UNCUT THREAD	OP. NEGLIGENCE	SHOW THE OP. - SINE		01/01/23
LABEL FAULT	OP. CARELESSNESS	SHOW THE OP. - SINE		0

Quality Supervisor
QC.IN
Floor In. (Fin)
AQM/DQM
QM
PM

Fig: Line Inspection Report 2

Sewing inspection report of 01-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.3.2 Data Table 2

Knit Concern Group

Hourly DHU REPORT

Date: 01-01-2023
 Order: AF2138MEL
 Style: 5001
 Buyer: H&M
 Sewing Line: A
 Floor: KCL 2

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam		1		1						2	4
Broken Stitch		1			1	1	1				4
Skip Stitch	1		1	2	1	2	2	2	3	1	15
Uneven Stitch											
Joint Stitch	1		2		2	1	2	2	2		12
Pleet		1			1						2
Measure Deviation											
Needle Hole											
Size Mistake							1				1
Dirty Spot	2	3	4	3	4	4	4	1	3	8	34
Oil Mark											
Uncut Thread	3	4	5	4	5	4	2	4	3	3	37
Reject								2	2		4

Emb/Print Mistake											
Label Displace			5	2	1		1	1	1		11
Rawedge	2	2		3	1	1	3	1	1		14
Tuck			2	1		2	2	1			8
Point up down	1	1	2		2	2	3	1	2		14
Down Stitch											
Puckering					1	2	1	3	3	2	12
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others	2	2	3	3	3	3	5	3	3	4	31
Total Check	110	133	190	190	200	200	222	220	232	188	1866
Total Pass	100	120	170	174	180	182	200	200	210	170	1706
Total Defective Garments	10	13	20	16	20	18	22	20	22	18	160
Total Defect	12	15	22	18	22	20	23	21	23	20	183
Total Defect %	10.90%	12.27%	11.57%	9.47%	11%	10%	10.36%	9.55%	9.91%	10.64%	9.8%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (183/1866) *100$$

$$=9.8\%$$

1st Highest Defects =Uncut threat 37 pcs

2nd Highest Defects = Dirty Spot 34 pcs

3rd Highest Defects = Skip Stitch 15 pcs

Total Pieces checked =1866

Total Defects =183

3.4 Attachment of sewing report

3.4.1 Line inspection report 3:

This report is the property of KC Group (Knit Concern Group) and collected from KCL 2 floor.

FIGC/SW/05
REVISION 01

KC PRINT LID.
57/1, Water Works Road, Godnail Narayanan
Hourly DHU Report (At Sewing QC Table)

DHU % = $\frac{\text{Total defects qty}}{\text{Total check qty}} \times 100$
 Date: 11/11/25
 DHU AVG %: 20.10

Order No.	Floor No.	Line No.	Table Quality Name	Style Name	Color	Hour																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
						08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
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<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Defects Name</th> <th>08-09</th> <th>09-10</th> <th>10-11</th> <th>11-12</th> <th>12-01</th> <th>02-03</th> <th>03-04</th> <th>04-05</th> <th>05-06</th> <th>06-07</th> <th>Total</th> </tr> <tr> <td>Broken stitch</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Button</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Button Hole</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Fabric fault</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Drop stitch</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Needle hole</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Improper shape</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Joint stitch</td> <td>11</td> <td></td> <td>111</td> <td>11</td> <td>11</td> <td></td> <td>11</td> <td></td> <td></td> <td></td> <td>10</td> </tr> <tr> <td>Label fault</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Measurement</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Needle mark</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Open seam</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Print fault</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Embroidery</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Puckering</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Pical</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Rawedge</td> <td>1</td> <td>11</td> <td>1</td> <td>1</td> <td>11</td> <td>11</td> <td>11</td> <td>1</td> <td>11</td> <td>1</td> <td>73</td> </tr> <tr> <td>Skipped</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Skip stitch</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Shading</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Thread Mistake</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Twisting</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Thread tension</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Up-down</td> <td>1</td> <td>11</td> <td>1</td> <td>11</td> <td>1</td> <td>11</td> <td>11</td> <td>1</td> <td>11</td> <td>1</td> <td>16</td> </tr> <tr> <td>Up-even</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Uncut thread</td> <td>111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>111111</td> <td>78</td> </tr> <tr> <td>Wavyness</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Wrong SPI</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Size Mistake</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Oil spot</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Dirty spot</td> <td></td> <td>11</td> <td>11</td> <td>1</td> <td>1</td> <td>1</td> <td>1</td> <td>1</td> <td>1</td> <td>1</td> <td>9</td> </tr> <tr> <td>Rejects</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Others</td> <td>11</td> <td>11</td> <td>111</td> <td>11</td> <td>11</td> <td>111</td> <td>11</td> <td>11</td> <td>11</td> <td>11</td> <td>23</td> </tr> <tr> <td colspan="17"> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>Total check gms</td> <td>128</td> <td>158</td> <td>166</td> <td>178</td> <td>182</td> <td>165</td> <td>180</td> <td>154</td> <td>163</td> <td>175</td> <td>167</td> </tr> <tr> <td>Total Pass gms</td> <td>120</td> <td>140</td> <td>150</td> <td>160</td> <td>165</td> <td>140</td> <td>162</td> <td>150</td> <td>130</td> <td>160</td> <td>150</td> </tr> <tr> <td>Total defective gms</td> <td>8</td> <td>18</td> <td>16</td> <td>18</td> <td>17</td> <td>19</td> <td>18</td> <td>14</td> <td>13</td> <td>15</td> <td>17</td> </tr> <tr> <td>Total defect qty</td> <td>10</td> <td>20</td> <td>18</td> <td>20</td> <td>19</td> <td>21</td> <td>20</td> <td>16</td> <td>16</td> <td>17</td> <td>17</td> </tr> <tr> <td>DHU %</td> <td>7.81%</td> <td>12.65%</td> <td>10.84%</td> <td>11.23%</td> <td>10.43%</td> <td>12.42%</td> <td>11.11%</td> <td></td> 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LQC / Super. Signature	<div style="display: flex; justify-content: space-between;"> <i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> </div>																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
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Quality Supervisor QC.IN Floor In. (Fin) AQM/DQM QM PM

Fig: Line Inspection Report 3

Sewing inspection report of 01-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.4.2 Data Table 3

Knit Concern Group

Hourly DHU REPORT

Date: 01-01-2023

Order: 467301-7837

Style: CHILLY S/J 3K

Buyer: H&M

Sewing Line: G

Floor: KCL 2

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Broken Stitch		1		1	1	1		1		1	6
Button											
Button Hole											
Fabric Fault											
Drop Stitch											
Needle Hole		1	1	1	1			1		1	6
Improper Shade											
Joint Stitch	2		3	2	2		2				10
Label Fault				1	1	1					3
Measurement											
Needle Mark											
Open Seam			1	1		2		2		1	7
Print Fault											

Embroidery											
Puckering											
Pleat				1			1				2
Rawedge	1	2	1		3	1	2	1	2	1	13
Up-down	1	2	1	2	1	2	3	1	2	1	16
Up-even											
Uncut Thread	4	8	8	8	9	9	8	7	8	8	78
Wavyness											
Wrong SPI											
Size Mistake											
Oil Spot		1				1					2
Dirty Spot		2	2	1		1	1	1		1	9
Rejects		1		1	1				1		4
Others	2	2	3	2	2	2	3	2	2	3	23
Total Check	128	158	166	178	182	169	180	164	163	175	1651
Total Pass	120	140	150	160	165	150	162	150	150	160	1507
Total Defective Garments	8	18	16	18	17	19	18	14	13	15	150
Total Defect	10	20	8	20	19	21	20	16	15	17	179
Total Defect %	7.18%	12.65%	10.84%	11.23%	10.43%	12.42%	11.11%	9.75%	9.2%	9.71%	10.84%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (179/1651) *100$$

$$=10.84\%$$

1st Highest Defects =Uncut threat 78 pcs

2nd Highest Defects = Up-down 16 pcs

3rd Highest Defects = Raw edge 13 pcs

Total Pieces checked =1651

Total Defects =179

3.5 Attachment of sewing report

3.5.1 Line inspection report 4:

This report is the property of KC Group (Knit Concern Group) and collected from KCL floor.

BP

KC PRINT LIMITED
57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH.
DEFECTS PER HUNDRED UNIT (DHU) SEWING

F/Q.C/ SEW/ 07
Revision No : 00

PROD. FLOOR: K.C.P LINE: K BUYER: NDT ORDER # NDT/1014 STYLE: T-8 DATE: 01-01-2023 CHECKER: Jip. Jorah

DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM		1		1	1		1	4	1				8
BROKEN STITCH	1												2
SKIP STITCH	1	1		1	4	4	11	1	11				24
UNEVEN STITCH			11	11	4	4	11	1	11				3
JOINT STITCH	1												
PLEET													
MEASUR. DAVIATION													
NEEDLE HOLE													1
SIZE MISTAKE				1			11	4	4				10
DIRTY SPOT	11	11	11	11	11	1	11		11				50
OIL MARK													10
UNCUT THREAD		4	4	4	11	4	4	4	4				9
REJECT	1		11			1	11	11	1				
EMB./PRINT MISTAKE													
LABEL DISPLACE			11	11	11	1	11	11	11				16
RIDGE	11						11	11					2
POINT UP DOWN				1					1				2
OTHERS						11	1	11	11				7
TOTAL PASS/CHECK	25	20	20	25	20	25	20	25	20	20			883
TOTAL DEFECTIVE GARMENTS	7	10	25	25	25	20	20	18	18				138
TOTAL DEFECTS	8	22	26	27	26	22	22	22	20				150
TOTAL DEFECTS %	25%	12%	16.84%	14.17%	21.33%	15%	16.8%	19.44%	22.73%				16.98%
LOC SIGNATURE													

DHU FORMULA : Total defects found x 100 / Total garments inspected

LINE QC: _____ SNR: _____ SEWING IN-CHARGE: _____ QC. MANAGER: _____ PROD. MANAGER: _____

Fig: Line Inspection Report 4

Sewing inspection report of 01-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.5.2 Data Table 4

Knit Concern Group Hourly DHU REPORT

Date: 31-12-2022

Order: NAF/014

Style: T-8

Buyer: NAF

Sewing Line: K

Floor: KCP

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam		1		1	1	1	1	2	1		8
Broken Stitch	1										1
Skip Stitch	1	1		1	1	1	2	1			8
Uneven Stitch			3	3	5	5	3	2	3		24
Joint Stitch	1					2					3
Pleet											
Measure Deviation											
Needle Hole											
Size Mistake				1			1				1
Dirty Spot	2	3	3	3	4	2	3	5	5		30
Oil Mark											
Uncut Thread		5	5	5	3	5	6	5	5		39
Reject	1		2			1	2	2	1		9
Emb/Print Mistake											
Label Displace											

Rawedge	2		3	2	2	1	2	2	2		16
Tuck				1			1				2
Point up down						1			1		2
Down Stitch				1		3		1			5
Puckering											
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others						2	1	2	2		7
Total pass/ Check	25/32	90/100	80/95	105/120	60/75	120/140	105/125	95/108	70/88		883
Total Defective Garments	7	10	15	15	15	20	20	18	18		138
Total Defect	8	12	16	17	16	21	21	21	20		150
Total Defect %	25%	12%	16.84%	14.17%	21.33%	15%	16.8%	19.44%	22.73%		16.98%

$$\begin{aligned}
 \text{DHU\%} &= (\text{Total No of Defect/Total no of Checked Product}) * 100 \\
 &= (150/883) * 100 \\
 &= 16.98\%
 \end{aligned}$$

1st Highest Defects =Uncut threat 39 pcs

2nd Highest Defects = Dirty Spot 30 pcs

3rd Highest Defects = Uneven Stitch 24 pcs

Total Pieces checked =883


Total Defects =150

3.6 Attachment of sewing report

3.6.1 Line inspection report 5:

This report is the property of KC Group (Knit Concern Group) and collected from KCL floor.

BP



KC PRINT LIMITED
 57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH.
DEFECTS PER HUNDRED UNIT (DHU) SEWING

F/Q.C/ SEW/ 07
 Revision No : 00

PROD FLOOR: K-1A LINE: I BUYER: Depeo ORDER #: 20230316 STYLE: 7011A DATE: 01-01-23 CHECKER: Mahabub

DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM	1	1		1			1		1		1		6
BROKEN STITCH	1	1	1	1	1		1	1	1	1			10
SKIP STITCH					1		1	1		1			4
UNEVEN STITCH													
JOINT STITCH	1	1	1	1	1		1	1	1	1			10
PLEET	1		1		1		1	1	1				6
MEASUR. DEVIATION													
NEEDLE HOLE													
SIZE MISTAKE													
DIRTY SPOT													
OIL MARK													
UNCUT THREAD	1	1	1	1	1		1	1	1	1	1		10
REJECT	1	1	1		1				1	1	1		6
EMB./PRINT MISTAKE													
LABEL DISPLACE													
Rawedge	1	1	1	1			1	1		1			6
Pocket P.			1				1	1			1		4
Collar	1	1	1	1	1		1	1	1	1	1		10
Yuck P.		1	1	1				1			1		4
over stitch													
Down stitch													
Other													
TOTAL PASS/CHECK:	110/120	150/168	240/262	150/165	120/132		110/120	100/110	110/120	100/110	100/110	100/110	1097
TOTAL DEFECTIVE GARMENTS	16	18	22	15	13		18	10	17	15	14		167
TOTAL DEFECTS	16	20	24	17	15		20	20	18	17	16		185
TOTAL DEFECTS %	14.28%	11.90%	9.16%	10.30%	11.28%		18.18%	20.00%	16.36%	17.00%	16.00%		9.26%
LQC SIGNATURE													

DHFU FORMULA : Total defects found x 100 / Total garments inspected

LINE QC

SNR. QC

SEWING IN-CHARGE

QC. MANAGER

PROD. MANAGER

Fig: Line Inspection Report 5

Sewing inspection report of 01-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.6.2 Data Table 5

Knit Concern Group Hourly DHU REPORT

Date: 01-01-2023
 Order: D00880746
 Style: Tent 9P
 Buyer: Pepco
 Sewing Line: I
 Floor: KCA

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam	2	1		1		2		2		1	9
Broken Stitch	2	3	2	3	1	2	3	1	2		19
Skip Stitch					2	3	1		3	2	11
Uneven Stitch											
Joint Stitch	3	2	3	2	1	3	2	3	2		21
Pleet	2		2		2	1	1	1			9
Measure Deviation											
Needle Hole											
Size Mistake											
Dirty Spot											
Oil Mark											
Uncut Thread	3	4	5	3	4	5	4	5	3	4	41
Reject	2	1	2		2	1	2	3	2	1	13
Emb/Print Mistake											
Label Displace											
Raw edge	1	3	2	3		1	2		2	1	15

Tuck		2	2	3			2	1	1	3	14
Pocket Problem			3			1	2			1	7
Contas	3	4	3	2	3	2	3	2	2	3	27
Point up down											
Down Stitch											
Puckering											
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total pass/ Check	110/126	150/168	140/162	150/165	120/133	220/238	230/249	220/237	190/205	200/214	1997
Total Defective Garments	16	18	22	15	13	18	19	17	15	14	167
Total Defect	18	20	24	17	15	20	20	18	17	16	185
Total Defect %	14.28%	11.9%	9.16%	10.30%	11.28%	8.4%	8.03%	7.59%	8.29%	7.47%	9.26%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (185/1997) *100$$

$$= 9.26\%$$

1st Highest Defects =Uncut threat 41 pcs

2nd Highest Defects = Contas 27 pcs

3rd Highest Defects = Joint Stitch 21 pcs


Total Pieces checked =1997

Total Defects =185

3.7 Attachment of sewing report

3.7.1 Line inspection report 6:

This report is the property of KC Group (Knit Concern Group) and collected from KCL floor.



KC PRINT LIMITED
57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH.


F/Q.C/ SEW/ 07
Revision No : 00


DEFECTS PER HUNDRED UNIT (DHU) SEWING


PROD. FLOOR K.C.P LINE G BUYER Okalck ORDER # 2/205-2 STYLE 500 DATE 12/12/22 CHECKER M.D. Amin

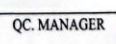
DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM	1	1	1	1	1	1	1	1	1	1	1	1	12
BROKEN STITCH	1	1	1	1	1	1	1	1	1	1	1	1	12
SKIP STITCH	1	1	1	1	1	1	1	1	1	1	1	1	12
UNEVEN STITCH	1	1	1	1	1	1	1	1	1	1	1	1	12
JOINT STITCH	1	1	1	1	1	1	1	1	1	1	1	1	12
PLEET	1	1	1	1	1	1	1	1	1	1	1	1	12
MEASUR. DAVIATION													
NEEDLE HOLE													
SIZE MISTAKE													23
DIRTY SPOT	1	1	1	1	1	1	1	1	1	1	1	1	12
OIL MARK													42
UNCUT THREAD	1	1	1	1	1	1	1	1	1	1	1	1	12
REJECT													
EMB./PRINT MISTAKE													16
LABEL DISPLACE													02
<i>Faint up down</i>													07
<i>Tuck Problem</i>													21
<i>Plaket Problem</i>													21
<i>Down stitch</i>	1	1	1	1	1	1	1	1	1	1	1	1	12
<i>Over stitch</i>													64
<i>Mash Problem</i>	1	1	1	1	1	1	1	1	1	1	1	1	12
<i>Rawedge</i>													07
TOTAL PASS/CHECK:	30	50	120	140	178	110	145	165	155	135	165	120	1155
TOTAL DEFECTIVE GARMENTS	20	30	38	35	30	30	32	32	25	30	32	25	240
TOTAL DEFECTS:	23	32	40	36	34	30	32	35	28	30	32	25	265
TOTAL DEFECTS %	46%	26.67%	35%	24.83%	17.43%	27%	22.22%	21.21%	18.18%	22.22%	22.22%	20.83%	22.94%
LQC SIGNATURE													

DHU FORMULA : Total defects found x 100 / Total garments inspected


LINE QC


SNR. QC


SEWING IN CHARGE


QC. MANAGER



PROD. MANAGER

Fig: Line Inspection Report 6

Sewing inspection report of 01-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.7.2 Data Table 6

Knit Concern Group Hourly DHU REPORT

Date: 03-01-2023

Order: 4/105-K

Style: B/C 008

Buyer: Okaidi

Sewing Line: G

Floor: KCP

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam	1	2	1	2		3	2	1			12
Broken Stitch	2	1	2	1	2	1	2	1			12
Skip Stitch			2					1			3
Uneven Stitch	4	5	7	1		2	5	4			28
Joint Stitch		2	1	4	3	1					11
Pleat		2	3	5	8	2	1	3			24
Measure Deviation											
Needle Hole											
Size Mistake											
Dirty Spot	1	3	2	6	5	3	2	1			23
Oil Mark											
Uncut Thread	3	2	10	7	7	3	4	5	5		41
Reject		1	2		1	1		1			6
Emb/Print Mistake											
Label Displace	1	2	1	1	1	2	3	2			13

Rawedge	3	1		1	1		1				7
Tuck	1		1			2	1	2			7
Point up down						1	1				2
Placket problem		4	5	2	2	2	5	1			21
Down Stitch	4	1	3	1	2	5	3	2			21
Mash Problem	2	6	5	5	3	4	5	4			34
Puckering											
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total pass/ Check	30/50	90/120	140/178	110/145	165/195	135/165	125/157	120/145			915/1155
Total Defective Garments	20	30	38	35	30	30	32	25			240
Total Defect	23	32	40	36	34	32	35	28			265
Total Defect %	46%	26.67%	35%	24.83%	17.43%	19.39%	22.29%	9.31%			22.94%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (265/1155) *100$$

$$= 22.94\%$$

1st Highest Defects =Uncut threat 41 pcs

2nd Highest Defects = Mash Problem 34 pcs

3rd Highest Defects = Uneven Stitch 28 pcs


Total Pieces checked =1155

Total Defects =265

3.8 Attachment of sewing report

3.8.1 Line inspection report 7:

This report is the property of KC Group (Knit Concern Group) and collected from KCA floor.



KC PRINT LIMITED
57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH.

F/Q C/ SEW/ 0,
Revision No : 00

DEFECTS PER HUNDRED UNIT (DHU) SEWING

PROD. FLOOR: KCA LINE: A BUYER: PEPCO ORDER # 000960974 STYLE: TAN TOP DATE: 03.01.23 CHECKER: Mshyoz

DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM			1				1	11					4
BROKEN STITCH	111	11	11	11	1	1	111	1	1111	111			26
SKIP STITCH		111	1111	1	1	111	111	1	11	1			24
UNEVEN STITCH			11		111			1	1				7
JOINT STITCH	1		11	1			11	1	11				16
PLEET					1		11			11			13
MEASUR. DAVIATION										11			2
NEEDLE HOLE				1									1
SIZE MISTAKE													
DIRTY SPOT	1	11	1	11	1	1		11	11	11			29
OIL MARK		1	1	11	1	1	1	1	1	1			9
UNCUT THREAD	11	111	1	1	1111	1111	11	11	111	111			32
REJECT			11	11	1	1	1	11	11	11			30
EMB./PRINT MISTAKE													
LABEL DISPLACE	1	1	1	111	11	111	11	11	11				27
Rowedac	1	1			1				11	111			17
Therx problem			1	1	1	1							5
OVER SEWING			11	11	1	1	1	1	111	11			27
TOTAL PASS/CHECK:	10	55	160	176	150	164	135	102	135	95	155	200	1804
TOTAL DEFECTIVE GARMENTS	8	16	18	17	18	17	20	14	25	20			173
TOTAL DEFECTS:	9	18	20	19	20	19	22	15	27	22			190
TOTAL DEFECTS %	15.52%	10.23%	12.19%	9.89%	9.89%	9.40%	11%	9.15%	12%				10.52%
LQC SIGNATURE													

DHU FORMULA : Total defects found x 100 = Total garments inspected

LINE QC

SNR. QC

SEWING IN-CHARGE

QC. MANAGER

PROD. MANAGER

Fig: Line Inspection Report 7

Sewing inspection report of 03-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.8.2 Data Table 7

Knit Concern Group Hourly DHU REPORT

Date: 03-01-2023
 Order: D00880775
 Style: TAN TOP
 Buyer: Pepco
 Sewing Line: A
 Floor: KCA

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam			1				1	2			4
Broken Stitch	3	2	2	2	1	1	5	1	4	5	26
Skip Stitch		5	4	1	1	5	4	1	2	1	24
Uneven Stitch			2		3			1	1		7
Joint Stitch	1		2	1			2	1	3		10
Pleet					1		2			2	5
Measure Deviation											
Needle Hole											
Size Mistake											
Dirty Spot	1	2	1	2	1	1		2	2	2	14
Oil Mark		1	1	1		1	1	1	1	1	8
Uncut Thread	2	5	1	1	6	4	2	3	5	3	32
Reject			2	2	1	1	1		2		9
Emb/Print Mistake											
Label Displace	1	1			1				2	5	10

Rawedge	1	1			1				2	5	10
Tuck		1	1	1	1	1				1	6
Point up down											
Placket problem											
Over Stitch			2	2	1	1	1	1	3	2	13
Mash Problem											
Puckering											
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total pass/ Check	50/58	160/176	150/168	175/192	185/203	185/202	180/200	150/164	200/225	200/220	1804
Total Defective Garments	8	16	18	17	18	17	20	14	25	20	173
Total Defect	9	18	20	19	20	19	22	15	27	22	190
Total Defect %	15.52%	10.23%	12.19%	9.89%	9.85%	9.40%	11%	9.25%	12%	10%	10.53%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (190/1804) *100$$

$$= 10.53\%$$

1st Highest Defects =Uncut threat 32 pcs

2nd Highest Defects = Broken Stitch 26 pcs

3rd Highest Defects = Skip Stitch 24 pcs

Total Pieces checked =1804

Total Defects =190

3.9 Attachment of sewing report

3.9.1 Line inspection report 8:

This report is the property of KC Group (Knit Concern Group) and collected from KCP 2 floor.

F/QC/SW/05
 REVISION: 01
 DHU % = Till defects qty x 100
 Till check qty
 Date: 03-01-2023
 DHU AVG. %
 Color: NAVY

KC PRINT LID.
 57/1, Water Works Road, Godnail Narayangan
Hourly DHU Report (At Sewing QC Table)

Order No.:	AF-3139		Style Name:	5051	
Floor No.:	K.C.P.02	Line No.:	C	Table Quality Name:	SHAKIL-YEASIR-MASUD

Defects Name	Hour										Total	
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07		
Broken stitch	11	11			11	D			11		1	12
Button												
Button Hole												
Fabric fault		1										14
Drop stitch					11	D			1			
Needle hole		1										
Improper shape												
Joint stitch	1	11	111	111	11	11	11		11	11		223
Label fault		1							11	11		6
Measurement												
Needle mark												
Open seam	1			1		11	1					5
Print fault												
Embroidery												
Puckering												
Pieal							1		111	11	11	8
Rawedge	11	11	111	1	1	1	11		111	11	1	76
Slanted												
Skip stitch	1			11	1	11	D		11		1	5
Shading												
Thread Mistake												
Twisting												
Thread tension												
Up-down	1			1	1	11	1		11	1		9
Up-even	1	11							11		1	90
Uncut thread	11	111	1111	111	111	111	111	111	111	111	111	90
Wavyness												
Wrong SPI												
Size Mistake												
Oil spot		111	11	111	1111	1111	1111	111	111	111	111	37
Dirty spot				1								
Rejects	11	11	1					11				20
Others	11			11	11	1	11			1		20
Total check gmts	192	220	185	198	210	206	198	218	209	196	1967	
Total Pass gmts	130	200	180	180	190	185	180	200	190	180	1800	
Total defective gmts	12	20	15	18	20	21	18	18	19	16	167	
Total defect qty	19	21	18	19	22	22	19	22	20	18	180	
DHU %	9.85%	9.64%	8.64%	9.55%	10.47%	10.62%	9.55%	10.09%	9.66%	9.18%	9.65%	
Defect rectified Qty	0	12	18	19	18	20	21	21	18	17	167	
Defect Balance qty	12	9	0	0	4	2	0	1	1	1	13	
Rectify Defects check & pass	0	12	18	19	18	20	21	21	18	17	167	
Rejects qty		09	04				03				93	
LQC / Super. Signature	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	

TCP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date

Quality Supervisor
QC.IN
Floor In. (Fin)
AQM/DQM
QM
PM

Fig: Line Inspection Report 8

Sewing inspection report of 03-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.9.2 Data Table 8

Knit Concern Group

Hourly DHU REPORT

Date: 03-01-2023

Order: AF-3139

Style: 5051

Buyer: H&M

Sewing Line: C

Floor: KCP 2

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Broken Stitch	2	3			2			2		1	10
Button											
Button Hole											
Fabric Fault		1									1
Drop Stitch		1			2			1			4
Needle Hole											
Improper Shade											
Joint Stitch	1	3	4	3	3	2	2		3	2	23
Label Fault		1						2	2		5
Open Seam	1			1		2	1				5
Pleat							1	3	2	2	8
Rawedge	2	2	3	1	1	1	2		3	1	16
slanted											

Skip Stitch	1			2	1	2		2		1	9
Up-down	1			1	1	2	1		2	1	9
Up-even	1	2						2		1	6
Uncut Thread	3	3	6	5	3	5	4	5	3	4	40
Wavyness											
Wrong SPI											
Size Mistake											
Oil Spot		3	2	3	6	6	4	5	4	5	37
Dirty Spot				1							1
Rejects		2	1				2				5
Others	2			2	2	1	2		1		10
Total Check	142	220	185	198	210	206	198	218	207	196	1967
Total Pass	130	200	170	180	190	185	180	200	190	180	1805
Total Defective Garments	12	20	15	18	20	21	18	18	17	16	162
Total Defect	14	21	16	19	22	22	19	22	20	18	189
Total Defect %	9.89%	9.54%	8.64%	9.59%	10.47%	10.67%	9.59%	10.09%	9.66%	9.18%	9.60%

$$\begin{aligned} \text{DHU\%} &= (\text{Total No of Defect}/\text{Total no of Checked Product}) *100 \\ &= (189/1967) *100 \\ &=9.60\% \end{aligned}$$

1st Highest Defects =Uncut threat 40 pcs

2nd Highest Defects = Oil Spot 37 pcs

3rd Highest Defects = Joint Stitch 23 pcs

Total Pieces checked =1967

Total Defects =189

3.10 Attachment of sewing report

3.10.1 Line inspection report 9:

This report is the property of KC Group (Knit Concern Group) and collected from KCP floor.

F/Q.C/ SEW/ 07
 Revision No : 00

KC PRINT LIMITED
 57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH.
DEFECTS PER HUNDRED UNIT (DHU) SEWING

DATE: 06.01.2023 CHECKER: FARIDA/ lucky

ORDER # 1/1000 STYLE: pink SHIRT

PROD. FLOOR: K.C.P LINE: A BUYER: ...

DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM	1		1	1	1	1	1	1					7
BROKEN STITCH					1	1	1	1					4
SKIP STITCH					1	1	1	1					4
UNEVEN STITCH		1	1		1	1	1	1					6
JOINT STITCH					1	1	1	1					4
PLEET													0
MEASUR. DAVIATION													0
NEEDLE HOLE													0
SIZE MISTAKE				1				1					2
DIRTY SPOT	1						1	1					3
OIL MARK	1			1	1	1	1	1					6
UNCUT THREAD	1	1	1	1	1	1	1	1					8
REJECT		1			1			1					3
EMB./PRINT MISTAKE								1					1
LABEL DISPLAC		1	1	1		1	1	1					6
<i>Raw edge</i>		1	1	1		1	1	1					6
<i>Truck</i>													0
<i>Print up-down</i>		1	1		1	1	1	1					5
<i>Down stitch</i>		1			1								2
<i>Placket Problem</i>		1						1					2
<i>Box Problem</i>		1											1
TOTAL PASS/CHECK:	45/9	85/9	90/9	65/20	125/145	100/12	120/142	70/80					702/794
TOTAL DEFECTIVE GARMENTS	4	14	10	15	10	13	22	15					92
TOTAL DEFECTS:	5	16	11	8	12	16	24	18					110
TOTAL DEFECTS %	10.22%	16.16%	10.89%	11.43%	9.27%	14.16%	16.99%	21.17%					13.85%
LQC SIGNATURE													

DHU FORMULA: Total defects found x 100 / Total garments inspected

LQC

SVR. QC

SEWING IN-CHARGE

QC. MANAGER

 PROD. MANAGER

Fig: Line Inspection Report 9

Sewing inspection report of 06-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.10.2 Data Table 9

Knit Concern Group Hourly DHU REPORT

Date: 06-01-2023

Order: 4/103D

Style: Polo Shirt

Buyer: Okaidi

Sewing Line: D

Floor: KCP

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam	1			1		1	1				4
Broken Stitch			2	1	1	1	1	1			7
Skip Stitch					1		1	1			3
Uneven Stitch		2	2		1	2	1	2			10
Joint Stitch		1				2	7	2			12
Pleet		2	2		2	1	1				8
Measure Deviation											
Needle Hole											
Size Mistake											
Dirty Spot	1			1				1			3
Oil Mark	1			2	1		2	1			7
Uncut Thread	2	2	2	2	3	3	4	2			20
Reject		1			1			1			3
Emb/Print Mistake											
Label Displace		2						1			3
Rawedge		1	1	1		1	1				5

Tuck											
Point up down		2	2		1	5	5	5			20
Placket problem		1			1						2
Down Stitch		1									1
Box Problem		1						1			2
Puckering											
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total pass/ Check	45/49	85/99	82/91	65/70	135/145	100/113	120/142	70/85			702/794
Total Defective Garments	4	14	9	15	10	13	22	15			92
Total Defect	5	16	11	8	12	16	24	18			110
Total Defect %	10.20%	16.16%	12.09%	11.43%	8.27%	14.16%	16.90%	21.17%			13.85%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (110/794) *100$$

$$= 13.85\%$$

1st Highest Defects =Uncut threat 20 pcs

2nd Highest Defects = Point Up down 20 pcs

3rd Highest Defects = joint Stitch 12 pcs

Total Pieces checked =794

Total Defects =110

3.11 Attachment of sewing report

3.11.1 Line inspection report 10:

This report is the property of KC Group (Knit Concern Group) and collected from KCP floor.

BP

KC PRINT LIMITED
57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANI, BANGLADESH.

F/Q.C/ SEW/ 07
Revision No : 00

DEFECTS PER HUNDRED UNIT (DHU) SEWING

PROD. FLOOR: K.C.P LINE: I BUYER: Depeo ORDER # DC08873016 STYLE: Yen top DATE: 06-01-23 CHECKER: Rakibul Mahabub

DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM	1	1		1	1		1	1	1		1		11
BROKEN STITCH	1	1	1	1	1		1	1	1	1	1		21
SKIP STITCH	1	1		1	1		1	1	1	1			10
UNEVEN STITCH													
JOINT STITCH	1	1	1	1	1		1	1	1	1	1		21
PLEET													12
MEASUR. DAVIATION													
NEEDLE HOLE													
SIZE MISTAKE													
DIRTY SPOT													
OIL MARK													
UNCUT THREAD	1	1	1	1	1		1	1	1	1	1		35
REJECT	1	1	1		1		1	1	1	1	1		13
EMB./PRINT MISTAKE													
LABEL DISPLACE													
Kawala	1	1	1	1	1		1	1	1	1	1		14
Pocket P:	1	1	1	1	1		1	1	1	1	1		06
contad:	1	1	1	1	1		1	1	1	1	1		25
Tuck P:	1	1	1	1	1		1	1	1	1	1		19
overz stitch	1	1	1	1	1		1	1	1	1	1		08
Down stitch with out Pocket													01
TOTAL PASS/CHECK:	100	105	100	100	100	100	100	100	100	100	100	100	2150
TOTAL DEFECTIVE GARMENTS	22	18	19	18	15		20	16	20	17	15		180
TOTAL DEFECTS:	24	20	21	20	17		21	17	21	18	16		196
TOTAL DEFECTS %	12.65%	9.39%	9.59%	8.79%	8.5%		8.75%	7.27%	7.92%	7.75%	7.99%		9.11%
LOC SIGNATURE	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	

DHU FORMULA : Total defects fount x 100=Total garments inspected

LINE QC: *[Signature]* SNR: *[Signature]* SEWING IN-CHARGE: *[Signature]* QC. MANAGER: *[Signature]* PROD. MANAGER: *[Signature]*

Fig: Line Inspection Report 10

Sewing inspection report of 06-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.11.2 Data Table 10

Knit Concern Group

Hourly DHU REPORT

Date: 06-01-2023
 Order: D00880746
 Style: Ten Top
 Buyer: Pepco
 Sewing Line: I
 Floor: KCA

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam	1	1		2	1	2	1	2		1	11
Broken Stitch	3	2	2	3	2	3	2	1	2	1	21
Skip Stitch	1	1		2	1	2		2	1		10
Uneven Stitch											
Joint Stitch	2	2	2	3	2	3	1	2	1	3	21
Pleet					2	3	1	3	2	1	12
Measure Deviation											
Needle Hole											
Size Mistake											
Dirty Spot											
Oil Mark											
Uncut Thread	4	3	4	3	2	3	4	5	4	3	35
Reject	1	2	1		2	1	2	1	2	1	13
Emb/Print Mistake											
Label Displace											

Rawedge	2	2	2	1	2		1	2	1	2	14
Tuck	4	2	3	2		2	2	2	2	1	19
Point up down											
Pocket problem	2	1	2	1							6
Over Stitch	1	2	2				1			2	8
Box Problem		1						1			2
Contas	3	2	3	2	3	2	3	2	3	2	25
Puckering											
With out Placket				1							1
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total pass/ Check	100/12 2	195/213	200/219	210/22 8	185/20 0	220/240	200/21 6	245/265	215/23 2	200/215	2150
Total Defective Garments	22	18	19	18	15	20	16	20	17	15	180
Total Defect	24	20	21	20	17	21	17	21	18	16	196
Total Defect %	19.67%	9.39%	9.59%	8.77%	8.5%	8.75%	7.27%	7.92%	7.75%	7.44%	9.11%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (196/2150) *100$$

$$= 9.11\%$$

1st Highest Defects =Uncut threat 35 pcs

2nd Highest Defects = Contas 25 pcs

3rd Highest Defects = joint Stitch 21 pcs

Total Pieces checked =2150

Total Defects =196

3.12 Attachment of sewing report

3.12.1 Line inspection report 11:

This report is the property of KC Group (Knit Concern Group) and collected from KCP floor.

KC PRINT LIMITED
57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ, BANGLADESH.

DEFECTS PER HUNDRED UNIT (DHU) SEWING

PROD. FLOOR: KCP LINE: F BUYER: WVAD ORDER # 111000 STYLE: BTM DATE: 05-01-23 CHECKER: Murshida/Naorana

DEFECTS CODE	1st HOUR	2nd HOUR	3rd HOUR	4th HOUR	5th HOUR	6th HOUR	7th HOUR	8th HOUR	9th HOUR	10th HOUR	11th HOUR	12th HOUR	TOTAL DEFECTS
OPEN SEAM													
BROKEN STITCH													
SKIP STITCH													
UNEVEN STITCH													14
JOINT STITCH													25
PLEET													7
MEASUR. DAVIATION													15
NEEDLE HOLE													
SIZE MISTAKE													
DIRTY SPOT													
OIL MARK													1
UNCUT THREAD													2
REJECT													
EMB./PRINT MISTAKE													26
LABEL DISPLACE													1
Drowsing up Down													31
Hole up Down													11
Lock Problem													31
Barcode													5
Others													17
													10
TOTAL PASS/CHECK:	60	22	15	14	14	12	12	12	12	12	12	12	135
TOTAL DEFECTIVE GARMENTS	14	22	16	18	17	17	17	10	13	13	12	12	178
TOTAL DEFECTS:	14	22	16	20	17	17	18	21	15	15	13	12	196
TOTAL DEFECTS %	23.33%	100%	106.67%	125%	121.43%	141.67%	150%	175%	125%	125%	108.33%	100%	143.33%
LOC SIGNATURE	Maria	Maria	Maria	Maria	Maria		Maria	Maria	Maria	Maria	Maria	Maria	

DHU FORMULA : Total defects found x 100 / Total garments inspected

LINE QC: Maria SNR. QC: [Signature] SEWING IN-CHARGE: [Signature] QC. MANAGER: [Signature] PROD. MANAGER: [Signature]

Fig: Line Inspection Report 11

Sewing inspection report of 05-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.12.2 Data Table 11

Knit Concern Group

Hourly DHU REPORT

Date: 05-01-2023

Order: 4/109C

Style: BTM

Buyer: Okaidi

Sewing Line: F

Floor: KCP

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	11th	Total
Open Seam		2		2	3	3	1	2				14
Broken Stitch		4	3	2		4	3	3	2	2	2	25
Skip Stitch		3	1		1		1		1			7
Uneven Stitch												
Joint Stitch	2	1	3	2	2					3	2	15
Pleet												
Measure Deviation												
Needle Hole												
Size Mistake	1											1
Dirty Spot				2								2
Oil Mark												
Uncut Thread	2		4	2		1	5	5	2	3	2	26
Reject						1						1
Emb/Print Mistake												
Label Displace		6	3	5	2	2	3	3	2	2	3	31

Rawedge			2		4	3	1	3	2	1	1	17
Tuck	1					1	1	2				5
Hole up down	5	4		3	3	3	2	3	4	2	2	31
Drawsting Updown	3	1	1	2	2	1	1					11
Others	2	2	1						2	2	1	10
Total pass/ Check	60/74	125/147	140/156	130/148	135/157	120/137	150/167	150/169	150/163	120/133	100/112	1380/1558
Total Defective Garments	14	22	16	18	17	17	17	19	13	13	12	178
Total Defect	16	24	18	20	19	19	18	21	15	15	13	196
Total Defect %	21.62 %	16.33%	11.54%	13.51 %	12.5%	13.87%	10.78 %	12.43%	9.20%	9.77%	10.71%	12.58%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (196/1558) *100$$

$$= 12.58\%$$

1st Highest Defects = Label Displace 31 pcs

2nd Highest Defects = Hole Uptown 31 pcs

3rd Highest Defects = Uncut Thread 26 pcs

Total Pieces checked =1558


Total Defects =196

3.13 Attachment of sewing report

3.13.1 Line inspection report 12:

This report is the property of KC Group (Knit Concern Group) and collected from KCP 2 floor.

F/QC/SW/05
 REVISION : 01
 DHU % = TII defects qty x 100
 TII check qty
 Date : 6-1-23
 DHU AVG. %


KC PRINT LIMITED
 57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ-1400

Hourly DHU Report (At Sewing QC table)

Order No : 489422	Style Name : 53 PJ 3PK	Color : 54-115
Floor No : KCP-3	Line No : M	Table Quality Name : 3TC

Defects Name	Hour										Total
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	
Broken stitch	11	11									2
Button											
Button Hole											
Fabric fault											
Drop stitch		1									1
Needle hole											
Improper shape											
Joint stitch	11	1				11	11	11	1	1	22
Label fault	11										
Measurement											
Needle mark											
Open seam	11	11			1	1	11	11	11	11	25
Print fault											
Embroidery											
Puckering											
Pleat	11	11			1		11		1		12
Rawedge		11			11						5
Slanted											
Skip stitch	11	11			11						2
Shading											
Thread mistake											
Twisting											
Thread tension											
Up-down	1				11			1			4
Un-even		11									
Uncut thread	12	11	11		11	11		11	11	1	33
Wavyness											
Wrong SPI											
Size Mistake								1			2
Oil spot											
Dirty spot											
Rejects	11	1	11			1				11	3
Others	11	11			1	1	11	11	11	11	33
Total check gmts	165	100	106		102	85	126	50	58	106	1001
Total Pass gmts	140	150	106		50	75	110	50	50	100	160
Total defectives gmts	25	50	0		52	10	16	0	8	6	160
Total defects qty	30	40	8		12	13	20	10	10	2	161
DHU %	18.2%	40%	7.54%		11%	15%	12.7%	20%	17%	2%	16.1%
Defects rectified qty	25	40	6		14	13	18	8	8	8	161
Defects Balance qty	5	0	2		8	0	2	2	2	0	0
Rectify Defects check & pass		95	40		6	12	13	16	8	8	
Rejects qty											
LQC / Super. Signature	A.P.M.	A.P.M.	A.P.M.		A.P.M.	A.P.M.	A.P.M.				

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date

Quality Supervisor
QC.IN
Floor In-Charge
AQM/DQM
QM
PM

Fig: Line Inspection Report 12

Sewing inspection report of 06-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.13.2 Data Table 12

Knit Concern Group

Hourly DHU REPORT

Date: 06-01-2023

Order: 479422

Style: SS Pj3PR

Buyer: H&M

Color: 54-115

Sewing Line: M

Floor: KCP 3

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Broken Stitch	2	2			1				1	1	7
Button											
Button Hole											
Fabric Fault											
Drop Stitch		1									1
Needle Hole											
Improper Shade											
Joint Stitch	2	1				4	10	2	1	1	22
Label Fault											
Measurement											
Needle Mark											
Open Seam	2	12			1	1	2	3	2	2	25

Pleat	3	3			1		3		1		12
Rawedge		2			2	1					5
slanted											
Skip Stitch	2	3			2						7
Up-down	1				2			1			4
Up-even											
Uncut Thread	12	7	3		2	3		3	2	1	33
Wavyness											
Wrong SPI											
Size Mistake			1					1			2
Oil Spot											
Dirty Spot			2				1				3
Rejects	2	1	2			1					6
Others	3	8			1	2	2	3	2	2	33
Total Check	169	190	106		102	83	128	59	58	106	1001
Total Pass	140	150	100		90	70	110	50	50	100	
Total Defective Garments	29	40	6		12	13	18	9	8	6	141
Total Defect	30	40	8		12	13	20	10	9	7	149
Total Defect %	17.75%	21.57%	7.54%		11%	16%	15%	11%	15%	7%	16%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (149/1001) *100$$

$$=16\%$$

1st Highest Defects =Uncut threat 33 pcs

2nd Highest Defects = Others 33 pcs

3rd Highest Defects = Open Stitch 25 pcs

Total Pieces checked =1001

Total Defects =149

3.14 Attachment of sewing report

3.14.1 Line inspection report 13:

This report is the property of KC Group (Knit Concern Group) and collected from KCP 3 floor.

F/QC/SW/05
 REVISION : 01

KC PRINT LIMITED
 57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ-1400

DHU % = TII defects qty x 100
 TII check qty
 Date : 6-1-23
 DHU AVG. %

Hourly DHU Report (At Sewing QC table)

Order No : 883544 Style Name : Tank TOP Color : Green
 Floor No : KCP-3 Line No : P Table Quality Name : W/BGM

Defects Name	Hour										Total
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	
Broken stitch	///	///	///	///	///	///	///	///	///	///	25
Button											
Button Hole											
Fabric fault											
Drop stitch											
Needle hole											
Improper shape											
Joint stitch											01
Label fault											6
Measurement											
Needle mark											
Open seam											
Print fault											7
Embroidery											
Puckering											
Pleat											
Rawedge											85
Slanted											
Skip stitch		///									13
Shading											
Thread mistake											
Twisting											
Thread tension											
Up-down											
Un-even <u>Color</u>	///	///						///	///	///	25
Uncut thread	///	///	///	///	///	///		///	///	///	40
Wavyness											
Wrong SPI											
Size Mistake											6
Oil spot											
Dirty spot											6
Rejects											14
Others							///				21
<u>TOP</u>							///				21
Total check gmts	150	207	190	152	165	112	22	158	190	200	1626
Total Pass gmts	130	160	120	140	130	150	150	150	182	195	
Total defectives gmts	20	27	20	22	16	15	22	18	8	7	184
Total defects qty	27	27	22	22	16	15	22	18	9	8	
DHU %	15%	13%	15%	14%	10%	10%	14%	10%	4%	4%	
Defects rectified qty	20	20	27	20	22	15	10	22	8	8	110%
Defects Balance qty	20	27	20	22	16	15	22	18	8	8	
Rectify Defects check & pass		20	27	20	22	15	22	22	18	8	
Rejects qty											
LQC / Super. Signature	[Signatures]										

TOP 3 defects	Root Cause	CAP	Responsible Person	Implementation Date
BROKEN STITCH	ଅନିୟମିତ	ଅଧିକ ଚାକିରି	S.Q.C	7.01.23
UNCUT THREAD	ଅନିୟମିତ	ଅଧିକ ଚାକିରି	A.P.M	7.01.23
UN-EVEN	ଅନିୟମିତ	ଅଧିକ ଚାକିରି	S.Q.C	7.01.23

Quality Supervisor
QC.IN
Floor In-Charge
AQM/DQM
QM
PM

Fig: Line Inspection Report 13

Sewing inspection report of 06-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.14.2 Data Table 13

Knit Concern Group

Hourly DHU REPORT

Date: 06-01-2023

Order: 882544

Style: Tank Top

Buyer: Pepco

Color: Green

Sewing Line: P

Floor: KCP 3

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Broken Stitch	3	4	3	3	2	3	4	2	1		25
Button											
Button Hole											
Fabric Fault											
Drop Stitch											
Needle Hole											
Improper Shade											
Joint Stitch								1			1
Label Fault	1	1	2	1			1				6
Measurement											
Needle Mark											
Open Seam		1		1	2	2		1			7

Print Fault											
Pleat			1				1	2	1		5
Rawedge	1		2	2	1	2					8
slanted											
Skip Stitch	1	3	2	1			2	1	1	2	13
Up-even Pocket	7	6	2	1	2	2	2	3			25
Uncut Thread	5	7	5	6	3	3		4	3	4	40
Wavyness											
Wrong SPI											
Size Mistake				1	3		2				6
Oil Spot											
Dirty Spot	1		2	3							6
Rejects		4	3	2		1	2	2			14
Others		1						2			3
Tuck	2	1		2	2		10		3	1	21
Total Check	150	207	140	162	165	112	212	198	190	200	1636
Total Pass	130	180	120	140	150	100	190	180	182	193	
Total Defective Garments	20	27	20	22	15	12	22	18	8	7	
Total Defect	21	28	22	23	16	13	23	19	9	8	182
Total Defect %	14%	13%	15%	14%	10%	12%	11%	10%	4%	4%	11%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (182/1636) *100$$

$$=11\%$$

1st Highest Defects =Uncut threath 40 pcs

2nd Highest Defects = Broken Stitch 25 pcs

3rd Highest Defects = Uneven Pocket 25 pcs

Total Pieces checked =1636


Total Defects =182

3.15 Attachment of sewing report

3.15.1 Line inspection report 14:

This report is the property of KC Group (Knit Concern Group) and collected from KCP 3 floor.

F/QC/SW/05
 REVISION : 01
 DHU % = TU defects qty x 100
 TU check qty


KC PRINT LIMITED
 57/1, WATER WORKS ROAD, GODNAIL, NARAYANGANJ-1400

Date : 6-1-23
 DHU AVG. %

Hourly DHU Report (At Sewing QC table)

Order No : 882544 Style Name : Tank top Color :
 Floor No : KCP-3 Line No : Table Quality Name : Hema Akhtar

Defects Name	Hour										Total
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	
Broken stitch											23
Button											
Button Hole											
Fabric fault											
Drop stitch											
Needle hole											
Improper shape											
Joint stitch											17
Label fault											
Measurement											
Needle mark											
Open seam											6
Print fault											
Embroidery											
Puckering											
Pleat											16
Rawedge											
Slanted											
Skip stitch											29
Shading											
Thread mistake											
Twisting											
Thread tension											
Up-down											
Un-even											
Uncut thread											33
Wavyness											
Wrong SPI											
Size Mistake											
Oil spot											4
Dirty spot											5
Rejects											4
Others											3
Total check grnts	154	196	193	196	200	196	194	192	134	111	1705
Total Pass grnts	140	180	180	180	180	180	180	180	120	100	
Total defectives grnts	14	16	13	16	20	16	14	12	14	11	
Total defects qty	15	16	14	17	20	17	14	15	15	12	148
DHU %		8%	7%	8%	10%	8%	7%	8%	11%	10%	
Defects rectified qty		14	14	16	16	16	16	16	13	15	
Defects Balance qty	14	16	13	16	20	16	13	12	13	12	
Rectify Defects check & pass		14	14	13	16	20	13	12	13	15	8.38%
Rejects qty											
LQC / Super. Signature											

TOP 3 defects	Root Cause	Responsible Person	Implementation Date
UNCUT THREAD	OP: Negligence	SR: Q.C. AI	06-01-23
BACKED STITCH	OP: Carelessness	SR: Q.C. AI	06-01-23
SKIP STITCH	OP: Negligence	SR: Q.C. AI	06-01-23

Quality Supervisor
QC.IN
Floor In-Charge
AQM/DQM
QM
PM

Fig: Line Inspection Report 14

Sewing inspection report of 06-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.15.2 Data Table 14

Knit Concern Group

Hourly DHU REPORT

Date: 06-01-2023

Order: 882544

Style: Tank Top

Buyer: Pepco

Color: Green

Sewing Line: Q

Floor: KCP 3

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Broken Stitch	3	3	2	3	2	2	2	2	2	2	23
Button											
Button Hole											
Fabric Fault											
Drop Stitch											
Needle Hole											
Improper Shade											
Joint Stitch	2	1	3	3	2	2	1	1	1	1	17
Label Fault					2	1			2	2	7
Measurement											
Needle Mark											
Open Seam	1	1				1	1	1	1		6

Print Fault											
Embroidery											
Puckering											
Pleat		2	1	2	2	2	2	2	2	1	16
Skip Stitch	3	3	2	3	5	4	3	2	2	2	29
Uncut Thread	4	3	3	4	4	3	3	2	4	3	33
Wavyness											
Wrong SPI											
Size Mistake											
Oil Spot				1	1		1	1			4
Dirty Spot	1	1	1								3
Rejects	1	2	1								4
Others						1	1	1			3
Tuck											
Total Check	254	196	193	196	200	196	194	192	134	111	1765
Total Pass	140	180	180	180	180	180	181	181	120	100	
Total Defective Garments	14	16	13	16	20	16	13	12	14	11	
Total Defect	15	16	14	17	24	17	14	13	15	12	148
Total Defect %	9.74%	8%	7%	8%	10%	8%	7%	6%	11%	10%	8.38%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (148/1765) *100$$

$$=8.38\%$$

1st Highest Defects =Uncut threat 33 pcs

2nd Highest Defects = Skip Stitch 29 pcs

3rd Highest Defects = Broken Stitch 23 pcs

Total Pieces checked =1765

Total Defects =148

3.16 Attachment of sewing report

3.16.1 Line inspection report 15:

This report is the property of JM Fabrics Ltd. (New Asia Group) and collected from Sewing floor.

J.M FABRICS LIMITED
South Nayapara, 6 No.Dogri, Bhawal, Mirzapur, Gazipur
QUALITY ASSURANCE DEPARTMENT
QUALITY CONTROL END LINE 100% INSPECTION REPORT (Q.C.E.I.R.)

JMF QC-Sew : 11
 Version No : 002
 Effective Date : 01-11-17
 Revision Date : 19.03.2019

CUSTOMER		DATE	
STYLE No		LINE No	
COLOR			
END LINE QC (Name)			

TIME	1st.H	2nd.H	3rd.H	4th.H	5th.H	6th.H	7th.H	8th.H	9th.H	10th.H	11th.H	12th.H	Total	%
RECEIVED QTY	68	70	69	70	70	70	67	67					624	
DEFECTIVE Pcs's QTY	6	7	9	7	8	9	8	7					61	9.77%
Code	Defect Description OPERATION													
0	Broken stitch													
1	Print Defect													
4	Component Shading												06	0.96%
6	Pleat													
7	Fly in (yam)													
127	Skip Stitch												19	3.04%
129	SKIP STITCH													
130	Wrong Thread Color													
131	Sharing													
133	Poor Bar Tack													
134	Missing Bar Tack												14	2.24%
135	Uncut Thread													
136	Poor Joining													
138	Wrong SPI													
139	Wavy													
145	Needle Holes												06	0.96%
176	Open Seam													
177	Raw Edges													
179	Uneven Top Stitch													
182	Puckering													
191	Scissor Cut													
198	Uneven Leg Open													
200	Wrong Bow Position													
217	Uneven Gathering													
247	Incorrect Label													
248	Defective Label													
249	Raw Edge												15	2.40%
326	Oil Stain													
328	Dirt /Stain													
	Down Stitch													
	Measurement OOT													
OTHERS	REJECT												61	9.77%
TOTAL DEFECTS	6	7	9	7	8	9	8	7					61	9.77%
PASSED GARMENTS	59	63	71	72	72	61	74	75					563	
DECFECT %													9.77%	
TAKEN FOR REPAIR/AFTER REPAIR PASSED	66	74	90	79	88	74	86	77					621	
SUPERVISOR SIGNATURE	[Signature]													
INLINE QC SIGNATURE	[Signature]													
Highest 3 Defect	1st Highest Defect SKIP STITCH			2nd Highest Defect OIL STAIN				3rd Highest Defect UNCUT THRED					19	
(Total Defects x 100) / Total garments spacted =	DHU%		(Total Defective Pcs's x 100) / Total garments Inspected =										Defective Pcs's %	

[Signature] SUPERVISOR	[Signature] QC EXECUTIVE	[Signature] TECHNICIAN	[Signature] APM/PM	[Signature] AQM/QM
---------------------------	-----------------------------	---------------------------	-----------------------	-----------------------

Fig: Line Inspection Report 15

Sewing inspection report of 04-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.16.2 Data Table 15

JM Fabrics Ltd. Hourly DHU REPORT

Date: 04-01-2023

Order:

Style: A4A1U

Buyer: GYMSHARK

Sewing Line: 11

Floor: 2nd

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam			2	1	1	1		2			6
Broken Stitch											
Skip Stitch	2	3	3	2	2	3	3	1			19
Uneven Stitch											
Joint Stitch											
Pleet	1	1		2			2				6
Measure Deviation											
Needle Hole											
Size Mistake											
Dirty Spot											
Oil Mark	2	1	2	1	3	3	1				15
Uncut Thread	1	2	2	2	2	2	1				14
Reject											

Emb/Print Mistake											
Label Displace											
Rawedge											
Tuck											
Point up down											
Down Stitch											
Puckering											
Button											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total Check	60	70	80	80	80	90	82	82			624
Total Pass	54	63	71	73	72	81	74	75			563
Total Defective Garments	6	7	9	7	8	9	8	7			61
Total Defect	6	7	9	7	8	9	8	7			61
Total Defect %	10%	10%	11.25%	8.75%	10%	10%	9.75%	8.53%			9.8%

$$\begin{aligned}
\text{DHU\%} &= (\text{Total No of Defect} / \text{Total no of Checked Product}) * 100 \\
&= (61/624) * 100 \\
&= 9.8\%
\end{aligned}$$

1st Highest Defects = Skip Stitch 19 pcs

2nd Highest Defects = Oil Mark 15 pcs

3rd Highest Defects = Uncut Tread 14

Total Pieces checked = 624

Total Defects = 61

3.17 Attachment of sewing report

3.17.1 Line inspection report 16:

This report is the property of LM Fabrics Ltd (New Asia Group) and collected from Sewing floor.

J.M FABRICS LIMITED
QUALITY ASSURANCE DEPARTMENT
QUALITY CONTROL END LINE 100% INSPECTION REPORT(Q.C.E.L.I.R.)

CUSTOMER		G.S		DATE		09.01.23	
STYLE No		A9A0N		LINE No		15	
COLOR		MAGENTA BROWN					
END LINE QC (Name)		MAREOME					

JMF QC-Sew : 11
 Version No : 002
 Effective Date : 01-11-17
 Revision Date : 19.03.2019

TIME	1st.H	2nd.H	3rd.H	4th.H	5th.H	6th.H	7th.H	8th.H	9th.H	10th.H	Total	%	
RECEIVED QTY	50	50	70	120	125	130	220	225			705		
DEFECTIVE Pcs's QTY	5	6	6	5	6	5	6	6			41	4.87%	
Code	DEFECT DESCRIPTION		OPERATION										
0	Broken stitch		SV/B.HEM		1	1	1	1	1		5	0.71%	
1	Print Defect												
4	Component Shading												
6	Pleat		SIDE/AK										
7	Fly in (yarn)												
127	Loose Stitch												
129	Damage		SKIP HEM		1		1	1	1		4	0.57%	
130	Wrong Thread Color												
131	Missing Back Tack												
133	Poor Bar Tack												
134	Missing Bar Tack												
135	Uncut Thread												
136	Poor Joining		HEM			1		1	1		3	0.43%	
138	Wrong SPI												
139	Stitch Tension												
145	Needle Holes		SIDE				1	1			2	0.28%	
176	Open Seam		SIDE/AK			1				1	1	0.14%	
177	Raw Edges												
179	Uneven Top Stitch												
182	Puckering												
191	Scissor Cut		SIDE/HEM		1		1				2	0.28%	
198	Uneven Leg Open												
200	Wrong Bow Position												
217	Uneven Gathering												
247	Incorrect Label												
248	Defective Label												
249	Raw Edge												
326	Oil Stain		ALL BODY		1	1	1	1	1		5	0.71%	
328	Dirt /Stain		ALL BODY				1		1		2	0.28%	
Measurement OOT													
OTHERS													
TOTAL DEFECTS													
PASSED GARMENTS													
DEFECT %													
TAKEN FOR REPAIR/AFTER REPAIR PASSED													
SUPERVISOR SIGNATURE													
INLINE QC SIGNATURE													
Highest 3 Defect			1st Highest Defect			2nd Highest Defect			3rd Highest Defect				
			OIL STAIN			BROKEN ST			POOR JOINING			5	
(Total Defects x 100) / Total garments spaced =			DHU% 4.87%			Total Defective Pcs's x 100 / Total garments Inspected =			4.87%			Defective Pcs's %	

[Signature]
SUPERVISOR
[Signature]
QC EXECUTIVE
[Signature]
TECHNICIAN
[Signature]
ACM/QM

900 PCS
 41 = 900

Fig: Line Inspection Report 16

Sewing inspection report of 04-01-2023. Here shows all defect after sewing. Per hour fault are recorded in this sheet and analysis how to reduce those faults by using those data.

3.17.2 Data Table

JM Fabrics Ltd. Hourly DHU REPORT

Date: 04-01-2023

Order:

Style: A4A3N

Buyer: GYMSHARK

Sewing Line: 15

Floor: 2nd

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam			1				1				2
Broken Stitch	1	2	1		2			2			8
Skip Stitch			1		1		1				3
Uneven Stitch											
Joint Stitch											
Pleat			1		1		1				3
Poor Joining		2				2		1			5
Needle Hole				1	2						3
Size Mistake											
Dirty Spot				1		2					3
Oil Mark	3	2	2	2		1	1	1			12
Uncut Thread											

Reject							2	1			3
Emb/Print Mistake											
Label Displace											
Rawedge											
Tuck											
Point up down											
Down Stitch											
Puckering											
Scissor Cut	1			1							2
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total Check	50	60	70	120	125	130	220	225			1,000
Total Pass	45	54	64	115	119	125	214	219			859
Total Defective Garments	5	6	6	5	6	5	6	6			44
Total Defect	5	6	6	5	6	5	6	6			45
Total Defect %	10%	10%	8.57%	4.16%	4.17%	3.8%	2.7%	2.7%			4.5%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (45/1000) *100 \%$$

$$=4.5 \%$$

1st Highest Defects =Oil Mark 12 pcs

2nd Highest Defects = Broken Stitch 5 pcs

3rd Highest Defects = Poor joining 5

Total Pieces checked =1,000

Total Defects =45

3.18 Attachment of sewing report

3.18.1 Line inspection report 17:

This report is the property of JM Fabrics Ltd. (New Asia Group) and collected from Sewing floor.


J.M FABRICS LIMITED
QUALITY ASSURANCE DEPARTMENT
QUALITY CONTROL END LINE 100% INSPECTION REPORT (Q.C.E.L.I.R.)

CUSTOMER	G.S	DATE	04.01.20
STYLE No	A2A0H	LINE No	14
COLOR	BLACK		
END LINE QC (Name)	ANIL J		

JMF QC-Sew : 11
 Version No : 002
 Effective Date : 01-11-17
 Revision Date : 19.03.2019

TIME	1st.H	2nd.H	3rd.H	4th.H	5th.H	6th.H	7th.H	8th.H	9th.H	10th.H	Total	%		
RECEIVED QTY →	100	150	150	150	151	150	152	150			1154			
DEFECTIVE Pcs's QTY →	05	07	06	08	07	07	08	06			54	4.67%		
Code	Defect Description													
0	Broken attich										11	0.94%		
1	Print Defect													
4	Component Shading													
6	Pleat										05	0.43%		
7	Fly-In (yam)													
127	Loose Stitch													
129	Damage SKJP										08	0.69%		
130	Wrong Thread Color													
131	Missing Back Tack													
133	Poor Bar Tack													
134	Missing Bar Tack													
135	Uncut Thread										06	0.52%		
136	Poor Joining										04	0.34%		
138	Wrong SPI													
139	Stitch/Tension													
145	Needle Holes													
176	Open Seam										04	0.34%		
177	Raw Edges													
179	Uneven Top Stitch													
182	Puckering													
191	Scissor Cut													
198	Uneven Leg Open													
200	Wrong Bow Position													
217	Uneven Gathering													
247	Incorrect Label													
248	Defective Label													
249	Raw Edge										12	1.03%		
326	Oil Stain													
328	Dirt/Stain													
Measurement OOT											04	0.34%		
OTHERS	REJECT													
TOTAL DEFECTS	05	07	06	08	07	07	08	06			54	4.67%		
PASSED GARMENTS	05	144	145	142	144	143	144	144			1100			
DECLFECT %	SV: 6.63% 4.53% 5.33% 4.63% 4.50% 5.13% 4.1%										4.67%			
TAKEN FOR REPAIR/AFTER REPAIR PASSED	05/05	07/07	06/05	08/08	07/06	07/05	08/07	06/06			50/50			
SUPERVISOR SIGNATURE														
INLINE QC SIGNATURE														
Highest 3 Defect	1st Highest Defect			2nd Highest Defect			3rd Highest Defect							
	RAW EDGE			BROKEN			SKJP			08				
(Total Defects x 100) / Total garments spacted =	DHU%			Total Defective Pcs's x 100 / Total garments Inspected =			Defective Pcs's %					4.67%		

QC PASS-1150



07/01/2020 10:39

Fig: Line Inspection Report 17

3.18.2 Data Table

JM Fabrics Ltd. Hourly DHU REPORT

Date: 04-01-2023

Order:

Style: A2A9H

Buyer: GYMSHARK

Sewing Line: 14

Floor: 2nd

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam		1		1		1		1			4
Broken Stitch	2	1	1	2	1	2	1	1			11
Skip Stitch	1	1	1	1	1	1	1	1			8
Uneven Stitch											
Joint Stitch											
Pleat		1	1	1			2				5
Poor Joining					2			2			4
Needle Hole											
Size Mistake											
Dirty Spot											
Oil Mark											
Uncut Thread	2	1	1			2					6
Reject			1		1		2				4
Emb/Print Mistake											
Label Displace											

Raw edge	2	1	1	2	2	3		1			12
Tuck											
Point up down											
Down Stitch											
Puckering											
Scissor Cut											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total Check	100	150	151	150	151	150	152	150			1,154
Total Pass	95	144	145	142	144	143	144	144			1,100
Total Defective Garments	5	7	6	8	7	7	8	6			54
Total Defect	5	7	6	8	7	7	8	6			54
Total Defect %	5%	4.67%	3.98%	5.33%	4.63%	4.50%	5.26%	4%			4.67%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (54/1,154) *100 \%$$

$$=4.67 \%$$

1st Highest Defects =Raw edge 12 pcs

2nd Highest Defects = Broken Stitch 4 pcs

3rd Highest Defects = Skip Stitch 8

Total Pieces checked =1,154

Total Defects =54

3.19 Attachment of sewing report

3.19.1 Line inspection report 18:

This report is the property of JM Fabrics Ltd. (New Asia Group) and collected from Sewing floor.


J.M FABRICS LIMITED
QUALITY ASSURANCE DEPARTMENT
QUALITY CONTROL END LINE 100% INSPECTION REPORT (Q.C.E.L.I.R.)


CUSTOMER: NEXT		DATE: 04-01-23
STYLE No: U.86-AGZ	LINE No: 10	
COLOR: BURGI		
END LINE QC (Name): NAROL		


JMF QC-Sew : 11
 Version No : 002
 Effective Date : 01-11-17
 Revision Date : 19.03.2019

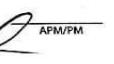
TIME			1st.H	2nd.H	3rd.H	4th.H	5th.H	6th.H	7th.H	8th.H	9th.H	10th.H	Total	%
RECEIVED QTY			100	102	120	150	150	140	360	204			1308	
DEFECTIVE Pcs's QTY			7	10	6	10	10	12	14	16			87	6.65%
Code	Defect Description	OPERATION												
0	Broken stitch	W.LEG											23	1.75%
4	Component Shading													
6	Pleat	WAIST											7	0.53%
7	Fly In (yarn)													
127	Loose Stitch													
129	Damage SKIP	P.W.L											19	1.45%
130	Wrong Thread Color													
131	Missing Back Tack													
133	Poor Bar Tack													
134	Missing Bar Tack													
135	Uncut Thread	ALLBODY											14	1.07%
136	Poor Joining	HEM.W											6	0.45%
138	Wrong SPI													
139	Stitch Tension													
145	Needle Holes													
176	Open Seam	WAIST											9	0.68%
177	Raw Edges													
179	Uneven Top Sttch													
182	Puckering													
191	Scissor Cut													
198	Uneven Leg Open													
200	Wrong Bow Position													
217	Uneven Gathering													
247	Incorrect Label													
248	Defective Label													
249	Raw Edge												6	0.45%
326	Oil Stain	ALLBODY											3	0.22%
328	Dirt /Stain	ALLBODY											3	0.22%
Measurement OOT													8	0.61%
OTHERS													8	0.61%
TOTAL DEFECTS			7	10	6	10	10	12	14	16			87	
PASSED GARMENTS			93	120	112	140	140	138	386	184			1219	93.35%
DEFECT %			7.1%	8.8%	5%	6.7%	6.7%	8.6%	3.9%	7.8%			6.6%	
TAKEN FOR REPAIR/AFTER REPAIR PASSED			7	10	6	10	10	12	14	16			87	
SUPERVISOR SIGNATURE			[Signatures]											
INLINE QC SIGNATURE			[Signatures]											
Highest 3 Defect			1st Highest Defect: BROKEN STITCH			2nd Highest Defect: SKIP STITCH			3rd Highest Defect: UNCUT THREAD			14		
(Total Defects x 100) / Total garments spacted =			DHU%			(Total Defective Pcs x 100) / Total garments Inspected =			Defective Pcs's %					

O.C. PASS = 1300/-


 SUPERVISOR


 QC EXECUTIVE


 TECHNICIAN


 APM/PM



 AQM/QM

Fig: Line Inspection Report 18

3.19.2 Data Table

JM Fabrics Ltd. Hourly DHU REPORT

Date: 04-01-2023

Order:

Style: U.86-467

Buyer: NEXT

Sewing Line: 10

Floor: 2nd

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam	1	3		3		1	1				9
Broken Stitch	3	4	2	4	4	1	2	3			23
Skip Stitch	1		2	1	4	5	3	3			19
Uneven Stitch											
Joint Stitch											
Pleat		1	1		1	1		3			7
Poor Joining				2	1		2	1			6
Needle Hole											
Size Mistake											
Dirty Spot		2		3	3						8
Oil Mark		1	1		2	2					6
Uncut Thread	2	1	1			5	2	3			14
Reject		2		3	3						8
Emb/Print Mistake											
Label Displace											

Raw edge											
Tuck											
Point up down											
Down Stitch											
Puckering											
Scissor Cut											
Button Hole											
Improper Shade											
Slanted											
Twisting											
Others											
Total Check	100	132	120	153	153	150	420	200			1,308
Total Pass	33	120	112	140	140	138	386	184			1,253
Total Defective Garments	7	10	8	10	10	12	14	16			87
Total Defect	7	10	8	10	10	12	14	16			87
Total Defect %	7%	7.5%	6.67%	6.5%	7.2%	8%	3.3%	8.6%			6.65%

$$\begin{aligned}
\text{DHU\%} &= (\text{Total No of Defect} / \text{Total no of Checked Product}) * 100 \\
&= (87 / 1,308) * 100 \% \\
&= 6.65 \%
\end{aligned}$$

1st Highest Defects = Broken Stitch 23 pcs

2nd Highest Defects = Skip Stitch 19 pcs

3rd Highest Defects = Uncut Thread 14 pcs

Total Pieces checked = 1,308

Total Defects = 87

3.20 Attachment of sewing report

3.20.1 Line inspection report 19:


This report is the property of JM Fabrics Ltd. (New Asia Group) and collected from Sewing floor.


J.M FABRICS LIMITED
 South Nayapara, 6 No. Dogri, Bhawal, Mirzapur, Gazipur
 QUALITY ASSURANCE DEPARTMENT
 QUALITY CONTROL END LINE 100% INSPECTION REPORT (Q.C.E.L.I.R.)


CUSTOMER: NEXT		DATE: 4.11.2019	
STYLE No: UG6512		LINE No: 13	
COLOR: YELLOW			
END LINE QC (Name): SABIKUNNAHAR			


JMF QC-Sew : 11
 Version No : 002
 Effective Date : 01-11-17
 Revision Date : 19.03.2019

TIME		1st.H	2nd.H	3rd.H	4th.H	5th.H	6th.H	7th.H	8th.H	9th.H	10th.H	11th.H	12th.H	Total	%
RECEIVED QTY →		100	101	100	102	100	200	202	208					1733	
DEFECTIVE Pcs's QTY →		5	9	4	10	7	6	10	14					65	5.74%
Code	Defect Description OPERATION														
0	Broken stitch WAIST	1		11				11	11					22	0.92%
1	Print Defect														
4	Component Shading													4	0.25%
6	Pleat L.P.W	1			1				11					14	0.81%
7	Fly in (yarn)													16	0.92%
127	Skip Stitch L.H.W.P	11	11	11		11	11	11	11					110	6.32%
129	Damage														
130	Wrong Thread Color													10	0.58%
131	Sharing WAIST				11	1	11		11						
133	Poor Bar Tack														
134	Missing Bar Tack													5	0.45%
135	Uncut Thread ALL BODY		11			11									
136	Poor Joining														
138	Wrong SPI														
139	Wavy														
145	Needle Holes				11									2	0.25%
176	Open Seam IN SEAM													4	0.35%
177	Raw Edges								11						
179	Uneven Top Stitch WAIST		1		1										
182	Puckering														
191	Scissor Cut														
198	Uneven Leg Open														
200	Wrong Bow Position														
217	Uneven Gathering														
247	Incorrect Label														
248	Defective Label														
249	Raw Edge ALL BODY		11				1	11						6	0.56%
326	Oil Stain ALL BODY		1				1							2	0.25%
328	Dirt/Stain ALL BODY		1				1								
	Down Stitch														
	Measurement OOT													5	0.45%
	OTHERS REJECT													25	1.52%
	TOTAL DEFECTS	5	9	4	10	7	6	10	14					106	6.10%
	PASSED GARMENTS	95	92	96	92	93	194	192	194					1627	
	DEFECT %	5%	9%	4%	10%	7%	6%	10%	14%					6.10%	
	TAKEN FOR REPAIR/AFTER REPAIR PASSED	5	9	4	10	7	6	10	14					106	6.10%
	SUPERVISOR SIGNATURE	[Signatures]													
	INLINE QC SIGNATURE	[Signatures]													
	Highest 3 Defect	1st Highest Defect		2nd Highest Defect		3rd Highest Defect									
		SKIP		Broken		Skirt									
	(Total Defects x 100) / Total garments spacted = 5.74% DHU%	(Total Defective Pcs's x 100) / Total Garments Inspected = 6.10%													


 SUPERVISOR


 QC EXECUTIVE


 TECHNICIAN


 APM/PM



 AQM/QM

Fig: Line Inspection Report 19

3.20.2 Data Table

JM Fabrics Ltd. Hourly DHU REPORT

Date: 04-01-2023

Order:

Style: U86512

Buyer: NEXT

Sewing Line: 13

Floor: 2nd

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam				2							2
Broken Stitch	1		2				3	5			22
Skip Stitch	3	2	2		3	2	2	2			16
Uneven Stitch	1		1		2						4
Joint Stitch											
Pleat	1			1				2			4
Poor Joining											
Needle Hole											
Size Mistake											
Dirty Spot		1				1					2
Oil Mark		2				1	3				6
Uncut Thread		2			3						5
Reject		1		2		2					5
Emb/Print Mistake											
Label Displace											

Raw edge											
Tuck											
Point up down											
Down Stitch											
Puckering											
Scissor Cut											
Sharing				4	1	2		3			10
Improper Shade											
Slanted											
Twisting											
Others											
Total Check	100	101	100	102	100	200	202	228			1,133
Total Pass	5	92	96	92	93	194	192	214			1,068
Total Defective Garments	5	9	4	10	7	6	10	14			65
Total Defect	5	9	4	10	7	6	10	14			65
Total Defect %	5%	8.9%	4%	9.8%	7%	3%	4.95%	4.4%			5.8%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (65/1,133) *100 \%$$

$$=5.8 \%$$

1st Highest Defects =Skip Stitch 16 pcs

2nd Highest Defects = Broken Stitch 11 pcs

3rd Highest Defects = Sharing 10

Total Pieces checked =1,133

Total Defects =65

3.21 Attachment of sewing report

3.21.1 Line inspection report 20:


This report is the property of JM Fabrics Ltd. (New Asia Group) and collected from Sewing floor.


J.M FABRICS LIMITED
 QUALITY ASSURANCE DEPARTMENT
 QUALITY CONTROL END LINE 100% INSPECTION REPORT (Q.C.E.I.R.)


CUSTOMER: <u>G.S</u>		DATE: <u>04.01.20</u>
STYLE No: <u>ALASX</u>		LINE No: <u>12</u>
COLOR: <u>BLACK</u>		
END LINE QC (Name): <u>SABHA SULTANA</u>		


JMF QC-Sew : 11
 Version No : 002
 Effective Date : 01-11-17
 Revision Date : 19.03.2019

TIME			1st.H	2nd.H	3rd.H	4th.H	5th.H	6th.H	7th.H	8th.H	9th.H	10th.H	Total	%
RECEIVED QTY →						20	60	40	20	11			251	
DEFECTIVE Pcs's QTY →						3	3	2	2	1			10	4.97
Code	Defect Description	OPERATION												
0	Broken stitch	Hw/TP				1							1	0.49
1	Print Defect													
4	Component Shading													
6	Pleat	AP/TP											1	0.49
7	Fly in (yam)		1			1								
127	Loose Stitch													
129	Damage													
130	Wrong Thread Color													
131	Missing Back Tack													
133	Poor Bar Tack													
134	Missing Bar Tack													
135	Uncut Thread	ALL PROCESS												
136	Poor Joining													
138	Wrong SPI													
139	Stitch Tension													
145	Needle Holes													
176	Open Seam													
177	Raw Edges													
179	Uneven Top Stitch													
182	Puckering													
191	Scissor Cut													
198	Uneven Leg Open													
200	Wrong Bow Position													
217	Uneven Gathering													
247	Incorrect Label													
248	Defective Label													
249	Raw Edge													
326	Oil Stain	ALL Body				1	1	11	1	1			5	2.98
328	Dirt /Stain	ALL Body				1	11						3	1.49
Measurement OOT														
OTHERS														
TOTAL DEFECTS						3	3	2	4	1			10	4.97
PASSED GARMENTS						67	57	38	19	10			191	100.00
DEFECT %						4.28	5.26	5.26	5.26	9.09				
TAKEN FOR REPAIR/AFTER REPAIR PASSED						03	03	02	01	02			10	20
SUPERVISOR SIGNATURE														
INLINE QC SIGNATURE														
Highest 3 Defect			1st Highest Defect			2nd Highest Defect			3rd Highest Defect					
			Oil Spot			Dirt Spot			Broken Stitch			1		
(Total Defects x 100) / Total garments spaced =			4.97			DHU%			(Total Defective Pcs's x 100) / Total garments inspected =			10	Defective Pcs's %	
			4.97						10			4.97		


 SUPERVISOR


 QC EXECUTIVE


 TECHNICIAN


 APM/PM



 AQM/QM

Fig: Line Inspection Report 20

3.21.2 Data Table

JM Fabrics Ltd. Hourly DHU REPORT

Date: 04-01-2023

Order:

Style: U86512

Buyer: NEXT

Sewing Line: 13

Floor: 2nd

Defects Code	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Open Seam											1
Broken Stitch				1							
Skip Stitch											
Uneven Stitch											
Joint Stitch											
Pleat				1							1
Poor Joining											
Needle Hole											
Size Mistake											
Dirty Spot				1	2						3
Oil Mark					1	2	1	1			5
Uncut Thread											
Reject											
Emb/Print Mistake											
Label Displace											

Raw edge											
Tuck											
Point up down											
Down Stitch											
Puckering											
Scissor Cut											
Sharing											
Improper Shade											
Slanted											
Twisting											
Others											
Total Check				70	60	40	20	11			201
Total Pass				67	57	38	19	10			191
Total Defective Garments				3	3	2	1	1			10
Total Defect				3	3	2	1	1			
Total Defect %				4.3%	5%	5%	5%	9.09%			4.77%

DHU% = (Total No of Defect/Total no of Checked Product) *100

$$= (10/201) * 100 \%$$

$$= 4.77 \%$$

1st Highest Defects = Oil Mark 5 pcs

2nd Highest Defects = Dirty Spot 3 pcs

3rd Highest Defects = broken Stitch 1

Total Pieces checked = 201

Total Defects = 10

Chapter 4

Result and Discussion

4.1 Result with chart

Line inspection reports” are taken from Knit Concern group and JM Fabrics Ltd. From this report we came to know about defect percentage with production hours. But the chart is made to identify which defect is most in that product on a specific day. It’s noted that all the defects are not included. Only most occurred defects are mentioned.

4.2 Sewing Garment Inspection Report (Knit Concern Group)

Report No./ Checked Pieces	Report 1	Report 2	Report 3	Report 4	Report 5	Report 6	Report 7	Report 8	Report 9	Report 10	Report 11	Report 12	Report 13	Report 14	Total	Defect (%)
Defects	1122	1866	1651	883	1997	1155	1804	1967	794	2150	1558	1001	1636	1765	21349	8.83%
Broken stitch	11	4	6	1	19	12	26	10	7	21	25	7	25	23	197	10.45%
Pleat	2	2	2		9	24	5	8	8	12		12	5	16	105	5.57%
Open seam	5	4		8	9	12	4		4	11	14	25		6	102	5.41%
Point up down		14		2		2									18	0.95%
Reject		4	4	9	13	6	9	5	3	13	1	6	14	4	91	4.83%
Puckering	2	12													14	0.74%
Uneven stitch	5			24		28	7		10						74	3.93%
Needle Hole			6												6	0.32%
Skip stitch	4	15		8	11	3	24	9	3	10	7	7	13	29	143	7.59%
Raw Edge	8	14	13	16	15	7	10	16	5	14	17	5	8		148	7.85%
Oil mark	12						8	37	7					4	68	3.61%
Joint Stitch		12	10	3	21	11	10		12	21	15	22	1	17	155	8.22%
Uncut thread	28	37	78	39	41	41	32	40	20	35	26	33	40	33	523	27.75%
Dirty spot	3	34	9	30		23	14	1	3		2	3	6	3	131	6.95%
Other		31	23	7							10	33	3	3	110	5.84%
Total	80	152	128	140	138	169	149	126	82	137	107	120	112	135	1885	100%

4.3 Sewing Garment Inspection Report (JM Fabrics Ltd.)

Report No./ Checked .pcs	Report1	Report2	Report3	Report4	Report5	Report 6	Total	Defect (%)
Defects	624	1,000	1,154	1,308	1,133	201	5,420	6.07%
Broken stitch		8	11	23	22		64	19.45%
Pleat	6	3	5	7	4	1	26	7.90%
Open seam	6	2	4	9	2	1	24	7.29%
Reject		3	4	8	5		20	6.08%
Uneven stitch					4		4	1.22%
Poor Joining		5	4	6			15	4.56%
Skip stitch	19	3	8	19	16		65	19.76%
Raw Edge			12				12	3.65%
Oil mark	15	12		6	6	5	44	13.37%
Uncut thread	14		6	14	5		39	11.85%
Dirty spot		3		8	2	3	16	4.86%
Total	60	39	54	100	66	10	329	100%

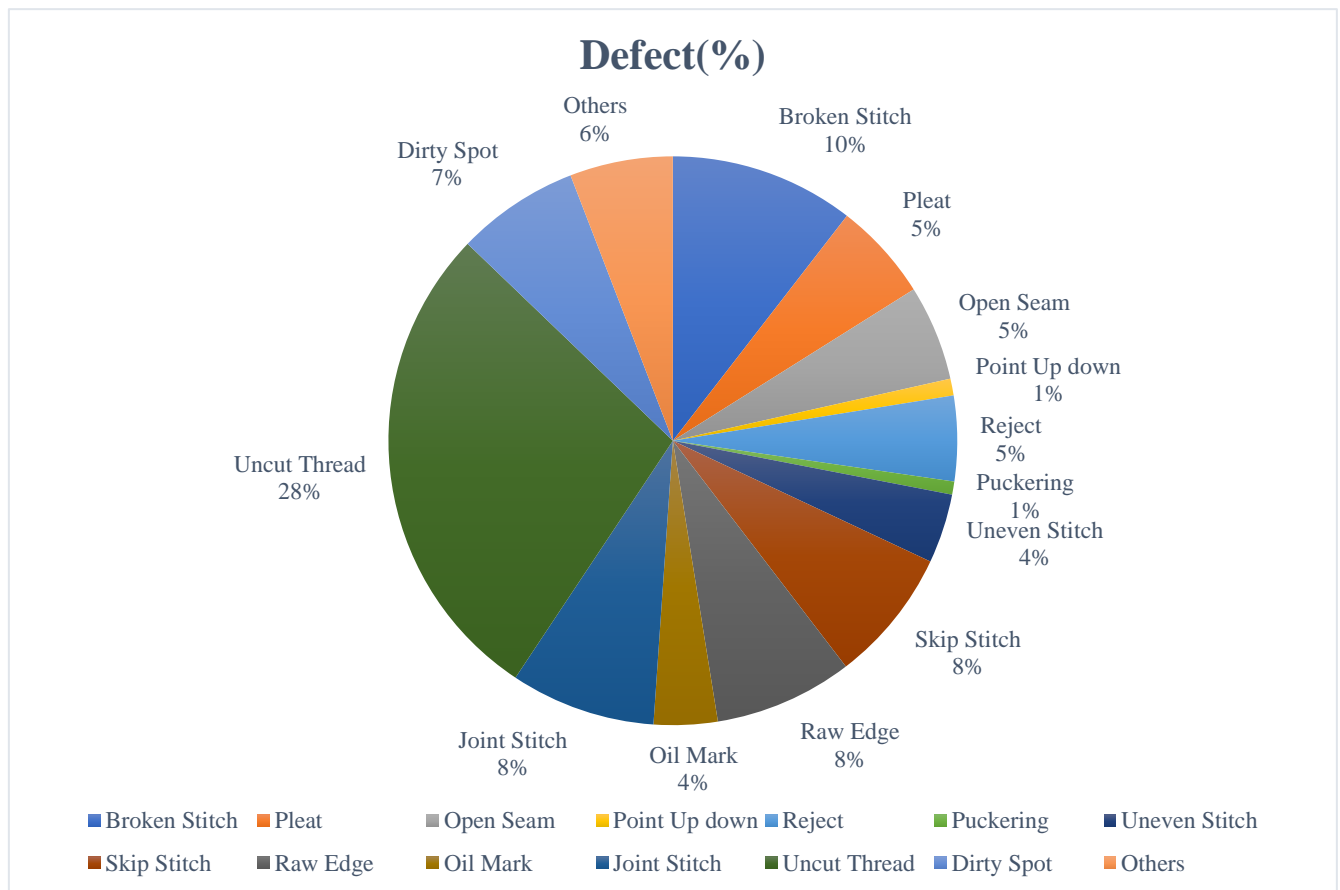
4.4 Intensity Wise Defect (Knit Concern Group)

Defects	Percentage
Uncut Thread	27.75%
Broken Stitch	10.45%
Joint Stitch	8.22%
Raw Edge	7.85%
Skip Stitch	7.59%
Dirty Spot	6.95%
Others	5.84%
Pleat	5.57%
Open Seam	5.41%
Reject	4.83%
Uneven Stitch	3.93%
Oil Mark	3.61%
Point Updown	0.955%
Puckering	0.74%
Needle Hole	0.32%
Total	100%

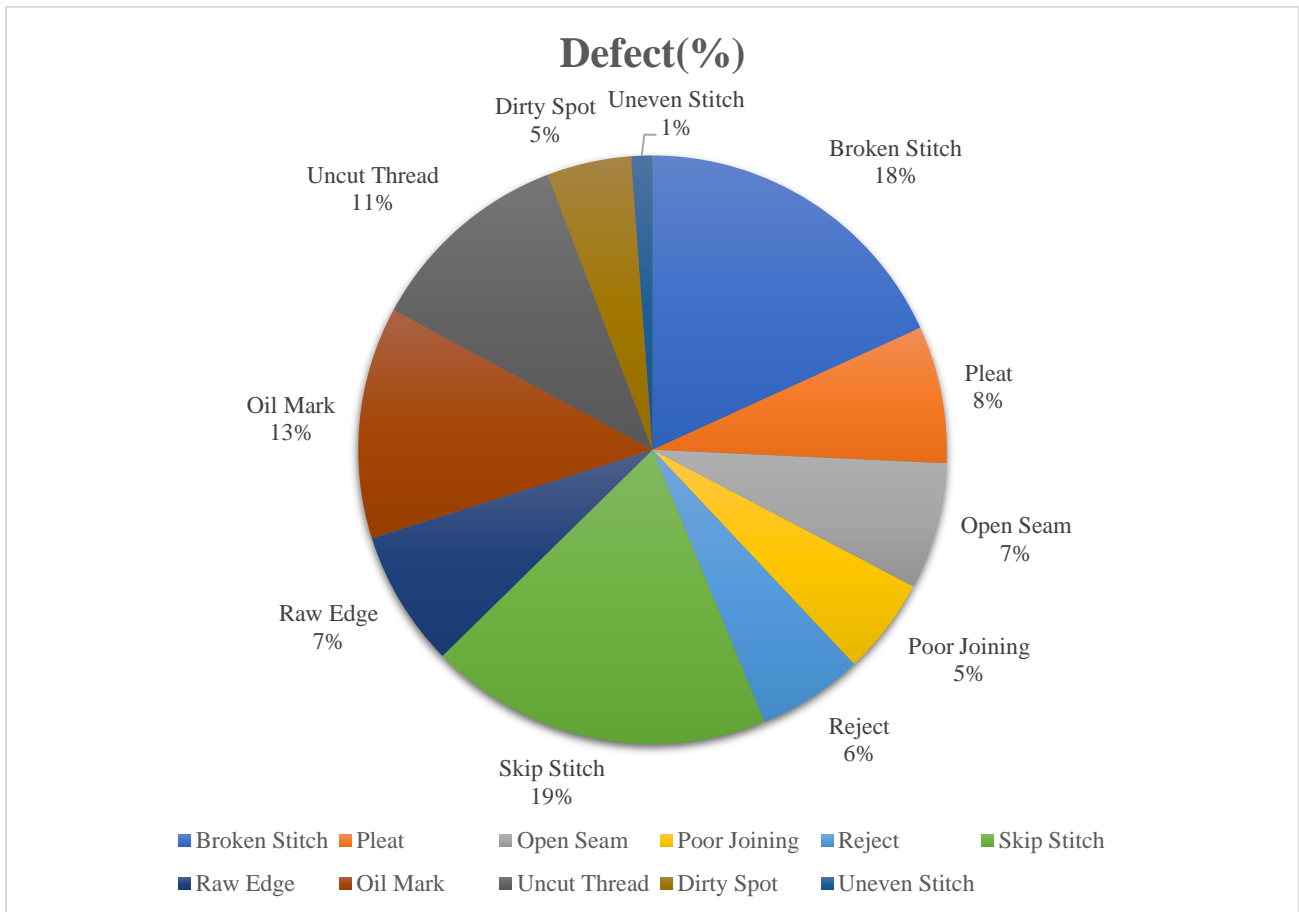
4.5 Intensity Wise Defect (JM Fabrics Ltd)

Defects	Percentage
Skip Stitch	19.76%
Broken Stitch	19.45%
Oil Mark	13.37%
Uncut Thread	11.85%
Pleat	7.90%
Open Seam	7.29%
Reject	6.08%
Dirty Spot	4.86%
Poor Joining	4.56%
Uneven Stitch	1.22%
Total	100%

4.6 Sewing Garments inspection report as Pie chart 1 (Knit Concern Group)



4.7 Sewing Garments inspection report as Pie chart 2 (JM Fabrics Ltd.)



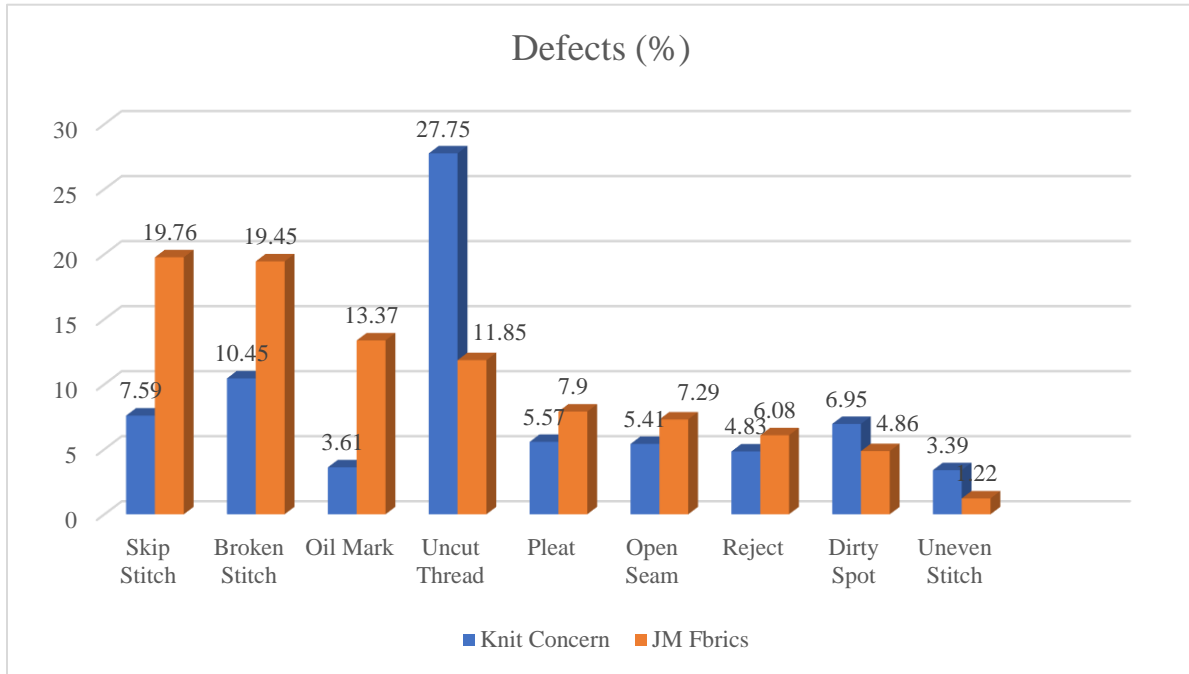
4.8 Description of Pie Charts

These pie charts are showing visual presentation of defect percentage from Knit Concern Group and JM Fabrics Ltd. From chart 1 and 2 we get a visual idea about amounts of defects. It should be mentioned that pie chart is showing full number as percentage, not fractional number.

On first pie chart from Knit Concern Group, here we can see uncut thread was first according to occurred defects and it was 28% among all defects. Then broken stitch is in second place with around 10% of defects. Skip Stitch, Joint Stitch and raw edge were almost same by percentage of 8%. After that we have seen dirty spot were about 7% of total defects. Pleat, Open seam and reject were 5% of total defects. Uneven Stitch and Oil mark were 4% of total defects. There were 1% of Puckering. And others defects were 6% of total amount.

On second chart, from JM Fabrics Ltd. We can see Skip Stitch was most in percentage about 19% of total defects. Broken Stitch was around 18% and second in place. Then we had Oil mark that was about 13% of Total defect amount. Uncut Thread is in top list with 11% of defects. Pleat was 8% of total defects. Open Seam and Raw edge were equally 7% of Total defects. Among all defects reject were 6%. Dirty spot and poor joining was about 5%. Around 1% of defects were uneven stitch

4.9 Comparative Defect Chart



Broken Stitch: (10.45% in Knit Concern Group & 19.45% in JM Fabrics Ltd.)

In the event that any lines are broken after sewing, it is referred to as a broken line.



Fig: Broken Stitch

Causes:

- i. This sort of flaw is happened as a result of lower quality thread
- ii. High string pressure during sewing
- iii. Poor Garments washing process Seam failure.
- iv. Uneven Washing process.
- v. This type of faults is occurred because of low quality thread.
- vi. High thread tension.
- vii. Garments Washing process.
- viii. Seam failure.
- ix. It appears due to improper trimming or machine usage.

Remedies:

- i. Needle plate, presser foot and feed dog should be checked periodically for damages.
- ii. Tension and threading should not be fiddled with much.
- iii. Proper trimming.
- iv. Make sure the nature of sewing thread
- v. Make sure the sewing thread quality.
- vi. Make sure better sewing Process
- vii. Monitoring the washing procedure, process durations, and temperatures to ensure they are impeccable with the goal that the most ideal article of clothing quality can be achieved.

Skip Stitch: (7.59% in Knit Concern Group & 19.45% in JM Fabrics Ltd.)

They occur when the machine's bobbin or circled cannot place the circle in the needle string. Lock line machine prompts used for shoe fastening produce a hole in the crease and a hideous appearance in the top sewing. Therefore, the defect is characterized as a skipped line when a fastener hole or missing line develops.



Fig: Skip Stitch

Causes:

- i. It appears due to improper handling of cut pieces or machine usage.
- ii. Improper sewing strain in the needle.
- iii. Failure of needle to enter circle at legitimate time.
- iv. Deflection of needle or twisted needle.
- v. Thread circle disappointment because of broken needle size for string size.
- vi. Failure of hook or looper and needle to enter loop at correct time.
- vii. Irregular thread tension on upper or lower loop.
- viii. If needle thread loop size is too small.
- ix. When flagging of fabrics is happened during sewing.

Remedies:

- i. Placing of needle properly.
- ii. Needle size & thread size must be adjusted.
- iii. The pressure of pressure foot must be adjusted accurately.

- iv. Check the needles is embedded and adjusted correctly.
- v. Proper machine freedom and timings
- vi. Replace the needle
- vii. Re altering the string tension
- viii. Examine the setting and timing between needle and hook or lopper.
- ix. The tension of thread should be adjusted.
- x. Needle size and thread should be adjusted.

Oil Mark: (3.61% in Knit Concern Group & 13.37%in JM Fabrics Ltd.)

When an oil stain appears on a fabric's surface, it contains both oil and wax. The machine oil that is used in machines is where it mostly happens.



Fig: Oil Spot

Causes:

If wax and oil are transferred from the sewing machine to the surface of the garment, an oil stain will result. It creates a terrible spot image on the surface of the clothes items.

Remedies:

A special spray called "Spot lifter" is used to remove oil stains from cloth. A device known as a "spot cleaning machine" first sprays on the spot before blowing air on it.

Joint Stitch: (8.22% in Knit Concern Group)

When joining two pieces of fabric or stitching a hem, there should be a stitch point where the sewing begins and ends. Joint stitch faults are when this joint point is not uniform.



Fig: Joint Stitch

Causes:

- i. For the lack of experience or concentration of worker.
- ii. Sometime for the machine problem.

Remedies:

- i. Seam is open and sewing again correctly.
- ii. If machine measurement problem, then solve it.

Open Seam: (5.41% in Knit Concern Group & 7.29% in JM Fabrics Ltd.)

The term "open seam" refers to a seam line that has gaps in it, has lost its thread, or both. It's one of the most prevalent sewing flaws.



Fig: Open Seam

Causes:

- i. Improper handling of the parts of garments.
- ii. Improper setting and timing between needle and looper or hook.
- iii. Needle diversion during sewing.
- iv. Thread circle disappointment during sewing.
- v. Incorrect sewing strain in the needle during sewing.
- vi. Flagging of texture because of poor control of presser foot.
- vii. It's basically mechanical problem.
- viii. Failure of needle to enter loop.
- ix. Needle deflection.

Remedies:

- i. Clear markings for stitch line.
- ii. Proper setting and timing between needle and looper or hook.
- iii. Tension should be quantifiable.
- iv. Check needles is inserted and aligned correctly Replace the needle.
- v. Re adjusts the thread tension.
- vi. Reset to standard and check loop formation through jog mechanism.
- vii. Re adjusts presser foot pressure.
- viii. Check needles is embedded and adjusted effectively supplant the needle.
- ix. Re altering the string pressure before sewing.
- x. Reset to standard and check circle arrangement through run mechanism Re alters presser foot weight before sewing.

Raw Edge: (7.85% in Knit Concern Group & 3.65% in JM Fabrics Ltd.)

Raw edge problem is a problem that occurs when unexpected elements of the clothing from the sewing region are visible.



Fig: Raw edge

Causes:

- i. Due to the employee's inexperience or lack of focus.

Remedies:

- ii. The unexpected section is precisely removed.
- iii. Restart stitching after opening and clearing the seam.

Uneven Stitch: (3.93% in Knit Concern Group & 1.22% in JM Fabrics Ltd.)

Uneven stitch is referred to as any seam line that is not straight, any two lines of stitching that are not parallel, or any seam where the real measurements are lacking.



Fig: Uneven Stitch

Causes:

- i. For the lack of experience or concentration of worker.
- ii. Sometime for the machine problem.

Remedies:

- i. Seam is open and sewing again correctly.
- ii. If machine measurement problem, then solve it.

Seam Puckering:

Puckering is the appearance of wrinkles along a crease line in a texture that is ideal. It is one of the flaws that frequently occurs. Puckering makes it appear as if there is an excessive amount of cloth and not enough string in the crease and as if the string is drawing the crease in. This is the reason why sewing thread is frequently blamed for puckering, albeit there are other causes for puckering's publicization as well.

Puckering may be seen after the sewing is complete, although some instances may appear after the garment has been washed or ironed. It is commonly believed that stitching on a textile always results in some degree of fabric mutilation or puckering. Texture from fake strands typically exhibits up puckering. A puckering is a common sewing issue that has been thoroughly investigated by scientists, who have identified 5 causes. When a seam gathers either immediately after sewing or after laundering, it creates an unattractive seam appearance.



Fig: Seam Puckering

Causes:

- i. Uneven stretching on to plies of fabric during sewing.
- ii. Improper thread tension.
- iii. Uneven extending on to utilizes of texture during sewing.
- iv. Wrong string tension.
- v. Wrong choice of sewing thread.
- vi. Dimensional flimsiness of the employs of texture.
- vii. Extension of sewing thread.
- viii. Fabric construction.
- ix. Mismatched patterns.
- x. Sewing threads shrinkage.
- xi. Fabric dimensional instability.
- xii. Variable an uneven stretch on fabric.

Remedies:

- i. Feed dog, eyelets and thread guides should be checked periodically for damages.
- ii. Machine feed mechanism must be better quality.
- iii. Feed canine, eyelets and string aides ought to be checked periodically.
- iv. Worker training.
- v. Tension, SPI and presser foot weight ought not to be tinkered with more.
- vi. Needle, string, texture blend ought to be well judged.
- vii. Properly select the sewing string.
- viii. Proper feed mechanism should be used with equal ply stretch.
- ix. Fabric shrinkage property must be almost equal.
- x. Fabric and sewing thread shrinkage% should be equal.
- xi. Using less tension to the thread.

Chapter 5

Conclusion

A report, combination of twenty DHU report is not enough to find out all the defects. As this study has been done in two different industries so we are hopeful about these two industries. We have listed some common defects those are regular in both industries. At Knit Concern Group we have found Uncut Thread 27.75%, Broken Stitch 10.45% Joint Stitch 8.22%, Raw Edge 7.85%, Skip Stitch 7.59%, Dirty Spot 6.95%, Others 5.84%, Pleat 5.57% , Open Seam 5.41%, Reject 4.83%, Uneven Stitch 3.93%, Oil Mark 3.61%, Point Up down 0.955%, Puckering 0.74% and Needle Hole 0.32%. Report collected from JM Fabrics Ltd. Showed defect percentage following amount Skip Stitch 19.76% Broken Stitch 19.45%, Oil Mark 13.37%, Uncut Thread 11.85%, Pleat 7.90%, Open Seam 7.29%, Reject 6.08%, Dirty Spot 4.86%, Poor Joining 4.56% and Uneven Stitch 1.22%.

Most of these defects are solvable by doing the process twice or well set up of machines. Some are critical and not solvable. These garments are considered as reject item. Most of the time we have seen uncut thread is present, it's easily solvable while on quality inspection table. Skip stitches go through re-process. It's very common, have oil and dirty spot. In this study we focused on defects percentage. Most amounts of defects per hundred checked garments are considered as most occurred defects. This study is not an overall guide for all types of knit items. We had some basic items like t-shirt, hoodie and pants. To ensure best quality these defects must be taken seriously for some basic knit garments item. Finally, with many limitations this study is presenting some sewing defects from Knit Concern Group and JM Fabrics Ltd.

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