



Faculty of Engineering
Department of Textile Engineering

Study on Quality Control of Different Types of
Garments in the Finishing Section

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A thesis submitted in partial fulfillment of the requirements for the degree of
Bachelor of Science in Textile Engineering.

Advance in Apparel Manufacturing Technology

February, 2023

LETTER OF APPROVAL

March 1, 2023

To

The Head

Department of Textile Engineering

Daffodil Smart City, Birulia-1216

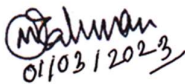
Subject: Approval of Industrial Attachment Report of B.Sc. in TE Program

Dear Sir

I am just writing to let you know that this report titled as “**Study on Quality Control of Different Types of Garments in the Finishing Section**” has been prepared by the student bearing ID: 191-23-5597 and ID: 191-23-5565 is completed for final evaluation. The whole report is prepared based on the factory data with required belongings. The students were directly involved in their industrial attachment activities and the report become vital to spark of many valuable information for the readers.

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

Yours Sincerely



Md. Mominur Rahman

Assistant Professor


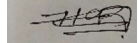
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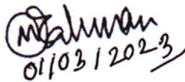
DECLARATION

We hereby declare that the work which is being presented in this report entitled, “**Study on Quality Control of Different Types of Garments in the Finishing Section**” is original work of our own, has not been presented for a degree of any other university and all the resource of materials uses for this thesis have been duly acknowledged.

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

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-The Author

ABSTRACT

A product's quality refers to its ability to satisfy client needs. Quality control of different types of garments in finishing section means the quality that ensures at the finishing procedures in various garment. The main factors affecting the quality of the finishing sector include the management of the clothing industry, skilled workers, supplies, machines, finishing techniques, and competent operators. Many factories in our nation maintain various sorts of finishing quality control systems. The quality control of several garment kinds in the Tusuka Group's finishing unit is covered in this project (thesis). This project uses the finishing section's quality control system. This report offers information on several quality issues and analyses the data for improvements in the finishing section's quality. As consumers are so concerned about product quality, quality is crucial in the RMG industry. We must offer our customers the highest possible product quality if we hope to advance in our industry. In this report, we offer several quality reports for various garments' finishing sections, analyze them, and show them using figures, tables, and charts. We also briefly discuss any issues that have arisen and their fixes. We must produce high-quality goods and adhere to finishing section quality standards if we want the RMG sector to expand. In this report we discussed about various finishing quality such as checking for hourly defects %, lot pass audit records, monthly lot pass defect summary, daily style check, finishing in line inspections, hourly rivet/button check report, hourly label check report, humidity check report, maintaining consistency in measurements, ensuring proper stitching, and proper labeling etc.

Contents

LETTER OF APPROVAL	II
DECLARATION.....	III
ACKNOWLEDGEMENT	IV
ABSTRACT	V
CHAPTER 1: INTRODUCTION.....	1
1.1 Introduction	1
1.2 Origin of the study.....	1
1.3 Objective of the study.....	1
1.4 Scopes.....	2
1.5 Limitations.....	2
CHAPTER 2: LITERATURE REVIEW.....	3
2.1 Introduction	3
2.2 Garment Finishing Section	3
2.3 Quality Control.....	3
2.4 Quality Control in Apparel Industry.....	3
2.5 Quality Control Ingredients	4
2.5.1 Quality of product	4
2.5.2 Quality of process	4
2.6 Benefits and Importance of Quality Control	4
2.6.1 Achieve Buyer or Customer Satisfaction.....	5
2.6.2 Maintaining Good Relations Among All.....	5
2.6.3 Reducing the Rate of Defects and Increasing Production	5
2.6.4 Maintain the Reputation of the Company.....	5
2.7 Machines Used in Finishing Section	6
2.8 Process Flow Chart of Finishing Section	6
2.9 Work Procedure of Finishing Section	6
2.9.1 Finishing Input (color, size and style wise)	6
2.9.2 Thread Sucking	7
2.9.3 Initial Iron	7
2.9.4 Quality Check	7
2.9.5 Sends Body to Get Up Check	7
2.9.6 Body Inspection	7

Study on Quality Control of Different Types of Garments in the Finishing Section

2.9.7 Iron.....	7
2.9.8 Folding.....	7
2.9.9 Accessories Attachment.....	7
2.9.10 Poly.....	7
2.9.11 Cartooning.....	8
2.9.12 Final Inspection.....	8
2.9.13 Shipment.....	8
2.10 List of Major Defects Found in Garment Finishing Section.....	8
CHAPTER 3: SURVEY DETAILS.....	9
3.1 Hourly Defect & Reject % of Finishing.....	9
3.2 Lot Pass Audit Record of Finishing.....	13
3.3 Monthly Lot Pass Defect Summary of Finishing.....	17
3.4 Daily Style Check Report:.....	21
3.5 Finishing In-Line / Pre-Finishing Inspection Report:.....	25
3.6 Hourly rivet/Button check Report:.....	29
3.7 Hourly Label Check Report:.....	33
3.8 Finishing Section Defect Summary:.....	37
3.9: Instand of Defect Summary:.....	41
3.10: Humidity Check Report:.....	45
3.11 Label & Packing Audit Report:.....	47
CHAPTER 4: DISCUSSION OF RESULTS.....	51
4.1: Hourly Defect & Reject % of Finishing.....	51
4.2: Lot Pass Audit Record of Finishing.....	55
4.3: Monthly Lot Pass Defect Summary of Finishing.....	57
4.4: Daily Style Check Report.....	59
4.5: Finishing In-Line / Pre-Finishing Inspection Report.....	60
4.6: Hourly rivet/Button Check Report.....	62
4.7: Hourly Label Check Report.....	64
4.8: Finishing Section Defect Summary.....	66
4.9: Instand of Defect Summary.....	68
4.10: Humidity Check Report.....	70
4.11 Label & Packing Audit Report.....	72
CHAPTER 5: PROFESSIONAL RESPONSIBILITIES, HEALTH, SAFETY, SOCIO-CULTURAL & ENVIRONMENTAL CONSIDERATION.....	73

Study on Quality Control of Different Types of Garments in the Finishing Section

5.1 Codes and Standards Used.....	73
5.2 Ethical Principles and Professional Commitment.....	73
5.3 Impact on Society, Health, Safety, Legal and Cultural Issues.....	74
5.4 Impact on Environment.....	74
CHAPTER 6: CONCLUSION	75
REFERENCE	75

LIST OF TABLE/GRAPH/FIGURE/CHART

Table No.	Title of Table	Page No.
Table: 3.2(a)	Lot Pass Audit Record.	15
Table: 3.2(b)	Lot Pass Audit Record.	17
Table: 3.3(a)	Monthly Lot Pass Defect Summary of Finishing.	19
Table: 3.3(b)	Monthly lot Pass audit	21
Table: 3.4(a)	Process Report	23
Table: 3.4(b)	Process Report	25
Table: 3.5(a)	Defect Classification	27
Table: 3.5(b)	Defect Classification	29
Table: 3.6(a)	Hourly rivet/button check total report	31
Table: 3.6(b)	Hourly rivet/button check total report	33
Table: 3.7(a)	Hourly label check total report	35
Table: 3.7(b)	Hourly label check total report	37
Table: 3.8(a)	Finishing Section Defect	39
Table: 3.8(b)	Finishing Section Defect	41
Table: 3.9 (a)	Instand of Defect	43
Table: 3.9 (b)	Instand of Defect	45
Table: 3.10 (a)	Humidity check report average	46
Table: 3.10 (b)	Humidity check report average	47
Table: 3.11 (a)	Label & packing audit process report	49
Table: 3.11 (b)	Label & packing audit process report	51

Figure No.	Title of Figure	Page No.
Fig: 3.1(a)	Hourly Defect & Reject % of Finishing	9
Fig: 3.1(b)	Hourly Defect & Reject % of Finishing	11
Fig: 3.2(a)	Lot Pass Audit Record of Finishing	13

Study on Quality Control of Different Types of Garments in the Finishing Section

Fig: 3.2(b)	Lot Pass Audit Record of Finishing	15
Fig: 3.3(a)	Monthly Lot Pass Defect Summary of Finishing.	17
Fig: 3.3(b)	Monthly lot Pass audit	19
Fig: 3.4(a)	Daily Style Check Report	21
Fig: 3.4(b)	Daily Style Check Report	23
Fig: 3.5(a)	Pre-Finishing Inspection Report	25
Fig: 3.5(b)	Pre-Finishing Inspection Report	27
Fig: 3.6(a)	Hourly rivet/button check total report	29
Fig: 3.6(b)	Hourly rivet/button check total report	31
Fig: 3.7(a)	Hourly label check total report	33
Fig: 3.7(b)	Hourly label check total report	35
Fig: 3.8(a)	Finishing Section Defect Summary	37
Fig: 3.8(b)	Finishing Section Defect Summary	39
Fig: 3.9 (a)	Instand of Defect Summary	41
Fig 3.9 (b)	Instand of Defect Summary	43
Fig: 3.10 (a)	Humidity check report	45
Fig: 3.10 (b)	Humidity check report	46
Fig: 3.11 (a)	Label & packing audit report	47
Fig 3.11 (b)	Label & packing audit report	49

Chart No.	Title of Chart	Page No.
Chart: 4.1(a)	Types of the defect.	52
Chart: 4.1(b)	Number of the Quality check.	53
Chart: 4.1(c)	Types of the defect.	54
Chart: 4.1(d)	Number of the Quality check.	55
Chart: 4.2(a)	Lot Pass Audit Record.	56
Chart: 4.2(b)	Lot Pass Audit Record.	57
Chart: 4.3(a)	Monthly Lot Pass Defect Summary of Finishing.	58

Study on Quality Control of Different Types of Garments in the Finishing Section

Chart: 4.3(b)	Monthly lot Pass audit.	59
Chart: 4.5(a)	Defect Classification chart.	61
Chart: 4.5(b)	Defect Classification chart.	62
Chart: 4.6(a)	Hourly rivet/button check total report chart	63
Chart: 4.6(b)	Hourly rivet/button check total report chart.	64
Chart: 4.7(a)	Hourly label check total report chart.	65
Chart: 4.7(b)	Hourly label check total report chart.	66
Chart: 4.8(a)	Finishing Section Defect Chart.	67
Chart: 4.8(b)	Finishing Section Defect Chart.	68
Chart: 4.9 (a)	Instand of Defect Chart.	69
Chart: 4.9 (b)	Instand of Defect Chart.	70
Chart: 4.10 (a)	Humidity check report average Chart.	71
Chart: 4.10 (b)	Humidity check report average Chart.	72

CHAPTER 1: INTRODUCTION

1.1 Introduction

The final phase in the apparel industry is finishing. In order to produce a high-quality product, finish the garments, get them ready for shipping, and ultimately deliver them to the buyer of the garments, quality control is required at every stage of the production process. Finishing is thus a crucial step in the manufacturing of clothing. A finishing quality control SOP of the apparel industry is to be established and followed accordingly to assure finishing quality control by the garment manufacturer. Standard Operation Procedure is used here. Ticketing, final quality checking, and garment decorating are all done during the clothing industry's finishing phase.

1.2 Origin of the study

The thesis as a whole is centered on finishing quality control. In this thesis, we'll discuss the finishing process's quality. This thesis explains quality control procedures and reports like hourly defect and reject percentages of finishing, lot pass audit records of finishing, daily lot pass or field data analysis, daily summaries of AQL Audits, monthly lot passed defects summaries of finishing, daily style check reports, summary of needle detection reports, etc. as a result. We will have a better knowledge of the significance of completing quality control at the end of this thesis.

1.3 Objective of the study

The fact that this project represents the entire quality control process used by Tusuka Trousers Ltd. is its most significant feature. We will research the methods they can use to carry out quality control checks in the finishing portion. Hence, the following are the key objectives of this report:

- find out the causes of the finishing garments section problem.
- To solve the problems of finishing garments section.
- To improve the process of quality control section.

1.4 Scopes

The Q.C Managers of Tusuka Trousers Ltd. helped to compile this report. It claims that the procedure of data collecting is rather straightforward. When studying about the "Quality Control in Finishing Section," they are quite helpful. We are incredibly fortunate to have acquired a wealth of in-depth knowledge about quality controls in finishing through discussion, factory visits, and the internet. We have also learned from books and significant articles from the apparel industry.

1.5 Limitations

1. The Quality Manager does not have enough time to provide detailed information.
2. Visit multiple quality sections for a short period of time.
3. It is tough for us to understand everything about quality in finishing within this short time.
4. Company can't provide us with proper data because of the strict rule's regulations about sensitive data

CHAPTER 2: LITERATURE REVIEW

2.1 Introduction

The textile and apparel industries have a huge requirement for quality control. The majority of clothing produced by the textile sector is sent abroad. In that situation, choosing high-quality apparel is crucial. There could be serious issues if there are any mistakes. As a result, there may be a negative relationship between the clothing sector and international consumers. So, ensuring that there are no issues with the apparel is entirely responsible for the problem.

2.2 Garment Finishing Section

In the clothing industry, the finishing department is responsible for pressing, packing, checking, and cleaning the finished products. The quality of the finished product can be enhanced, and orders can be shipped on schedule. The garment finishing sector plays a significant role in garment shipment. By performing operations to show the product in accordance with the needs of the buyer, the finishing section adds value to the product and draws in customers.

2.3 Quality Control

Quality control is the ongoing, regular monitoring of the factors that influence the final product's quality. The process of creating, manufacturing, reviewing, and assessing products to ascertain that they satisfy the required quality level for a company's target market is known as quality assurance. In general, quality control refers to inspecting things for quality after they have been made and divided into acceptable and unacceptable categories. Companies who solely consider quality in terms of quality control and do not adopt a quality assurance system incur costs.

2.4 Quality Control in Apparel Industry

It organized, gathering raw data, investigating it, and putting it into practice. Several control forms are used in the quality control process to monitor the control at different stages of the garment production process. This aids in preserving consistency in quality control.

Documentation will regulate further production process monitoring. The stage-by-stage documentation aids in both completing production within the allotted time frame and obtaining the desired quality. The daily application of quality assurance is known as quality control, and success requires extreme initiative at all levels. Quality controllers must become as knowledgeable as possible about every facet of the organization because they will have to communicate with all corporate divisions as well as clients and suppliers. A sort of insurance, investment in quality control aims to stop disasters from happening in the first place rather than waiting for them to occur and then paying out. If done correctly, it keeps your supply chain maintained, serviced, and repaired.

2.5 Quality Control Ingredients

There are two quality control ingredients.

2.5.1 Quality of product

The phrase "quality of product" refers to the product's quality. This category in the textile industry comprises things like Appearance, Fabric, Design, Measuring, Stitching, Cleanliness, Presentation, Safety, Pricing, and Ease of Availability.

2.5.2 Quality of process

Man, Machine, Materials, Method, Procedure, and Money are the components of Process Quality.

2.6 Benefits and Importance of Quality Control

There are several reasons why it is important to regulate the quality of products or services provided by the apparel sector. Listed below are a few of them:

2.6.1 Achieve Buyer or Customer Satisfaction

Customers' demand for garments in this specialty has greatly increased. As a result, not only does consumer demand for the product continue to increase, it also does so. It is possible to do this in order to satisfy the customer. Any industry that produces clothing must prioritize quality control. This makes it possible for the consumer to select the good or service that best suits their requirements and ensures their satisfaction with it.

2.6.2 Maintaining Good Relations Among All

A productive environment is created by quality control in the in the garment sector, quality control fosters a culture where everyone is committed to producing flawless work. Quality control is the process of periodically educating employees, establishing standards for judging the caliber of a good or service, and determining whether there is a major variation in the caliber of the goods or services provided. Hence, it is crucial. The corporation must follow a number of predetermined policies, procedures, or methods on the creation of its unique products or services that are in accordance with international standards while producing a garment product.

2.6.3 Reducing the Rate of Defects and Increasing Production

Customers in the textile business do not accept low-quality goods. There are some things that cannot be exported in the allotted period. When the defect rate is high, the production falls, and it costs more time and money to fix the flaws in low-quality goods. Also, it is unable to ship on time due to poor manufacturing. And as a result of the corporation offering such things, the customer lacks faith in it. By quality control, these issues can be resolved and consumers and buyers' confidence can be increased. Thus, it plays a huge role in the garment sector.

2.6.4 Maintain the Reputation of the Company

By quality control, product quality can be preserved. As a result, the company's reputation is preserved. Clothes are appealing to buyers. On the other side, if the fabric or color quality is poor, the product quality suffers. As a result, the company loses the customer and the demand for the product declines.

2.7 Machines Used in Finishing Section

- ❖ Thread sucker machine
- ❖ Thread Cutter
- ❖ Hand tag Gun
- ❖ Lifter
- ❖ Iron
- ❖ Metal detector
- ❖ Textile cleaning Gun etc.

2.8 Process Flow Chart of Finishing Section

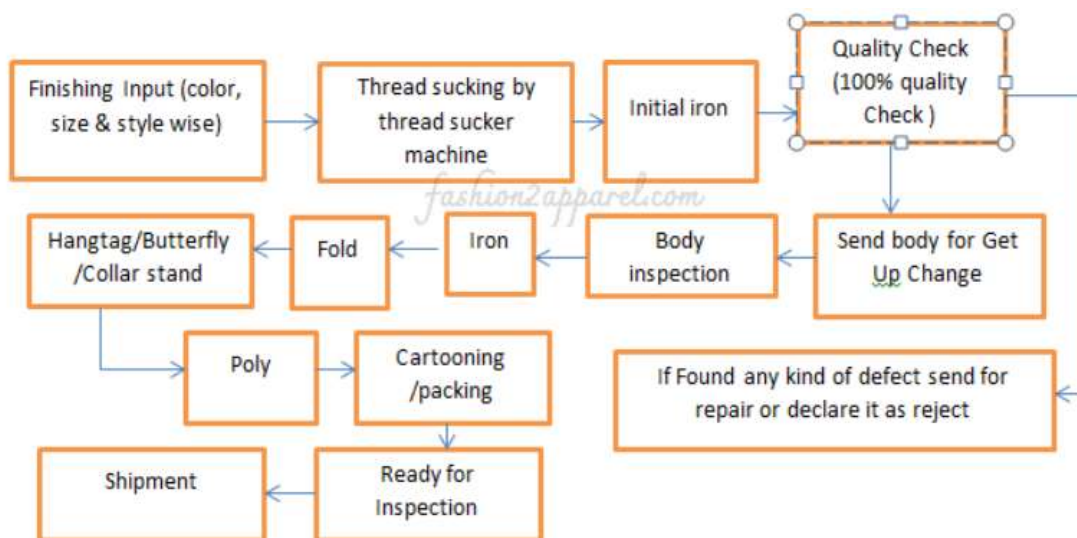


Figure: Process Flow Chart of Finishing Section

2.9 Work Procedure of Finishing Section

2.9.1 Finishing Input (color, size and style wise)

At this stage, the finishing section receives the body as an input from the sewing section according to color, style, or size.

2.9.2 Thread Sucking

To remove loose thread from the body, completing input is brought in contact with a thread-sucking machine in this instance.

2.9.3 Initial Iron

Closing all of the buttons on the clothing and ironing the clothing are done at this stage to make the next step easier.

2.9.4 Quality Check

Here, a quality examination is performed on the body to look for any swing, washing, or other flaws in the clothing. If a fault is discovered, the clothing is either rejected or sent to the repair area. This place has a 100% quality check.

2.9.5 Sends Body to Get Up Check

An inspector checks the clothing to see if it's in good condition at this point.

2.9.6 Body Inspection

A random inspection is performed on a selection of clothing to examine whether the measurements are accurate, whether the quality check was completed correctly, and whether the initial ironing complied with specifications.

2.9.7 Iron

Here, clothes are carefully ironed for folding in accordance with customer preferences.

2.9.8 Folding

The clothing is folded in the direction of the buyer once it has been ironed.

2.9.9 Accessories Attachment

Before the garments are poly, accessories like hang tags, security tags, collar stands, butter flies, and so forth are attached.

2.9.10 Poly

At this stage, clothing is being polymerized to prevent it from dust and to guarantee its safety in the cartoon.

2.9.11 Cartooning

The packing list indicates that after being polymerized, clothing is being cartooned for shipping.

2.9.12 Final Inspection

At this point, buyer's representatives check the clothing based on the AQL label to see if it matches the specification sheet or not.

2.9.13 Shipment

The garment has passed inspection and is prepared for shipping.

2.10 List of Major Defects Found in Garment Finishing Section

- ❖ High / low pockets
- ❖ Buttons, snap defect
- ❖ Button hole raveling, incomplete not cut properly / miss aligned
- ❖ Sizing problem
- ❖ Brand: care or size label missing
- ❖ Shading
- ❖ Wrong color
- ❖ Hole in fabric damage
- ❖ Poorly trimmed garments threads
- ❖ Broken stitches
- ❖ Skipped stitches
- ❖ Open seam
- ❖ Conspicuous repair
- ❖ Poor construction
- ❖ Conspicuous spoilage (inside or outside)
- ❖ Conspicuous abrasion marks from wash process

CHAPTER 3: SURVEY DETAILS

3.1 Hourly Defect & Reject % of Finishing

TUSUKA TROUSERS LTD.
(PREMIUM ZONE)
Neelnagar, Konabari, Gazipur.

TTL/FQA/001

Hourly Defect & Reject % of Finishing

Name of Buyer : <u>H&M</u>	Date : <u>10-09-22</u>
Style No <u>REGULAR LOW PRICE JEANS - SIMON</u>	Line/Unit : <u>F-03</u>
P.O No <u>402019-EG72</u>	Name & Card No of Q.I <u>REZAKUL-807</u>
Order Qty : <u>97.517 PLU</u>	Name of Process <u>REGLET-UP</u>

Name Of Defect	Hour's										TOTAL
	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	
Open Stitch											
Broken Stitch											05
Skip Stitch											02
Join Stitch											
Down Stitch											
Tension Loose											
Uncut Thread											02
Uneven Topstitch											
Looseness Waistband											
Twisting											04
Loop Slanted											
Pocket Hi-Low											
Pocket Gap Up-Down											
Uneven Pocket Opening											
Label Missing											
Wrong Label Placement											
Yoke Hi-Low											
Mouth Close Hi-Low											
Size Mistake											
Rawedge											
Puckering											
Rooping											
Pleat											02
Bartack Missing											
Bartack Wrong Placement											02
Eyelet Hole Missing											
Button Missing											
Rivet Missing											
Shading											
Dirty/Oil Spot											10
Reject/Damage											
Fabrics Hole											

Checked Qty	63	104	53	83	82	73	82	72			612
Passed Qty	60	100	50	80	80	70	80	70			590
Defective Qty	03	04	03	03	02	03	02	02			22
Defect Qty	03	05	03	03	03	03	03	04			27
Defect %											4.41%
Qty Returned to Alteration	1+2	2+2	1+2	2+1	1+1	1+2	1+1	1+1			22
Qty After Alteration	03	04	03	03	02	03	02	02			22
Reject Qty											

Fin. Supervisor			
Fin. Quality Controller			

Quality Controller
 P. Manager
 Q.A Manager
 G. Manager

Fig: 3.1(a) Hourly Defect & Reject % of Finishing

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 405019-5672
Style Number: Regular low-price jeans	Name of Process: Reget. up

Types of defects:

- Broken stitch: 05
- Pleat: 02
- Skip stitch: 02
- Bar tack wrong placement: 02
- Uncut thread: 02
- Oil spot: 10
- Twisting: 04

Total number of quality check:

- Checked quality: 612
- Passed quality: 590
- Defective quality: 22
- Quality return to allowance: 22
- Quality after allowance: 22

Study on Quality Control of Different Types of Garments in the Finishing Section

TUSUKA TROUSERS LTD.
Neelnagar, Konabari, Gazipur.

TTL/FQA/001

Hourly Defect & Reject % of Finishing

Name of Buyer :	H8111	Date	01-09-2022
Style No	KH COINB HWA WIDELEG	Line/Unit	1/E FINISHING
P.O No	399026/39900-8717	Name & Card No of Q.I	399026-874
Order Qty:	39,036 Pcs	Name of Process	WAIST BAND (INSIDE)

Name Of Defect	Hour's										TOTAL
	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	
Open Stitch			1								04
Broken Stitch	1	1	11	11	11	1	11	11			34
Skip Stitch	11	11	11	1	1	11	11	11			34
Join Stitch											
Down Stitch		1		1	1			1			04
Tension Loose											
Uncut Thread		1		1							02
Uneven Topstitch											
Looseness Waistband											
Twisting											
Loop Slanted											
Pocket Hi-Low											
Pocket Gap Up-Down											
Uneven Pocket Opening											
Label Missing											
Wrong Label Placement											
Yoke Hi-Low											
Mouth Close Hi-Low											
Size Mistake											
Rawedge	1	1			1						03
Puckering											
Rooping											
Pleat											
Bartack Missing											
Bartack Wrong Placement											
Eyelet Hole Missing											
Button Missing											
Rivet Missing											
Shading											
Dirty/Oil Spot											
Reject/Damage											
Fabrics Hole											

Checked Qty	285	297	298	289	299	285	299	296			2048
Passed Qty	282	292	295	285	294	282	295	292			2317
Defective Qty	03	05	03	04	05	03	04	04			31
Defect %	04	06	05	05	06	04	05	06			1.1
	1.40%	2.02%	1.76%	1.73%	2.00%	1.40%	1.76%	2.02%			1.74%
Qty Returned to Alteration	2+1	3+2	2+1	2+2	3+2	2+2	2+2	2+2			32
Qty After Alteration	03	05	03	04	05	03	04	04			31
Reject Qty											

Fin. Supervisor		P. Manager	
Quality Controller		Q.A Manager	
		G. Manager	

Fig: 3.1(b) Hourly Defect & Reject % of Finishing

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 39902-8717
Style Number: Rh Collab H.W Wide leg	Name of Process: Waist Band (Inside)

Types of defects:

- Open Stitch: 04
- Broken stitch: 14
- Skip stitch: 14
- Down Stitch: 04
- Uncut thread: 02
- Raw-edge: 03

Total number of quality check:

- Checked quality: 2348
- Passed quality: 2317
- Defective quality: 31
- Quality return to allowance: 31
- Quality after allowance: 31

3.2 Lot Pass Audit Record of Finishing

TUSUKA TROUSERS LTD.
(PREMIUM ZONE)
Korabat, Noida Nagar, Gazipur

TPZ/FQA/002

Lot Pass Audit Record of Finishing

Buyer		H-SM		Unit		03	
Style No		REGULAR LOW PRICE JEAN - SIMON		Section		FINISHING	
Order No		402019-5672		Name of Auditor		MD: RAKIB HOSSAIN	
O/Qty		97,514 Pcs		Date		10-09-2022	
AQL	1.5	Lot Qty	330 Pcs	Sample Qty	20 Pcs	Time	08:54 AM
Comments				Critical		Major	
* NO DEFECT FOUND				00		00	
Total Defect Found				Allowed	Found	Allowed	Found
				00	00	00	00
Result		Fail Return Qty	Rcvd Qty	Sign	Q.I	L/C	Q.C
Pass	Fall		330				
AQL	1.5	Lot Qty	510 Pcs	Sample Qty	32 Pcs	Time	09:51 AM
Comments				Critical		Major	
* SKIP STITCH AT W/B				00		01	
* LEG TWISTING							
Total Defect Found				Allowed	Found	Allowed	Found
				00	00	01	01
Result		Fail Return Qty	Rcvd Qty	Sign	Q.I	L/C	Q.C
Pass	Fall		510				
AQL	1.5	Lot Qty	230 Pcs	Sample Qty	15 Pcs	Time	10:54 AM
Comments				Critical		Major	
* MAIN SIZE LABEL SLANTED				00		00	
Total Defect Found				Allowed	Found	Allowed	Found
				00	00	00	01
Result		Fail Return Qty	Rcvd Qty	Sign	Q.I	L/C	Q.C
Pass	Fall		230				
AQL	1.5	Lot Qty	400 Pcs	Sample Qty	20 Pcs	Time	11:58 AM
Comments				Critical		Major	
* WAIST MOUTH UP DOWN				00		00	
Total Defect Found				Allowed	Found	Allowed	Found
				00	00	00	01
Result		Fail Return Qty	Rcvd Qty	Sign	Q.I	L/C	Q.C
Pass	Fall		400				
Running Analysis							

F. Controller

Fig: 3.2(a) Monthly Lot Pass Defect Summary of Finishing

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Types of defects:

Defect name	Critical	Major	Minor	Total
Skip stitch	0	1	0	1
Leg twisting	0	0	1	1
Main size label slanted	0	0	1	1
Waist mouth up down	0	0	1	1

Table: 3.2(a) Types of defects

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 406435-8717
Style Number: D+W Fancy wide leg CW6	Section: Finishing

Types of defects:

Defect name	Critical	Major	Minor	Total
Small crease mark at body	0	0	1	1
Uncut thread at back part	0	2	0	2
Dirty spot at body	0	1	0	1
Fabric fault at body	0	1	0	1
Small spot at body	0	0	1	1
Without bar-tack at front part	0	1	0	1

Table: 3.2(b) Types of defects

3.3 Monthly Lot Pass Defect Summary of Finishing

Name of Month		FINISHING	
Section		3	
Unit		3	
Date		Name of Defects	
01-09-2021		Open Stc	
02-09-2021		Skip Stc	
03-09-2021		Broken Stc	
04-09-2021		Down Stitch	
05-09-2021		Rawedge	
06-09-2021		Joint Stitch	
07-09-2021		Poor Joint Stitch	
08-09-2021		Ruping	
09-09-2021		Puckerfing	
10-09-2021		Pleat	
11-09-2021		Uneven Stitch	
12-09-2021		Poor Shape	
13-09-2021		Pkt Hi- Low	
14-09-2021		Hi-King	
15-09-2021		Up-Down	
16-09-2021		Pkt Slanted	
17-09-2021		Loop Slanted	
18-09-2021		Loop Missing	
19-09-2021		Bartack Missing	
20-09-2021		Bartack Misplaced	
21-09-2021		Shading	
		Taglin	
		Crease Mark	
		Spot	
		Needle Cut	
		Twising	
		Lyra Breakage	
		Size/Label Mistake	
		Uncut Thread	
		Button & Rivet Missing	
		Button & Rivet Misplaced	
		Fabrics Fault	
		Damage	
		Reject	
		Total Checked Qty	1510
		Total Defect Qty	04
		Total Defective Qty	
		Defect %	
	TOTAL		

TUSUKA TROUSERS LTD (PREMIUM ZONE)
 Neelingar, Kozhikode, Kerala

TTU/ORS/05

100/

Fig: 3.3(a) Monthly Lot Pass Defect Summary of Finishing

Study on Quality Control of Different Types of Garments in the Finishing Section

Types of defects:

Skip stitch: 1	Up-down: 7
Broken stitch: 2	Pkt slanted: 7
Down Stitch: 1	Loop slanted: 10
Poor join stitch: 5	Bar tack misplaced: 3
Puckering: 2	Crease mark: 8
Pleat: 4	Spot: 13
Uneven stitch: 1	Twisting: 4
Poor shape: 6	Size/Label mistake: 6
Pkt Hi--low: 2	Uncut thread: 02
Hi-king: 8	Button & Tivet misplaced: 2
Fabrics fault: 03	

Table: 3.3(a) Types of defects

Study on Quality Control of Different Types of Garments in the Finishing Section

Monthly lot Pass audit:

Lot Quantity	184
Pass Lot Quantity	177
Fail Lot Quantity	7
Pass Lot Quantity (%)	96.2%

Table: 3.3(b) Monthly lot Pass audit

3.4 Daily Style Check Report:

TUSUKA TROUSER LTD.
 (PREMIUM ZONE)
 Konabari, Neelnagar, Gazipur.

DAILY STYLE CHECK REPORT


TTC/FQA/006


BUYER <u>H&M</u>	Section <u>FINISHING</u>
STYLE <u>REGULAR LOWPRICE(SIMON)</u>	Unit <u>03</u>
PO <u>42019-5672</u>	Inspected By <u>MD. FARID</u>
OI/QTY <u>97517 PC</u>	Date <u>23-09-22</u>


S.L	NAME OF PROCESS	OK	PROBLEM	REMARKS
1	Wash Standard (Approval)	✓		
2	Main Label Size Label	✓		
3	Care Label	✓		
4	Barcode/Eancode Label	✗		
5	Badge Label	✗		
6	Zipper	✓		
7	Button	✓		
8	Rivet	✓		
9	Elastick	✗		
10	Eyelet	✗		
11	Drawcord	✗		
12	Print/Embroidery	✗		
13	Size Strip	✗		
14	Hanger	✗		
15	Tag Pin	✗		
16	Leather Patch	✗		
17	Waist Tag	✓		
18	Pocket Flasher	✗		
19	Hang Tag	✓		
20	Plastick Clip	✗		
21	Poly Bag	✓		
22	Poly Sticker	✓		
23	Country Sticker	✓		
24				
25				
26				

COMMENTS :

STYLE TAG IS OK


 F. Controller


 Fin-In-Charge


 P. Manager

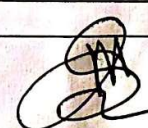

 Q.A Manager

Fig: 3.4(a) Daily Style Check Report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Process Report:

Process needed	Process doesn't needed
Wash standard	Barcode
Main label size label	Badge label
Care label	Elastic
Zipper	Draw cord
Button	Print
Eyelet	Size strip
Rivet	Hanger
Waist tag	Tag pin
Hang tag	Leather Patch
Poly bag	Pocket flasher
Poly sticker	Plastic clip
Country sticker	

Table: 3.4(a) Process Report

TUSUKA TROUSER LTD.
Konabari, Neelnagar, Gazipur.

TTL/FQA/006

DAILY STYLE CHECK REPORT

BUYER	Helen	Section	Finishing
STYLE	Dual Pancy Wide Leg Blk Carpenter	Unit	12
P.O	405435-8717	Inspected By	MD: SAHADUL HOSEIN
O/QTY	22-543 fm	Date	22/09/22

S.L	NAME OF PROCESS	OK	PROBLEM	REMARKS
1	Wash Standard (Approval)			
2	Main Label Size Label	✓		
3	Care Label	✓		
4	Barcode/Eancode Label	✓		
5	Badge Label	✓		
6	Zipper	✓		
7	Button	✓		
8	Rivet	✓		
9	Elastick	✓		
10	Eyelet	✓		
11	Drawcord	✓		
12	Print/Embroidery	✓		
13	Size Strip	✓		
14	Hanger	✓		
15	Tag Pin	✓		
16	Leather Patch	✓		
17	Waist Tag	✓		
18	Pocket Flasher	✓		
19	Hang Tag	✓		
20	Plastick Clip	✓		
21	Poly Bag	✓		
22	Poly Sticker	✓		
23	Country Sticker	✓		
24				
25				
26				

COMMENTS: style is OK


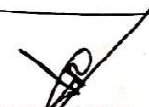
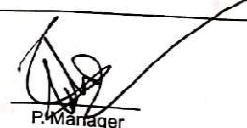

 F. Controller
 Fin. In-Charge
 P. Manager
 Q.A Manager

Fig: 3.4(b) Daily Style Check Report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Process Report:

Process needed	Process doesn't needed
Wash standard	Barcode
Main label size label	Badge label
Care label	Draw cord
Zipper	Print
Button	Size strip
Eyelet	Hanger
Rivet	Leather Patch
Elastic	Pocket flasher
Tag pin	Plastic clip
Waist tag	Poly bag
Hang tag	Poly sticker
	Country sticker

Table: 3.4(b) Process Report

3.5 Finishing In-Line / Pre-Finishing Inspection Report:

TUSUKA TROUSERS LTD.
(PREMIUM ZONE)
Neelnagar, Konabari, Gazipur.

TPZ/FQA/007

Finishing In-Line / Pre-Final Inspection Report

Buyer	H&M	Type of Inspection	Unit	03
Style	SIMON REG	In Line	Inspection Date	03-09-22
Order	402019-5672	Pre-Final	Shipment Date	
O/Qty	97517 Pcs	Final	Inspected By	MD. FARID

Styling and Specification	<input checked="" type="checkbox"/>	Main Fabrics	<input checked="" type="checkbox"/>	Lining	<input checked="" type="checkbox"/>	Pocketing	<input checked="" type="checkbox"/>	Piping	<input checked="" type="checkbox"/>
Approved Wash	<input checked="" type="checkbox"/>	Wash Standard	<input checked="" type="checkbox"/>	Main Label	<input checked="" type="checkbox"/>	Size/Care Label	<input checked="" type="checkbox"/>	Ean/Bar Code	<input checked="" type="checkbox"/>

Defect Classification					
Check Point	Major	Minor	Check Point	Major	Minor
1. Fabrics Defects			4. Trims		
A. Flams/Slub/Hole			A. Label Missing / Insecured/Damaged/		
B. Bowing			Inccrect/Misplaced		
C. Incorrect Weight/Construction			B. Button/Rivet/Eyelet/Zipper/Eyehole		
D. Creases	MARK	1	Missing/Insecured/Incorrect/Misplaced		
E. Shading			C. Drwcord/Drawsting/Missing/Incorrect		
F. Foreign Yarn / Thick Yarn			Length		
G.			D.		
2. Construction & Stitches			5. Wash & Finish		
A. Seam Twisted/Puckered/Pleated			A. Wash not within Standard or Tolerance		
B. Skip/Open/Broken Stitches	BTM	1	B. Wash Shade		
C. Loose/Tight Tension			C. Handfeel		
D. Irregular S.PI			D. Iron Marks/Shining marks/Creas Marks		
E. Overlapping Stitches			E.		
F. Uneven Double Needle Tot Stitches			6. Cleanliness		
G. Needle Hole/Rawedge/Open Seam			A. Dirty Spot/Oil Stain/Soil/Stamp Marks		1
H. High-Low Pocket/ Yoke/Hem		1	B. Uncut Thread/Loose Thread		1
I. Twisting/Torquing			C.		
J. Misalignment			D.		
K. Missing/Displaced/Insecured Bartack			7. Packing Accuracy		
L. Neck/Placket Crooked/Out op Shape			A. Incorrect Information On Poly Bag		
M. Sewing Thread Not Matching			B. Incorrect Folding/Poly Bag Size		
N.			C. Carton Size Out of Spec		
O.			D. Content Incorrect/Incorrect Assortment		
P.			E. Quantity Incorrect		
Q.			F. Incorrect Carton Marks		
R.			G. Poor Carton Quality		
3. Print & Embroidery			8. Measurement		
A. Print/Embroidery Defects			A. Correct		
B. Color Mismatch			B. Incorrect		
C.					
Total Major/Minor Defects	01	02	Total Major/Minor Defects	01	01

Unit Inspected	50 Pcs	G. Total Major / Minor	02 03	AQL Level	1.5	Accepted	2	Rejected	3
Inspected Ctns #	LOOSE GARMENTS INSPECTION.								
Comments	ATTN: (F.IN) (P.M) (R.M) (G.M) & CC @ G.M SIR								
PLS: TACK CARE ABOVE POINT RECTIFY.									

Production Status				Estimate Completion Date		Inspection Result	
Cutting	Sewing	Wash	Carton			Pass	Fail
		LOOSE	1500			<input checked="" type="checkbox"/>	

Inspected By: FARID
 In-Charge: [Signature]
 F.Q.C: [Signature]
 P.M: [Signature]
 Q.A/Manager: [Signature]
 G. Manager: [Signature]

Fig: 3.5(a) Pre-Finishing Inspection Report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: SIMON REG	Section: Finishing

Defect Classification:

Defect name	Major	Minor
Crease mark	0	1
Skip/open/Broken stitch	1	0
High-low pocket/Yoke	0	1
Dirty spot/Stamp marks	0	1
Uncut thread/ loose thread	1	0

Table: 3.5(a) Defect Classification

TUSUKA TROUSERS LTD.
Neelnagar, Konabari, Gazipur.

TTL/FQA/007

Finishing In-Line / Pre-Final Inspection Report

Buyer: H & M	Type of Inspection		Unit: FINISHING I-B
Style: SUPER SKINNY FIT TROUSERS	In Line: FINISHING I-B	Inspection Date: 10.08.2022	Shipment Date:
Order: 270606-2031	Pre-Final:	Inspected By: MD. SHARIF ULLAH	
O/Qty: 5232 Pcs	Final:		

Styling and Specification: <input checked="" type="checkbox"/>	Main Fabrics: <input checked="" type="checkbox"/>	Lining: <input type="checkbox"/>	Pocketing: <input type="checkbox"/>	Piping: <input type="checkbox"/>
Approved Wash: <input checked="" type="checkbox"/>	Wash Standard: <input checked="" type="checkbox"/>	Main Label: <input checked="" type="checkbox"/>	Size/Care Label: <input checked="" type="checkbox"/>	Ean/Bar Code: <input type="checkbox"/>

Defect Classification					
Check Point	Major	Minor	Check Point	Major	Minor
1. Fabrics Defects			4. Trims		
A. Flams/Slub/Hole			A. Label Missing / Insecured/Damaged/ Inccrect/Misplaced		
B. Bowing			B. Button/Rivet/Eyelet/Zipper/Eyehole Missing/Insecured/Incorrect/Misplaced		
C. Incorrect Weight/Construction			C. Drwccrd/Drawsting/Missing/Inccrect Length		
D. Creases			D. WASHING MARK AT BODY I		
E. Shading			5. Wash & Finish		
F. Foreign Yarn / Thick Yarn			A. Wash not within Standard or Tolerance		
G. POTOM HEM HIKING	I		B. Wash Shade		
2. Construction & Stitches			C. Handfeel		
A. Seam Twisted/Puckered/Pleated			D. Iron Marks/Shining marks/Creas Marks		
B. Skip/Open/Broken Stitches			E.		
C. Loose/Tight Tension			6. Cleanliness		
D. Irregular S.P.I			A. Dirty Spot/Oil Stain/Soil/Stamp Marks		
E. Overlapping Stitches			B. UNCUT THREAD/LOOSE THREAD AT BODY I		
F. Uneven Double Needle Tot Stitches			C.		
G. Needle Hole/Rawedge/Open Seam			D.		
H. High-Low Pocket/ Yoke/Hem			7. Packing Accuracy		
I. Twisting/Torquing			A. Incorrect Information On Poly Bag		
J. Misalignment			B. Incorrect Folding/Poly Bag Size		
K. Missing/Displaced/Insecured Bartack			C. Carton Size Out of Spec		
L. Neck/Placket Crooked/Out op Shape			D. Content Incorrect/Incorrect Assortment		
M. Sewing Thread Not Matching			E. Quantity Incorrect		
N. LITTLE SPOT AT BODY		II	F. Incorrect Carton Marks		
O.			G. Poor Carton Quality		
P.			H.		
Q.			8. Measurement		
R.			A. Correct		
			B. Incorrect		
Total Major/Minor Defects	01	02	Total Major/Minor Defects	02	00

Unit Inspected	G. Total Major / Minor	AQL Level	Accepted	Rejected
Inspected Ctns #	03	1.5	03	04

Comments: **ATTEN: MR. Q. N. P. M. & INC. CC: G. M. S. I. R. FINISHING RUNNING PRODUCTION PROBLEM. I FOUND 01 BOTTOM HEM HIKING. LITTLE SPOT AT BODY. WASHING MARK AT BODY. UN CUT LOOSE THREAD AT IN GARMENTS.**

Production Status				Estimate Completion Date	Inspection Result	
Cutting: <input checked="" type="checkbox"/>	Sewing: <input checked="" type="checkbox"/>	Wash: <input checked="" type="checkbox"/>	Poly: <input checked="" type="checkbox"/>	Carton: <input checked="" type="checkbox"/>	Pass: <input checked="" type="checkbox"/>	Fail: <input type="checkbox"/>

Inspected By: **[Signature]** F. In-Charge: **[Signature]** F.Q.C: **[Signature]** P.M: **[Signature]** Q.A Manager: **[Signature]** G. Manager: **[Signature]**

Fig: 3.5(b) Pre-Finishing Inspection Report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 370606-2034
Style Number: Super shinny hw hl Lewis	Section: Finishing

Defect Classification:

Defect name	Major	Minor
Bottom hem making	1	0
Little spot at body	0	2
Washing mark at body	1	0
Uncut thread/ loose thread	1	0

Table: 3.5(b) Defect Classification

3.6 Hourly rivet/Button check Report:

TUSUKA TROUSERS LTD. (PREMIUM ZONE)

TPZ/FQA/010

Hourly Rivet/Button Check Report

Buyer	HSM	Unit	03
Style	REFRUPP 1007P107 JAYS SIMAN	Section	Finishing
P.O No	402019-5672	Name & Card No of Q.I	Keja-735
O/Qty	27,517 - PCS.	Date	22-09-22

Name of Defects	Hour's										Total	
	1th	2th	3th	4th	5th	6th	7th	8th	9th	10th		
Broken Button												
Broken Rivet			1			1	11					
Half Stich at Button											04	
Label Part Missing												
Loose Tension at Button												
Button Sharpedge												
Rivet Sharpedge				1								
Button Missing	11				1	1					01	
Rivet Missing	1	1	11		11		1	11			04	
Button Displace											09	
Rivet Displace		11		1	11		1	1			07	
Insecured Button												
Insecured Rivet	1		1			1					03	

Total Check	304	203	204	202	255	203	224	203			1798
Total Passed	300	200	200	200	250	200	220	200			1770
Total Defect	04	03	04	02	05	03	04	03			28
Defect %											1.55%
Miss Qty											
Qty Return to Alteration	2+2	2+1	2+2	1+1	3+2	2+1	2+2	2+1			28
Qty After Alteration	04	03	04	02	05	03	04	03			28
Reject Qty											

Fin. Supervisor										
Fin. Controller										
Fin. In-Charge										

Fin. In-Charge
 Fin. Controller
 _____ P. Manager
 Q.A Manager
 _____ G. Manager

Fig: 3.6(a) Hourly rivet/button check report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Hourly rivet/button check total report:

Total check	1798
Total passed	1770
Total defect	28
Quantity returns to alteration	28
Quantity after alteration	28
Reject quantity	0
Defect%	1.55%

Table: 3.6(a) Hourly rivet/button check total report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 406435-8717
Style Number: Fancy wide leg carpenter	Section: Finishing

Hourly rivet/button check total report:

Total check	3850
Total passed	3813
Total defect	37
Quantity returns to alteration	37
Quantity after alteration	37
Reject quantity	0
Defect%	0.96%

Table: 3.6(b) Hourly rivet/button check total report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Hourly label checks total report:

Total check	3159
Total passed	3070
Total defect	89
Quantity returns to alteration	89
Quantity after alteration	89
Reject quantity	0
Defect%	2.81%

Table: 3.7(a) Hourly label check total report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Suppe skinny hw	Section: Finishing

Hourly label checks total report:

Total check	3390
Total passed	3334
Total defect	56
Quantity returns to alteration	56
Quantity after alteration	56
Reject quantity	0
Defect%	1.65%

Table: 3.7(b) Hourly label check total report

3.8 Finishing Section Defect Summary:

TUSUKA TROUSERS LTD (PREMIUM ZONE) KONABARI, NEELNAGAR, GAZIPUR.			
Finishing Section Defect Summary			
Buyer	HBM	O/Qty	97519 PCS
Style	REGULAR LOWPRICE JEANS SIMON	Unit	03
P.o No.	402019-5672	Date	20-05-22
Name of Defect	Number of Defect	Number of 100% Defect GMTS	Remarks
Wash Shade Check			
A) Dark Shade			
B) Light Shade			
C) Washing Spot/Off			
D) More or Less Whisker			
E) Over Destroy/3D			
F) Over Grinding			
G) Light or More Hand Brush			
H) Reject	10562	300	
*Inside Check			
I) Open Stitch/Seam	02		
J) Broken Stitch	83	1.57%	
C) Skip Stitch	65		
D) Down Stitch	25		
E) Rawedge	40		
F) Bartack Missing	26		
G) Damage	14		
H) Dirty Spot	17		
I) Poor/Ugly Join Stitch	10		
J) UNDOIT THREAD	85		
Top Side Check			
A) Open Stitch/Seam	04		
B) Broken Stitch	33	2.07%	
C) Skip Stitch	32		
D) Down Stitch	15		
E) Rawedge	24		
F) Bartack Missing	25		
G) Damage	08		
H) Dirty Spot	24		
I) Poor/Ugly Join Stitch	03		
J) Eyelet Hole Missing UNDOIT THREAD	40		
K) Washing Crease Mark			
L) Waist Loop Slanted			
Get-Up Check			
A) Open Stitch/Seam	2571	106	
B) Broken Stitch	73	4.12%	
C) Skip Stitch	70		
D) Down Stitch			
E) Rawedge UNDOIT THREAD	32		
F) Bartack Missing	17		
G) Damage	01		
H) Dirty Spot	15		
I) Poor/Ugly Join Stitch			
J) Eyelet Hole Missing/Twisting			
K) Washing Crease Mark			
L) Waist Loop Slanted			
Button and Rivet			
CHECK-3641	41	1.12%	
Measurement			
CHECK-2646	86	3.25%	

Fig: 3.8(a) Finishing Section Defect total report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Finishing Section Defect total report:

Style check name	Defect %
Wash shade check	1.64 %
Inside check	8.07 %
Top side check	8.31 %
Get-up check	6.64 %
Button & rivet check	1.12 %
Label check	3.25 %

Table: 3.8(a) Finishing Section Defect total report

TUSUKA TROUSERS LTD


Neelnagar, Konabari, Gazipur.

TTL/FQA/012


Finishing Section Defect Summary

Buyer	HBM	O/Qty	2254320
Style	D+W FANCY WIDELEG@WGLTAR	Unit	118
P.o No.	406435-8717	Date	20-09-2022

Name of Defect	Number of Defect	Number of 100% Defect GMTS	Remarks
*Wash Shade Check 4020			
A) Dark Shade	38		
B) Light Shade	20		
C) Washing Spot/Off	08		
D) More or Less Whisker			
E) Over Destroy/3D			
F) Over Grinding			
G) Light or More Hand Brush			
H) Reject			
*Inside Check 3990			
A) Open Stitch/Seam	35		
B) Broken Stitch	80		
C) Skip Stitch	81		
D) Down Stitch	29		
E) Rawedge	50		
F) Bartack Missing	26		
G) Damage	05		
H) Dirty Spot	16		
I) Poor/Ugly Join Stitch			
J)			
*Top Side Check 3876			
A) Open Stitch/Seam	32		
B) Broken Stitch	63		
C) Skip Stitch	32		
D) Down Stitch	10		
E) Rawedge	21		
F) Bartack Missing	83		
G) Damage	05		
H) Dirty Spot	68		
I) Poor/Ugly Join Stitch			
J) Eyelet Hole Missing	08		
K) Washing Crease Mark			
L) Waist Loop Slanted			
*Get-Up Check 3591			
A) Open Stitch/Seam			
B) Broken Stitch	36		
C) Skip Stitch	27		
D) Down Stitch			
E) Rawedge	10		
F) Bartack Missing	39		
G) Damage			
H) Dirty Spot	43		
I) Poor/Ugly Join Stitch			
J) Eyelet Hole Missing/Twisting	45		
K) Washing Crease Mark			
L) Waist Loop Slanted	41		
*Button and Rivet	31		
*Measurement			
*Label	59		


Finishing Controller


Finishing in-Charge


Production Manager


Q.A Manager

Fig: 3.8(b) Finishing Section Defect total report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 406435-8717
Style Number: D+W Fancy wide leg cw6lt	Section: Finishing

Finishing Section Defect total report:

Style check name	Defect %
Inside check	1.57 %
Top side check	2.07 %
Get-up check	4.12 %
Button & rivet check	2.87 %
Label check	4.15 %

Table: 3.8(b) Finishing Section Defect total report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Instand of Defect total:

	Total check	Total passed	Total defect	Defect %
Inside	19562	19305	257	1.57%
Topside	9884	9723	161	2.07%
Rivet/ Button	3641	3600	41	1.12%
Label	2571	2465	106	4.12%
Get-up	2646	2560	86	3.25%

Table: 3.9 (a) Instand of Defect total

Study on Quality Control of Different Types of Garments in the Finishing Section

Buyer	Style	O.No	O.DV	Getup	Measurement	Label	Rivet Button	Topside	Inside	Process Name			
HFM D/W FANCY WIDE LEG LOW CUT CAPRI PANTS	106435-3217	32543 P	1	36				63	80	Broken Stitch			
				21				32	81	Skip Stitch			
										32	35	Open Stitch	
												Uneven Stitch	
												Joint Stitch	
				45								Uncut Thread	
												Puckering	
												Pleat	
												Shading	
												Pocket Slanted	
												Pocket Hi-Low	
				41								Loop Slanted	
												Poor Shape	
												Poor Iron	
												Rivet Missing	
												Button Missing	
												Needle Cut	
				10							21	50	Rawedge
													Size Mistake
				39							83	26	Bartack Missing
							08		Twisting EYELET MISSING				
									Lycra Breakage				
							10	29	Up-Down STITCH				
43							68	16	Spot				
									Creas Mark				
									Tagpin				
									Fabrics Fault				
							05	05	Reject				
3541	3290	3270	3876	3990					Total Checked				
3339	3236	3239	3600	3728					Total Passed				
2354	54	31	316	317					Total Defect				
6.64%	1.64%	0.94%	8.25%	7.94%					Defect%				

Finishing Section Instand Defect Summary

Neelnagar, Konabari, Gazipur.

TTL/FQA013

Unit: 118
Date: 20-09-2002

Finishing Incharge

Finishing Controller

Production Manager

Quality Manager

Fig: 3.9 (b) Instand of Defect

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 406435-8717
Style Number: D+W Fancy wide leg cw6lt	Section: Finishing

Instand of Defect:

	Total check	Total passed	Total defect	Defect %
Inside	3990	3728	317	7.94%
Topside	3876	3600	316	8.25%
Rivet/ Button	3270	3139	31	0.94%
Label	3290	3236	54	1.64%
Get-up	3541	3339	235	6.64%

Table: 3.9 (b) Instand of Defect

3.10 Humidity Check Report:

TUSUKA TROUSERS LTD. (PREMIUM ZONE)
Neelinger, Konabari, Gazipur.

TTU/FQA/020

Humidity Check Report

Date	Time	C	W%	Checked by
07/09/22	8:15 A.M	29.06 C		
"	11.00 A.M	30.05 C	82%	
"	3.00 P.M	31.05 C	79%	
08/09/22	8.20 A.M	31.00 C	72%	
"	12.03 P.M	31.05 C	70%	
"	3.00 P.M	32.03 C	67%	
09/09/22	8.06 A.M	30.09 C	65%	
"	11.03 A.M	32.04 C	70%	
"	3.00 P.M	32.02 C	62%	
10/09/22	8.00 A.M	31.09 C	58%	
"	12.00 P.M	32.06 C	70%	
"	3.06 P.M	31.02 C	62%	
13/09/22	8.04 A.M	28.08 C	65%	
"	11.04 A.M	29.01 C	70%	
"	3.04 P.M	28.02 C	72%	
14/09/22	8.20 A.M	28.01 C	76%	
"	11.00 A.M	28.00 C	81%	
"	3.10 P.M	28.02 C	83%	
15/09/22	8.07 A.M	27.09 C	81%	
"	11.06 A.M	28.07 C	79%	
"	3.06 P.M	29.03 C	81%	
17/09/22	8.00 A.M	29.01 C	81%	
"	11.06 A.M	30.02 C	77%	
"	3.00 P.M	30.07 C	70%	
20/09/22	8.20 A.M	30.09 C	68%	
"	11.07 A.M	30.09 C	65%	
"	3.00 P.M	31.05 C	62%	
21/09/22	8.04 A.M	30.04 C	70%	
"	11.03 A.M	30.09 C	68%	
"	3.02 P.M	31.03 C	65%	

Fig: 3.10(a) Humidity Check Report

Humidity check report average:

Humidity check time	Humidity average %
Morning	75.3
Noon	71.4
After-noon	69.8

Table: 3.10 (a) Humidity check report average

Humidity Check Report

Date	Time	C	W%	Checked by
04.09.22	8:50 AM	30.8C	77%	[Signature]
"	12:24 PM	30.9C	78%	[Signature]
"	4:54 PM	31.1C	77%	[Signature]
06.09.22	8:20 AM	30.5C	83%	[Signature]
"	12:30 PM	30.4C	80%	[Signature]
"	4:30 PM	30.5C	78%	[Signature]
07.09.22	8:30 AM	30.8C	83%	[Signature]
"	12:20 PM	31.7C	77%	[Signature]
"	4:48 PM	32.4C	70%	[Signature]
08.09.22	8:20 AM	31.6C	75%	[Signature]
"	12:35 PM	32.8C	72%	[Signature]
"	4:22 PM	32.0C	69%	[Signature]
09.09.22	8:20 AM	31.5C	69%	[Signature]
"	12:25 PM	32.9C	62%	[Signature]
"	4:30 PM	33.3C	62%	[Signature]
10.09.22	8:40 AM	32.2C	71%	[Signature]
"	12:35 PM	32.9C	65%	[Signature]
"	4:32 PM	31.8C	60%	[Signature]
11.09.22	8:50 AM	31.2C	66%	[Signature]
"	12:30 PM	31.6C	64%	[Signature]
"	4:20 PM	30.9C	70%	[Signature]
13.09.22	8:42 AM	29.7C	70%	[Signature]
"	12:27 PM	29.1C	70%	[Signature]
"	4:39 PM	29.0C	70%	[Signature]
14.09.22	8:30 AM	28.5C	83%	[Signature]
"	12:30 PM	28.7C	86%	[Signature]
"	4:38 PM	28.7C	82%	[Signature]
15.09.22	8:45 AM	28.5C	82%	[Signature]
"	12:20 PM	29.6C	79%	[Signature]
"	4:25 PM	29.9C	83%	[Signature]

Fig: 3.10(b) Humidity Check Report

Humidity check report average:

Humidity check time	Humidity average %
Morning	79.2
Noon	72.5
After-noon	71.7

Table: 3.10 (b) Humidity check report average


3.11 Label & Packing Audit Report:


PREMIUM (ZONE)
 Neelnagar, Konabari, Gazipur.


Label & Packing Audit Report

Check By	RAHR	
Card No with Title	150	
Buyer	H&M	
Order No	40200-5672	
Style Name	REGULAR LOW WAIST JEANS - SIMON	
Order Qty	97,517 Pk	
Date	21-09-2022	

Hour	Country	Order Qty	Check Qty	Main Label	Size Label	Care Label	Additional Label	Price Tag	Waist Tag	Information Tag	Additional Sticker	Warning Tag	Signature
8-9	BE	97,517	850	✓	✓	✓	-	✓	✓	-	-	-	Pakir
9-10	11	11	850	✓	✓	✓	-	✓	✓	-	-	-	Pakir
10-11	11	11	400	✓	✓	✓	-	✓	✓	-	-	-	Pakir
11-12	11	11	100	✓	✓	✓	-	✓	✓	-	-	-	Pakir
12-1	11	11	820	✓	✓	✓	-	✓	✓	-	-	-	Pakir
2-3	11	11	420	✓	✓	✓	-	✓	✓	-	-	-	Pakir
3-4	11	11	850	✓	✓	✓	-	✓	✓	-	-	-	Pakir
4-5	11	11	800	✓	✓	✓	-	✓	✓	-	-	-	Pakir
			25000			61			61				


Fin. d.c.


Fin. Inc.


P. Manager



G. Manager

Fig: 3.11(a) Label & Packing Audit Report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 402019-5672
Style Number: Regular low-price jeans	Section: Finishing

Label & packing audit process report:

Process needed	Process doesn't needed
Main label	Additional label
Size label	Information tag
Care label	Additional sticker
Price tag	Warning tag
Waist tag	

Table: 3.11 (a) Label & packing audit process report

IUSUKA TROUSERS LTD.

Neelnagar, Konabari, Gazipur.

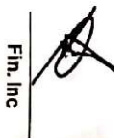
Label & Packing Audit Report

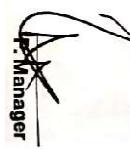
TTV/FOA/025

Check By	MD. MAH FUR2
Card No with Title	710-660
Buyer	H&M
Order No	406435-8712
Style Name	D&W FANCY BODECEG-CHIFFONER
Order Qty	225y3
Date	20.9.22

Hour	Country	Order Qty	Check Qty	Main Label	Size Label	Care Label	Additional Label	Price Tag	Waist Tag	Information Tag	Additional Sticker	Warning Tag	Signature
8.0 AM	SE.	225y3	950	✓	✓	✓	—	✓	✓	—	—	✓	the
9-16	'	'	466	✓	✓	✓	—	✓	✓	—	—	✓	the
10-11	'	'	466	✓	✓	✓	—	✓	✓	—	—	✓	the
11-12	'	'	466	✓	✓	✓	—	✓	✓	—	—	✓	the
12-1	'	'	350	✓	✓	✓	—	✓	✓	—	—	✓	the
2-3	'	'	400	✓	✓	✓	—	✓	✓	—	—	✓	the
3-4	'	'	430	✓	✓	✓	—	✓	✓	—	—	✓	the
4-5	'	'	380	✓	✓	✓	—	✓	✓	—	—	✓	the

Fin. Inc 

Fin. Inc 

Manager 

Q. Manager 

G. Manager

Fig: 3.11(a) Label & Packing Audit Report

Study on Quality Control of Different Types of Garments in the Finishing Section

Name of buyer: H&M	P.O no: 406435-8717
Style Number: D+W Fancy wide leg cw6lt	Section: Finishing

Label & packing audit process report:

Process needed	Process doesn't needed
Main label	Additional label
Size label	Information tag
Care label	Additional sticker
Price tag	
Waist tag	
Warning tag	

Table: 3.11 (b) Label & packing audit process report

CHAPTER 4: DISCUSSION OF RESULTS

4.1 Analysis of Hourly Defect & Reject % of Finishing

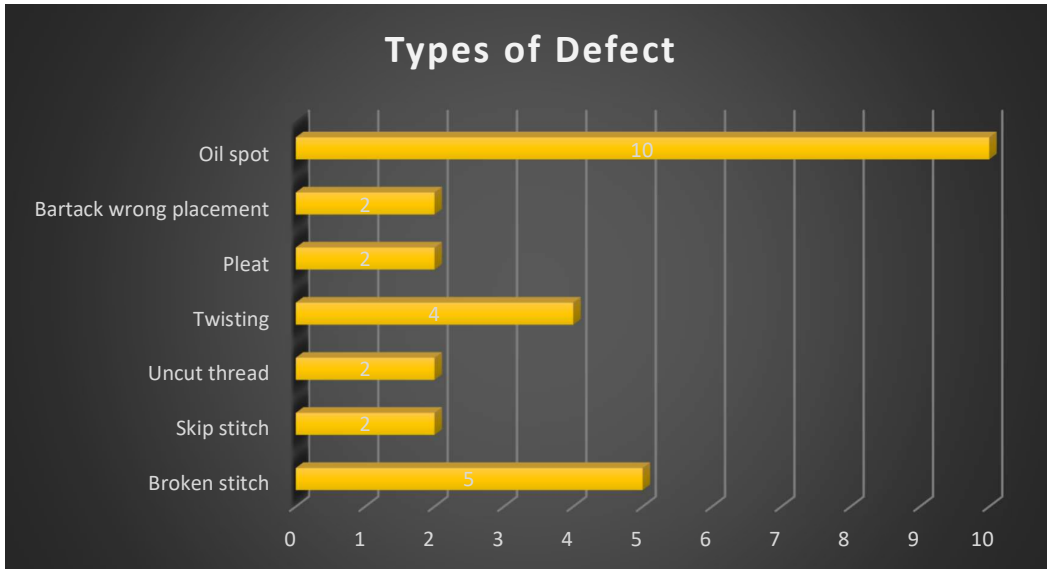


Chart: 4.1(a) Types of defects

Here, the chart of types of defects shows us which defects take place and their quantity in every defect. We see that Broken stitch: 05, Pleat: 02, Skip stitch: 02, Bar tack wrong placement: 02, Uncut thread: 02, Oil spot: 10, and Twisting: 04 are recorded in a one-day defect chart.

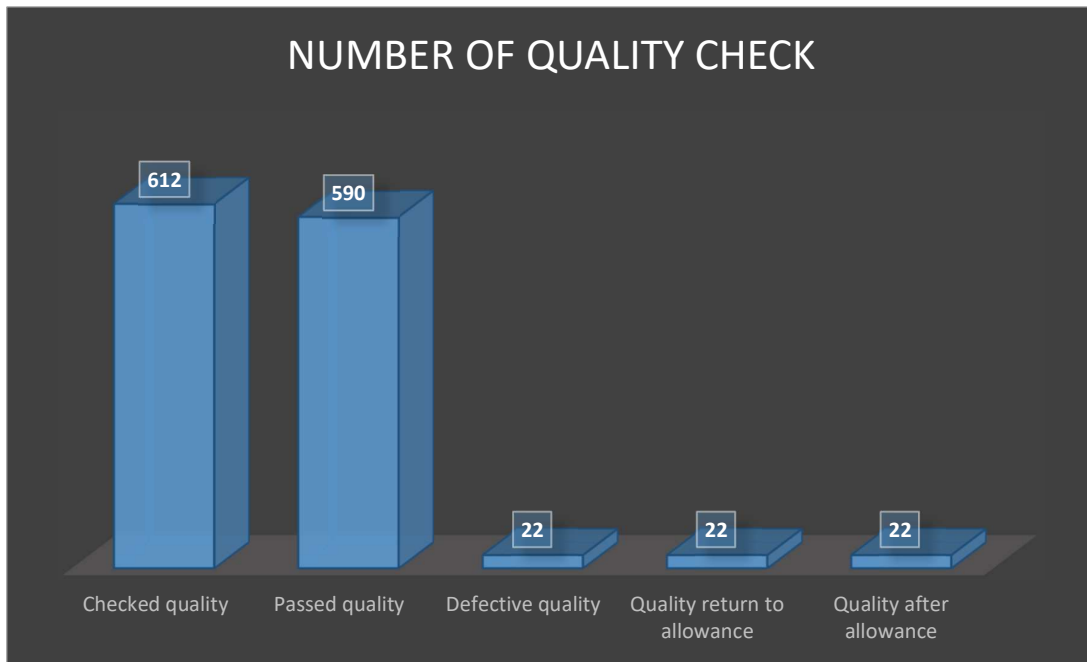


Chart: 4.1(b) Number of Quality check

Here, the chart of total number of quality check shows us checked quantity, passed quantity, defective quantity, quantity return to allowance, quantity after allowance and their quantity. We see that checked quantity: 612, passed quantity: 590, defective quantity: 22, quantity return to allowance: 22, quantity after allowance: 22 are recorded in a one-day number of quality check.

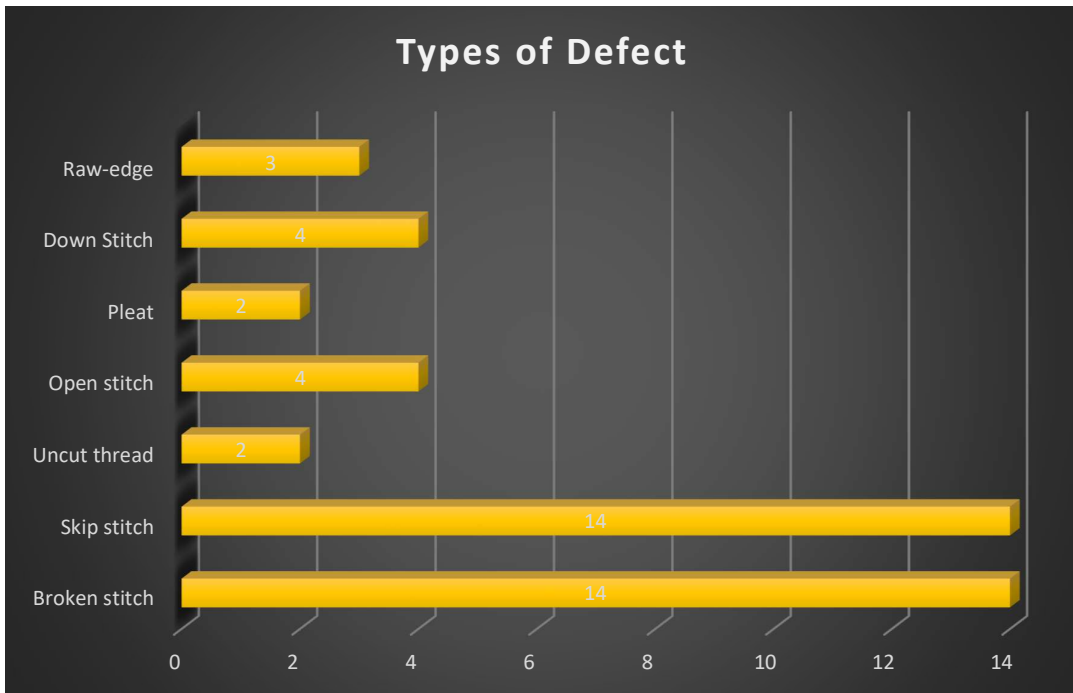


Chart: 4.1(c) Types of defects

Here, the chart of types of defects shows us which defects take place and their quantity in every defect. We see that open stitch: 04, broken stitch: 14, skip stitch: 14, down stitch: 04, uncut thread: 02, raw-edge: 03 are recorded in a one-day defect chart.

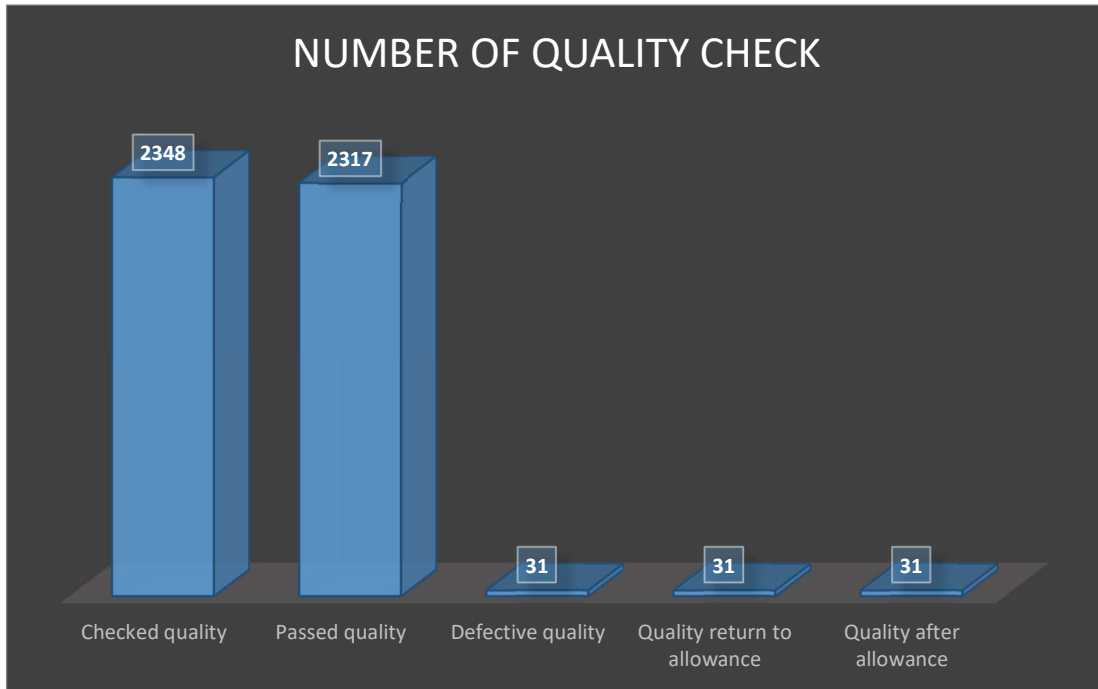


Chart: 4.1(d) Number of Quality check

Here, the chart of total number of quality check shows us checked quality, passed quality, defective quality, quality return to allowance, quality after allowance and their quantity. We see that checked quality: 2348, passed quality: 2317, defective quality: 31, quality return to allowance: 31, quality after allowance: 31 are recorded in a one-day number of quality check.

4.2 Analysis of Lot Pass Audit Record of Finishing

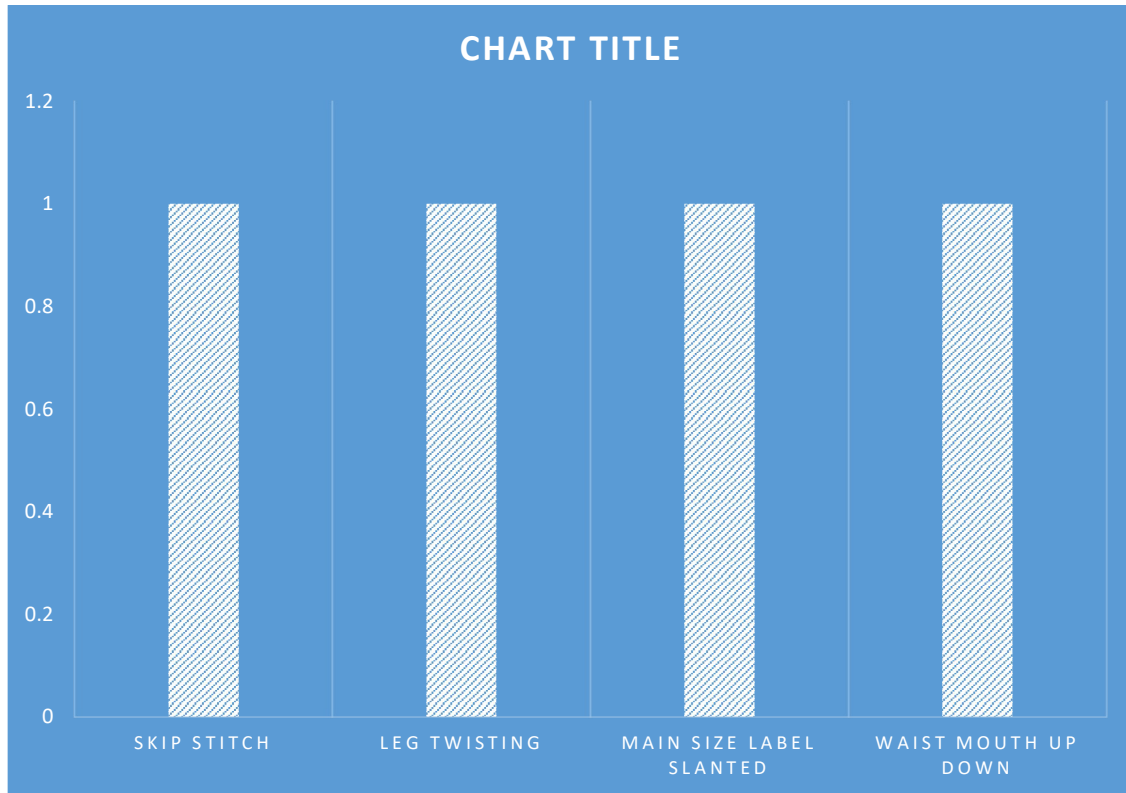


Chart: 4.2(a) Lot Pass Audit Record.

Here, the chart of lot pass audit record shows us which defects take place and their quantity in every defect. We see that skip stitch, leg twisting, main size label, waist mouth up down. Every defect has 1 major or minor defect and this data are recorded in a one-day lot pass audit record of finishing.

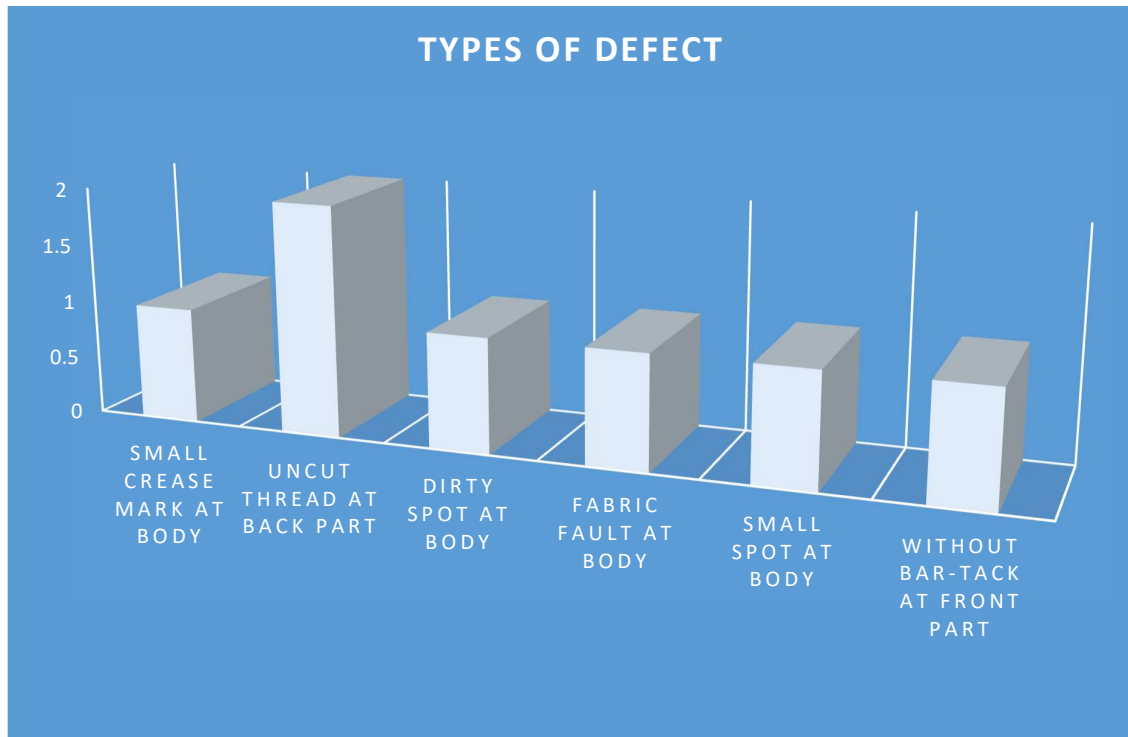


Chart: 4.2(b) Lot Pass Audit Record.

Here, the chart of lot pass audit record shows us which defects take place and their quantity in every defect. We see that small crease mark at body, uncut thread at back part, dirty spot at body, fabric fault at body, Small spot at body, without bar-tack at front part. Every defect has 1 or 2 major or minor defect and this data is recorded in a one-day lot pass audit record of finishing.

4.3 Analysis of Monthly Lot Pass Defect Summary of Finishing

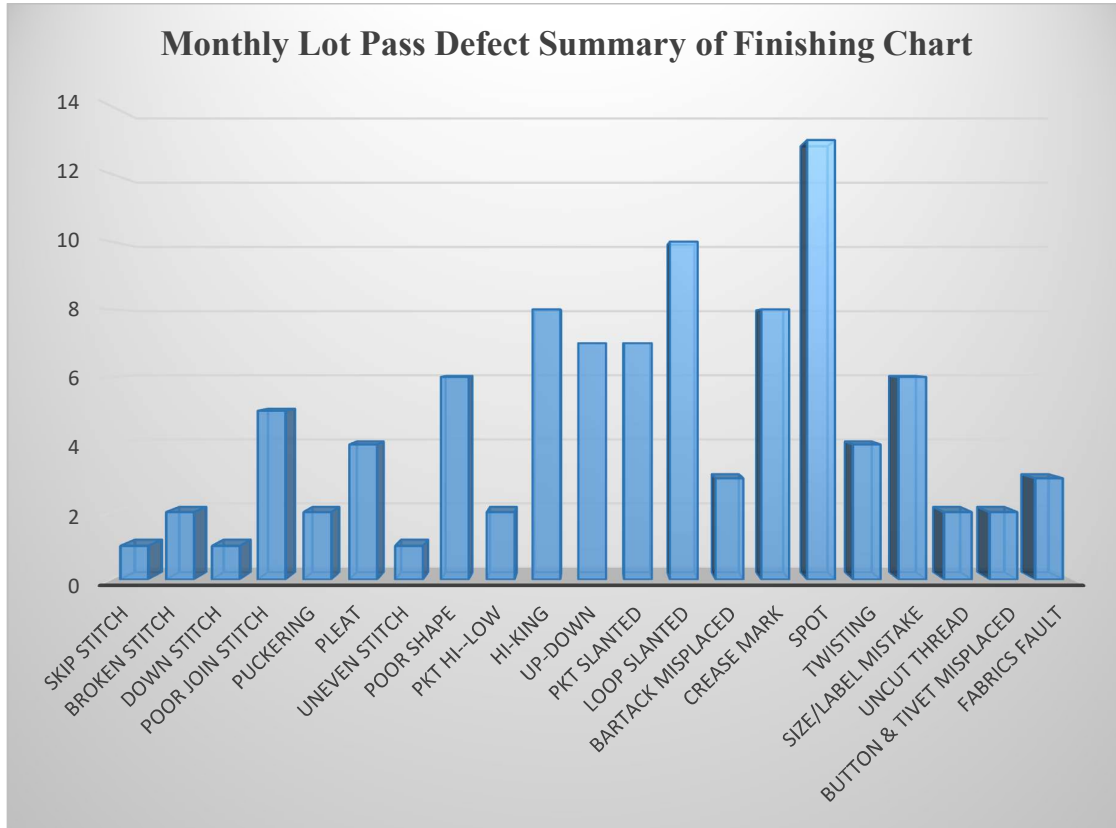


Chart: 4.3(a) Monthly Lot Pass Defect Summary of Finishing

Here, the chart of monthly lot pass defect summary of Finishing shows us which defects take place and their quantity in every defect. We see that skip stitch: 1, up-down: 7, broken stitch: 2, pkt slanted: 7, down Stitch: 1, loop slanted: 10, poor join stitch: 5, Bar tack misplaced: 3, puckering: 2, crease mark: 8, pleat: 4, spot: 13, uneven stitch: 1, twisting: 4, poor shape: 6, size/Label mistake: 6, pkt Hi--low: 2, uncut thread: 02, hi-king: 8, button & rivet misplaced: 2, fabrics fault: 03 are recorded in a one-day defect chart.

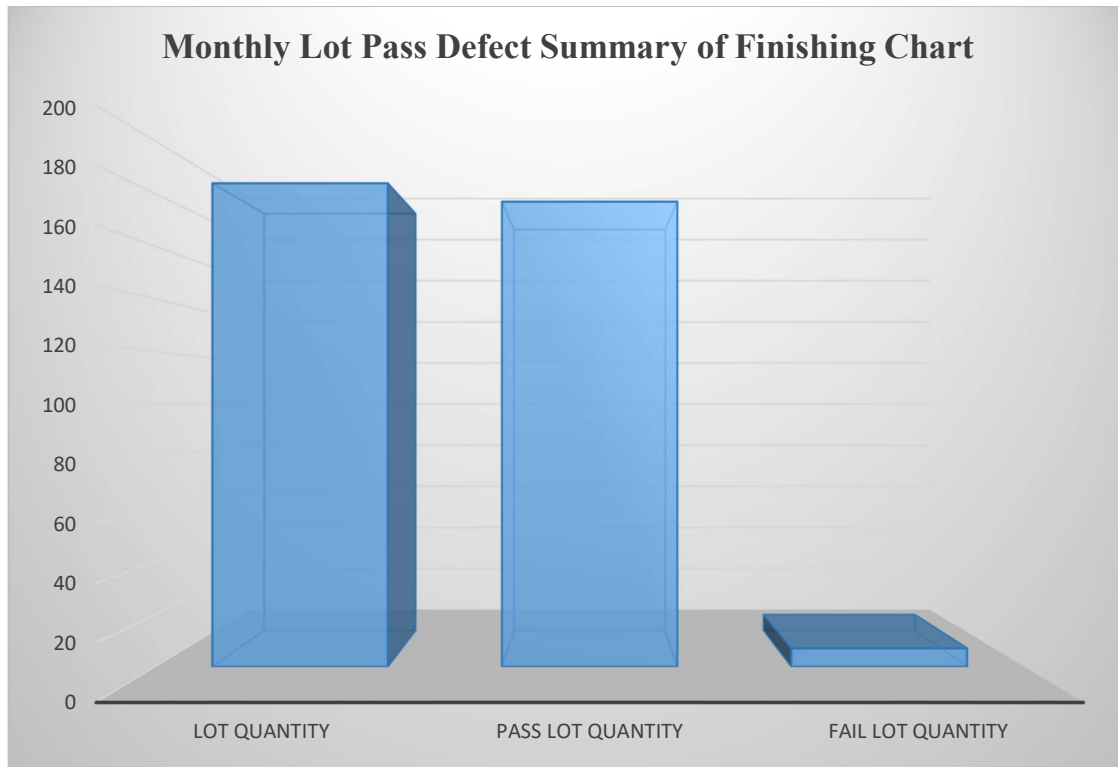


Chart: 4.3(b) Monthly lot Pass audit.

Here, the chart of monthly lot pass defect summary of Finishing shows us which defects take place and their quantity in every defect. We see that lot quantity 184, pass lot quantity 177, fail lot quantity 7, pass lot quantity 96.2% are recorded in a one-month 'Monthly Lot Pass Defect Summary of Finishing Chart' defect chart.

4.4 Analysis of Daily Style Check Report

Here, the chart of Daily Style Check Report shows us which defects take place and their quantity in every defect. We see that the Process needed, Wash standard, Main label size label, Care label, Zipper, Button, Eyelet, Rivet, Waist tag, Hang tag, Polybag, Poly sticker, Country sticker and The process doesn't needed are Barcode, Badge label, Elastic, Draw cord, Print, Size strip, Hanger, Tag pin, Leather Patch, Pocket flasher, Plastic clip. These are recorded in a one-day Daily Style Check Report Chart.

4.5 Analysis of Finishing In-Line / Pre-Finishing Inspection Report

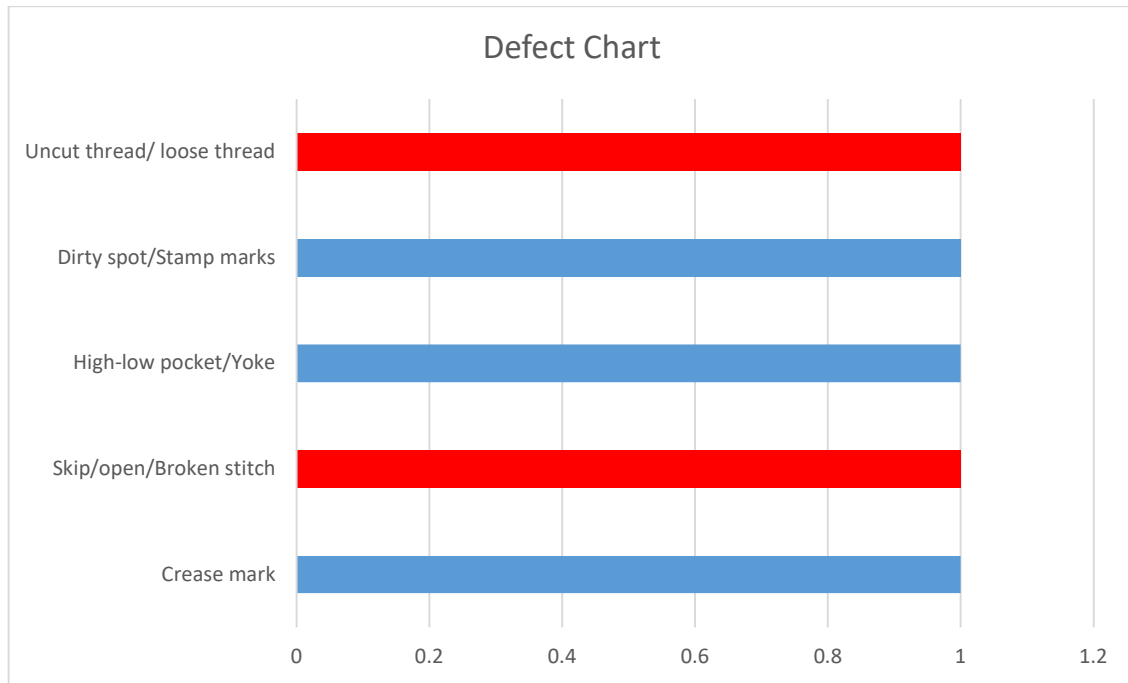


Chart: 4.5(a) Defect Classification chart

Here, the chart of Finishing In-Line / Pre-Finishing Inspection Report shows us which defects take place and their quantity in every defect. We see that small Crease mark, Skip/open/Broken stitch, High-low pocket/Yoke, Dirty spot/Stamp marks, Uncut thread/ loose thread. Every defect has 1 major or minor defect and this data is recorded in a one-day Finishing In-Line / Pre-Finishing Inspection Report chart.

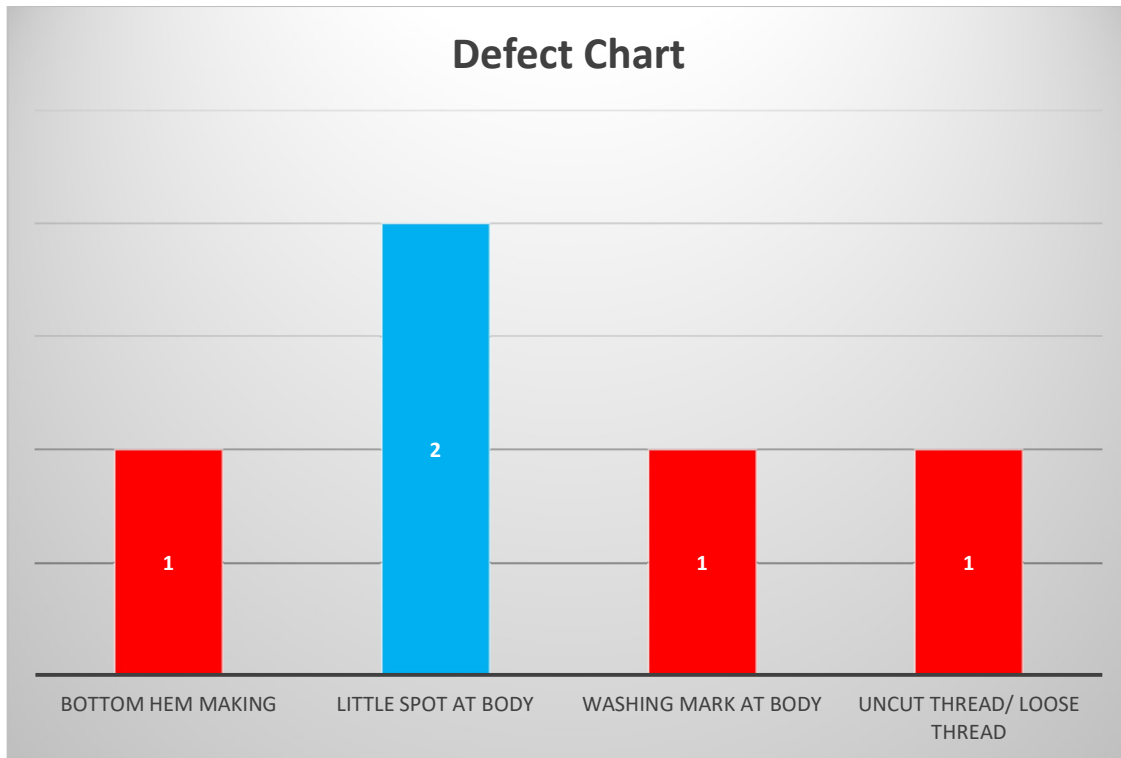


Chart: 4.5(b) Defect Classification chart

Here, the chart of Finishing In-Line / Pre-Finishing Inspection Report shows us which defects take place and their quantity in every defect. We see that bottom hem making, little spot at body, washing mark at body, uncut thread/loose thread. Every defect has 1 or 2 major or minor defect and this data is recorded in a one-day Finishing In-Line / Pre-Finishing Inspection Report chart.

4.6 Analysis of Hourly rivet/Button Check Report

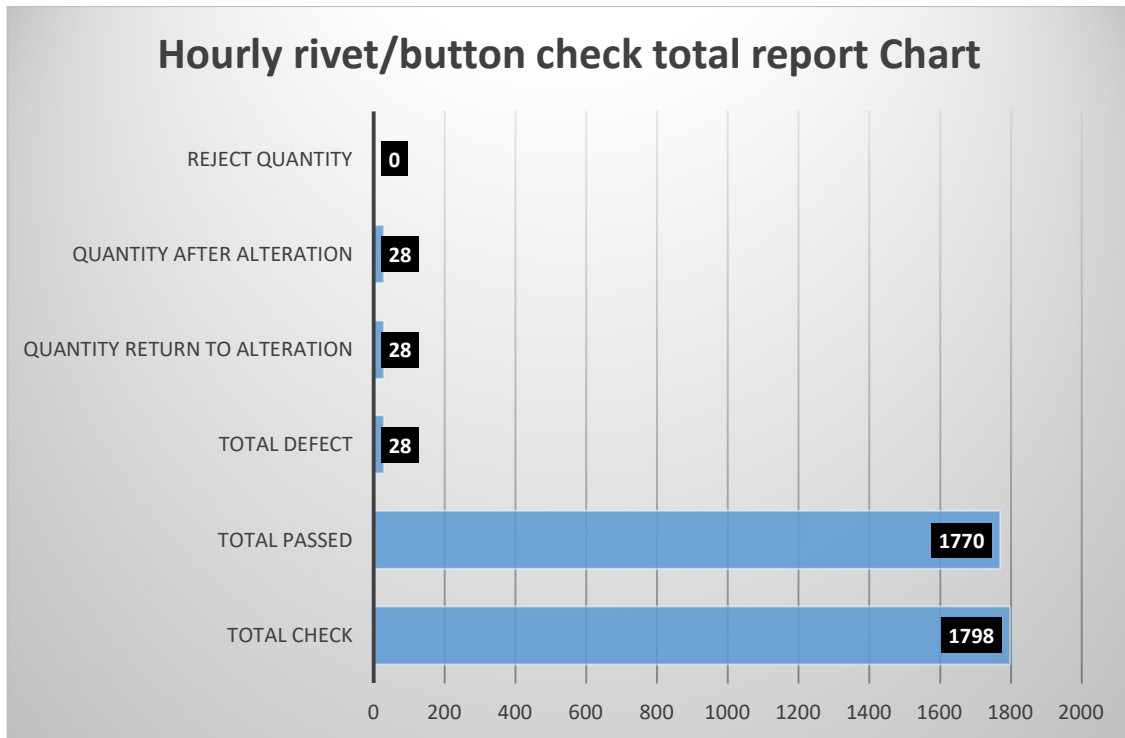


Chart: 4.6(a) Hourly rivet/button check total report chart

Here, the chart of Hourly rivet/button check total report shows us which defects take place and their quantity in every defect. We see that total check: 1798, total passed: 1770, total defect: 28, quantity return to alteration: 28, quantity after alteration: 28, reject quantity: 0 and this data is recorded in a one-day Hourly rivet/button check total report of finishing.

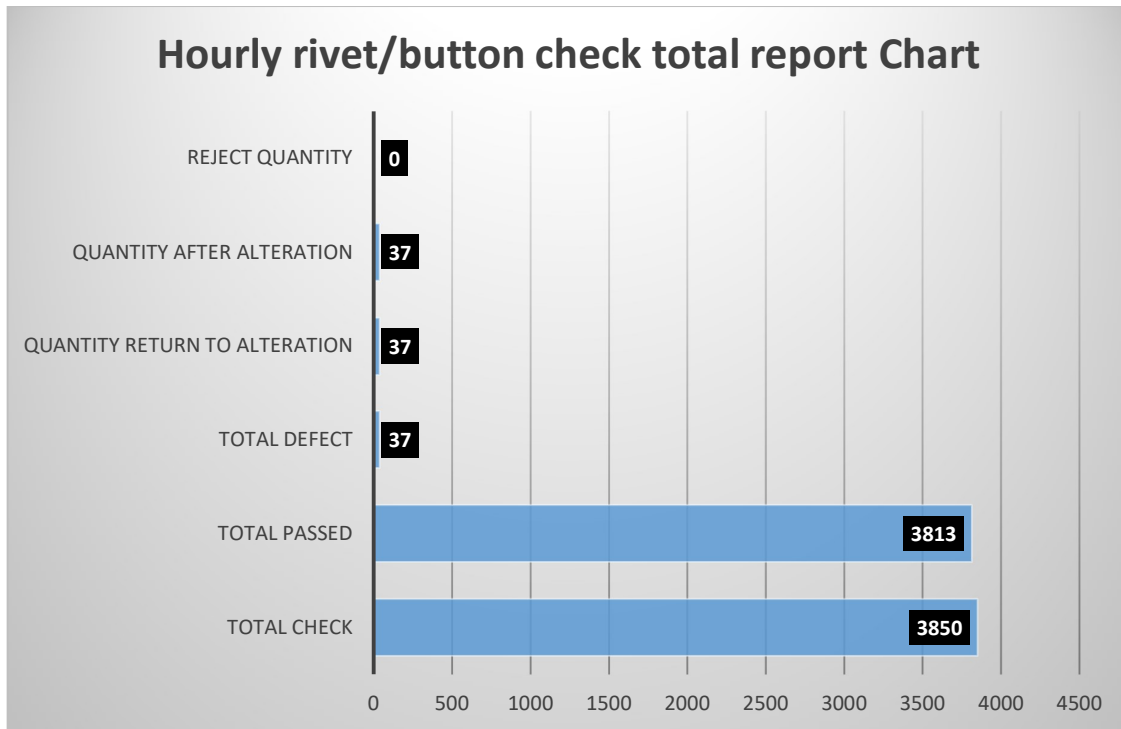


Chart: 4.6(b) Hourly rivet/button check total report chart.

Here, the chart of Hourly rivet/button check total report shows us which defects take place and their quantity in every defect. We see that total check: 3850, total passed: 3813, total defect: 37, quantity return to alteration: 37, quantity after alteration: 37, reject quantity: 0 and this data is recorded in a one-day Hourly rivet/button check total report of finishing.

4.7 Analysis of Hourly Label Check Report

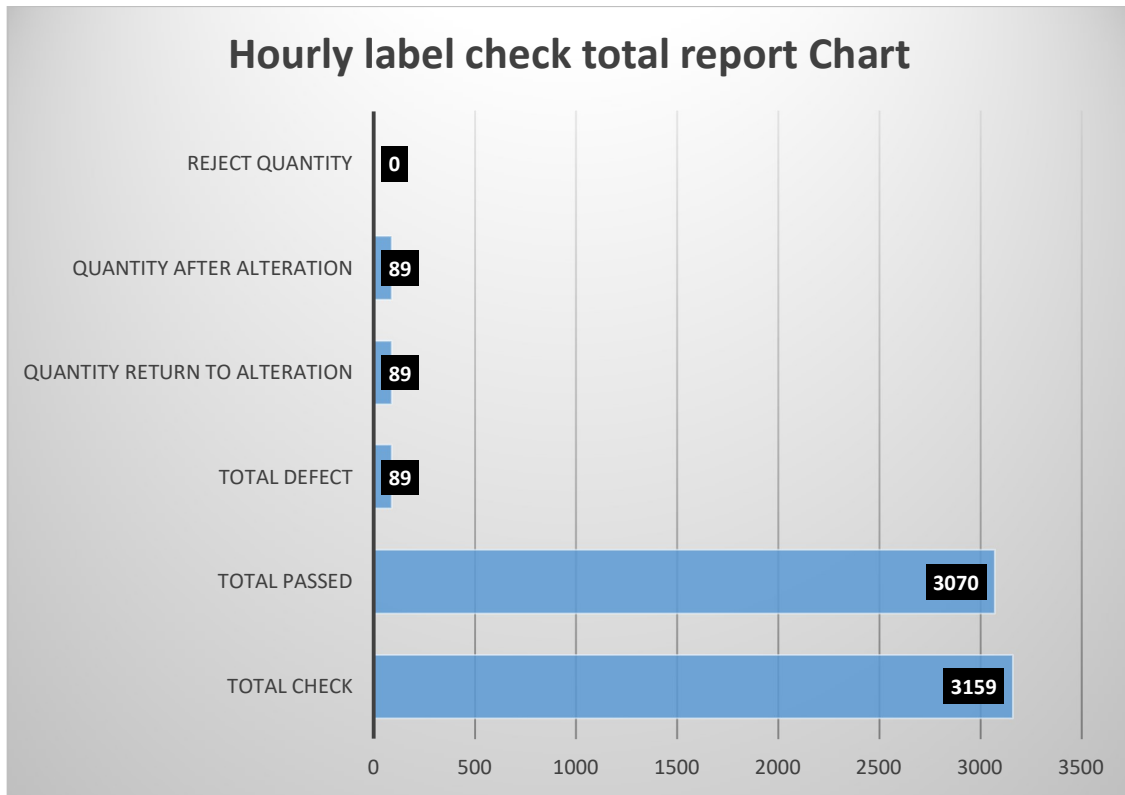


Chart: 4.7(a) Hourly label check total report chart.

Here, the chart of Hourly rivet/button check total report shows us which defects take place and their quantity in every defect. We see that total check: 3159, total passed: 3070, total defect: 89, quantity return to alteration: 89, quantity after alteration: 89, reject quantity: 0 and this data is recorded in a one-day Hourly rivet/button check total report of finishing.

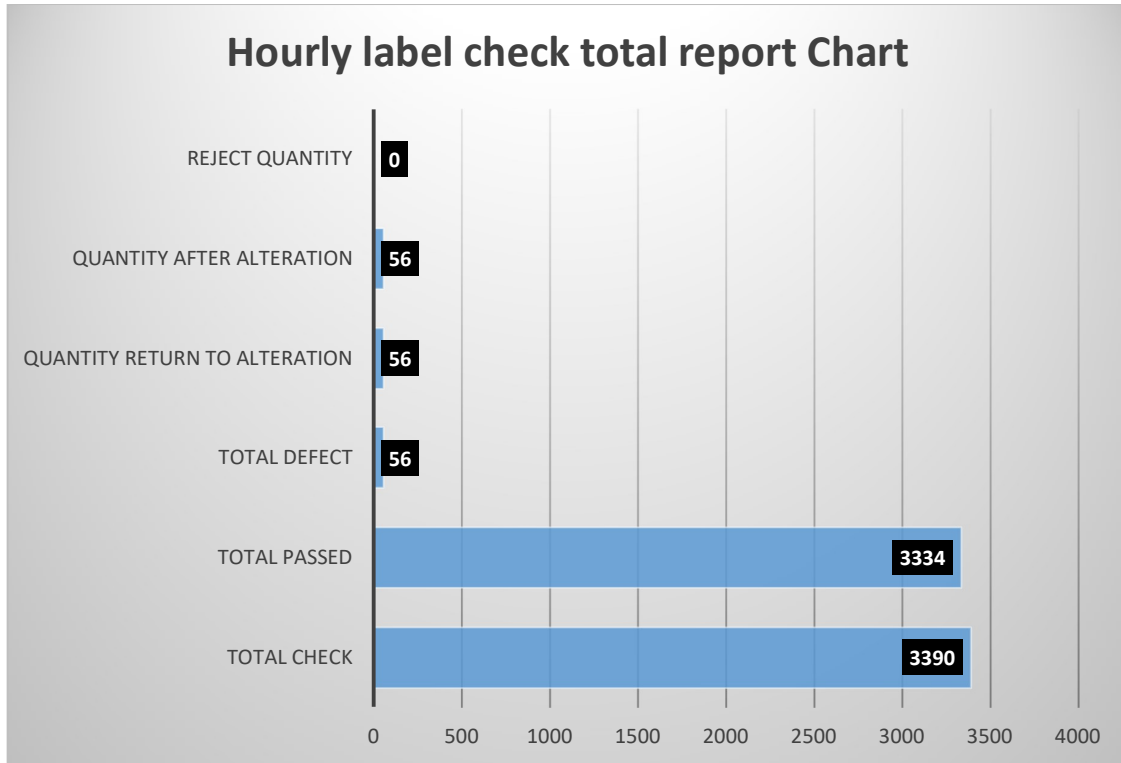


Chart: 4.7(b) Hourly label check total report chart.

Here, the chart of Hourly rivet/button check total report shows us which defects take place and their quantity in every defect. We see that total check: 3390, total passed: 3334, total defect: 56, quantity return to alteration: 56, quantity after alteration: 56, reject quantity: 0 and this data is recorded in a one-day Hourly rivet/button check total report of finishing.

4.8 Analysis of Finishing Section Defect Summary

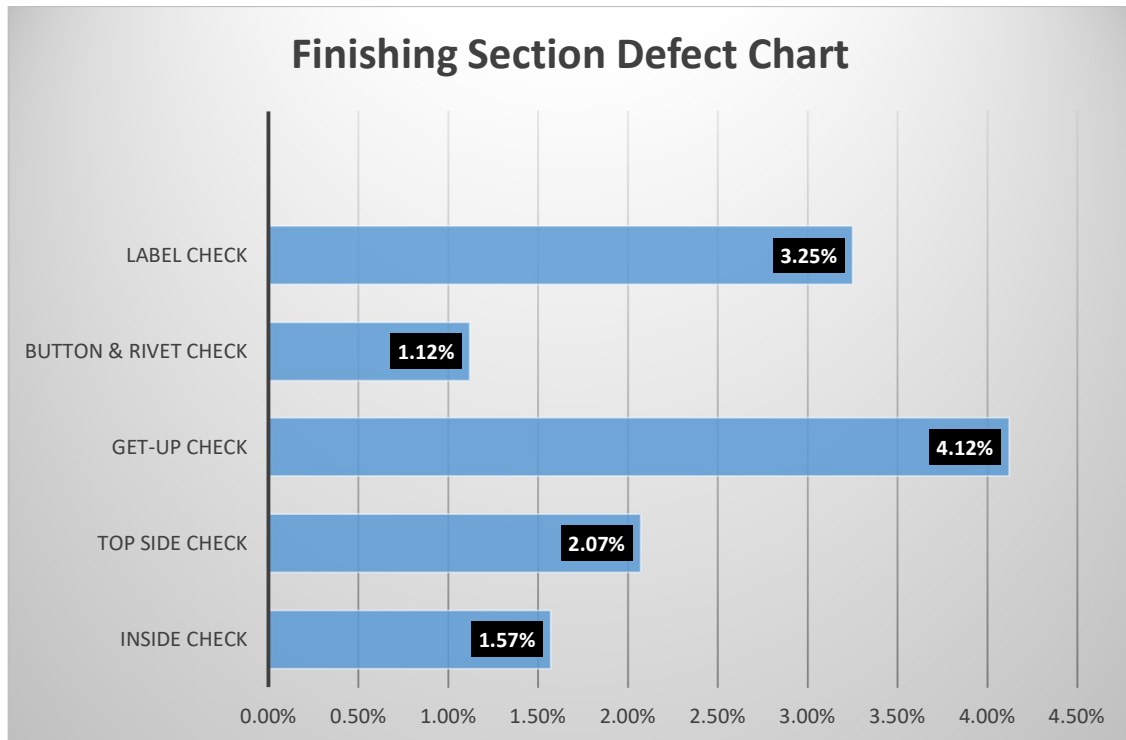


Chart: 4.8(a) Finishing Section Defect Chart.

Here, the chart of Finishing Section Defect summary shows us which defects take place and their quantity in every defect. We see that wash shade check: 1.64 %, inside check: 8.07 %, top side check: 8.31 %, get-up check: 6.64 %, button & rivet check: 1.12 %, label check: 3.25 % and this data is recorded in a one-day finishing section defect summary.

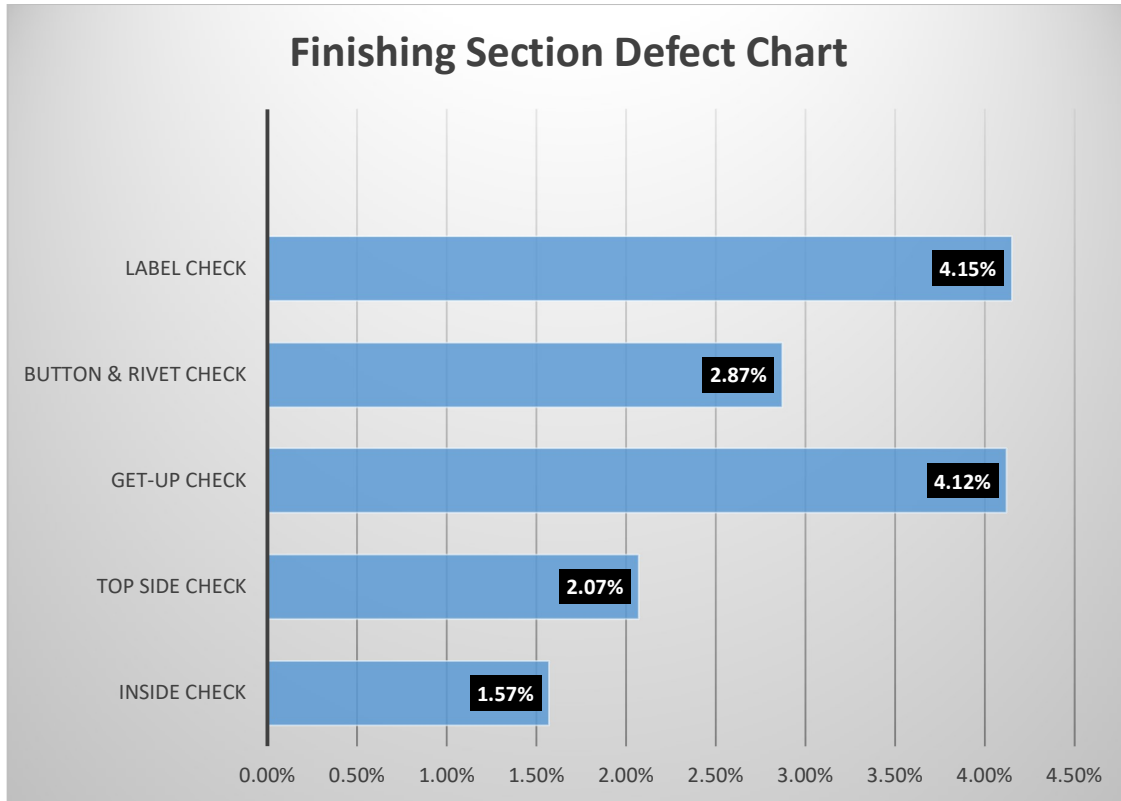


Chart: 4.8(b) Finishing Section Defect Chart.

Here, the chart of Finishing Section Defect summary shows us which defects take place and their quantity in every defect. We see that inside check 1.57 %, top side check 2.07 %, get-up check 4.12 %, button & rivet check 2.87 %, label check 4.15 % and this data is recorded in a one-day finishing section defect summary.

4.9 Analysis of Instand of Defect Summary

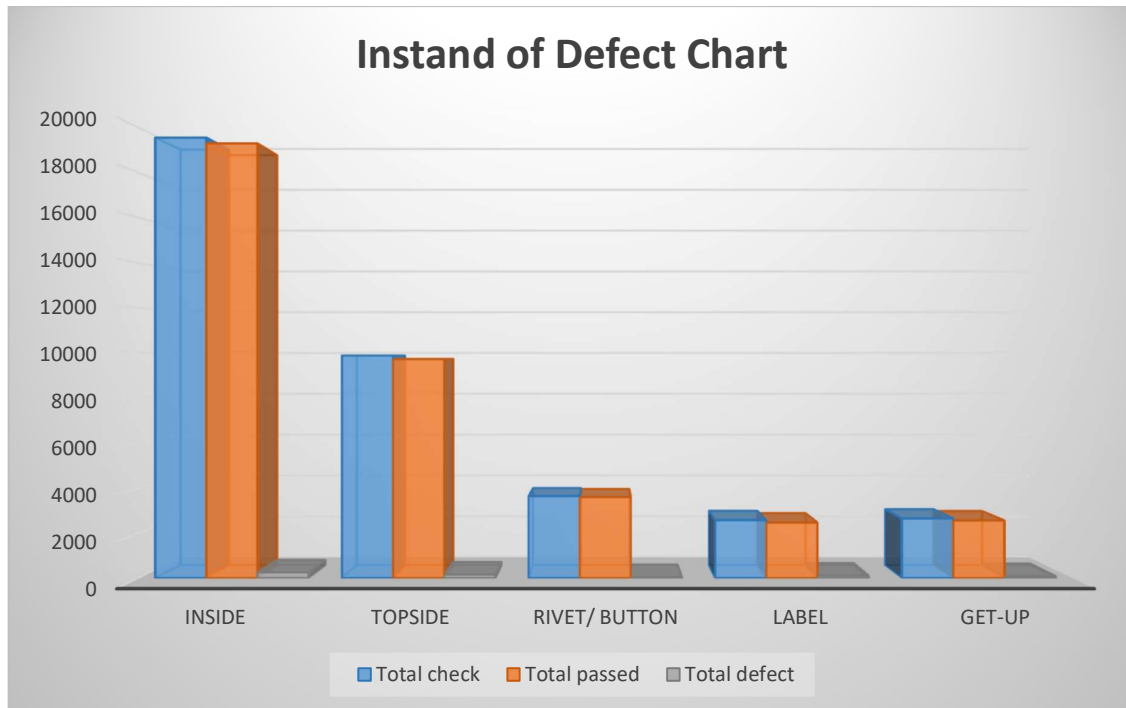


Chart: 4.9 (a) Instand of Defect Chart.

Here, the chart Instand of Defect summary shows us which defects take place and their quantity in every defect. We see that for inside total check 19562, total passed 19305, total defect 257, defect 1.57%, for topside total check 9884, total passed 9723, total defect 161, defect 2.07%, for rivet/ Button total check 3641, total passed 3600, total defect 41, defect 1.12%, for label total check 2571, total passed 2465, total defect 106, defect 4.12%, for get-up total check 2646, total passed 2560, total defect 86, defect 3.25% and this data is recorded in a one- Instand of Defect summary.

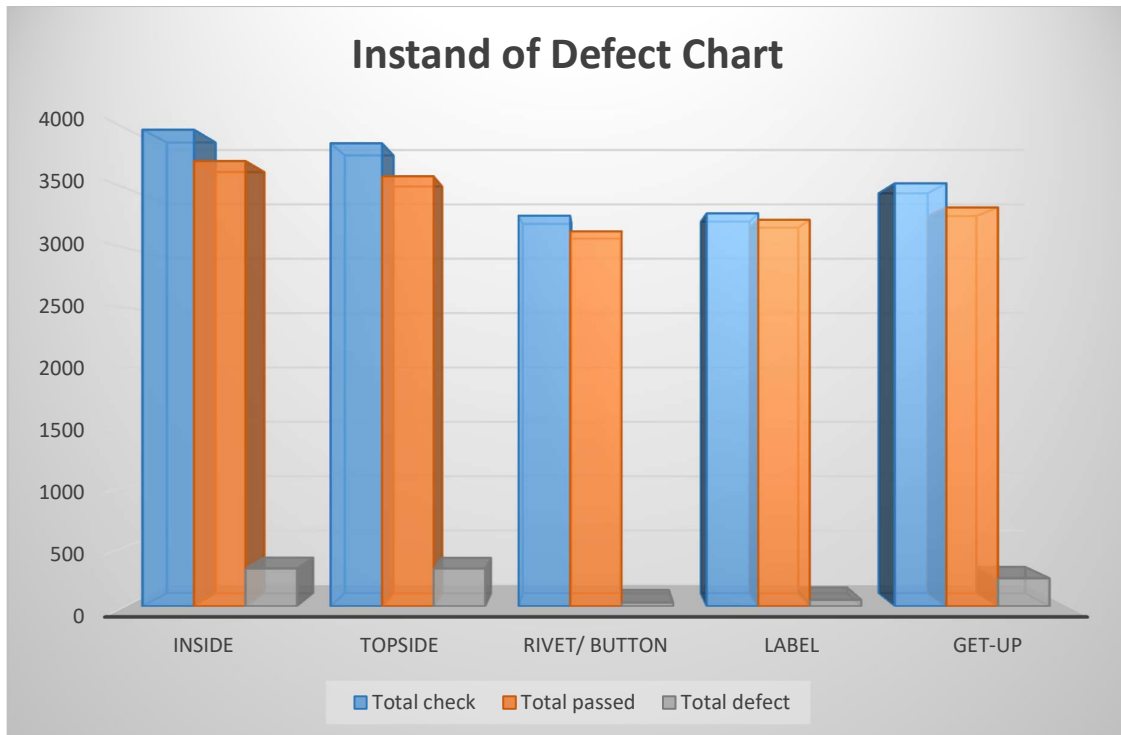


Chart: 4.9 (b) Instand of Defect Chart.

Here, the chart Instand of Defect summary shows us which defects take place and their quantity in every defect. We see that for inside total check 3990, total passed 3728, total defect 317, defect 7.94%, for topside total check 3876, total passed 3600, total defect 316, defect 8.25%, for rivet/ Button total check 3270, total passed 3236, total defect 31, defect 0.94%, for label total check 3541, total passed 3236, total defect 54, defect 1.64%, for get-up total check 3541, total passed 3339, total defect 235, defect 6.64% and this data is recorded in a one- Instand of Defect summary.

4.10 Analysis of Humidity Check Report

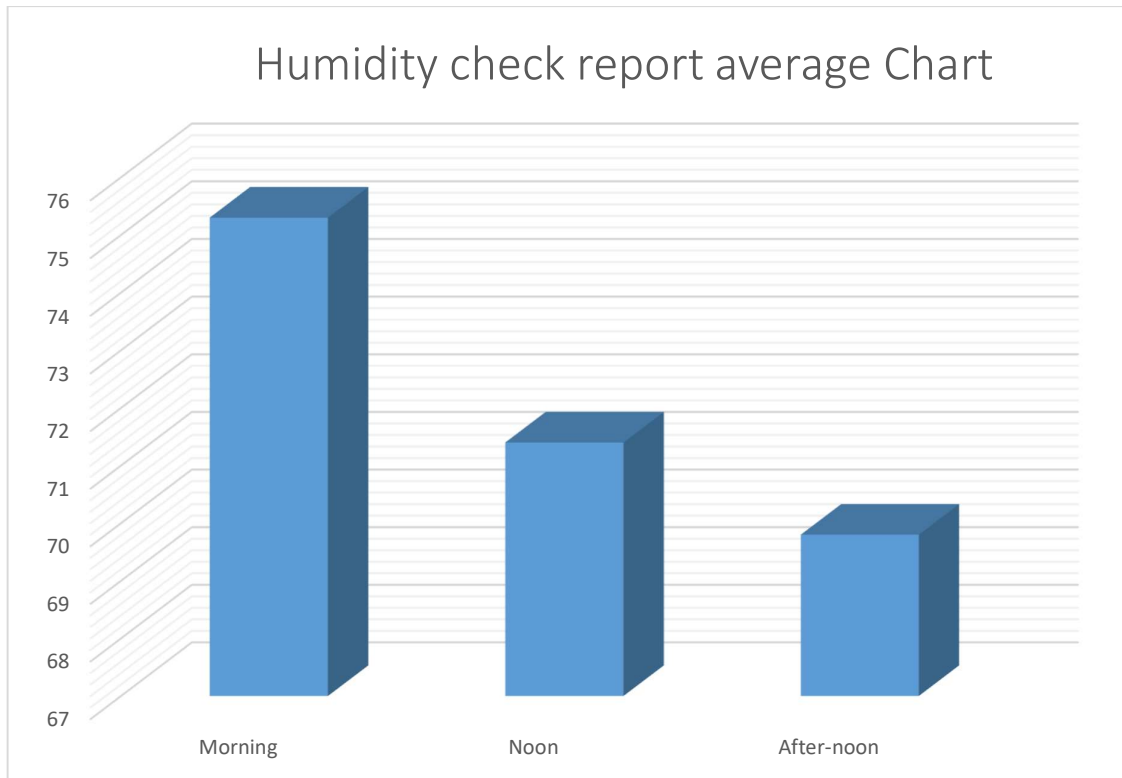


Chart: 4.10 (a) Humidity check report average Chart.

Here, the chart of Humidity check report shows us humidity and their quantity(average) in every day. We see that Morning 75.3%, Noon 71.4%, After-noon 69.8% and this data is recorded in a one-month Humidity check report average Chart.

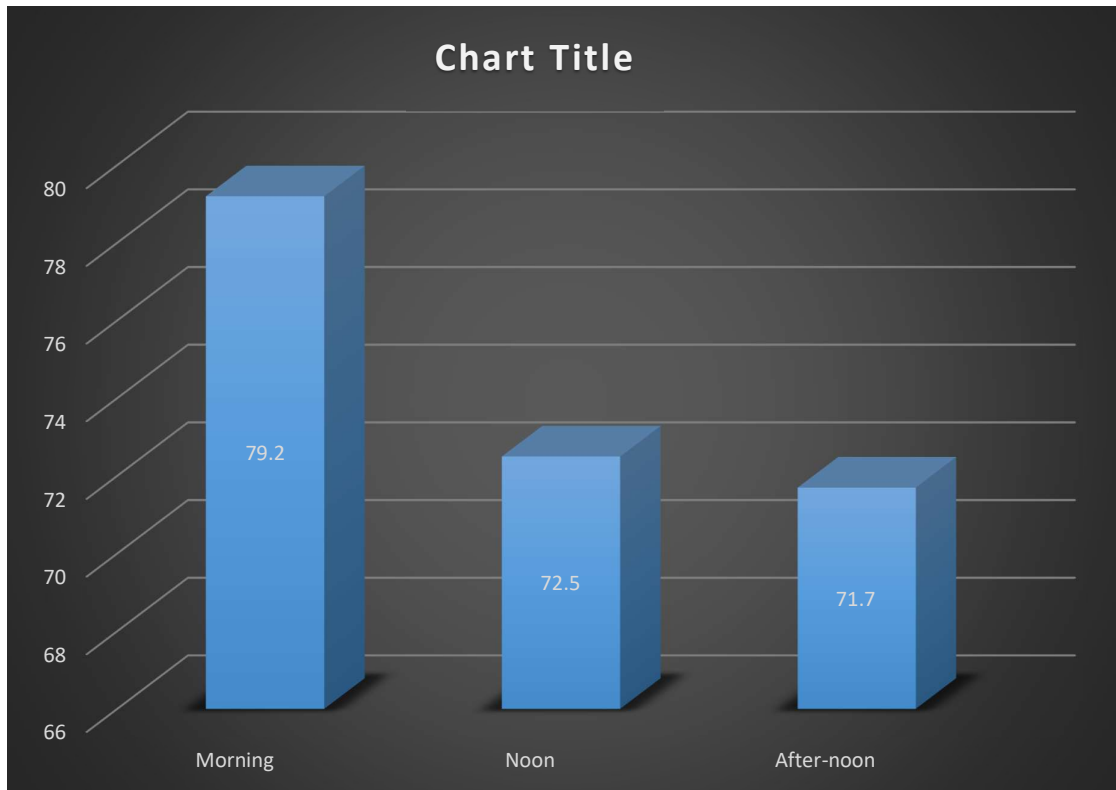


Chart: 4.10 (b) Humidity check report average Chart.

Here, the chart of Humidity check report shows us humidity and their quantity(average) in every day. We see that Morning 79.2%, Noon 72.5%, After-noon 71.7% and this data is recorded in a one-month Humidity check report average Chart.

4.11 Analysis of Label & Packing Audit Report

Here, the chart of Daily Style Check Report shows us which defects take place and their quantity in every defect. We see that the Process needed, main label, size label, care label, price tag, waist tag and the process doesn't needed are additional label, information tag, additional sticker, warning tag. These are recorded in a one-day Daily Style Check Report Chart.

CHAPTER 5: PROFESSIONAL RESPONSIBILITIES, HEALTH, SAFETY, SOCIO-CULTURAL & ENVIRONMENTAL CONSIDERATION

Here we will discuss whether the work done in our industries will not have any bad impact on the environment. And which aspects are better if we maintain such Health, Safety, and social responsibilities.

5.1 Codes and Standards Used

Tusuka Group Ltd. is one of the reputed garments industries of Bangladesh. Most buyers of Tusuka Group Ltd. are world-famous and conscious about the environment. Therefore, the precondition of their order is that all international codes of conduct must be maintained. BSCI & CSR rules and regulations must be followed. Zero tolerance for child labor, so that unusual problems can be avoided. Also, maintain ISO 9001 which defines the international standard for quality management. Must be maintained the ETP process. So, starting from sample production to bulk production, the amount of water required cannot have a bad effect on the environment.

5.2 Ethical Principles and Professional Commitment

The main principle & commitment is to work ourselves in the right way keeping the environment healthy for the next generation. Try to produce sustainable products. There is a practice of using organic cotton yarn to make garments. Using good quality dye chemicals which do not harm the environment or the body. Avoid abuse & harassment during the working period. After the main duty and not forced to do part-time for a long time. Gender discrimination must be stopped.

Fire drill at least once every month. And to ensure that all the workers leave the factory within 6 minutes.

5.3 Impact on Society, Health, Safety, Legal and Cultural Issues

Maintaining the code of conduct of international organizations has a positive impact on society. For example, by following the rules of BSCI, all the benefits of the workers are ensured. No workers can be added to overtime after specified duty. Paying wages on time, not taking child labor, and strictly monitoring the aspects of abuse or harassment of women workers fall under the norms of BSCI. Currently, most buyers have a must requirement to maintain BSCI principles. By doing this, workers are getting their fair benefits correctly, which is having a positive effect on society. CSR activities are another international organization's rules and regulations. Here all types of social issues are ensured. For example, ensure maternity leave and allowances for women workers. Make a mosque or school around the area where there are industries. As a result, it has a positive impact on society. As a result of maintaining ISO standards, customers are getting the right quality products. Safety issues of industries are monitored through social audits. As a result, industries are always prepared to extinguish the fire, with fire alarms installed everywhere, some emergency exits made, and some people always kept in the factory to extinguish the fire. Moreover, whether the workers have a standard washroom or not, and whether the workplace is proper or not, are observed in the social audit. Here, the safety of the workers is seen and on the other hand, and the working environment is also ensured.

5.4 Impact on Environment

Nowadays ETP is a common term in textile industries. We know that a lot of water is needed to produce garments. And if these waters are released in the same condition as they are used, then it has a serious negative effect on the environment. ETP Process is introduced to get rid of this. Through this, the water is treated and discharged into the environment which does not harm the environment. This ETP process is having a good positive impact on the environment. On the other hand, the industry is trying to produce sustainable products. Dry wash is trying to make it usable. Using organic yarn. All these works are having a good impact on the environment.

CHAPTER 6: CONCLUSION

In conclusion, quality control in the finishing section of garment manufacturing is essential to ensure that the final product meets customer requirements and standards. The study on quality control of different types of garments in the finishing section highlights the various aspects that need to be considered, such as checking for hourly defects %, lot pass audit records, monthly lot pass defect summary, daily style check, finishing in line inspections, hourly rivet/button check report, hourly label check report, humidity check report, maintaining consistency in measurements, ensuring proper stitching, and proper labeling. The study also emphasizes the importance of proper training of quality control personnel to ensure that they can detect defects and ensure that garments meet the required standards. Overall, the findings of this study suggest that quality control should be an integral part of the finishing section of garment manufacturing to ensure customer satisfaction and maintain a good reputation in the market.

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