Faculty of Engineering

Department of Textile Engineering

REPORT ON

"Identification of frequently found quality defects of woven and knit garment production"

Course Title: Project (Thesis)

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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

Faculty of Engineering

Department of Textile Engineering

Approval Sheet

This research entitled **"Identification of frequently found quality defects of woven and knit garment production' Daffodil International University, August, 2018** prepared and submitted by **Md. Mahfujur Rahman Sagar(ID: 111-23-2537) & Sonjoy Kumar Pk(ID: 143-23-3988)** in partial fulfillment of the requirement for the degree of BACHELOR OF SCIENCE IN TEXTILE ENGINEERING has been examined and hereby recommended for approval and acceptance.

Md. Abdullah Al Mamun
Assistant Professor
Supervisor

Declaration

We vouch that this report is absolutely our very own work, aside from where we have given completely recorded references to crafted by others and that the materials included in this report have not recently been submitted for evaluation in any formal course of study. In the event that we do anything, which is going to encroachment the primary statement, the analyst/administrator has the most extreme ideal to drop my report anytime of time.

……

Md. Mahfujur Rahman Sagar

ID: 111-23-2537

……..

Sonjoy Kumar Pk

ID: 143-23-3988

Dedication

Dedicated to the Teachers of our university and also our parents who sacrifice their whole life to make our future bright.Specially this thesis work is dedicated to our supervisor teacher Mr. Md Abdullah Al-Mamun. Asst.Professor & Associate head of textile department of Daffodil International University.

Acknowledgements

Research is not a very easy task. Different types of assistance and guidance are required to fulfill this task properly. This project entitled as '' **Identification of frequently found quality defects of woven and knit garment production**'' been completed by our own hands. This report is a series of inspiration, guidance and co-operation that we received from various persons during the work time. The whole project paper making time, teaches us a lot of new path which will be very fruitful for future life.

At the beginning,we want to express our heartiest gratitude to almighty. We are so grateful to our project supervisor **Abdullah Al Mamun sir,** Assistant Professor & Associate head, Department of textile engineering. We're grateful to him for being patience despite all of our mistakes.

We enhance our earnest thanks to all course teachers department of textile engineering , Daffodil International University for their valuable suggestions and important lecture in class at all stages of this research.We would like to thank library officials of central library of Daffodil International University for their support and co-operation at the time of literature review and study. Without which it was unattainable to conduct the research. Special thanks goes to **NiloyParvez, IE manager, Aman Graphics & Design Ltd ;** and Also Thanks to **Mr.Arup Kumar Sarker, Impress-Newtex Composite Textiles Ltd.** All who helped us giving their advice and valuable times for complete this work. We like to give them our heartiest thanks.

Abstract

Aman Graphics and Design Ltd and Impress Newtex Composite Textile Ltd clothes personalised restricted forayed throughout the textile trade. ab initio recognized to cope with the accelerated demands of the export advertise, today, folks are witness energetic presence with the footwear road of Bangladesh. the educational was drained Aman Graphics and style Ltd and Impress Newtex Composite Textile Ltd clothes by mistreatment of giant quantity regular stitching machines, ironing manufacturers. each info and cutting appliance is enforced in it. The agency is manufacturing lots clothes every and each day. Defect prevalence is concerning the most perils moon-faced by simply them however it's going to discover by the 2 machine furthermore as operator mistake. during this case, distinctive this often occurring defects whereas within the garment is important in an endeavor to attenuate most of the prevalence. the educational has conjointly been found variety of knit and woven materials fault severally. Defective items and thus the categories involving defects will be uncovered by the project. Analyses are designed with the small print and faults share is unquestionably found.The initial facilitate by this analysis is sometimes a scientific study from the assembly department to spot the failings. The generated information had been classified. straightforward tables had been ready along with generously aware of show the actual classified information to form straightforward together with higher savvy of the analyze. the commonly occurring defects and thus the defects that are tributary additional with the whole magnitude relation of disorders are recognized by categorization quest and researching. The nearly all occurring defects whereas within the clothes tend to be found to become skipped sew, lubricate spot and even loop slanted as an example. the key factors that cause prevalence of defects will be improper tension with the disk, repetitive entry to machines, improper handling for the garment additionally to needle carelessness. .It is sure instructed the very fact that the corporate will target these defects chiefly furthermore as technically variety of suggestions are shown to decrease the faults. This possibly means designed for raising the condition of productivity and conjointly save time.

Table of Content

Chapter -01

Introduction

Background of the study:

· Material assumes a delegated job all through the market of Bangladesh. By basically that, it is the way of life for the Bangladeshi monetary condition. Be that as it may, this methodology put neglects to get the accompanying spot rapidly. The material business with respect to our way of life is so old. From the expanding request toward the eastern development from the generation in cutting edge silk, cotton yarn, dependable couture strands seek and moreover development are composed.

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· The greatest assembling schedules of cloth and clothing segment Bangladesh. It gives guide occupations to 5,000,000 people.Textile and furthermore attire foundations supplies a solitary technique to achieving financial development inside the quickly obtaining economy associated with our nation. Fare with respect to materials in addition to articles of clothing is clearly the principle strategy to get remote money income. This area is simply not developed inside a brief timeframe.

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· Article of clothing High quality Control requires looking at a stock, administration, or process in the base nature of a base garments quality. In the event that a trouble is discovered, it may be incidentally to surrender creation of the quality ensure group or perhaps proficient. Depending identifying with explicit items, as splendidly as the sort of issue, creation or notwithstanding forming in regards to recognized strings undoubtedly isn't totally not open.

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· In the genuine attire industry quality control is polished ideal from the first stage in sourcing introductory waste brief of staying completed thing of article of clothing. For material and attire industry supplement quality is no ifs ands or buts estimated while considering quality notwithstanding standard associated with filaments, yarns, materials development, surface structures also, the last done article of clothing items and arrangements. Dimension of value desires with the end goal of fare are regarding and in addition the client sections and furthermore the retail put.

Objectives of this thesis:

· To know the super quality control.
· To target the individual reason of dresses fails.
· To know the take care of quality in the garments.
· To have a very good statistics flow of sample disappointed.
· To identify and summaries knit and woven garment faults amounts.

Scope of this thesis:

· Study, measure and help individual efficiency.

· Establish a more suitable system in order to rectify the particular sample disasters.

· Find and take necessary action for specific defects.

Research Design:

Research design part is called the blue print of the research. It shows the way of how the research work is done. The research design varies with qualitative, quantitative and mixed methodology all the time.

However, it is the planning of the research. Research design includes the time management, planning, action etc. An overall research of our research design is given below:

Title: time frame of the study

Activities	Date
Selection of topic	6th June of 2018
Literature review	7th to 14th June of 2018
Development of questionnaires/ checklist	25th June of 2018
Data collection coding and analysis	25th June to 7 July of 2018

Chapter -02
Literature Review

Quality:

Each and every product features some special characteristics for which it is in demand by consumers. History of quality is as old as human civilization itself. Aristotle 2500 years ago defines quality as following:

1. Quality is the difference between products.

2. It is the goodness or badness in products.

This definition holds true till this date. However, in general terms quality encompasses important characteristics of a product for which it is in demand. According to Philip Corsby, quality is “Conformance to requirements.”

2.1 Quality:

Each and each product options some special characteristics that it's in demand by customers. History of quality is as recent as human civilization itself. philosopher 2500 years agone defines quality as following:
1. Quality is that the distinction between merchandise.

2. it's the goodness or badness in merchandise.

This definition holds true until this date. However, normally terms quality encompasses necessary characteristics of a product that it's in demand. per Prince Philip Corsby, quality is “Conformance to needs.”

Quality objectives:
• Finding customer’s demands and expectations, and meeting their demands to the best.

• Knowing and fullfill the applicable regulative demands.

• incessantly growing market shares.

• rising production and reducing prices.

• Providing needed assets as well as data to not tell coaching to employees.

• Adding worker in the least levels.

• Meeting high standards of safety, health and atmosphere.

Quality Types:

1. Product control:
The management that is employed to decrease defective things at intervals completely different plenty of created sensible is thought as product management. it's used when production method.

2. method control:
Controlling of method sequence or steps to provide desired quality product is named method management. There are 2 kinds of method management that is given below

a. on-line quality control:
This categories of internal control is performed in method position . while not move the assembly method, throughout the assembly time period schedule, the machine mechanically tests the model and takes prompt step to correct the variation. this sort from internal control is performed in method position i. e. no end the assembly method, throughout sometimes the assembly time period frame, the machine mechanically tests the model and takes prompt step to correct the variation.

b. Offline quality control:
This individual internal control consists of laboratory tests that are sometimes done by ceasing the assembly course of action. Here requir steps are taken to check result.
Example: clothes final check from ton Shade matching coloring time.

customer Quality Types:
In terms of quality level consumers, vesture is classed in three classes likes, the primary quality – A grade
Second quality - B grade Third quality - C grade

1. 1st Quality:

The buyer WHO are able to gratify the consumers and maintain all its qualitative options which is also not in each major accident is taken into account 1st quality or maybe a grade. A-grade dress appearance sensible. they are doing not possess any leading accidents throughout purchase and so aren't denied towards wear quality.

2. Second quality:

The buyer WHO are in a position tosatisfy the consumers and maintain all its qualitative options which is also not in everymajor accident is taken into account 1st quality or maybe a grade. A-grade dress looksgood. They donotpossessanyleadingaccidents throughout purchaseand thus aren't denied towards wear quality.

3. Third quality:

Although this specific dress has abundant small wounds, maintaining useful quality and as a procurement sperson, like the salecapability. Theysometimeslosesomegeneral good-lookingfeatures butdo not lose acceptancebecause of consumers. Someof sometimes theflaws visiblefrom outsidemay even be these dresses. Somebuyers enable 2 major flaws through second quality apparel. three or any major flaws flip down them

Importance of quality:

1. betting on product quality, customers have to be happy in stipulations of beauty, attraction, taste, shape, style and longevity.
2. while not quality nothing will live utterly.

internal control
Quality Control is seen because the agent of Quality Assurance or Total internal control. within the fashion industry internal control is practiced right from the initial stage of sourcing raw materials to the stage of ultimate finished garment. For textile and rag trade product quality is calculated in terms of quality and normal of fibers,

yarns, cloth construction, color fastness, surface styles and also the final finished garment merchandise. but quality expectations for export are associated with the kind of client segments and also the stores. internal control and standards are one among the foremost necessary aspects of the content of any job and so a significant think about coaching

Objectives of Total Quality Contro

The main object is nearly forever to maximise the formation of products at intervals the desired tolerances properly the primary time.

Find all reasonably defect touching quality.

the wants of internal control

For every purpose of way of life we would like quality. Quality is often a lot of necessary than amount. while not sensible qualityeven wedon't comply with have a simplepen. thus quality is alwaysthe 1st choice to any given needs.

internal control perform

The first live for internal control is nearly forever to know, establish & take the customers'ood needs. This involvesthe next steps: -

• obtaining customers specifications relating to the standard.
• Finding our past performance.
• created dialogue with the standard management Department.
• activity with sometimes the assembly Department.
• realize the Feed Back to the customers.
• Receiving the altered quality needs from the shoppers.
• acceptive the standard parameters.

1. check Properties of Yarn

• If routine checks are disbursed on yarn choose a delivery of general tex (count,denier).
• If incoming yarn isn't checkedthen take alook at the tex (count, denier) of the delivery for samples and solely use if it's at intervals acceptable ambit.

Record details from yarn sort, supplier, tex (denier, count) etc. andpass recommendation to knittinghome.

2. Knitting Specification

• Save alldetails requiredto producethe clothesor garmentblanks as well as all, sew length similarly as any instrument choices.
• Record all details of creating the accessories
• Write any difficulties encountered e. g. sew pattern inflicting occasional drop stitches. Pass data to creating space.

3. Making-up Specification

• Record all details of making-up, as well as the kind and count of this stitching thread, and also the order of seaming the components.b)
• Note any difficulties encountered e. g. tough operation to connect collar

4. check for Physical Properties of clothes

Documented

the dimensionsof the apparelas it iscompleted

Forfiber of highmoistureregain realize theweight incorrect condition. Wash appareland re-check themmeasurements'.

internal control with CostDepartment
Supplycost department withall info.
create associate degree allowancefor any anticipated extradifficulties, or the next than traditional rate ofseconds.

internal control knowledge generated

Data is provided at eachQC issue. This should end up to be recorded in easy systems to supplyvisual on-goingprobes. These recordsprovide the means that for worker responsibility and designed for fast feedbackintendedfor management action.

1. Raw Materials:
• Shade - realize to be withintolerance from normal pattern.
• Delivery weight - checked andany limitation claimed.

2. Yarn Checks

• Bulking Tests on ContinuousFilament TexturedYarns: Check regarding consistency, and upon Filamentation
• Condition Checks: Checkconcerning incorrect condition
• Yarnwrapping
• Levelness ofyarn (also Buyerlevelness).

3. textile machine Settings

• Yarn 10 sion - leveled and toknittin specification.
• Distribution - T. O. Depth dialsheight - set to specification.
• Loop/course length : dispute leveled and tospecification, positive givefood to checked.
• Take-down tensions - checkedfor consistency

4. cloth Parameters, cloth or Garment Blank Checks

• Shade as wellas look correct jacquardtrend correct, absencefrom barrenness.
• Widt traditional
• Finishingloss
• Responsibilityof knitters

5. stitching Checks

• Stitches per metric linear unit. and thread dispute quantitative relation checked to be at intervals tolerance of the specification.
• Evenness, balance and proper bight, nostitching uncomprehensible
• demand and securitycorrect (i.e. no cracking or laddering).
• Absenceeofskip handicraft.
• Responsibility ofmachines
6. Final Inspection:

• Cut is actuallycorrect - o. g. neck, collar and sleevesbalanced, pocketscorrect.
• Measurements at intervals tolerance of specification, weight correct.
• look correct, patternsmatching.
• Seams finished properly, absence frommiss handicraft, cracking and laddering.
• Accessories properly applied andworking

• Recovery review

1. Check on amountof offer sensible resultssuccessfully recovered.
2. turning away of workrecycling

• Product Tests

1. Color quick cape so as to agreedagencies: (e. g. washing, rubbing, perspiration, lights) - examine and on-going continuity cardsgenerated, showing score, checked against designs.
2. Stability: Shrinkage,and extension recovery whereneeded - to be at intervals tolerate in specification
3. Endurance: Abrasion,pilling or snagging - certifiedwhere required. Rating checked againstspecification.

Quality standards

Quality control and standards are one among themost importantaspects of the content of any job and thereforea major think about coaching.
By a QualityStandard we have a tendency to mean the institution of the edge at that level of severity adefect becomes unacceptable, i.e. a fault. it's the equivalent of tolerances applicable to measurable factors.
Systematic coaching involvesthe coaching of someone in: -

Basic data

Correct ways

Quality standards

Without thislast item defective production cannot beprevented.

These standards areestablished from theSpecification and shopping for sample, etc.
Next stepis management ofconsistency, - i.e. superintendence of,and review when, every stage ofmanufacture.

The importance of internal control

• Rejectionof merchandise, accessories
• need outside qualitycontrol services (extra expenses)
• Degradationof mill and BrandValue
• Low impelled workers,nobodywants to induce blame
• could causefor arecall
• Delay inproductiontimes

When theright QCin no meansin place it willcost you time together with moneyhurting your brandnamealong the way.

the way to management quality:

The keystep tocontrolling qualityin the textileindustry ought to begin at the clothes mill which requiresspecialized instrumentation. Textiletesting instrumentation is that the best and price effectiveway of keepingstandards inplace throughvarious wares productions. There areadditional waysto guarantee internal control within the mill and theinclude:

1. guarantee operatorhaveproper coaching and use quality stitching materials
2. perceive and followquality specifications
3. give sensible and unhealthy feedbackon merchandise being factory-made

internal control in cloth section

The quality of the material is responsible forquality analysis with internal control and also the responsibility to spot whether or not adress is a foothold to satisfy the requirements of consumers. Generally, sample samples are testedby the client and per approved samples. within the cloth the standard is testedto meet the customer's needs. Quality controlfunctions Assoon because the allocation for the standard Innovation Department of Fabian In-House andKatie Division begins.

Most inspectors are given the responsibility to go to finished clothes while not adequate coaching for material variations and their causes. the ultimate answer is, of course, each major and minor flaws are supplied with actual examples or images. This sectionprovides an inventory oferrors and explanations and simplifies the language and judgments used tocreate visual cloth surveys. internal control manager will give this list to inspectors as a sensible toolfor achieving uniform review selections.

Quality parameters of plain-woven, unwoven and non-woven Fabrics:

Generally to check the standard parametersof plain-woven, knittedand non-woven cloth, the material should beconditioning at twenty four hours within the normal testing atmosphere. It isvery necessary for all kinds of material. for all kinds offabric.

Quality parameters of plain-woven fabrics:

There are some quality parameters of plain-woven cloth

1. Dimensionalcharacteristics:

- Length
- Width
- Thickness.

2. Weight of fabric:

- Weight per unit space.

- Weight per unit length.

3. cloth strength and extensibility:

- strength.
- Tearing strength.

4. Threads per in. of fabric:

- Ends per in..
- Picks per in..

5. Yarn count:

- Warp count
- yarn count.

6. Crimp:

- Warp crimp
- yarn crimp.

7. Handle:

- Stiffness
- Drape.

8. Crease resistance and crease recovery.

9. Air porosity.

10. Abrasion resistance.

11. Water resistance.

12. Shrinkages.

13. completely different fastness properties:

- Fastness to lightweight.
- Fastness to clean.
- Fastness to perspiration.
- Fastness to Rubbing.

Quality parameters of unwoven fabrics:

There are some qualityparameters of knit
1. Strength and extensibility.
2. Coursedensity.
3. Wales's density.
4. Loplength.
5. Elasticity.
6. Deformation.
7. Grams persquare meter(G.S.M)
8. Yarn count.
9. Design.

Quality parameters of non-woven fabrics:

There are some quality parameters of non-woven cloth

1. Strength and extensibility of material.
2. Weight.
3. Thickness.
4. Airpermeability.
5. Crease resistance.
6. Stability of laundry.
7. Stability of cleansing.
8. Dimensional stability.
9. Elasticity.

cloth Quality review

Regarding vesture trade, it's potential tovisit a visible check or material (such as cloth, knitting thread, button, trim etc.). it's a vital side before the assembly of vesture to avoid cloth because of qualityof the material and to avoid facing the surprising loss of production. the standard of a final garment depends on the standard of a material once it's obtained as a roll. Eventhe greatest production ways cannot atone for faulty materials.Generally, we have a tendency to assess and appraise tenth of their rolls basedon a four-point system. during this means, we are able to avoid cloth connected quality issues beforewe are created.

cloth Quality review methodology

Normally four systems are used for review of finished clothes.

a) four purpose system
b) ten purpose system
c) Graniteville "78"system.
d) urban center system.

4- purpose review system

In this system, what number defect purposes in one hundred sq yards of material are known by inspection? the material is meant to be rejected if the amount of defect point is forty or a lot of in every one hundred sq yards of material. Allowable defect points is also over forty relying upon theprice and quality of clothes, however it really comesout by betting on the understanding between customer and manufacturer. Thedefect purpose distribution for various styles of fault is given the subsequent slide:

Basic principle:

Defect purpose values ought to be counted in one hundred yd2 cloth. If defects purpose values are forty or less then it indicates 1st quality cloth. The grading vary is given below:

Point grade

2.3.1 All the above processes have discussed in the belowtable:

S/L No.	Process	Procedure
01	Input material check	It is the first processof quality control in sewing section. Here all the input materials should be checked to complete all the sewing processes accurately.
02	Cutting panel and accessories checking	All the cutting panels andaccessories should be checked here to avoid mismatching with the other cutting parts and trimmings.
03	Checking sewing machine	According to buyers approvedsample, right sewing machine should be selected here to complete all the required sewing for the garments.
04	Sewing thread checking	It's a very importantmatter in sewing section. Sewing thread should be selectedhere according to buyers approved sample.
05	Sewing needle checking	Here, required sizes needleshould be selected to complete fault free sewing for the garments.
06	Embroidery and printing panel checking (If there)	If there's any embroidery or printlies in the garments, then it should be checked by maintaining buyers approved sample.
07	Stitching fault checking	After making thegarments, here garments checked to identify stitch fault free garments.
08	Seam fault checking	After checking stitch, allthe seam of garments must be checked here.
09	Measurement checking	According to buyer's instruction, garmentsmeasurement has to check here.
10	Shade variation checking	Sometimes various types of shade variationhave seen in the garments which should be checked here.
11	Size mistake checking	For submitting perfect size of garmentsto the buyer, an extra checkinghas needed here.
12	Trimmings checking	According to buyers approved sample,required trimmings of garments should be checked here to make fault free garments.
13	Interlining checking	Interlining checking should bedonehereby the quality inspector whether it is perfect or not.
14	Crease or wrinkle appearance checking	It is the last process of quality control insewing section, where quality inspector confirms crease or wrinkle free garments.

stitching Department:
method examination insewing line quality examination

1. stitching Line quality Check List
Buyer Approved Sample& MeasurementSheet Check. Sample Wise InputCheck.
BuyerApproved Trims CardCheck.
Buyer ApprovedSample Wise StyleCheck. All Machinethread Tension Check.
Style Wise Print & Embroidery Placement Check. All method MeasurementCheck.
All MachineOil check.
All method S.P.ICheck as Per purchaser demand.
Input Time Shading, BundleMistake & Size Mistake Check. purchaser Approved Wise distinction Color Check.

As per purchaser RequirementWise Styling Check. All sewing-machine stitch Tension Balance Properly.

2. stitching Table examination
vogue WiseGarments Check.
All ProcessMeasurement Check...
Front Part, Back Part,Sleeve &Thread; Shading Check.
S.P.I Check for All method.
Print/EmbroideryPlacementCheck.
Main Label,Care Label, Size Label &Care; image Check. Size MistakeCheck.
S All ProcessAlterCheck.
Anyfabric fault/Rejection Check.

internal control in finishing:

Machine and instrumentality utilized in finishingsection:

1. Thread sucker machine
2. Thread Cutter
3. Hand tag Gun
4. Lifter
5. Iron
6. Metaldetector
7. Textilecleaning Gun etc.

method Flow Chart of GarmentFinishing:

Finishing input (style, color & size wise)

↓
Initial quality check
↓
SpotRemoving
↓ Ironing/Pressing
↓ examination
↓ Hang tag
↓
Getup modification
↓ Folding
↓ Poly
↓
Barcode (buyer wise sticker)
↓ Metal check
↓ Cartooning/Packaging
↓
Final examination by purchaser

internal control policy for garment finishingsection:

To maintain top quality, garment qualitypolicy should be adopted within the finishing floor. Some essential policies are as follows:

once trimming the redundant threadall clothes are being sent to iron sectiondirectly.

QC prepares a report in thisregard and place up to AGM of the ground for his review.

At the top of the day anotherQC person isdoing the day-final and creating a report during this respect and keeping record. If thegarments are found with drawback in thday final; then allthe clothes are being opened and re- checked.

At the end, once completefinishing operation ofany order they're doing the pre-final or ton pass examination from the purpose of viewof purchaser and creating an entire report in his regard maintaining record additionally. If the result are going to be found OK solely then they'll offer finalinspection.

once the garmentpass the pre-final or mock upinspection then all the clothes are unbroken underneath constantobservation.

during this stage, garment makers areorganized final examination for clothes. once finishing the ultimate examination from the consumers representative and that they are build finalinspection reports. If the reports are OK then the orders areready forshipment.

Steps of clothes Finishing:

The steps of clothes finishing are as follows-

1. merchandise Received from SewingSection:

At first, finished clothes are received from stitching section as per order amount. sensible received fromsewing section is that the beginning to finishing section.

2. Thread suction byMachine:

In this ste further lose sewingthread are suction by suckingmachine in clothes. Threads aresuckered by twosystems. Oneby done byhand that is manual system and therefore the otheris done bysucking machine.

3. Ironing:

Ironing isa finishing method doneby a artifact to heatand pressure with orwithout steam to get rid of creases and toimpart a flat look to clothes. Ironing methodis additionally calledas pressing process. Aftercompleting ironing, garmentshave to befolded.

After on top of method,different types of tags andaccessories areattached with the clothes Turkish monetary unit purchaser comment. Foran export order, mustattach value tags withthe clothes.

7. MetalDetection:

Garmentsare passed throughinto the metaldetection m/c for metal check. Nowmost of the customer suggested to use metaldetector for clothes moresafety. Touse metaldetector for kid'sitem ismust.

8. Folding:

Garments are closed in line with purchaser directions in astandard space. There are fore varieties of folding in clothes. they're as follows-

a. Stand up

b. Semistandup

c. Flatback

d. Hangerpack.

8. Packing:

After folding clothes are prepared for packing. the dimensions of synthetic resin is vary in line with the dimensions, clothes magnitude relation. Before packing it's required to confirm the position of sticker in correct place.

9. Assortment:

After finishing the packing, it mustbe placed the clothes during a preset packed by sorting in line with the dimensions andcolor is named assortment.

10. Cartooning:

At last cartooning is doneaccording to purchaser comment into the inner boxes and is properlywarped by the scotch tape. Sominformation like carton box no, size, shipping mark, destinationare written on thecartoon.

11. Final Inspection:

Final examination is a crucial half andlast step of clothes finishing.

Methodology

Locationof thestudy:

The study has principally on primarydata. Mixedmethod has beenadopted. info has beencollected fromworker ; howevertheunit of research isindividual . Secondary sources of informationhave alsoused. The researchhas been conductedatAman Graphics and style Ltd (A Sister concern of Unifillgroup) and ImpressNewtex Composite Textile Ltd

Sample size and Sampling technique:

Atotal of a line are selectedforsample .factory iscomposed of 3500 folks The analysis has been conducted. It hasbeen hand-picked throughconsultation with quality department andsewing sectionauthority. In here are half-dozen daypurposively hand-picked as sample for information analysis in qualitative methodology.

Criteria of sample selection:

Sample has been hand-picked purposively following 2 criteria:

- employee aged between 18-30years
- are operating atindustry a minimum of for last 2years

DataCollection:

Defects per hundred unites calculation:

- "Defect per hundred Units" It means that variety of defeats found or detected per one hundred clothes.
- Defects per hundred unite = Total Alter pcs *100/ Total clothes
- during this analysis all datacollect during a finish Line examination Report sheets

information collectionperiod:

10 days of June 2018

Limitations of thethesis:

Most of the analysis study hassome limitations. As a investigator, this analysis additionally has some limitations.Researcher desires to outlines some the constraints of the study:

method limitations: investigator has used mixed methodology in conducting this analysis. investigator believes realistic approach is acceptable for this analysis investigation. At the identical it's believed that quantitative nd mixed methodology may make a case for thetopic.
Time : Time is extremely vital think about conducting any analysis. investigator believesthat for a decent, neutral analysis timeframe is extremely essential. however during this researchresearcher solely gets up to 5-6 month. this point isn't enough forconducting such aresearch.
Budget : investigator doesn't getany cash from department. All the expenses are beardby the investigator himself. As a student it appears a touch burden for the investigator. He had to chop some essential to keep up hisbudget.
because of the shortage of timewe couldn't get at depth data of thequality.
Sufficient records, facts and figures don't seem to be on the market.

5. Measurement Check byQC:

6. Attach Price Tags andAccessories:

After above process,different types of tags andaccessories areattached with the garments asper buyer comment. Foran export order, mustattach price tags withthe garments.

7. MetalDetection:

Garmentsare passed throughinto the metaldetection m/c for metal check. Nowmost of the buyer recommended to use metaldetector for garments moresafety. Touse metaldetector for kid'sitem ismust.

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Garments are folded according to buyer directions in astandard area. There are fore types of folding in garments. They are as follows-

a. Stand up

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d. Hangerpack.

8. Packing:

After folding garments are ready for packing. The size of polythene is vary according to the size, garments ratio. Before packing it is needed to ensure the placement of sticker in proper place.

Garments Packing Process

9. Assortment:

10. Subsequent to finishing the pressing, it mustbe put the pieces of clothing in a foreordained stuffed by arranging as indicated by the size andcolor is called grouping.

11. Cartooning:

Finally cartooning is doneaccording to purchaser remark into the internal boxes and is properlywarped by the scotch tape. Sominformation like container box no, measure, shipping mark, destinationare imprinted on thecartoon.

12. Final Inspection:

Final inspection is an important part andlast step of garments finishing.

Methodology

Locationof thestudy:

The study has mainly on primarydata. Mixedmethod has beenadopted. Information has beencollected fromworker ; howevertheunit of analysis isindividual . Secondary sources of informationhave alsoused. The researchhas been conductedatAman Graphics and Design Ltd (A Sister concern of Unifillgroup) and ImpressNewtex Composite Textile Ltd

Sample size and Sampling technique:

Criteria of sample selection:

Sample has been selected purposively following two criteria:

- Worker aged between 18-30years
- Have been working atindustry at least for last 2years

DataCollection:

Defects per hundred unites calculation:

- **"Defect per hundred Units"** It mea ns number of defeats found or detected per 100 garments.
- Defects per hundred unite = Total Alter pcs *100/ Total garments
- In this analysis all datacollect in a **End Line Inspection Report** sheets

Data collectionperiod:

10 days of June 2018

Limitations of thethesis:

The greater part of the exploration think about hassome restrictions. As a scientist, this exploration additionally has some limitations.Researcher needs to diagrams some the restrictions of the examination:

Methodological confinements: Researcher has utilized blended philosophy in directing this exploration. Specialist accepts naturalistic methodology is suitable for this exploration examination. At a similar it is trusted that quantitative nd blended technique can likewise clarify thetopic.

Time : Time is imperative factor in directing any examination. Analyst believesthat for a decent, unbiased research time span is exceptionally fundamental. In any case, in this researchresearcher just gets up to 5-multi month. This time isn't sufficient forconducting such aresearch.

Financial plan : Researcher doesn't getany cash from office. Every one of the costs are beardby the scientist himself. As an understudy it appears a little weight for the specialist. He needed to slice some fundamental to keep up hisbudget.

Because of the deficiency of timewe couldn't get at profundity learning of thequality.

Adequate records, statistical data points are not accessible.

Data Analysis

Sewing defect report of the Knit garment:

Impress Newtex CompositeTextile Ltd

Table 1

Order No: AO17-17-792				Style No: S18AFLPOWO2				Color: R1		
Buyer: Kmart								Date: 24-06-2018		
Defects Name	Hour									
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Broken stitch											
Button/snap/ Adjustable		2 33									
Button hole											
Fabric fault											
Dropstitch			2								
Needle hole						7					
Cut damage											
Improper tuck											
Improper shape							4				
Joint stitch				4							
Label fault											
Needlemark									5		
Open seam											
Print fault											
Embroidery								4			
Puckering											
Raw edge					1						
Reverse											
Slanted										6	2
Skip stitch											
Shading											
Strip not match											
Thread mistake			2			1					
Twisting								5			
Thread tension									5		1
Measurement deviation(+)			1								
Measurement Deviation(-)											
Updown					4						
Un even											

Uncut thread		2		2		4		5		5	
Waviness											
Wrong SPI									1		
Labelwrong placement											
Yarn contamination											
Collar						2					
Placket											
Rocket			2								
Pleat										2	
Side band											
Oil spot											
Dirty spot							2		5	4	
Rejects	2		5	1							
Others					2						
Total Inspected Qty	2	5	5	6	2	7	5	5	4	3	55
Total OK Goods	2	22	5		5	22	1	2	1	4	
Total Defectives Qty	50	23	15	14	20	22	123	24	6	4	
Reject Qty											
DHU%											9.21%
QC pass%											90.19%

Table 3.1: Quality Report on 24.06.2018 of a knit garment factory

Order No: 30A05O95			Style No: TAZ TEE			Color: GREEN DARK				
Buyer: M&S						Date: 26-05-18				
Defects Name	Hour									
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Broken stitch			5			2	2	2			
Button/snap/ Adjustable											
Button hole											
Fabric fault											
Drop stitch											
Needle hole											
Cut damage											
Improper tuck											
Improper shape											
Joint stitch											
Labelfault											
Needle mark											

Open seam											
Printfault											
Embroidery											
Puckering				2	1	5		1	2		10
Raw edge											
Reverse											
Slanted											
Skip stitch				5		1	6				12
Shading											
Strip not match											
Thread mistake											
Twisting											
Threadtension											
Measurement deviation(+)											
Measurement Deviation(-)											
Up down					1	3					4
Un even			5	1					1		7
Uncutthread											
Waviness											
Wrong SPI											
Label wrong placement											
Yarn contamination											
Collar											
Placket											
Rocket											
Pleat											
Side band											
Oil spot		1	2	4		4	3			1	20
Dirty spot											
Others											
Rejects											
Total Inspected Qty			20	35	65	65	75	40			300
Total OKGoods			25	30	70	60	80	35			300
Total Defectives Qty			4	5	11	13	12	12			58
Rejects Qty											
DHU%											19.34%
QC pass%											80.66%

Table 3

Order No: 274274			Style No: RONNY				Color: white			
Buyer: BigW							Date: 27-05-2018			
Defects Name	Hour									
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Broken stitch	1		2			2		2			7
Button/snap/ Adjustable											
Button hole											
Fabric fault											
Dropstitch											
Needle hole											
Cutdamage											
Improper tuck											
Improper shape											
Joint stitch	1	3	1	2	2			2			11
Label fault											
Needlemark											
Open seam			1	1		1		1			4
Print fault											
Embroidery											
Puckering	1	1	2		1	2	1		1		9
Rawedge		1		4	1	2	1				9
Reverse											
Slanted											
Skip stitch		1			2			1			41
Shading											
Strip not match											
Thread mistake											
Twisting											
Thread tension											
Measurement deviation(+)											
Measurement Deviation(-)											
Up down		1	3	4	2			1			11
Un even	1	1	1		2	3		2			10
Uncut thread	1	6	4	1	3	4	3	4			26
Waviness											
Wrong SPI											
Label wrong placement											
Yarn contamination											
Collar											
Placket											

Rocket											
Pleat											
Side band											
Oil spot		1					3				4
Dirty spot											
Others	1		1	1			1	1			5
Rejects											
Total Inspected Qty	90	160	150	140	150	170	100	110			1070
Total OK Goods	90	160	150	140	150	170	100	110			1070
Total Defectives Qty	10	14	12	16	17	13	10	14			106
Rejects Qty											
DHU%											9.90%
QC pass%											90.1%

Table 4

Order No: 223256			Style No: LEE LONG				Color: WHITE			
Buyer: H&M							Date: 22-06-2018			
Defects Name	Hour									
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Broken stitch											
Button/snap/ Adjustable											
Button hole											
Fabric fault	2	1									3
Drop stitch											
Needle hole											
Cut damage											
Improper tuck											
Improper shape				1							1
Joint stitch											
Label fault											
Needlemark											
Open seam											
Print fault											
Embroidery											
Puckering											
Rawedge											
Reverse											
Slanted											
Skip stitch	3	1		1						5	

Shading											
Stripnot match				2						2	
Thread mistake											
Twisting											
Thread tension											
Measurement deviation(+)											
Measurement Deviation(-)											
Up down											
Un even											
Uncut thread											
Waviness											
Wrong SPI											
Label wrong placement											
Yarn contamination											
Collar											
Placket											
Rocket											

Pleat											
Sideband											
Oil spot											
Dirty spot	1										1
Others											
Rejects											
Total Inspected Qty	100	110	116	100	111						537
Total OK Goods	100	110	116	100	111						537
Total Defectives Qty	3	4	1	3	4						15
Reject Qty											
DHU%											2.77%
QC pass%											97.23%

Summary of Reports (Impress Newtex Composite Textile Ltd.) in sewing section.

Date	Buyer	InspectedQty	Defects																			
			Brokenstitch	Labelfault	Slanted	Skipstitch	Updown	Uncuttread	peat	Puckering	Uneven	Oilspot	Joinstich	Reverse	Needlemark	Impropertuck	Openedge	Rawedge	Dirtyspot	Needle hole	Rejects	Others
24-06-18	sportmaster	1104	5	7	14	1	7	31	8												4	4
26-06-18	H&M	300	7			11	3			12	6	19										
27-01-18	H&M	1070	6			3	9	36		8	12	3										7
28-06-18	H&M	855	6			4	15	45				5	10	10								3
29-06-18	H&M	1250	2			3		17				2	2	1	2							1
30-06-18	H&M	1340	09	1	4	20		48	12		22					17	1	5	14			
22-06-17	H&M	537	3				5	2											1	1		
Total		6456	38	8	18	42	39	**179**	20	20	40	29	12	11	2	17	1	5	15	1	4	15
			516 (7.95%)																			
	Defect %		7.36	1.55	3.88	8.13	7.55	**34.68**	3.87	3.87	7.75	5.62	2.32	2.13	0.38	3.29	0.19	0.96	2.90	0.19	0.77	2.90

Here is the highest defects % is **34.68** that is uncut thread

Woven data from sewing section:

b)Aman Graphics & Design Ltd.

Date	Buyer Name	Style	Total No. of Pieces Inspected	Total No. of Pieces Pass	Total No. of Defective Pieces	Man											Materials					Machine			Method			Total Defects	DHU	Percentage of Defective
						Un cut thread	Puckering	Broken Stitch	Bartack missing	Button or hole Missing	Uneven Shap	Up Down	Shading	Other	OPEN SEAM	Joint Stitch	Raw edge	Down Stitch	Spot/Dirty Spot	Rejects	Skip stitch	Thread tension	Pleat	Revars	Lebel wrong position/Open	Loop Slanted	Style mistake			
01-Jun	M & S	2722J	643	548	95			6			8	28		15	8	10	5				10		10					100	15.55	14.77%
02-Jun	M & S	2722J	678	595	83			21		10	10	21			7	5	11						3			3		91	13.42	12.24%
03-Jun	M & S	2722J	716	638	78		5	15		8	10	17		14	5	3	2						4					83	11.59	10.89%
04-Jun	M & S	2722J	560	501	59			5	5		8	17			5	7	3						3					53	9.46	10.54%
05-Jun	M & S	2722J	624	550	74			17			10	26			7	5	5						4					74	11.86	11.86%
06-Jun	M & S	2722J	548	485	63			17	3		6	8		4		4					19		5					66	12.04	11.50%
07-Jun	M/CARE	NA163	275	216	59						5	29		10			5	11			3		5					68	24.73	21.45%
08-Jun	M/CARE	NA163	661	581	80		4	9	22		11			3		4	8	7	2		7		3					80	12.10	12.10%
09-Jun	M/CARE	NA163	810	711	99		11	6	4	5	3	20		15			7	5			3		20					99	12.22	12.22%
10-Jun	M/CARE	NA163	1021	926	95			7	6		10	33				7	7	5			3		8			10		96	9.40	9.30%
11-Jun	M/CARE	NA163	855	764	91		3	8			14	18			3	4	14	5			12		3				10	94	10.99	10.64%
12-Jun	M/CARE	NA163	590	541	49		10	10	3		5	4											5				8	45	7.63	8.31%
13-Jun	MYER	19028	424	354	70			6			7	10			14		23	10										70	16.51	16.51%
14-Jun	MYER	19028	1125	999	126		10				7	10	25		18		41	8			10							129	11.47	11.20%
15-Jun	MYER	19028	451	393	58						4	4					24				5		5			16		58	12.86	12.86%
				0																								0		
				900																								0		
				900																								0		

			950																							**0**		
																										0		
Total Defect		9981	11552	1179	0	43	127	43	23	118	245	25	61	67	49	155	51	2	0	72	0	78	0	0	29	18	**1206**	**12.08**	**11.81%**

knitting data from finishing section:

Finishing section Table 1

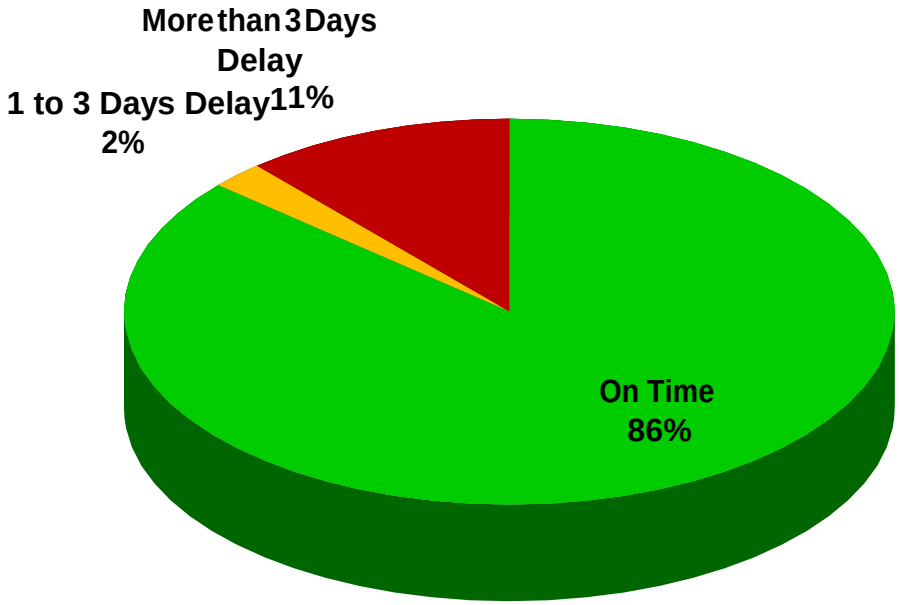
Order No: AO-17-1304			Style No:LEE				Color: WHITE			
Buyer: H&M							Date: 22-6-18			
Defects Name	Hour									
	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total
Brokenstitch											
Button/snap/ Adjustable											
Button hole		3	3		2	1	1	3	3	2	18
Fabric fault	1							1			2
Drop stitch											
Needlehole											
Cut damage											
Improper tuck											
Improper Shape											
Joint stitch											
Label fault											
Needle mark											
Open seam											
Print fault											
Embroidery	1	1	1					1	2		6
Puckering											
Raw edge											
Reverse											
Slanted	1								1		2
Skipstitch											
Shading											
Strip not Match	1	1				1	1	1			5
Thread mistake											
Twisting											
Thread tension											
Measurement deviation(+)											
Measurement Deviation(-)											
Updown											
Un even											
Uncut thread											
Waviness											

Wrong SPI											
Label wrong placement											
Yarn contamination											
Collar	1	2	1	2	2	1	2				11
Placket											
Rocket										1	1
Pleat	3	4	3	3	5	4	2			2	26
Sideband											
Oil spot				1				2			3
Dirtyspot											
Others											
Rejects											
Pressing defects											
Loosetread											
Poor ironing Shape											
Others											
Total Inspected Qty	120	140	120	120	150	120	130	100	120	130	1250
Total OK Goods	120	140	120	119	150	120	130	98	120	130	1247
Total Defectives Qty	8	11	8	6	9	7	6	8	6	5	74
Rejects Qty				1				2			3
DHU%											5.92%
QC pass%											94.08%

WEEKLY SAMPLE PERFORMANCE

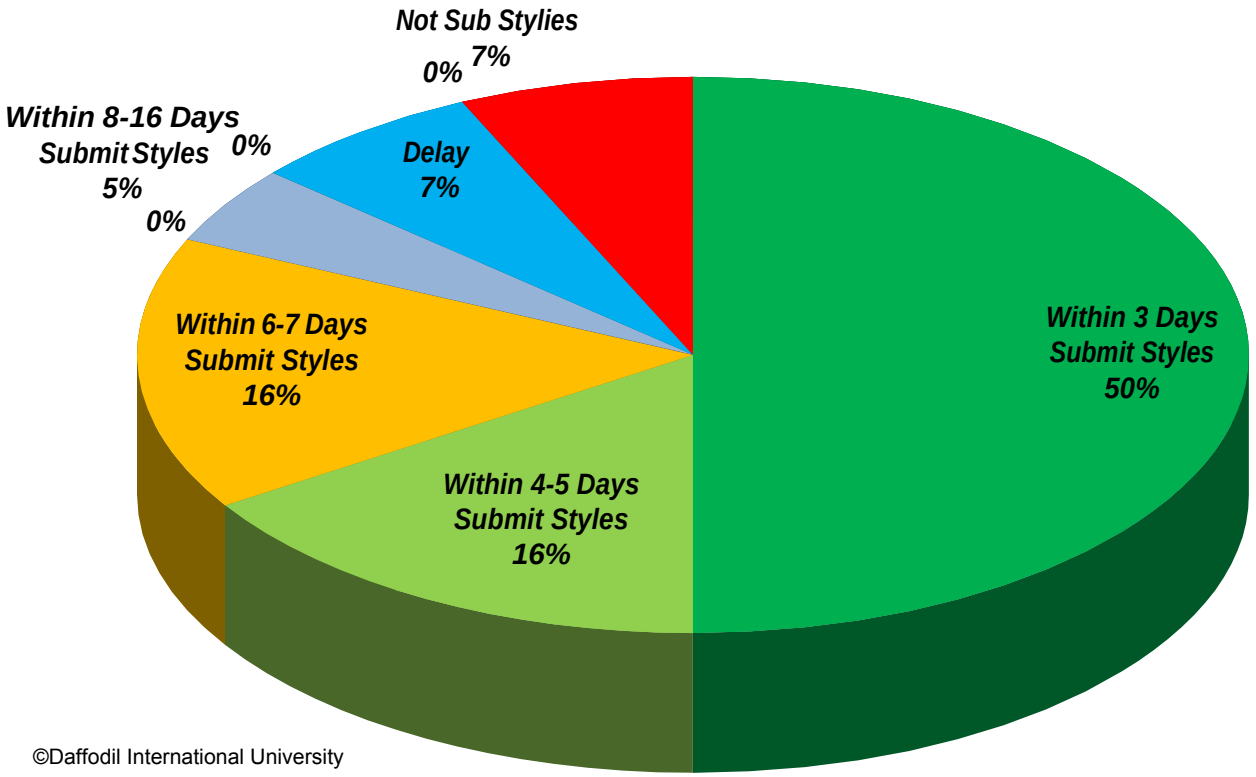
Present Week 11-17 April -2018

SAMPLE DEPARTMENT(Fit/Others) PERFORMANCE



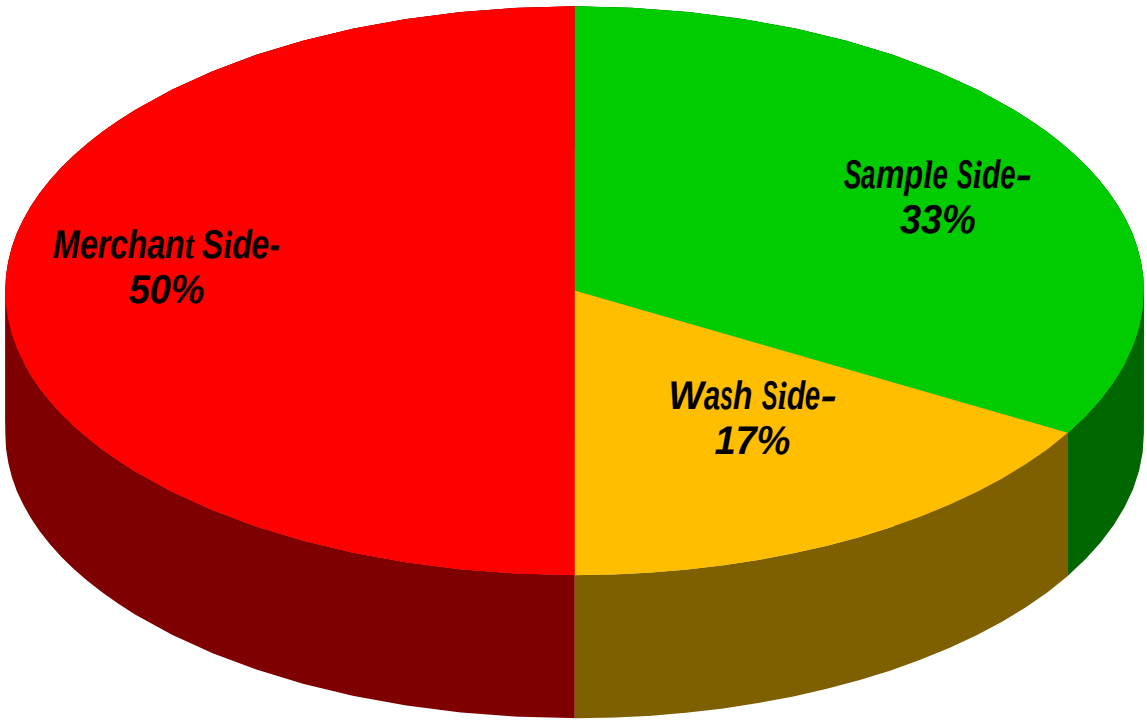
Total	Within 3 Days Submit Styles	Within 4-5 Days Submit Styles	Within 6-7 Days Submit Styles	Within 8-16 Days Submit Styles	Delay	Not Sub Styles
44	22	7	7	2	3	3
Delay %	50%	16%	16%	4%	7%	7%

Sample Update(Fit & Others)Status



Reason For Delay					
Total Delay Style	Sample Side-	Wash Side-	Merchant Side-	Print Side-	Others Side-
6	2	1	3		
Delay %	33%	17%	50%	0%	0%

Reason For Delay

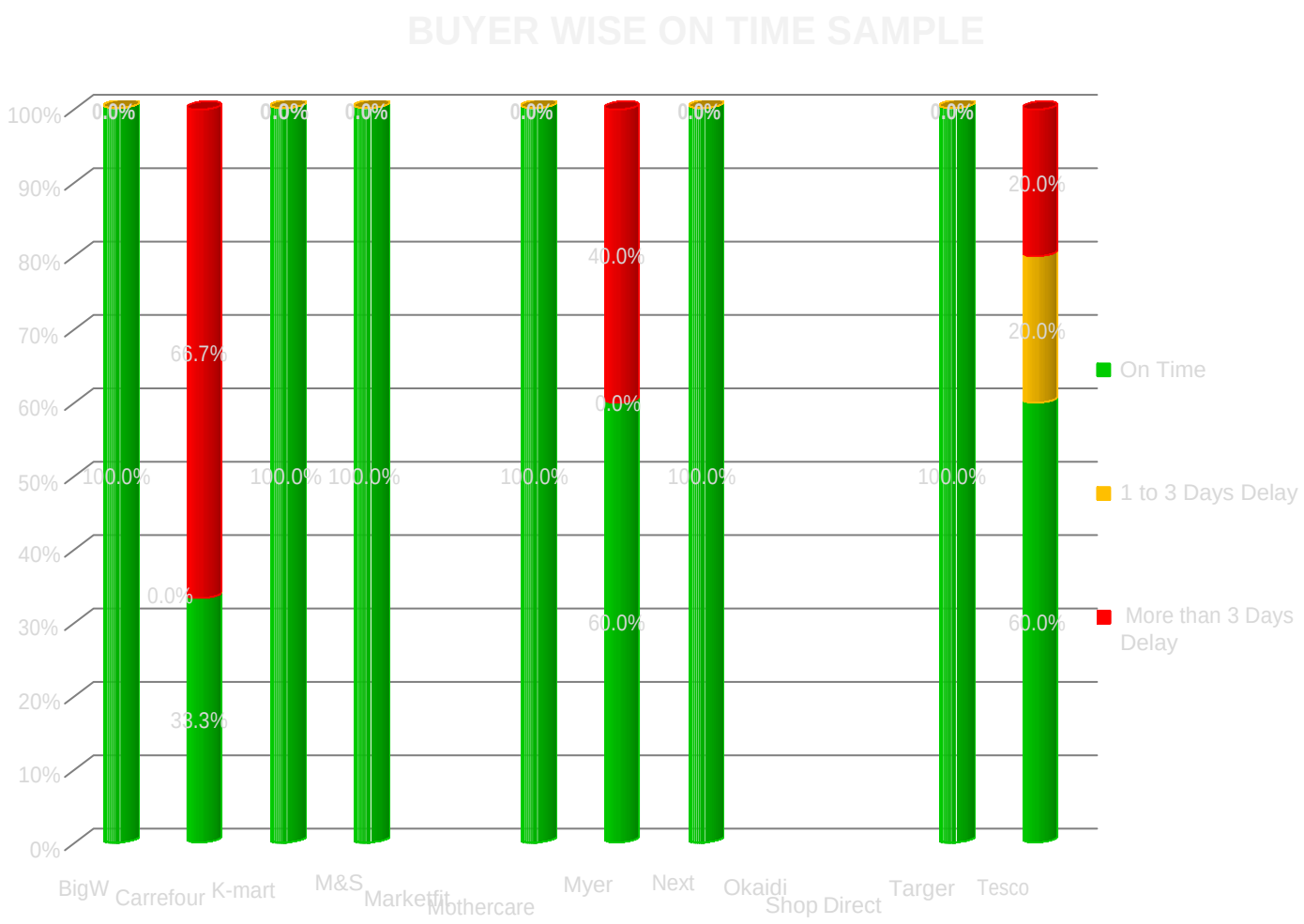


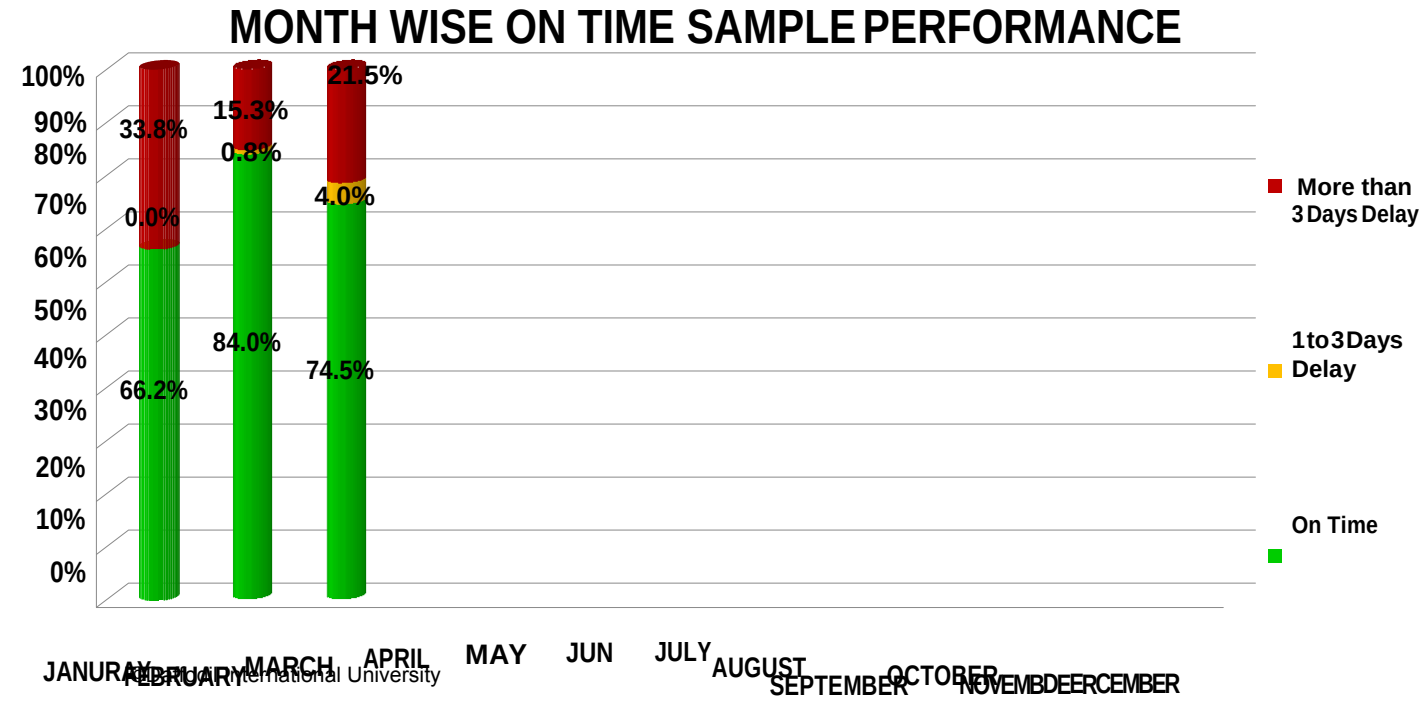
8-Apr	15-Apr	Carrefour	I809630	Online	4	Not	Not submit for internal reject due to wrong rib attach by sample man
8-Apr	15-Apr	Carrefour	I809630	PP	7	Not	Not submit for internal reject due to wrong rib attach by sample man
9-Apr	16-Apr	MYER	TGS19001 CW2	PP+Test	6	Not	Not submit for internal reject due to Wash Reject
2-Apr	9-Apr	TESCO	KD825409	Size Set	14	11-Apr	2 Day Delay For Care Label Given Delay By Merchant
3-Apr	9-Apr	TESCO	KD825408	Size Set	7	15-Apr	6 Day Delay For Care Label Given Delay By Merchant
3-Apr	10-Apr	MYER	LGS19003A CW5	PP	4	17-Apr	7 Days Delay Due to Draw Cord Given Delay By Merchant

WEEKLY BUYER WISE ON TIME SAMPLE

11-17 April -2018

Present Week



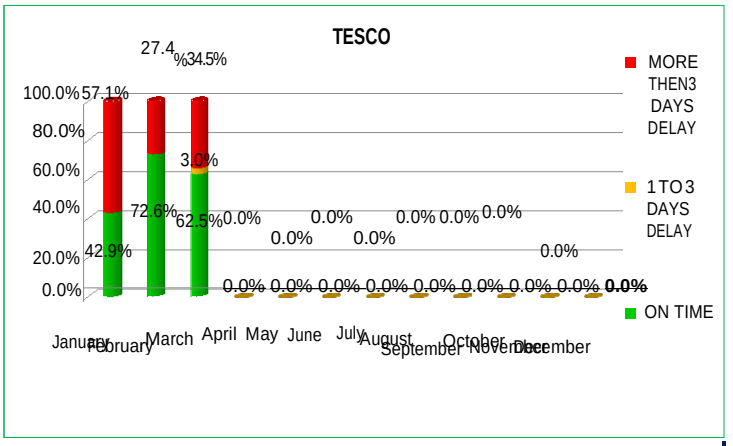


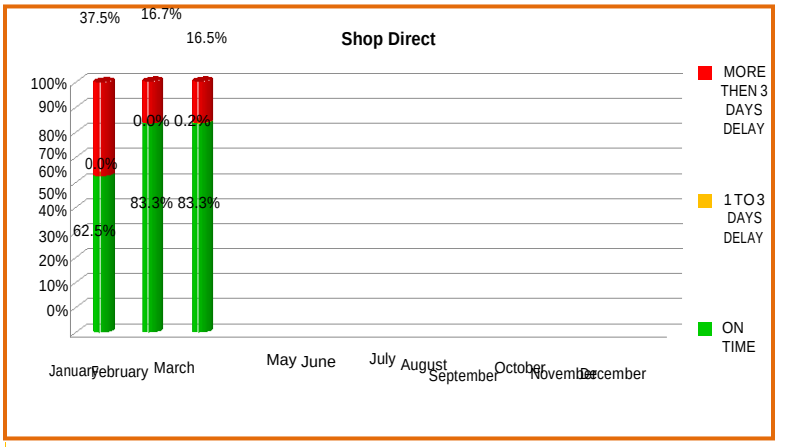
Sample weekly efficiency report

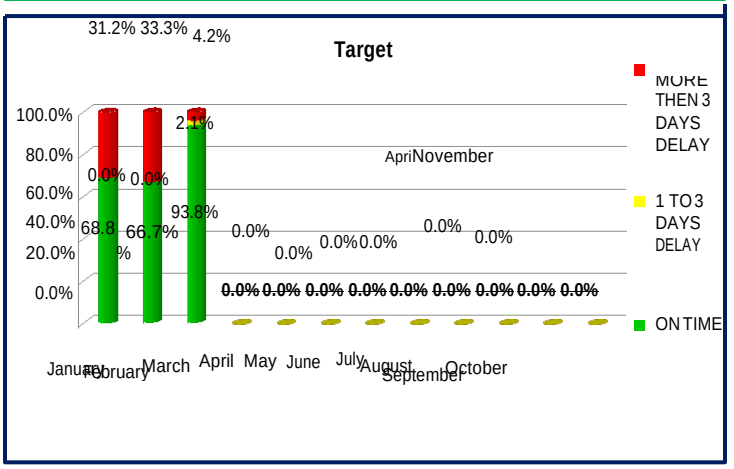
WEEK OF-16th (11th April To 117th April)

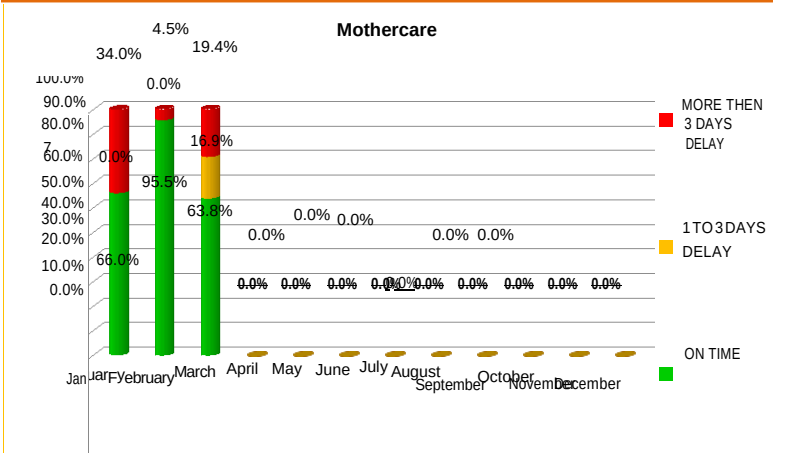
Date	TARGET 65%	ACHIEVE	Ver(+,-)	EFF%
11-Apr	170	176	6	67%
12-Apr	190	170	-20	58%
15-Apr	150	173	23	75%
16-Apr	180	150	-30	54%
17-Apr	175	183	8	68%
Total	**865**	**852**	**-13**	**65%**

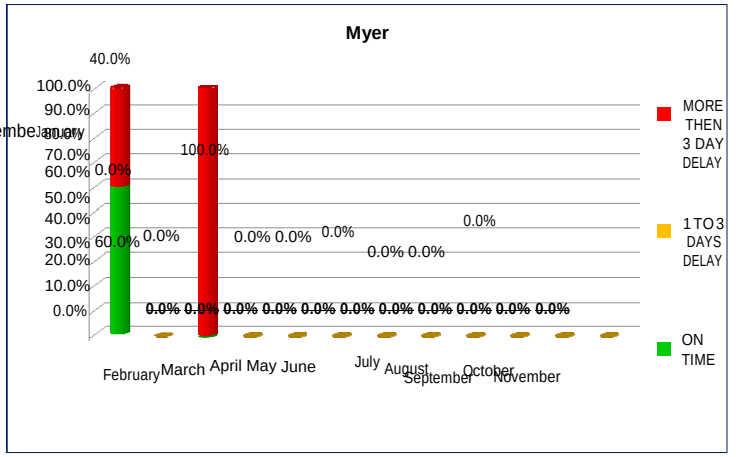
MONTHLY BUYER WISE ON TIME SAMPLE

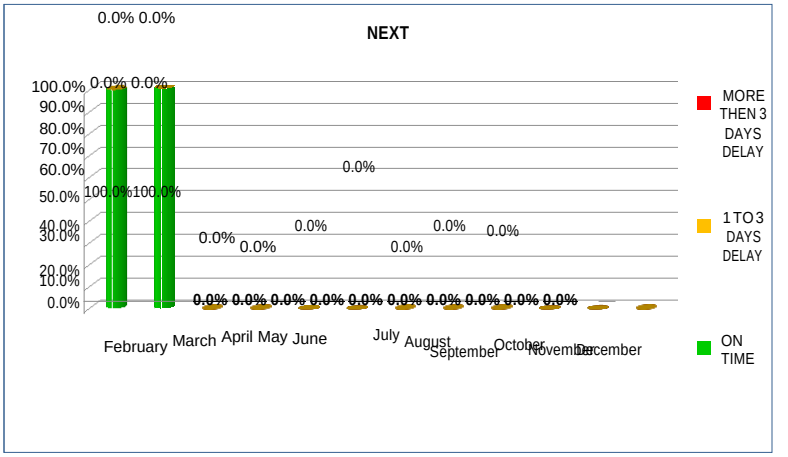


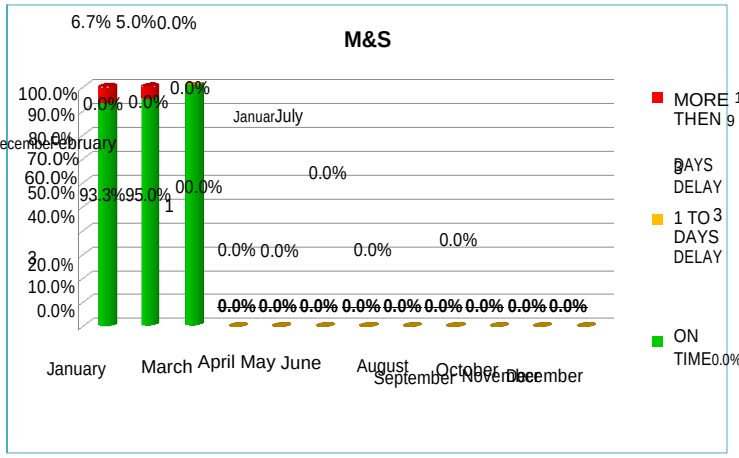


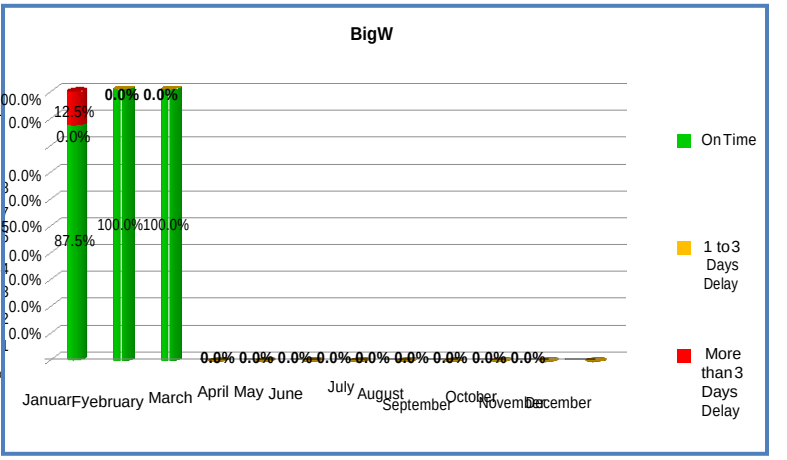


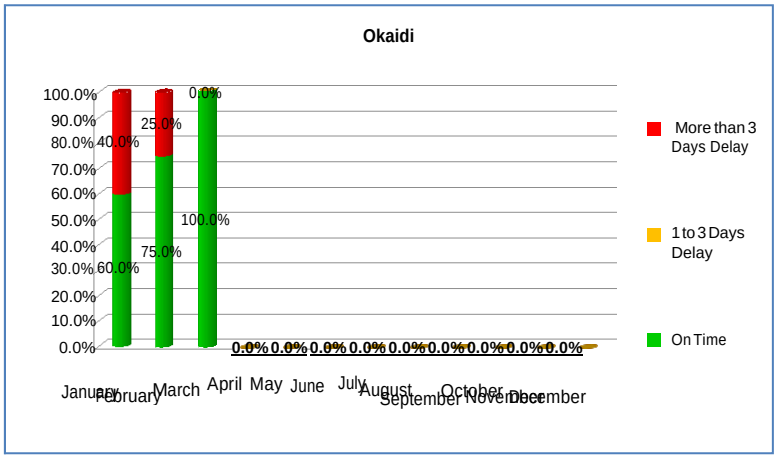


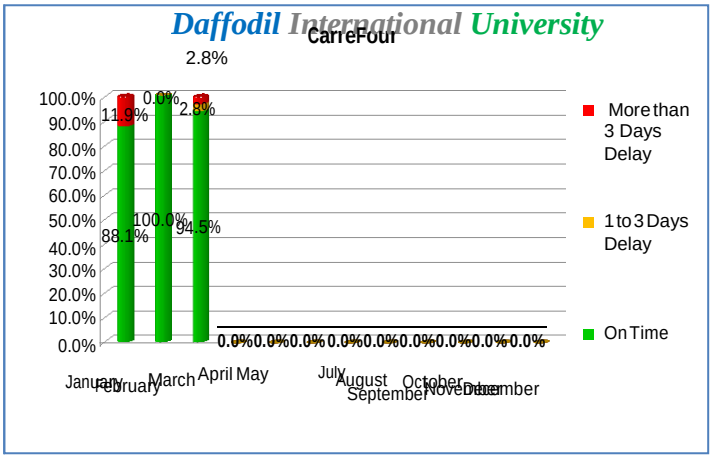


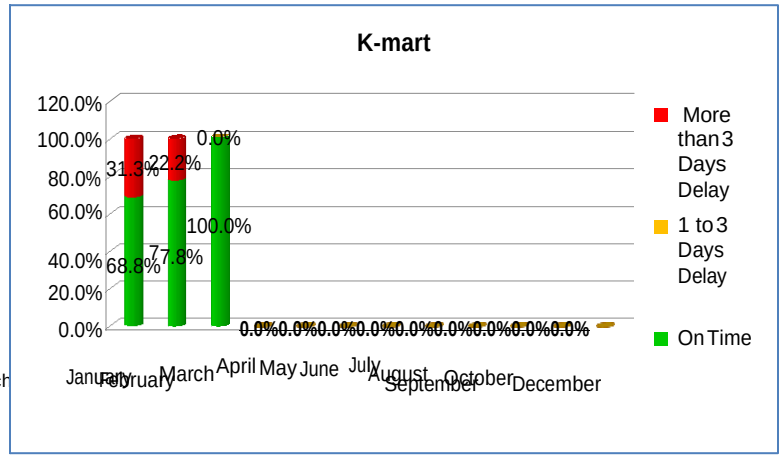


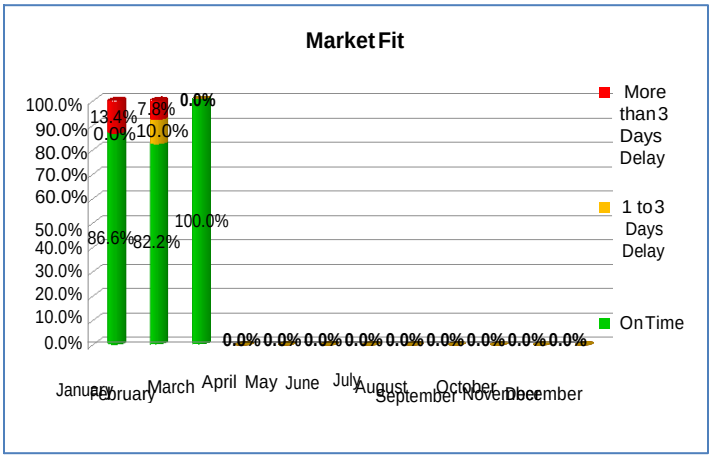


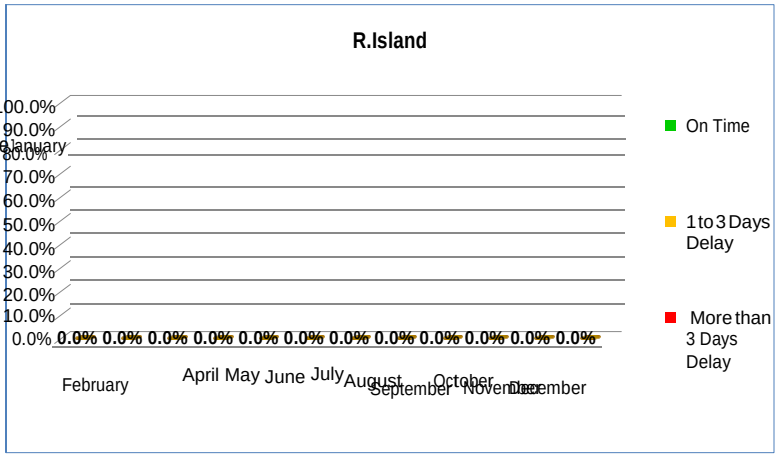


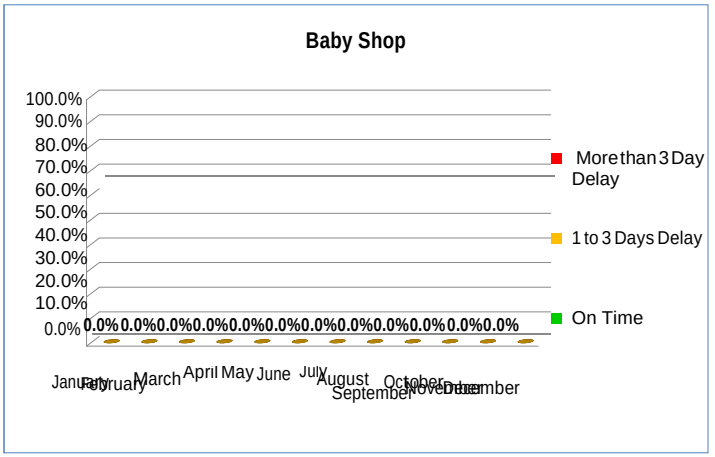






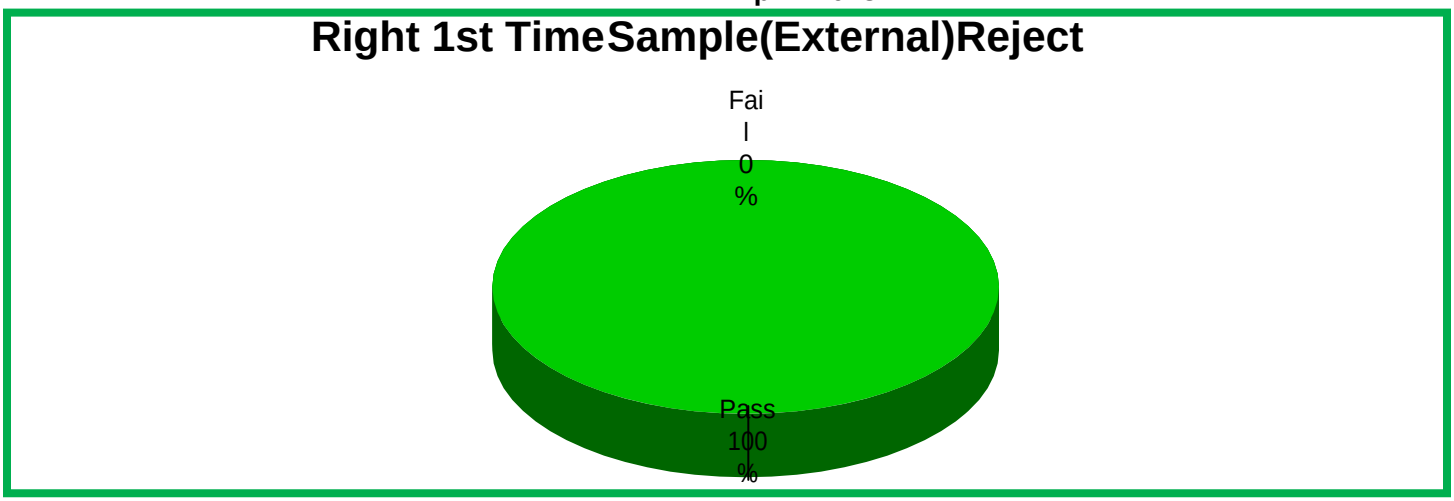




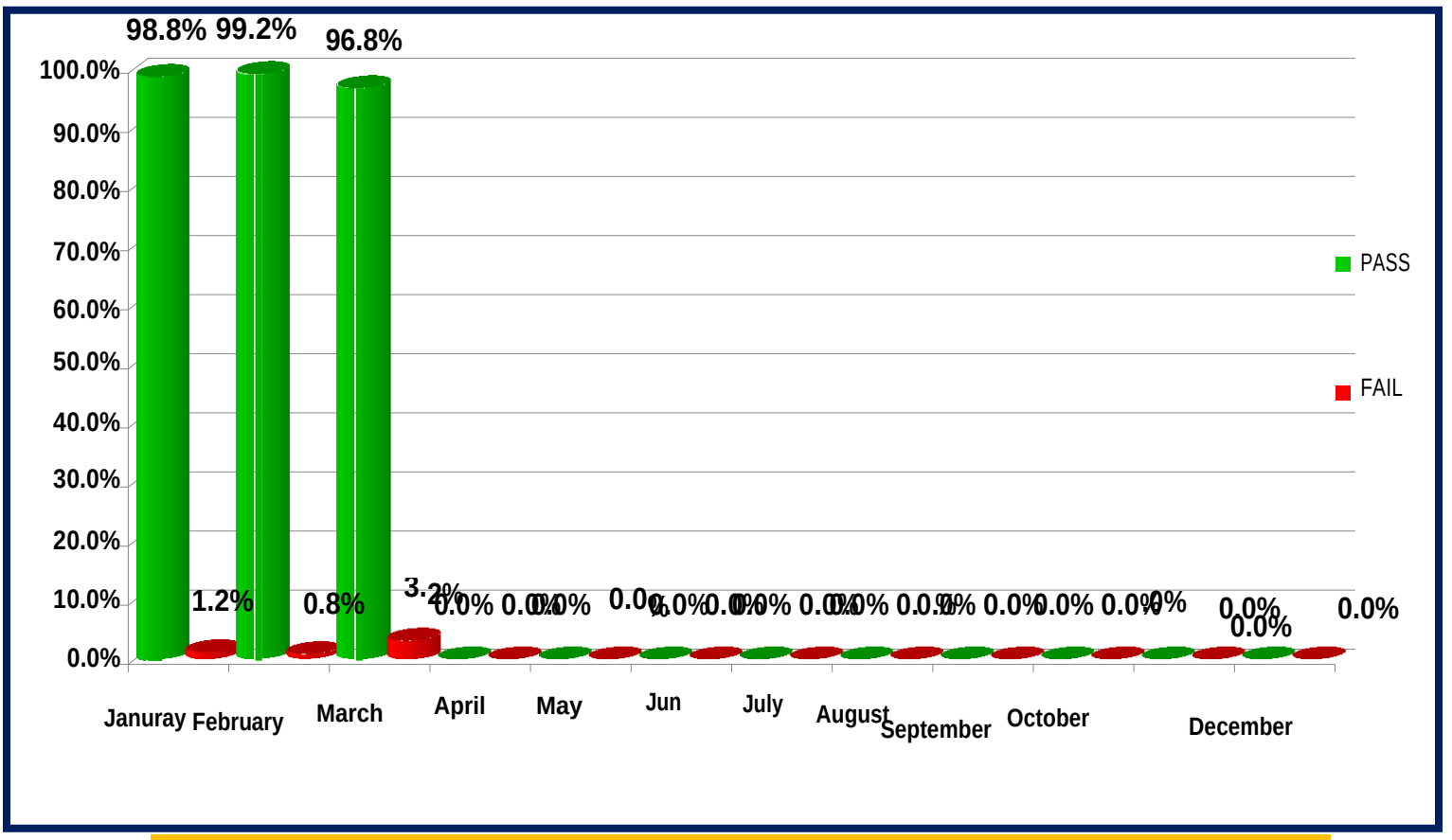


Weekly Sample External Rejected

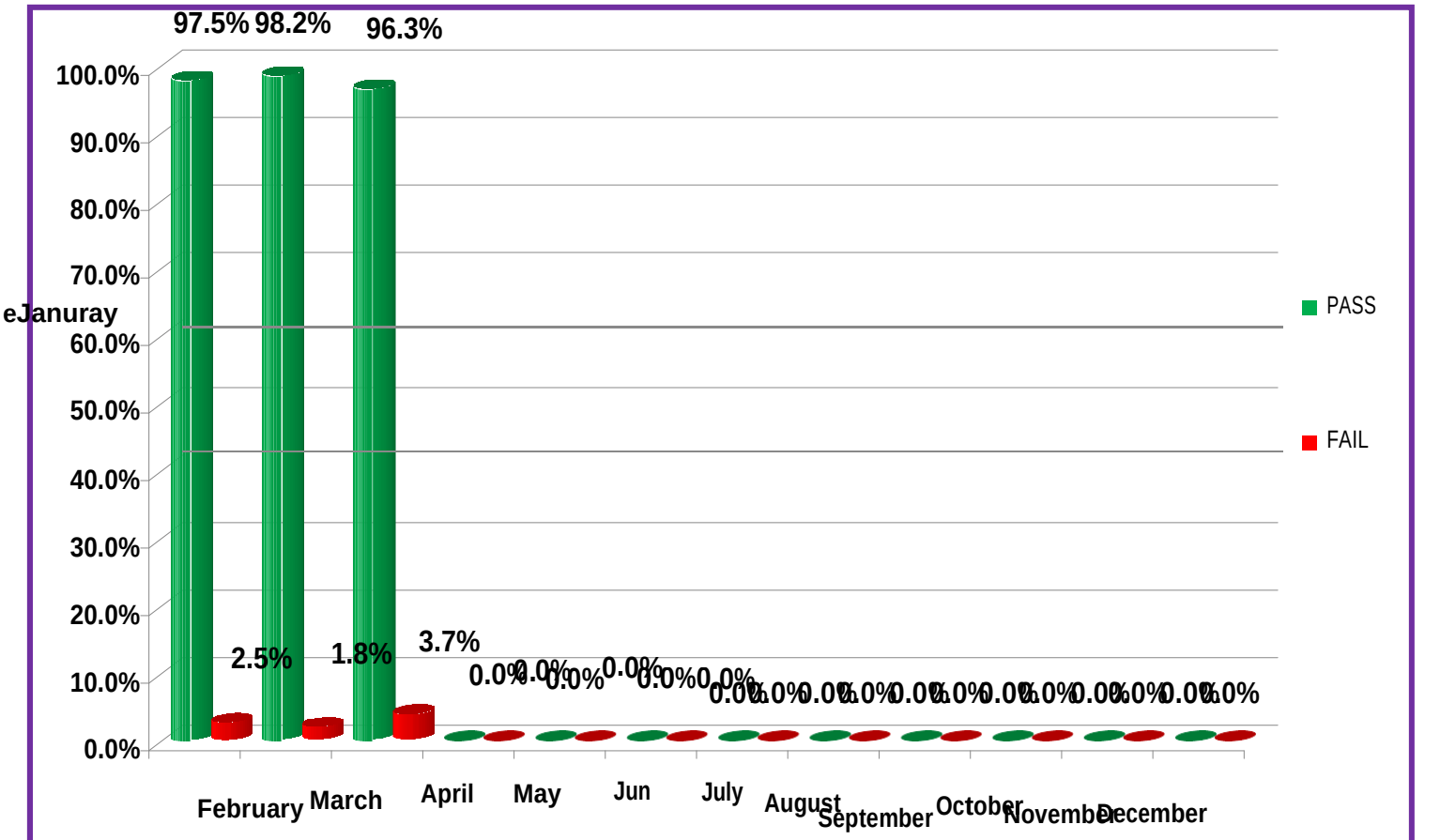
11-17 April -2018



MONTH WISE FIRST TIME PASS & FAIL(EXTERNAL)RATE-2018



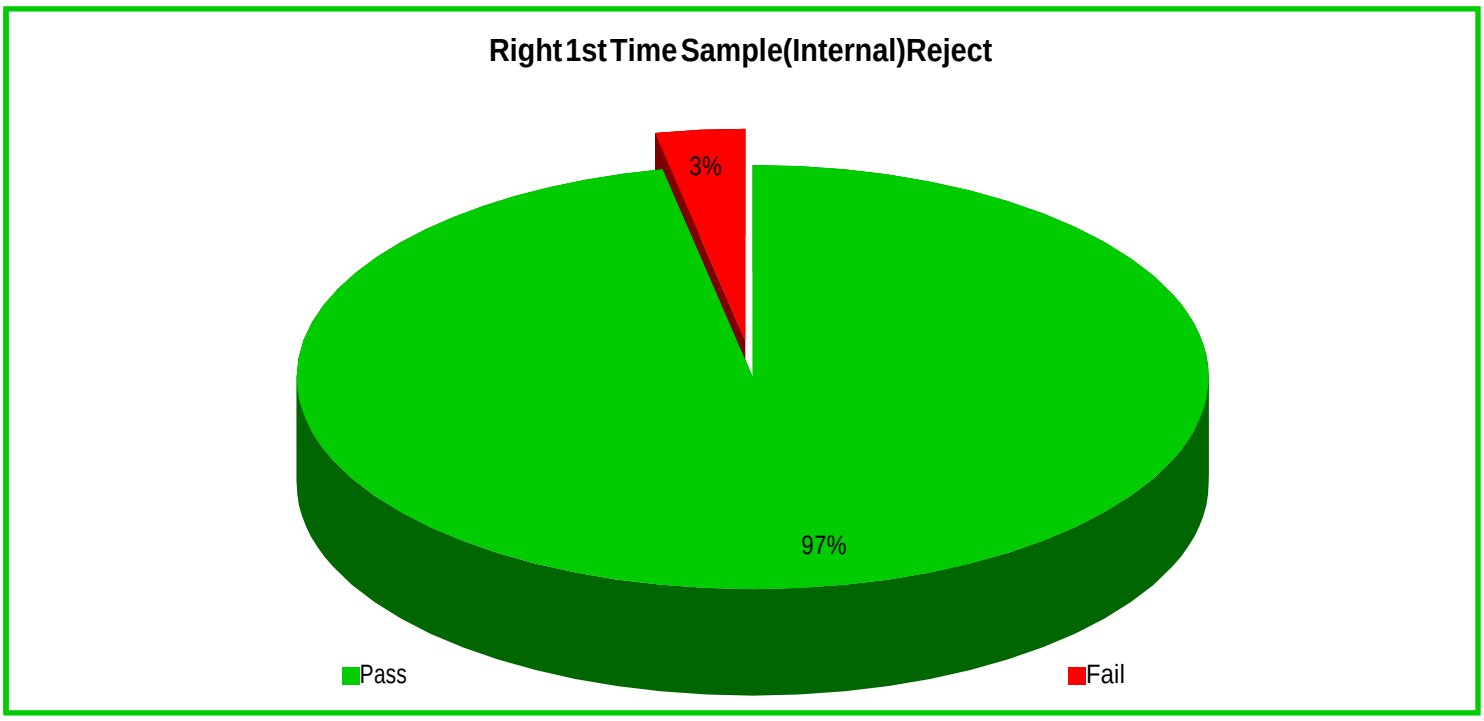
MONTH WISE FIRST TIME PASS & FAIL(INTERNAL)RATE-2018

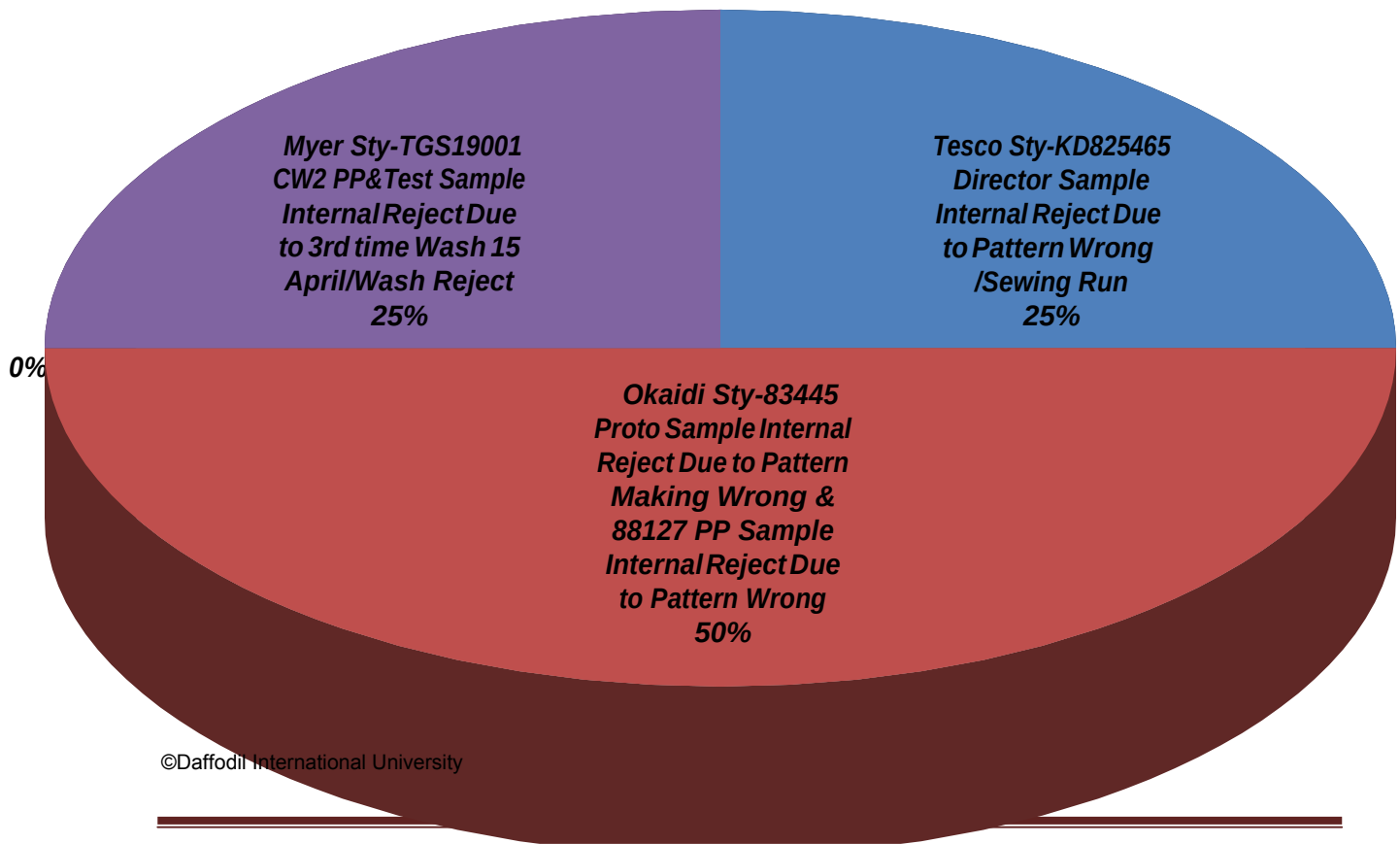


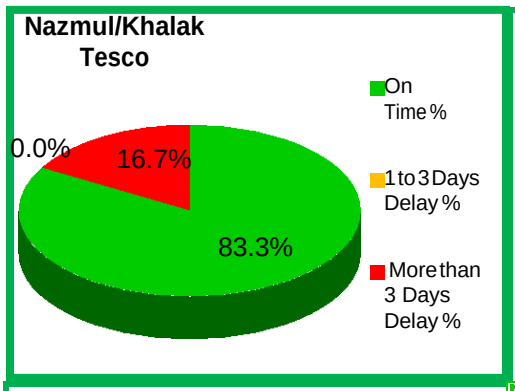
Weekly Sample Internal Rejected

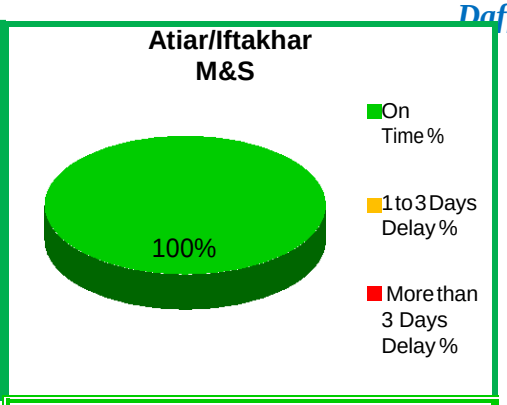
PresentWeek

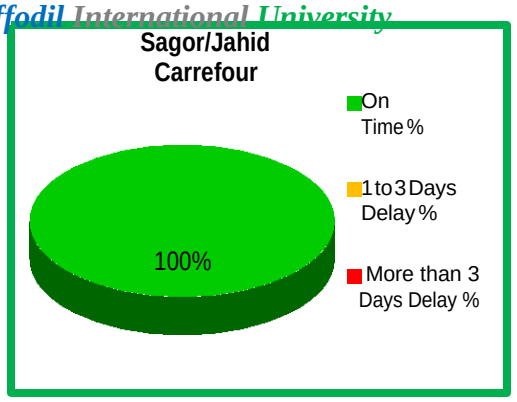
11-17 April -2018

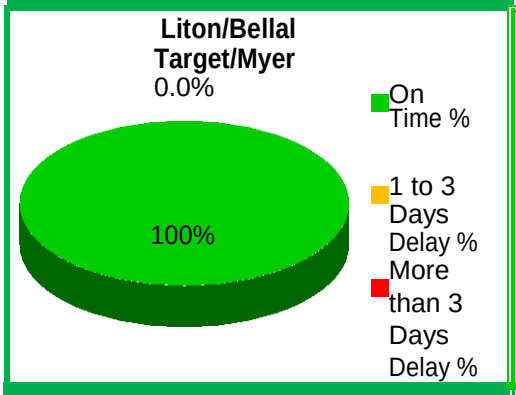


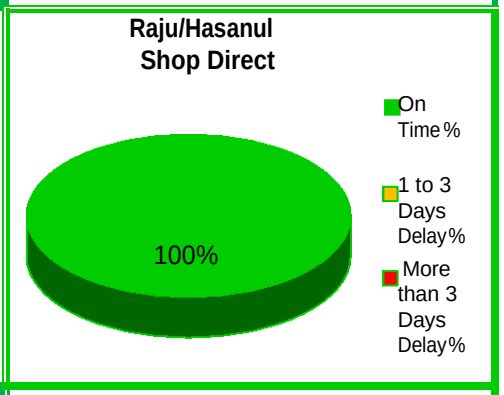


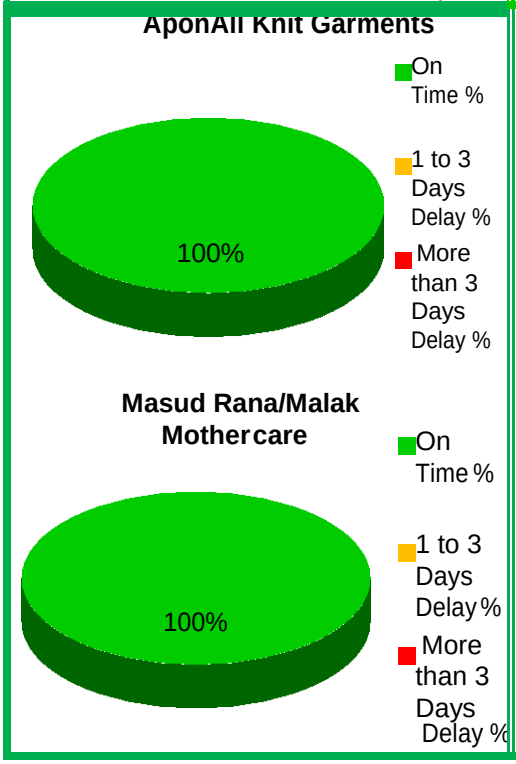


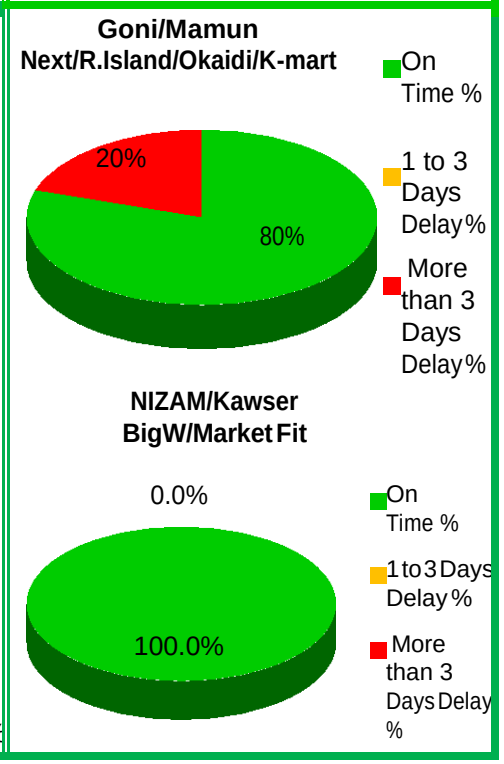








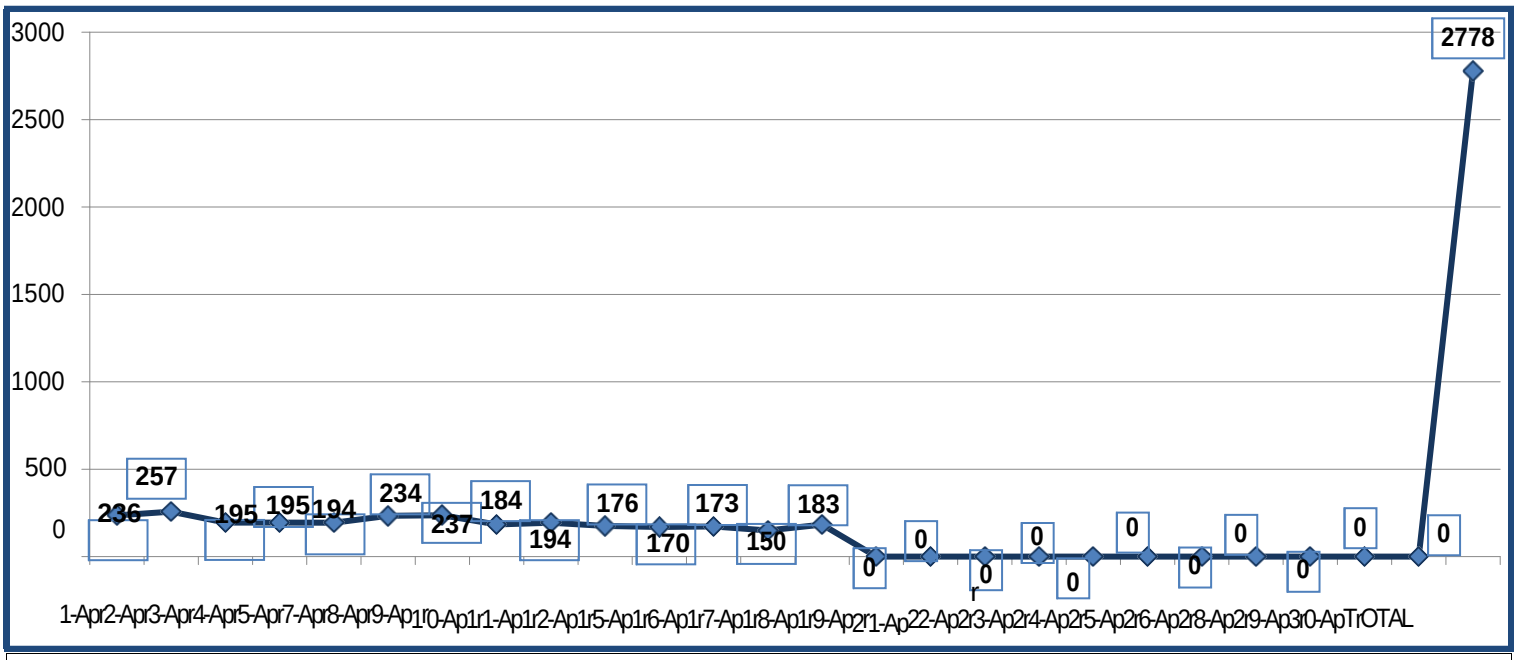




Types of Buyer wise on time							
Buyer	Total Style	On Time		1 to 3 Days Delay		More than 3 Days	
		On Time Total Style	On Time	Total (1 to 3 Days Delay)	1 to 3 Days Delay	Total More than 3 Days Delay	More than 3 Days Delay
BigW	4	4	100.0%	0	0.0%	0	0.0%
Carrefour	3	1	33.3%	0	0.0%	2	66.7%
K-mart	16	16	100.0%	0	0.0%	0	0.0%
M&S	5	5	100.0%	0	0.0%	0	0.0%
Marketfit	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Mothercare	1	1	100.0%	0	0.0%	0	0.0%
Myer	5	3	60.0%	0	0.0%	2	40.0%
Next	1	1	100.0%	0	0.0%	0	0.0%
Okaidi	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Shop Direct	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Targer	4	4	100.0%	0	0.0%	0	0.0%
Tesco	5	3	60.0%	1	20.0%	1	20.0%
Total :	44	38	86.4%	1	2.3%	5	11.4%

SAMPLE TYPE	Total Style	On Time		1 to 3 Days Delay		More than 3 Days	
		On Time Total Style	On Time %	Total (1 to 3 Days Delay)	1 to 3 Days Delay %	More than 3 Days Delay	More than 3 Days Delay %
Bulk	4	4	100.0%	0	0.0%	0	0.0%
CS	1	1	100.0%	0	0.0%	0	0.0%
Catalog	1	1	100.0%	0	0.0%	0	0.0%
GCS	1	1	100.0%	0	0.0%	0	0.0%
Marketing	1	1	100.0%	0	0.0%	0	0.0%
Online	1	0	0.0%	0	0.0%	1	100.0%
pp	12	9	75.0%	0	0.0%	3	25.0%
Press	1	1	100.0%	0	0.0%	0	0.0%
QA	1	1	100.0%	0	0.0%	0	0.0%
Size Set	4	2	50.0%	1	25.0%	1	25.0%
Test	5	5	100.0%	0	0.0%	0	0.0%
WASH	12	12	100.0%	0	0.0%	0	0.0%
Total :	44	38	86.4%	1	2.3%	5	11.4%

DAILY SAMPLE SEWING OUTPUT April-2018

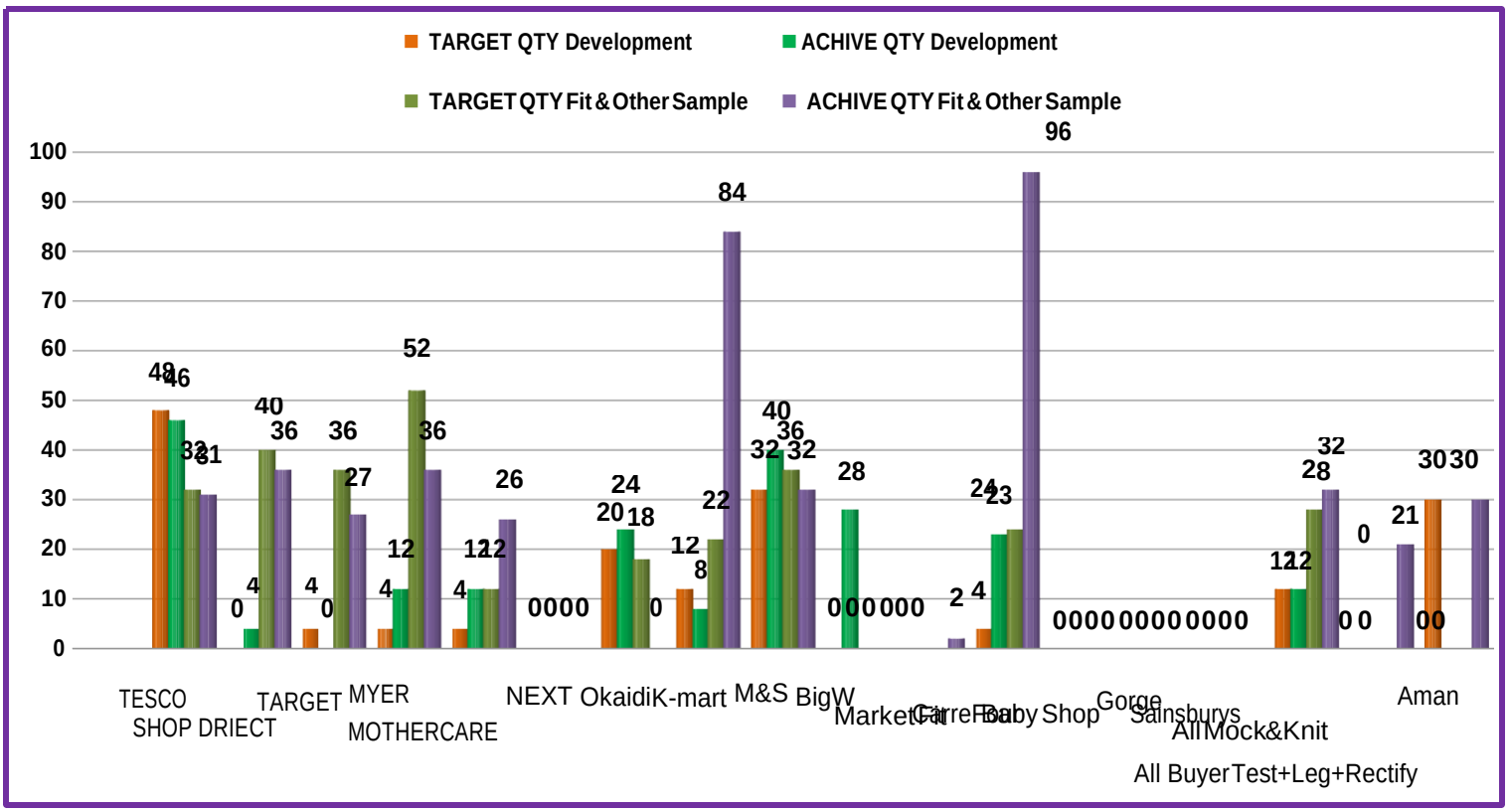


WEEKLY BUYER WISE TARGET QUANTITY & ACHIVE QUANTITY

BUYER	TARGET QTY Development	ACHIVE QTY Development	TARGET QTY Fit & Other Sample	ACHIVE QTY Fit & Other Sample	TARGET QTY	ACHIVE QTY	Next Week Target Plan 18.04.2018 To 24.04.2018		
							DV	Other	Total
TESCO	48	46	32	31	80	77	36	52	88
SHOP DRIECT	0	4	40	36	40	40	16	42	58
TARGET	4	0	36	27	40	27	8	72	80
MYER	4	12	52	36	56	48	8	58	66
MOTHERCARE	4	12	12	26	16	38	8	4	12
NEXT	0	0	0	0	0	0	0	0	0
Okaidi	20	24	18	0	38	24	12	18	30
K-mart	12	8	22	84	34	92	16	56	72
M&S	32	40	36	32	68	72	20	44	64
BigW	0	28	0	0	0	28	0	40	40
Market Fit	0	0	0	2	0	2	0	0	0
CarreFour	4	23	24	96	28	119	32	12	44
Baby Shop	0	0	0	0	0	0	0	0	0
Gorge	0	0	0	0	0	0	0	0	0
Sainsburys	0	0	0	0	0	0	0	0	0
All Mock&Knit	12	12	28	32	40	44	18	12	30
All Buyer Test+Leg+Rectify	0	0	0	21	0	21	0	0	0
Aman	30	0	0	30	30	30	30	0	30
Production	0	0	0	0	0	190	0	0	0

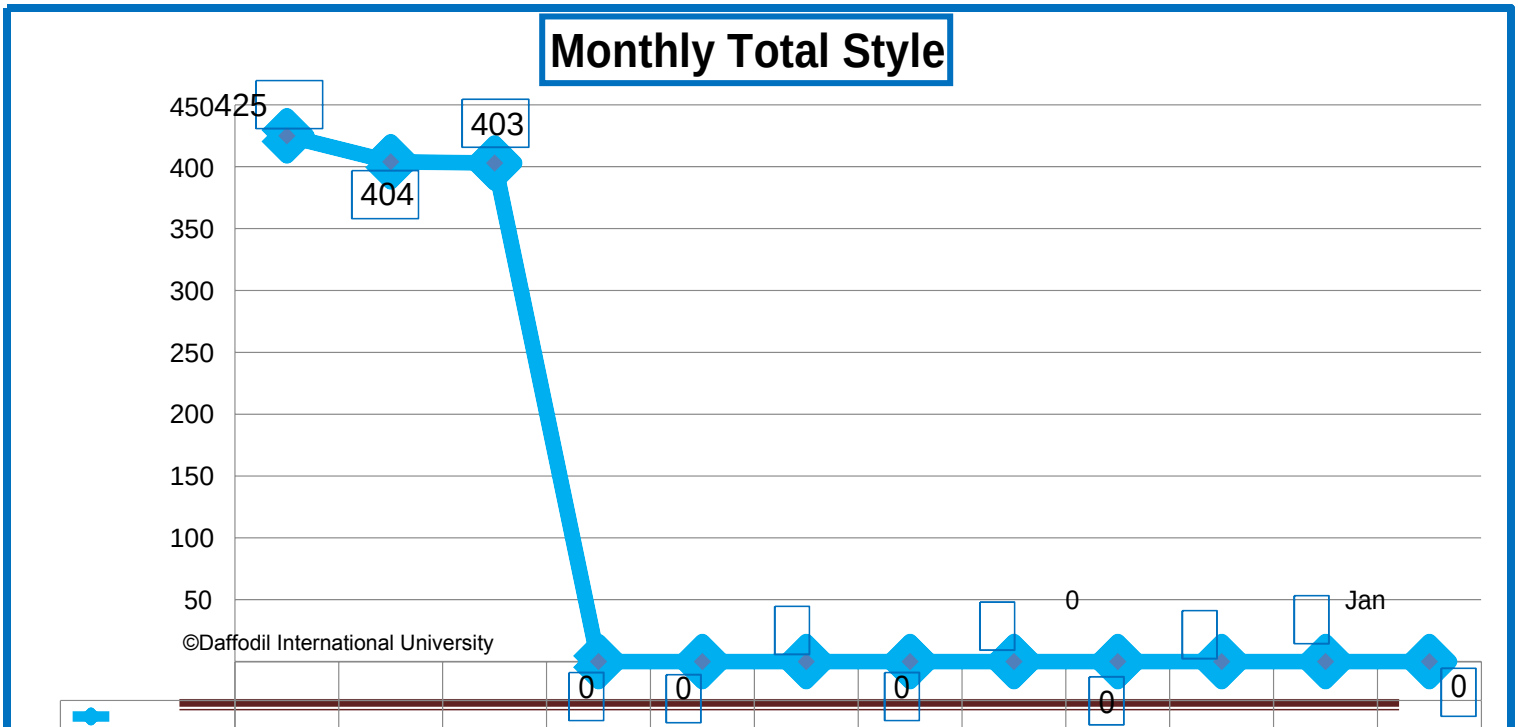
Total :									

WEEKLY BUYER WISE TARGET QUANTITY & ACHIVE QUANTITY



Style -2018

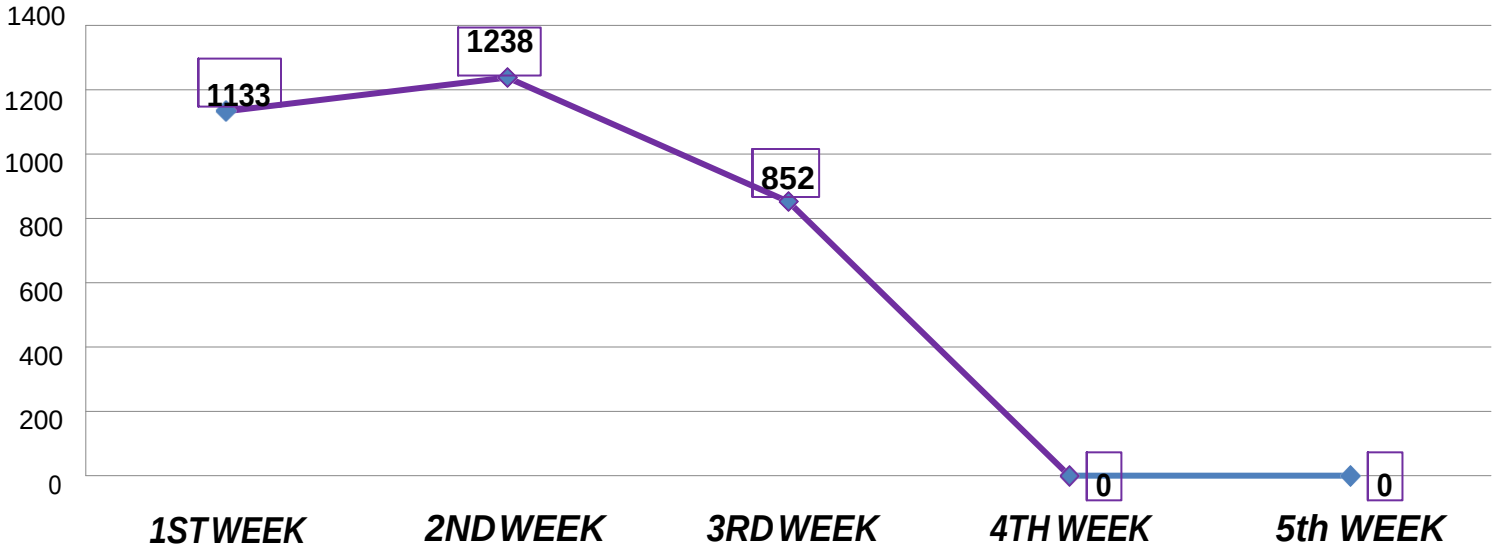
Month	Jan	Feb	Mar	Apr	May	Jun	Jul	Aug	Sep	Oct	Nov	Dec	2018
DV	153	134	194										481
Others	272	270	209										751
Total Style	425	404	403										1,232



Total Style 425

					0		0		0	0	
	Feb	Mar	Apr	May	Jun	July	Aug	Sep	Oct	Nov	Dec
	404	403	0	0	0	0	0	0	0	0	0

WEEKLY PRODUCTION QTY

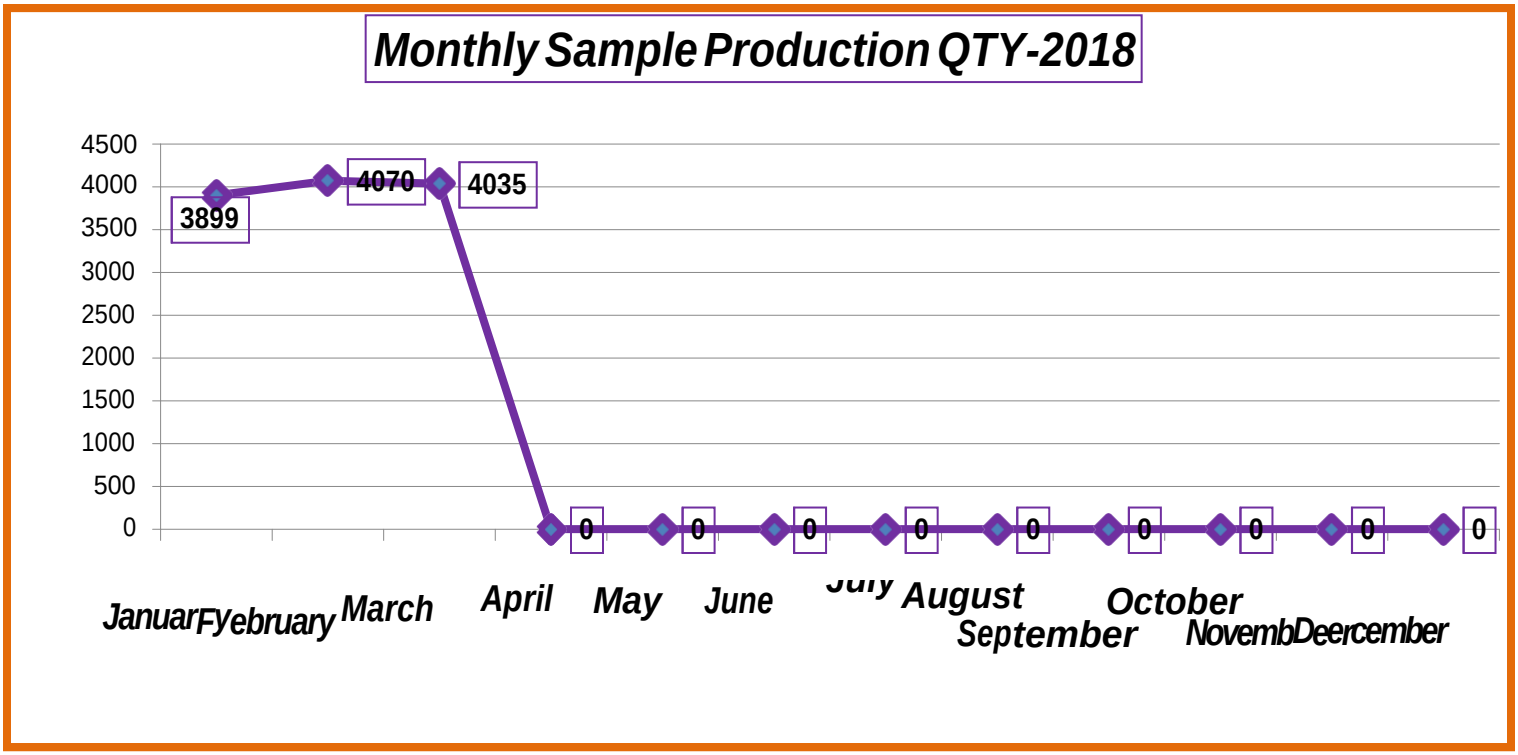


MONTHLY PRODUCTION QTY

AMAN GRAPHICS & DESIGNS LTD

Monthly Sample production QTY-2018

Month	Jan-18	Feb-18	Mar-18	Apr-18	May-18	Jun-18	Jul-18	Aug-18	Sep-18	Oct-18	Nov-18	Dec-18	Total
Total Production-2017	**3899**	**4070**	**4035**										**12,004**



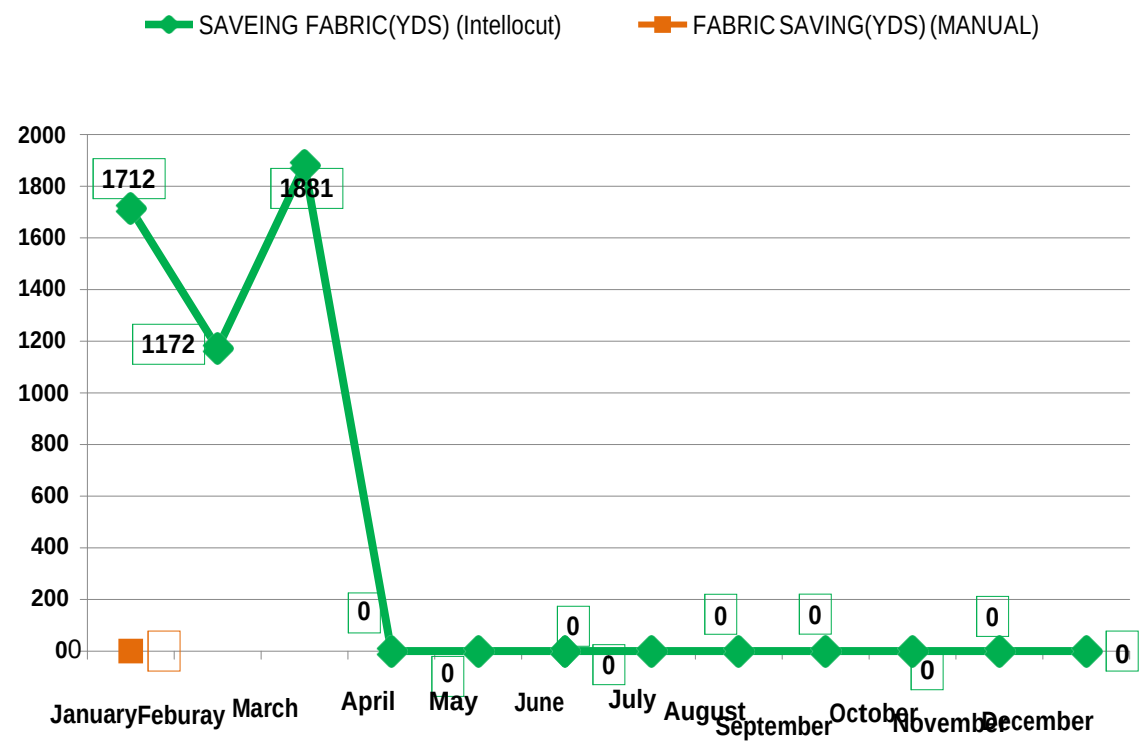
AMAN GRAPHICS & DESIGNE LTD.
MONTHLY TOTAL FABRIC SAVING
YEAR-2018

MONTH	Style (Intellect)	FABRIC SAVEING YDS (Intellect)	SAVEING %	Style (MANUAL)	FABRIC SAVING(YDS) (MANUAL)
January	32	1712	1%	0	0
Feburay	29	1172	1%	0	0
March	29	1881	1.54%		
April					
May					
June					
July					
August					
September					
October					
November					
December					
TOTAL	**90**	**4765**	**1%**	**0**	0

AMAN GRAPHICS & DESIGNE LTD.

MONTHLY TOTAL FABRIC SAVING-**(Intellect)&(Manual)**

YEAR-2018



Aman Graphics & Design Ltd.

Nizamnagar, Hemayetpur Savar Dhaka.

SAMPLE DEPARTMET OTHER EXPENCES BUDGET

MONTH OF - 2018

SL NO	PARTICULARS	January-2018		February-2018		March-2018	
		Budget	cost	Budget	cost	Budget	cost
1	TIFFIN	10,000	0 BDT	10,000	2,548 BDT	10,000	5383.50 BDT
1	FRIDAY & Night	50,000	0 BDT	50,000	18,250 BDT	50,000	5,675 BDT
TOTAL =		60,000	0 BDT	60,000	20,798 BDT	60,000	11,058.50 BDT
Balances=			0 BDT		39,202 BDT		48,941.50 BDT

Aman Graphics & Design Ltd.

Nizamnagar, Hemayetpur Savar Dhaka.

SAMPLE DEPARTMET CONVEYANCE BUDGET

CONVEYANCE BUDGET			25,000 BDT
1	01.04.2018 To 12.04.2018	BUDGET	6,250 BDT
		Our Cost	6,825 BDT
		Over Budget =	-575 BDT
2		BUDGET	6,250 BDT
		Our Cost	BDT
		Balances =	BDT
3		BUDGET	6,250 BDT
		Our Cost	BDT
		Balances =	BDT
4		BUDGET	6,250 BDT
		Our Cost	
		Balances =	BDT

Aman Graphics & Design Ltd.

Shinger Road, Hemayetpur Savar Dhaka.

SAMPLE DEPARTMET CONVEYANCE BUDGET

CONVEYANCE BUDGET	25,000 BDT

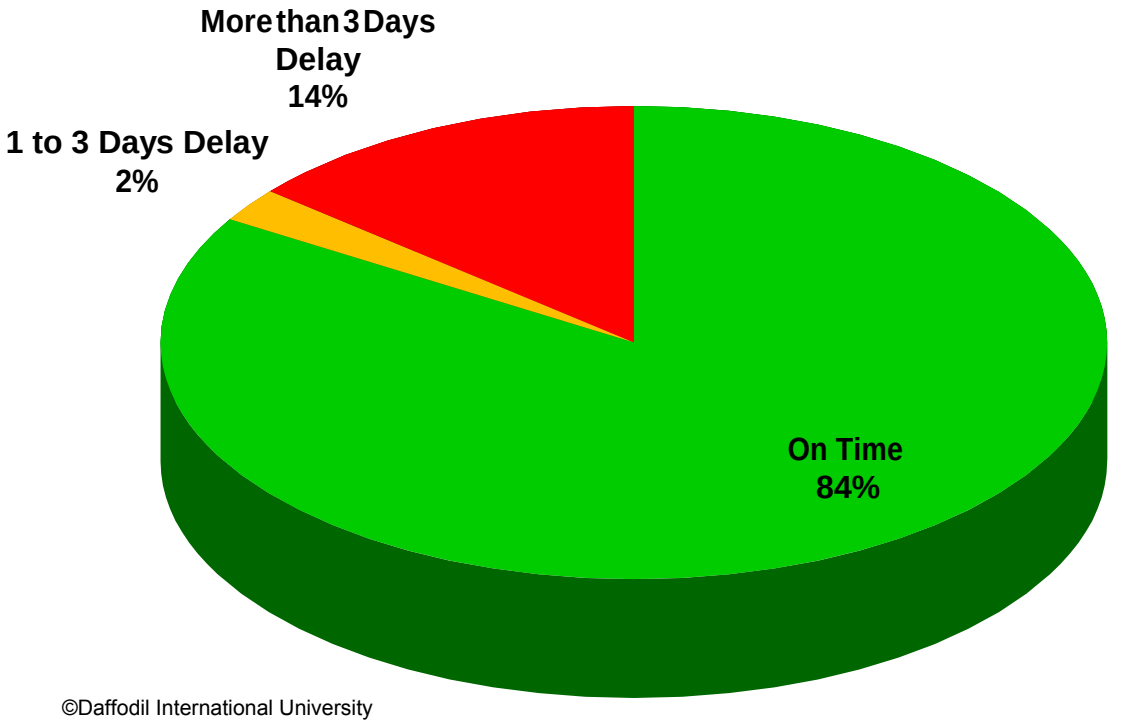
1	***Our Cost***	***17,192 BDT***
2	***Balances =***	***7,808 BDT***

AMAN GRAPHICS & DESIGN LTD										
Najimnagar,Hemayetpur,Savar,Dhaka										
Sl. NO	DATE	Time	NAME	ID	Designation	A/C	CONVANCE BILL	FOOD BILL	Others BILL	TOTAL
1	01.04.2018	1	Kabil Hossain	0301419	Ass.Manager	244.151.43820	270	200	0	470
2	02.04.2018 To 07.04.2018	2	Abdur Rashed	0301624	QA	244.103.121234	360	200	0	560
3	02.04.2018 To 04.04.2018	2	Ashraful	500174	Q.A	223.103.42024	495	90	0	585
4	03.04.2018 To 05.04.2018	2	Aslam Khan	0300346	Q.A.E	223.103.14344	835	90	0	925
5	03.04.2018 To 05.04.2018	2	Shakawat	0300964	Q.A.E	244.103.9989	990	540	0	1530
6	05.04.2018 To 07.04.2018	2	Shohel Shojib	0301448	QA	244.151.43820	565	90	0	655
7	09.04.2018	1	Didaru Islam	0500433	QA	223.103.15620	420	180	0	600
8	10.04.2018 To 12.04.2018	2	Masud	0300005	P.Master	223.151.2712	400	300	0	700
9	12.04.2018	1	JALAL UDDIN OVE	0300917	Q.D.A	244.103.7019	0	850	0	850
Total							4335	2540	0	6875

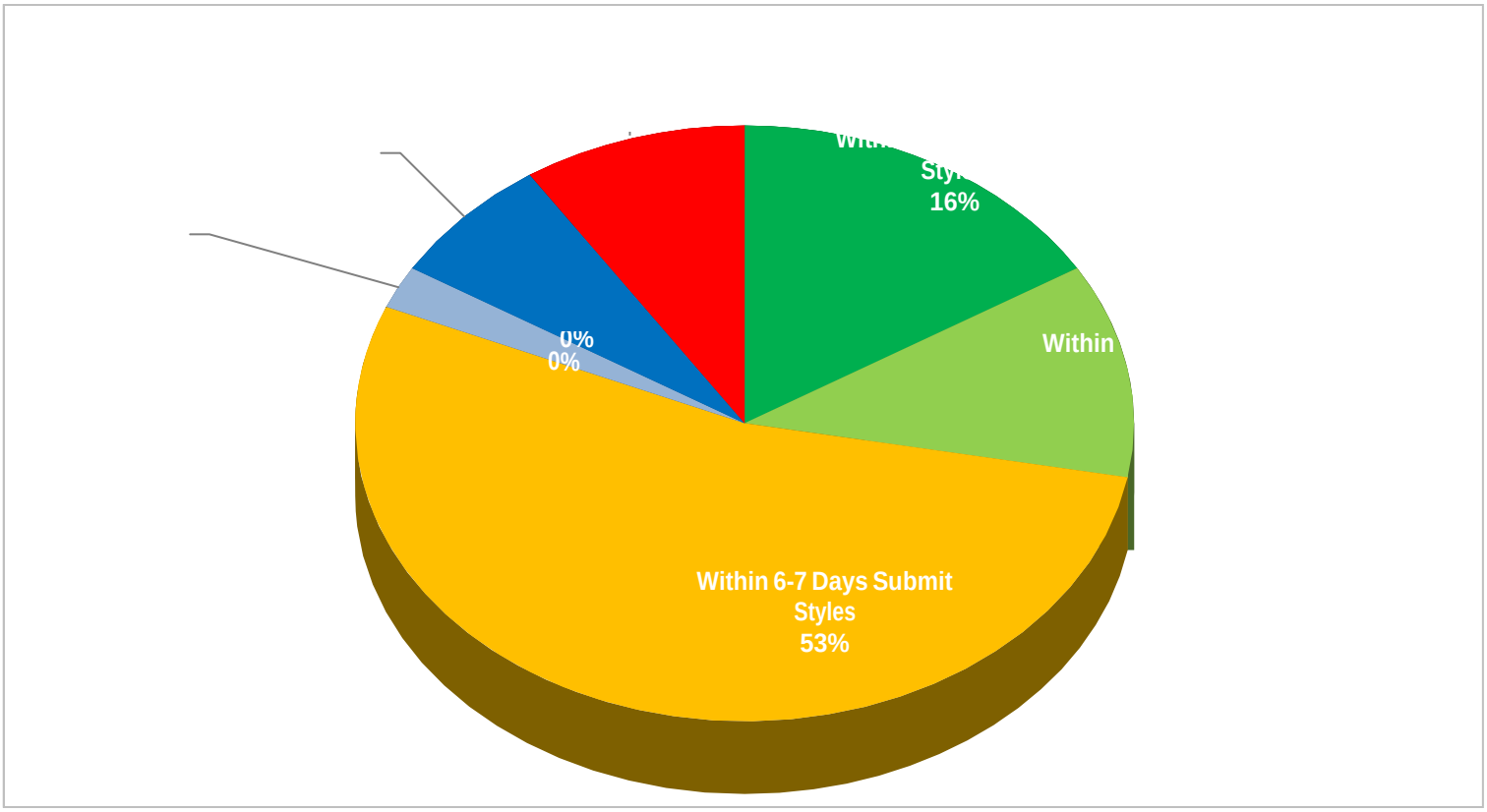
WEEKLY SAMPLE PERFORMANCE

Present Week 11-17 April -2018

SAMPLE DEPARTMENT(Development) PERFORMANCE

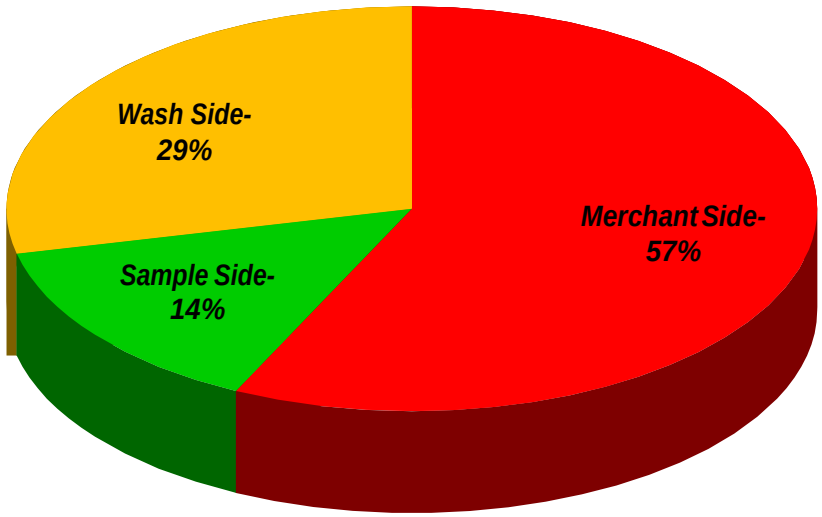


Total	*Within 3 Days Submit Styles*	*Within 4-5 Days Submit Styles*	*Within 6-7 Days Submit Styles*	*Within 8-10 Days Submit Styles*	*Delay*	*Not Sub Stylies*
43	*7*	*5*	*23*	*1*	*3*	*4*
Delay %	*16%*	*12%*	*54%*	*2%*	*7%*	*9%*



Reason For Delay					
Total Delay Style	Merchant Side-	Sample Side-	Wash Side-	Print Side-	Embroidery Side-
7	4	1	2	0	0
Delay %	57%	14%	29%	0%	0%

Reason For Delay

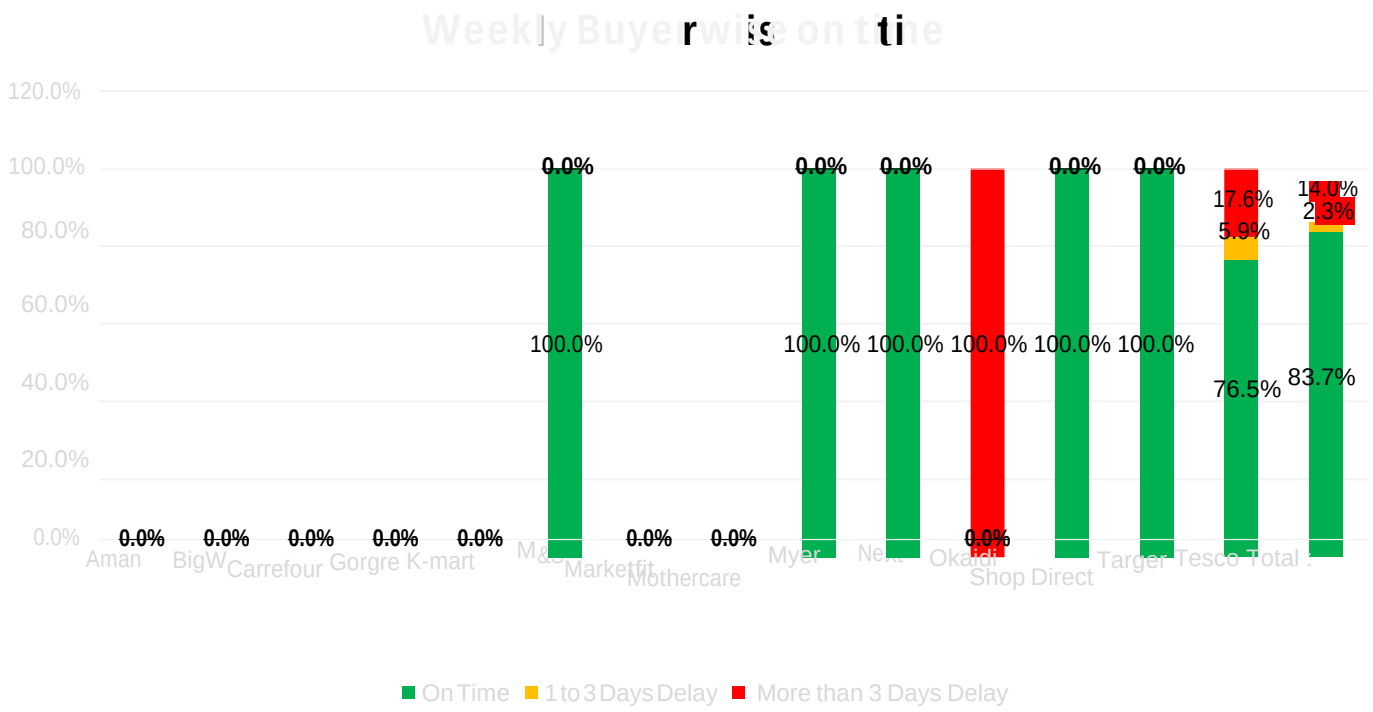


Delay & Not Sub Styles							
8-Apr	15-Apr	OKAIDI	83445	Proto	4	Not	Not Sub For Internal Reject Due to Pattern Making Wrong
11-Apr	16-Apr	OKAIDI	83445	Proto	4	Not	Not Sub For Wash Sent 15 April Still Not Come Over Dye Wash
8-Apr	15-Apr	OKAIDI	87968	Proto	4	Not	Not Sub For Wash Sent 15 April Still Not Come Over Dye Wash
1-Apr	8-Apr	TESCO	2PK Twill Short	Develop	4	11-Apr	3 Day Delay For Trims Given Delay By Merchant
4-Apr	11-Apr	TESCO	R.W.R.UpTrouser	Develop	4	15-Apr	4 Day Delay For Draw Cord Given Delay By Merchant
5-Apr	12-Apr	TESCO	Baseball Shirt	Develop	4	16-Apr	4 Day Delay For Rib Given Delay By Merchant
9-Apr	17-Apr	TESCO	Lightweight Woven Jogger	Develop	4	Not	Not Sub For Draw Cord Pending By Merchant

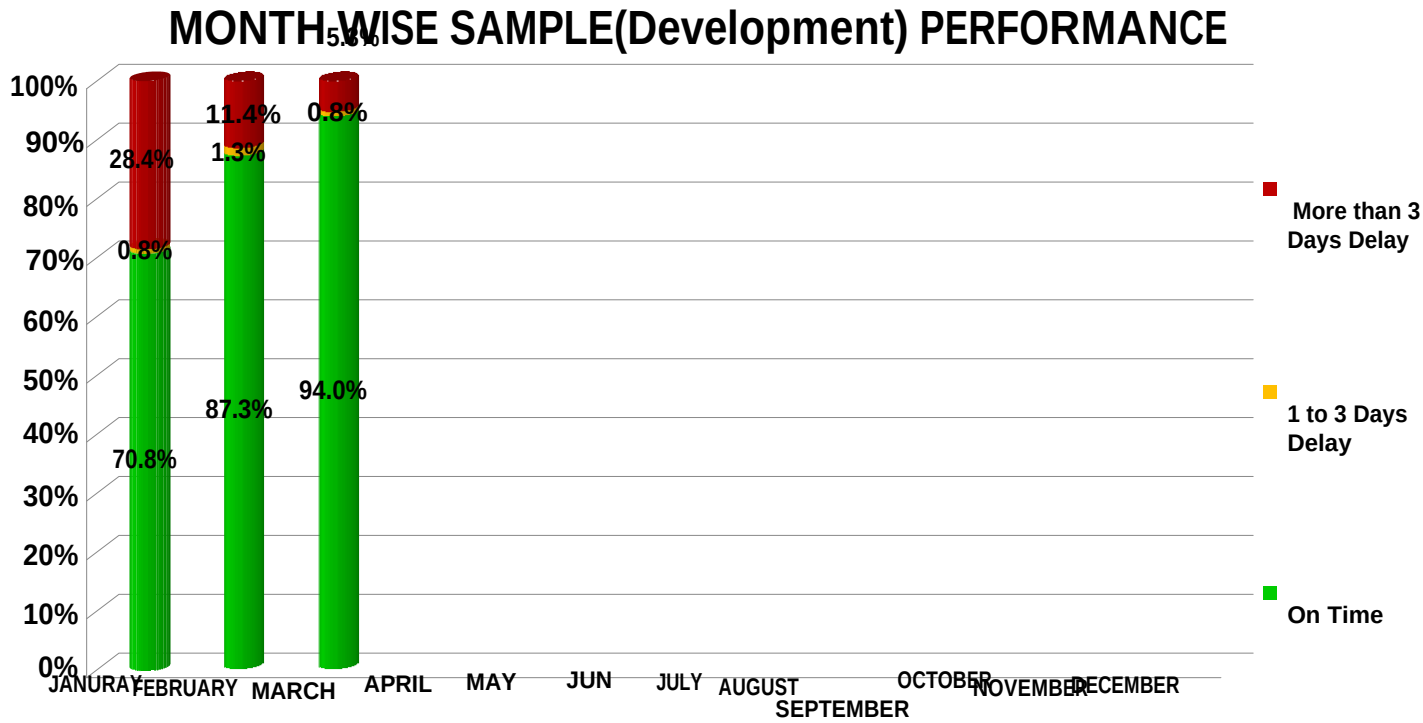
WEEKLY BUYER WISE ON TIME SAMPLE

11-17 April-2018

Present Week

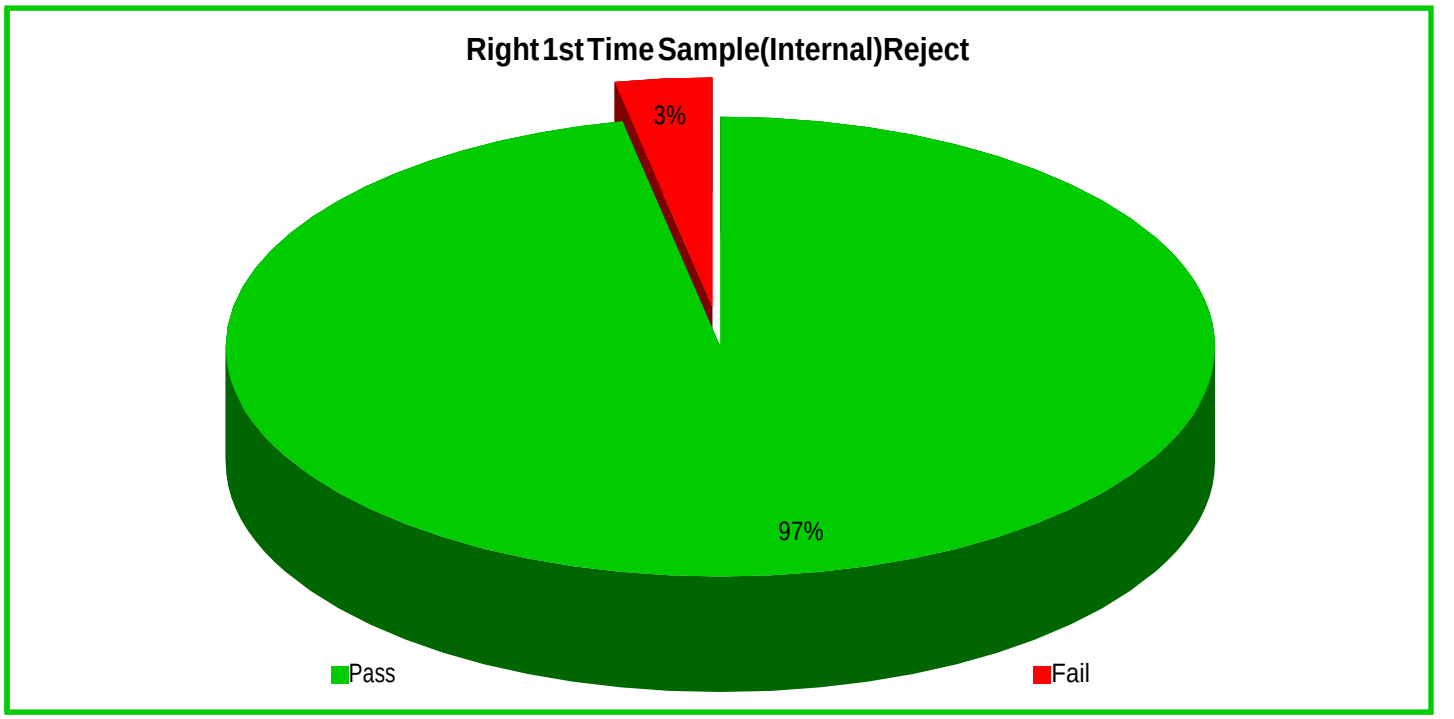


Monthly BUYER WISE ON TIME SAMPLE

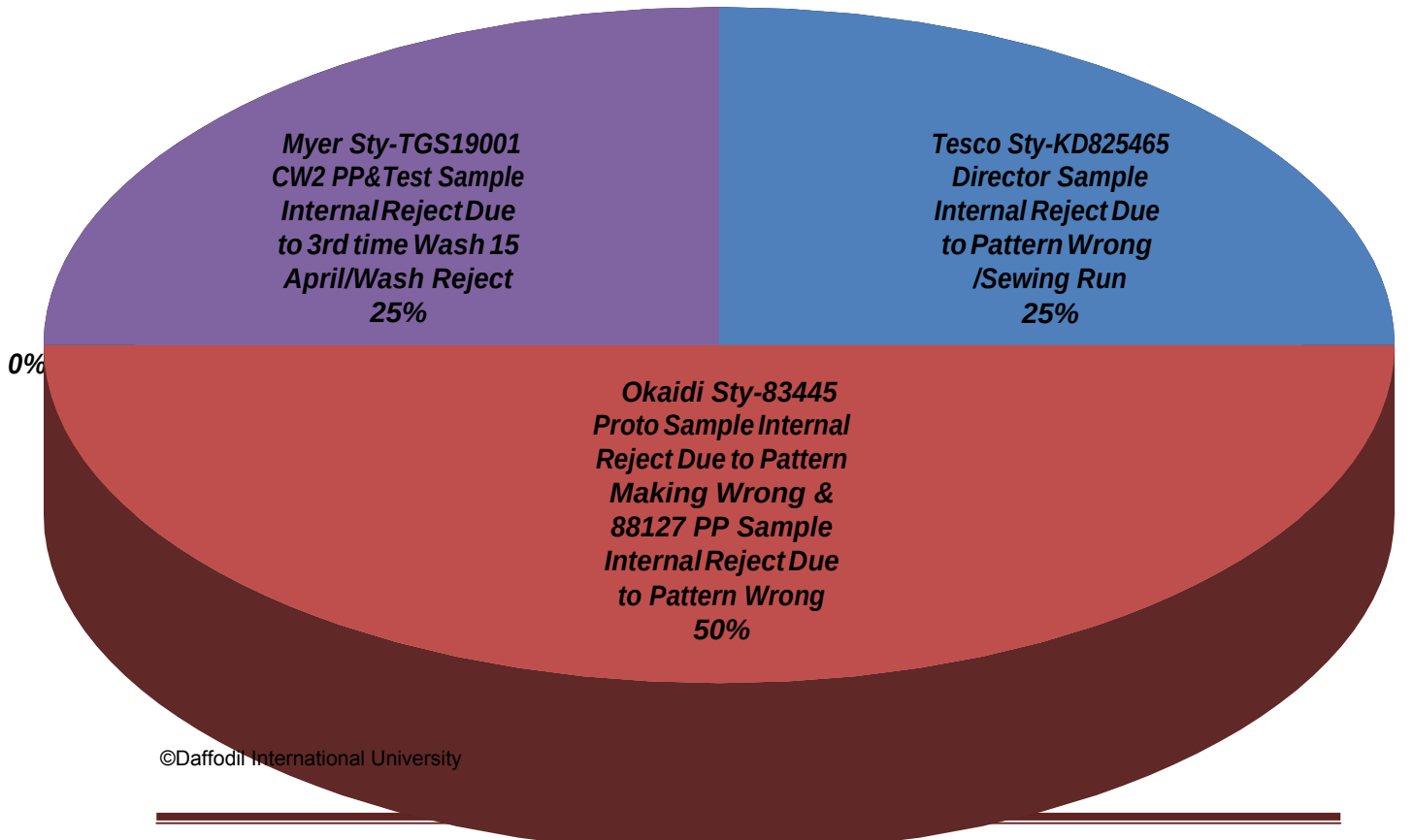


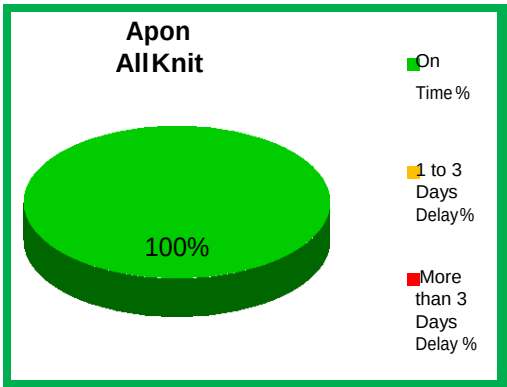
Weekly Sample Internal Rejected

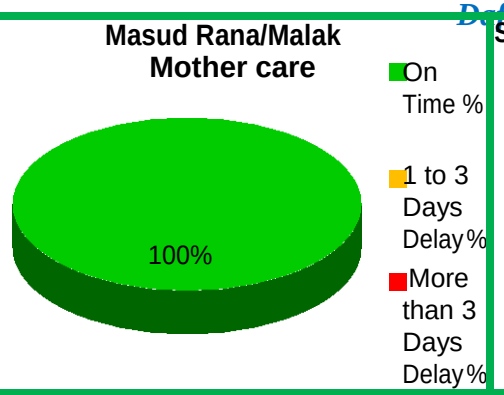
Present Week 11-17 April -2018

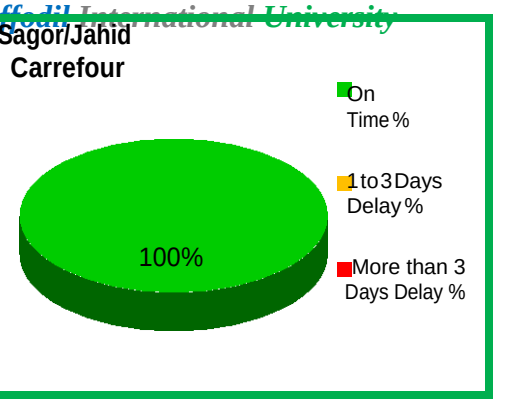


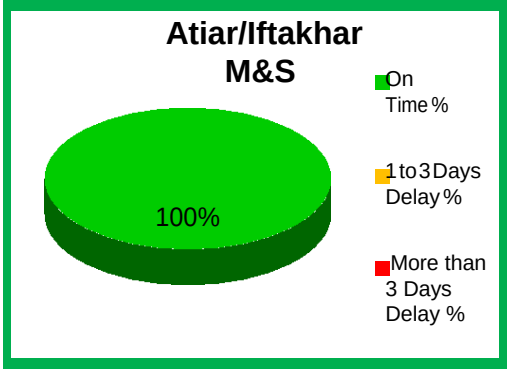
Present Week 11-17 April -2018

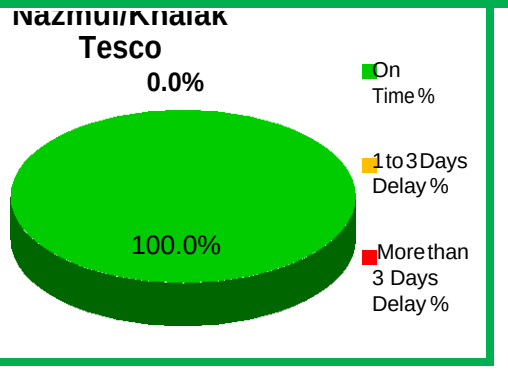


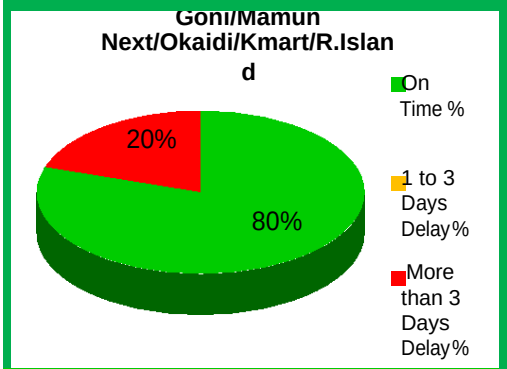


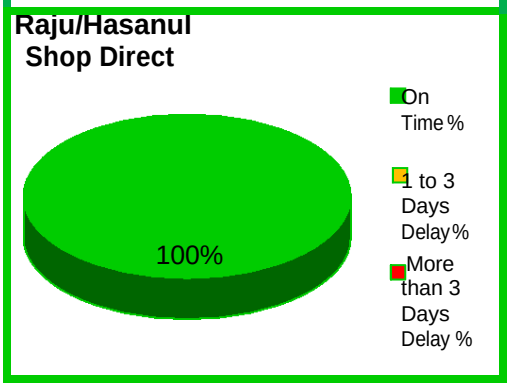


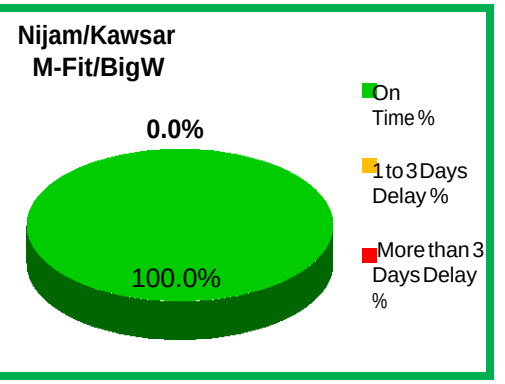












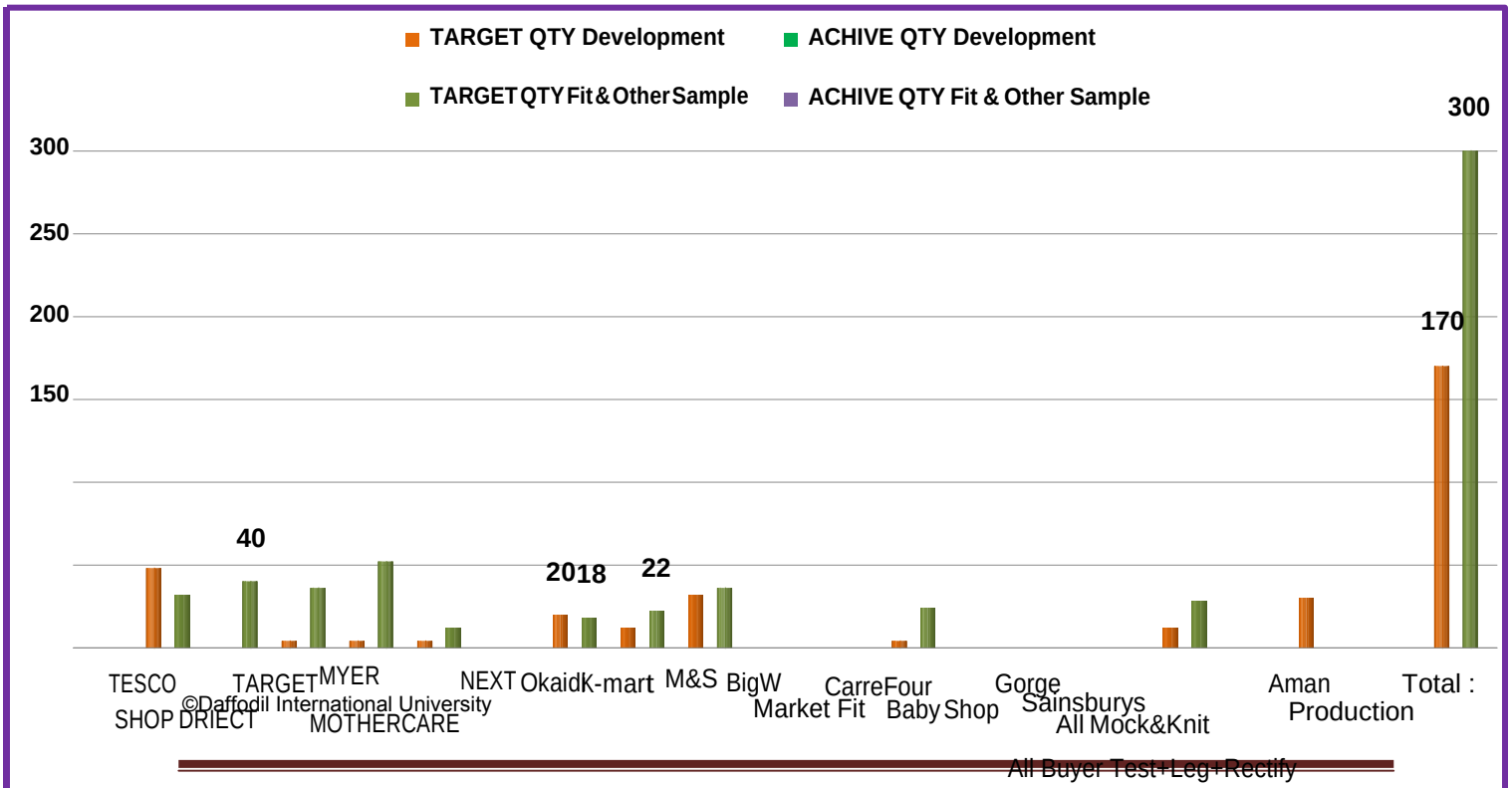
Types of Buyer wise on time

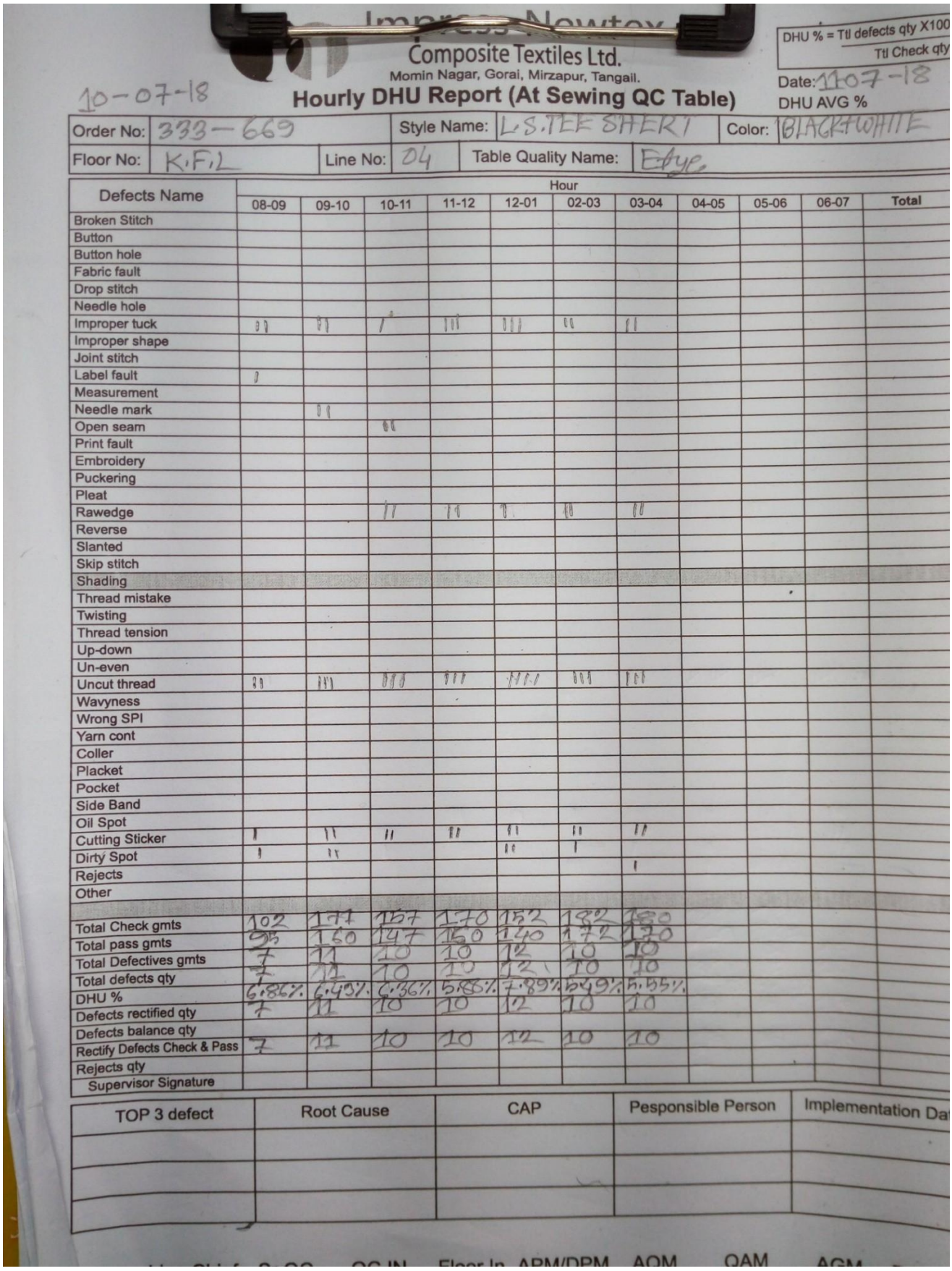
Buyer	Total Style	On Time		1 to 3 Days Delay		More than 3 Days	
		On Time Total Style	On Time	Total (1 to 3 Days Delay)	1 to 3 Days Delay	Total More than 3 Days Delay	More than 3 Days Delay
Aman	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
BigW	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Carrefour	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Gorgre	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
K-mart	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
M&S	12	12	100.0%	0	0.0%	0	0.0%
Marketfit	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Mothercare	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Myer	1	1	100.0%	0	0.0%	0	0.0%
Next	5	5	100.0%	0	0.0%	0	0.0%
Okaidi	3	0	0.0%	0	0.0%	3	100.0%
Shop Direct	4	4	100.0%	0	0.0%	0	0.0%
Targer	1	1	100.0%	0	0.0%	0	0.0%
Tesco	17	13	76.5%	1	5.9%	3	17.6%
Total :	43	36	83.7%	1	2.3%	6	14.0%

SAMPLE TYPE	Total Style	On Time		1 to 3 Days Delay		More than 3 Days	
		On Time Total Style	On Time %	Total (1 to 3 Days Delay)	1 to 3 Days Delay %	More than 3 Days Delay	More than 3 Days Delay %
Block	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Buying	7	7	100.0%	0	0.0%	0	0.0%
Development	28	24	85.7%	1	3.6%	3	10.7%
Fit	1	1	100.0%	0	0.0%	0	0.0%
Proto	7	4	57.1%	0	0.0%	3	42.9%
RR	0	0	#DIV/0!	0	#DIV/0!	0	#DIV/0!
Total :	43	36	83.7%	1	2.3%	6	14.0%

WEEKLY BUYER WISE TARGET QUANTITY & ACHIVE QUANTITY

BUYER	TARGET QTY Development	ACHIVE QTY Development	TARGET QTY Fit & Other Sample	ACHIVE QTY Fit & Other Sample	TARGET QTY	ACHIVE QTY	Next Week Target Plan 18.04.2018 To 24.04.2018		
							DV	Other	Total
TESCO	48	46	32	31	80	77	36	52	88
SHOP DRIECT	0	4	40	36	40	40	16	42	58
TARGET	4	0	36	27	40	27	8	72	80
MYER	4	12	52	36	56	48	8	58	66
MOTHERCARE	4	12	12	26	16	38	8	4	12
NEXT	0	0	0	0	0	0	0	0	0
Okaidi	20	24	18	0	38	24	12	18	30
K-mart	12	8	22	84	34	92	16	56	72
M&S	32	40	36	32	68	72	20	44	64
BigW	0	28	0	0	0	28	0	40	40
Market Fit	0	0	0	2	0	2	0	0	0
CarreFour	4	23	24	96	28	119	32	12	44
Baby Shop	0	0	0	0	0	0	0	0	0
Gorge	0	0	0	0	0	0	0	0	0
Sainsburys	0	0	0	0	0	0	0	0	0
All Mock&Knit	12	12	28	32	40	44	18	12	30
All Buyer Test+Leg+Rectify	0	0	0	21	0	21	0	0	0
Aman	30	0	0	30	30	30	30	0	30
Production	0	0	0	0	0	190	0	0	0
Total :	170	209	300	453	470	852	204	410	614





Composite Textiles Ltd.
Momin Nagar, Gorai, Mirzapur, Tangail.

10-07-18

Hourly DHU Report (At Sewing QC Table)

DHU % = Ttl defects qty X100 / Ttl Check qty

Date: 11-07-18

DHU AVG %

Order No: 333-669 | Style Name: L.S.TEE SHERT | Color: BLACK/WHITE

Floor No: K.F.L | Line No: 04 | Table Quality Name: Edye

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											
Button											
Button hole											
Fabric fault											
Drop stitch											
Needle hole											
Improper tuck	2	2	1	3	3	2	2				
Improper shape											
Joint stitch											
Label fault	1										
Measurement											
Needle mark		2									
Open seam			2								
Print fault											
Embroidery											
Puckering											
Pleat											
Rawedge			1	1	1	2	2				
Reverse											
Slanted											
Skip stitch											
Shading											
Thread mistake											
Twisting											
Thread tension											
Up-down											
Un-even											
Uncut thread	3	3	3	3	4	3	3				
Wavyness											
Wrong SPI											
Yarn cont											
Coller											
Placket											
Pocket											
Side Band											
Oil Spot											
Cutting Sticker	1	1	1	1	1	1	1				
Dirty Spot	1	1			1	1					
Rejects							1				
Other											
Total Check gmts	102	171	157	170	152	182	180				
Total pass gmts	95	160	147	160	140	172	170				
Total Defectives gmts	7	11	10	10	12	10	10				
Total defects qty	7	11	10	10	12	10	10				
DHU %	6.86%	6.43%	6.36%	5.88%	7.89%	5.49%	5.55%				
Defects rectified qty	7	11	10	10	12	10	10				
Defects balance qty											
Rectify Defects Check & Pass	7	11	10	10	12	10	10				
Rejects qty											
Supervisor Signature											

TOP 3 defect	Root Cause	CAP	Pesponsible Person	Implementation Da

Floor In APM/DPM AQM QAM AGM

Summary of Reports (Aman Graphics & Design Ltd.) in finishing section

Date	Buyer	InspectedQty	Defects																	
			Brokenstitch	Button	Openseam	Rawedge	Skipstitch	pleat	Oilspot	Dirtyspot	Uncutthread	Cutdamage	Yarn contamination	waviness	Joinstitch	Twisting	Needlehole	Slanted	Rejects	Others
22-06-18	H&M	1250	18	2	6	2	5	11	1	26	0	0	0	0	0	0	0	0	3	0
3-6-18	VEKO MODA	1400	3	0	0	0	4	3	0	15	20	0	0	0	0	0	0	0	1	0
11-06-18	H&M	1990		0	1	0	1	0	0	11	1	3	4	0	0	0	0	0	2	0
12-06-18	H&M	1510	7	0	0	0	1	0	6	9	0	0	0	0	0	0	0	0	0	0
13-06-18	H&M	2029	3	0	1	0	1	0	12	1	0	3	0	5	0	0	0	0	1	2
3-06-18	H&M	6170	10	0	3	1	14	7	4	200	0	1	0	0	3	2	0	0	10	0
22-06-2018	H&M	455	4	0	1	3	0	0	5	0	6	1	0	0	0	0	1	2	1	0
Total	14804		45	2	12	6	26	21	28	**262**	27	8	4	5	3	2	1	2	18	2
			474 (3.20%)																	
	Defect %		9.49	0.42	2.53	1.26	5.48	**4.43**	5.90	**55.27**	5.69	1.68	0.84	1.05	0.63	0.42	0.21	0.42	3.79	0.42

Here is the highest defects % **55.27** dirty spot.

Woven data from finishing section:

AMA

DAILY SE

July-18

Line Name	Total No. of Pieces Inspected	Total No. of Pieces Pass	Total No. of Defective Pieces	M				
				Un cut thread	Puckering	Broken Stitch	Bartack missing	
Line -1	3384	3304	188	3	18	9	0	
Line -2	1477	1325	152	0	3	0	0	
Line -3	5073	4870	203	9	0	7	4	
Line -4	4371	4182	189	2	0	12	7	
Line -5	3937	3714	223	0	13	6	1	
Line -6	5621	5371	250	3	1	4	4	
Line -7	6548	6254	294	3	1	1	3	
Line -8	6819	6695	124	12	0	2	2	
Line -9	3300	3074	226	0	31	15	0	
Line -10	6077	5914	163	1	0	0	0	
Line -11	4305	4065	240	5	8	0	0	
Line -12	5557	5395	162	0	0	0	0	
Line -13	3730	3547	183	4	10	8	2	
Line -14	3570	3384	186	0	1	6	3	
Line -15	4389	4173	216	0	10	0	3	
Line -16	2920	2802	118	15	3	0	0	
Line -17	3542	3424	118	3	11	1	1	

Line -18	3053	2986	67	0	3	0	0
Line -19	2520	2467	53	0	3	3	1
Line -20	3622	3450	172	0	0	0	0
Line -21	2929	2842	87	0	0	2	1
Line -22	5221	5097	124	0	0	3	1
Line -23	5588	5233	355	0	18	10	0
Line -24	5285	5122	163	0	0	0	0
Line -25	3971	3885	86	0	2	0	0
Line -26	**4797**	4464	**333**	**0**	**8**	**9**	**17**
Line -27	**3120**	3015	**105**	**0**	**4**	**0**	**0**
Line -28	**2107**	2010	**97**	**0**	**1**	**2**	**0**
Line -29	**2926**	2790	**136**	**0**	**0**	**0**	**2**
Line -30	**4298**	4024	**274**	**11**	**1**	**1**	**2**
Line -31	**5551**	5288	**263**	**6**	**0**	**0**	**4**
	114726	**110054**	**4780**	**60**	**148**	**98**	**50**
Total Defect				0.05	0.13	0.09	0.04
DHU							
Defect Classification							
Classification %							

AMA

SEWING

July-18

Line Name	**Tot**	**Tot**	**Tot**	**M**

	al No. ofPieces Inspected	al No. of Pieces Pass	al No. of Defective Pieces	Un cut thread	Puckering	Broken Stitch	Bartack missing
Line -1	4100	3973	127	9	3	5	0
Line -2	5820	5653	167	0	0	3	0
Line -3	4200	4010	190	11	2	9	0
Line -4	2306	2191	115	0	0	12	8
Line -5	1485	1398	87	0	0	0	0
Line -6	4521	4310	211	1	7	31	0
Line -7	5175	4916	259	0	21	21	20
Line -8	5615	5438	177	0	9	19	25
Line -9	1476	1308	168	0	7	0	0
Line -10	5011	4747	264	0	0	0	11
Line -11	4111	3851	260	3	14	15	6
Line -12	3075	2794	281	1	3	0	0
Line -13	4466	3977	489	0	23	31	9
Line -14	2400	2163	237	0	0	42	2
Line -15	4670	4418	252	0	17	41	42
Line -16	4850	4500	350	0	14	30	0
Line -17	3260	2968	292	0	4	64	11
Line -18	7119	6855	264	0	4	9	0
Line -19	4760	4518	242	0	0	81	0
Line -20	4220	3909	311	0	18	21	23
Line -21	5605	5461	144	17	0	40	25
Line -22	4357	4242	115	0	1	9	0
Line -23	3500	3282	218	0	18	27	0
Line -24	6425	6283	142	15	0	0	0
Line -25	4650	4500	150	0	0	2	4
Line -26	**3520**	3341	**179**	**0**	**5**	**22**	**0**
Line -27	**6300**	6004	**296**	**0**	**0**	**37**	**0**
Line -28	**4350**	4191	**159**	**0**	**40**	**23**	**3**

Line -29	4260	4029	231	0	35	4	22
Line -30	4029	3838	191	0	0	38	0
Line -31	3719	3461	258	0	12	11	7
	116997	111010	5987	57	170	571	186
Total Defect				0.05	0.15	0.49	0.16
DHU							
Defect Classification							
Classification %							

c

AMAN GRAPHICS & DESIGN LTD.

WEEKLY INPROCESS INSPECTION REPORT WAIST BAND

July-18

Inspector Name: JASMIN

LINE NAME: 9+GET UP

Date	Buyer Name		Total No. of Pieces Inspected	Total No. of Pieces Pass	Total No. of Defective Pieces	Man										Materials					Machine			Method			Total Defects	DHU	Percentage of Defective
						Un cut thread	Puckering	Broken Stitch	Bartack missing	Button or hole Missing	Uneven Shap	Up Down	Shading	Open Seam	Others	Joint Stitch	Raw edge	Down Stitch	Spot/Dirty Spot	Rejects	Skip stitch	Thread tension	Incorrect S.P.I	Pleat	Lebel wrongposition/Open	Loop Slanted	Style mistake			
1-Ju	MYER	19U12	788	730	58		17	6			8	8				3	3	6			2			1				60	7.61	7.36%

l																											
2-Jul	MYER	190112	7559	698	61		15	9			9	9				2	3	9						6			62	8.17	8.04%
3-Jul	MYER	190112	8022	729	73		13	3			9	7				2	2	25			8			4			73	9.10	9.10%
4-Jul	m/care	7366	78	58	20		9				2	3						2	4								20	25.64	25.64%
5-Jul	m/care	7366	3755	318	57		14	3			12	15				3	2	7						3			59	15.73	15.20%
7-Jul	m/care	7366	6533	599	54		9	3			5	8				3	3	14			4	3		2			54	8.27	8.27%
8-Jul	m/care	7366	6499	599	50		8	3			5	11				2	2	13			2						46	7.09	7.70%
9-	m/	73	60	558	47		6				2	4	5			3	4	11			2						37	6.1	7.77%

Jul	care	6	5																								2	
10-Jul	m/care	736	644	589	55		5	4			5	2	9			5	4	16			2						52	8.07	8.54%
11-Jul	m/care	736	614	569	45		3	2			7	7	5			3	6	10									43	7.00	7.33%
12-Jul	m/care	736	712	658	54			3																			3	0.42	7.58%
14-Jul	TESCO	535	50	24	26																						0	0.00	52.00%
15-Jul	TESCO	535	289	247	42																						0	0.00	14.53%

16-Jul	TESCO	535	384	302	82																						0	0.00	21.35%
17-Jul	TESCO	535	593	529	64																						0	0.00	10.79%
				0																							0	#DIV/0!	#DIV/0!
				0																							0	#DIV/0!	#DIV/0!
				0																							0	#DIV/0!	#DIV/0!
				0																							0	#DIV/0!	#DIV/0!
				0																							0	#DIV/0!	#DIV/0!
				0																							0	#DI	#DIV/0

																											V/0!	!
			7995	7207	788	0	99	36	0	0	64	74	19	0	0	26	29	113	4	0	20	3	0	22	0	0	0	509	6.37	9.86%
Total Defect						0.00	1.24	0.45	0.00	0.00	0.80	0.93	0.24	0.00	0.00	0.33	0.36	1.41	0.05	0.00	0.25	0.04	0.00	0.28	0.00	0.00	0.00	-	-	-
DHU						318											29					25			0			-	-	-
Defect Classification						62.48%											5.70%					4.91%			0.00%			-	-	-
Classification %																														

Agent :ABA
Date :14-06-2018
Buyer :TRENT

Style :SHORT

AMAN GRAPHICS

WEEKLY INPROCESS INSPECT

July-18 Inspector Name: Seragul

Date	Buyer Name	Style	Total No. of Pieces Inspected	Total No. of Pieces Pass	Total No. of Defective Pieces	Man										
						Un cutthread	Puckering	Broken Stitch	Bartack missing	Button or hole Missing	Uneven Shap	HOLL	Up Down	Shading	Open Seam	
1-Jul	TESCO	3689	850	814	36			7	6	8			8			
2-Jul	TESCO	3689	740	705	35			6	5	8						
3-Jul	TESCO	3689	770	731	39			4	9	6			8			
4-Jul	TESCO	3689	820	780	40			8	9				8			
5-Jul	TESCO	3689	800	775	25			2	5		2					2
7-Jul	TESCO	3689	904	858	46			9	4				11			
8-Jul	TESCO	3689	915	870	45			8	9				9			
9-Jul	TESCO	3689	1015	969	46			8		10			5			
10-Jul	TESCO	3689	835	794	41			12	8				9			
11-Jul	TESCO	3689	847	820	27				8							
12-Jul	TESCO	3689	290	275	15			3					4			
14-Jul	M & S	2528 M	100	89	11											
15-Jul	M & S	2528 M	425	396	29			9					6			

16-Jul	**M & S**	2528 M	294	278	16						2		4			2
17-Jul	**M & S**	2528 M	350	333	17						1		4			3
18-Jul				0												
				0												
				0												
				0												
				0												
				0												
				0												
			9955	**9487**	**468**	**0**	**0**	**76**	**63**	**32**	**5**	**0**	**76**	**0**	**0**	**7**
Total Defect						0.00	0.00	0.76	0.63	0.32	0.05	0.00	0.76	0.00	0.00	0.7
DHU						259										
Defect Classification						55.82%										
Classification %																

			Tota								
									Un cutthread	Puckering	Broken Stitch
2-Jul	shop derect		1219	75	65	10					
3-Jul	shop derect		1219	183	162	21					2
4-Jul	shop derect		1219	340	318	22					5
7-Jul	M/CARE		863	410	387	23					
8-Jul	M/CARE		863	497	468	29					
9-Jul	M/CARE		863	550	523	27					2
10-Jul	M/CARE		863	360	338	22					
11-Jul	M/CARE		863	215	201	14					
12-Jul	M/CARE		863	635	607	28		`			
14-Jul	M/CARE		863	480	455	25					
16-Jul	TESCO		825525	20	15	5					
17-Jul	TESCO		825525	135	120	15					
					0						
					0						
					0						
					0						
					0						
				3900	3659	241			0	0	9
Total Defect									0.00	0.00	0.23

DHU	
Defect Classification	
Classification %	

Factory : BEATS FASHION LTD Item :126222
Inspector : LAILY PO/Art :325459

Description		1	2	3
Total Received		643	463	340
		643	1103	1443
Ok		600	451	320
		600	1050	1350
Alter		43	40	40
		43	83	123
Alter Rectified		20	10	20
		20	30	50
TotalOk		620	451	320
		620	1050	1350
	Waist	B-10	B-10	SK- 5/D3
	Front part	SK- 5/B-5	BR- 6/D-3	BR- 5/D-2
	Side seam	O5P-3	BR-3/SK-5	SK-5/0P-2
	In seam		SK-3	
	Back part	B-10	SK-5	B-10
	Bottom	B-10	B-5	B-10
L/Chief sing				
Chief Controller				

BB	Brocken stitch	E	Embroidery	IS	Incomplete stitch	N	Needle Mark	P	Puckering	SK	Skip Stitch	TH	Thread Mistake	V	Visible Edge
BB	Bubbling	F	Fabric fault	IM	Ink mark	NS	Narrow Stitch	R	Run Of Stitch	SP	Slanted Pocket	U	Uneven Stitch	W	Weaveb Zipper
BR	Bar tack missing	G	Gathering	L	Level mistake	o	Oil Mark	RE	Raw Edge	T	Twisted	UP	Uneven Point	WM	
D	Damage	HP	High law PKT	LS	Loop Slanted	Op	Open Stitch	RJ	Reject	TT	Tension Tight	UI	Uneven Lob	WS	
DT	Dirty	HW	High low waist	M	Missing Stich	Ov	Over Stitch	S	Shading	TL	Tension Loose	UW	Uneven widthWidth	DS	

SummaryofReports(FAIRTRADGROUP)inFinishingsection

Date	Buyer	Inspected Qty	Defects																		
			Broken stitch	Button	Open seam	Raw edge	Skip stitch	pleat	Oil spot	Dirty spot	Uncut thread	Cut damage	BAR TACK MISSING	Damage	Join stitch	Twisting	Needle hole	Slanted	Rejects	Others
21.-06-18	OKAIDI	3554	63				54		88					22			27			
20-06-18	MSMODE	2664	63				60		124					20						
19-06-18	MS MODE	3288	108				67		35				93	-						
18-06-18	OKAIDI	4644	97		-		101		82				43	-			51			
17-06-18	OKAIDI	5474	44		54		28		105				52	-			21			
15-06-18	OKAIDI	4465	75		85		49		86				51	-			39			
Total	TOTAL	24089	450		139		359		**520**				239	42			111			
	TOTAL FAULT		1860																	
	DEFECT%		7.72%																	
	Defect %		24.19		7.47				**27.95**				12.84	2.25			5.96			

Hereisthehighest defects %**27.95** dirtyspot.

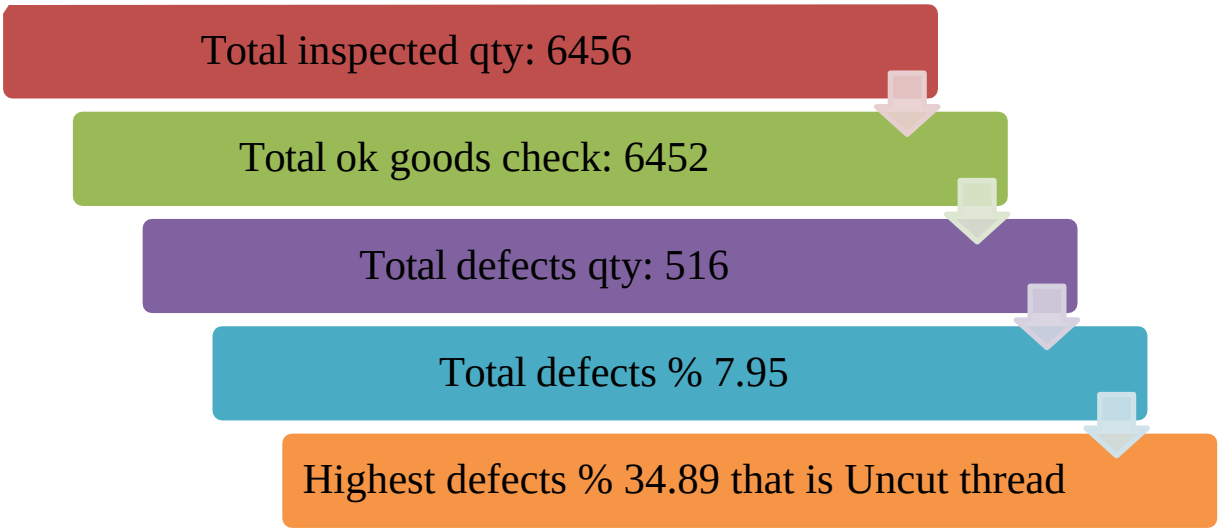
Chapter: 4

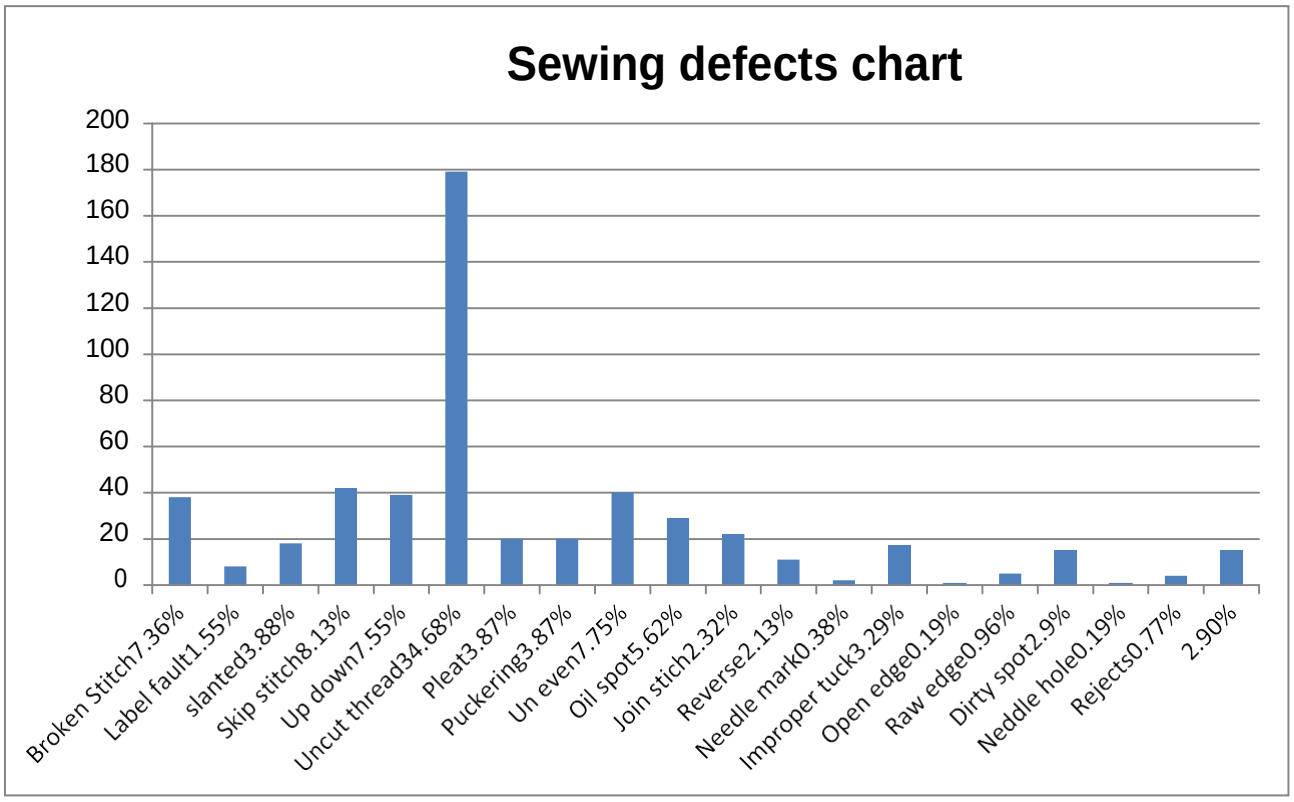
Results & Discussion

Results:

Sewing section data:

a) Impress Newtex Composite Textiles Ltd





b)Aman Graphics & Design Ltd

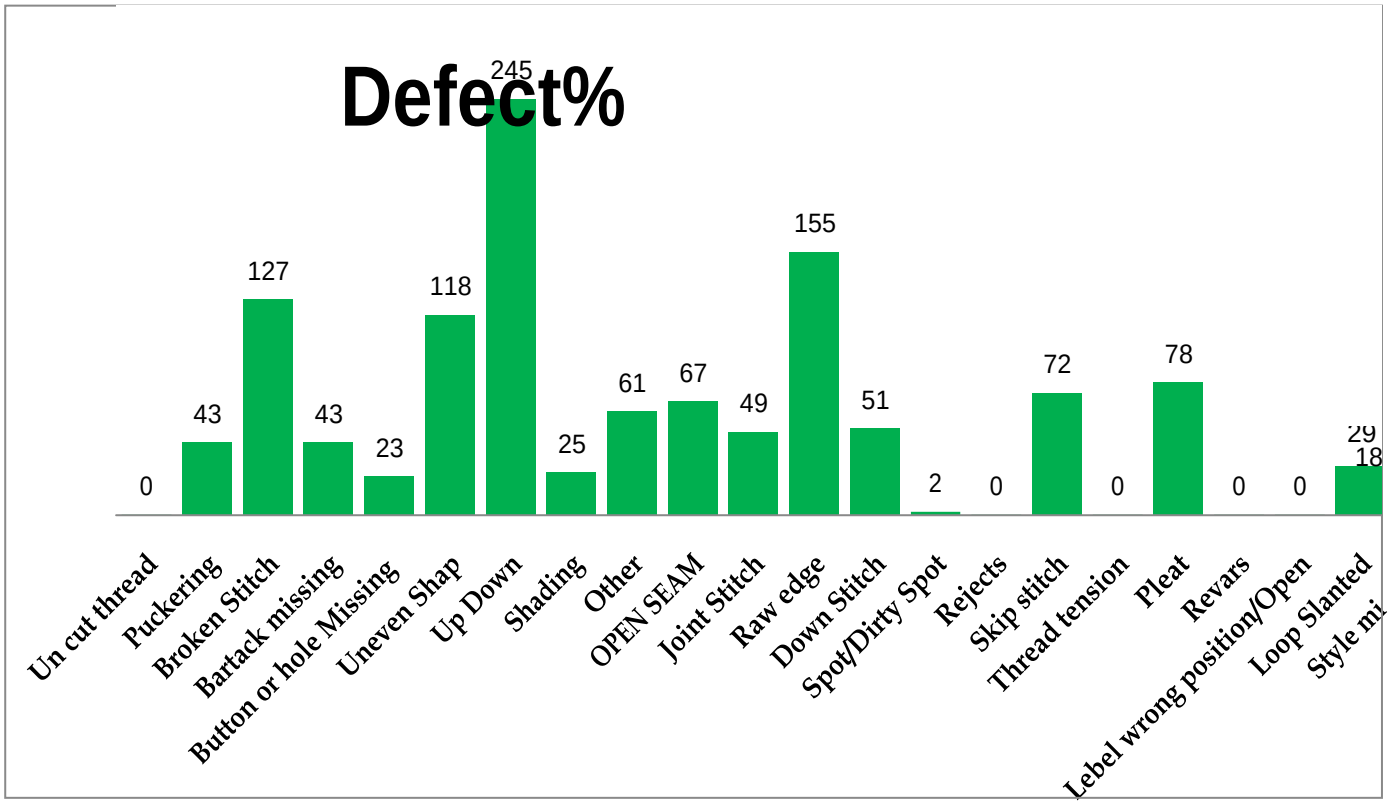
Total inspected qty:11552

Total ok goods check:11552

Total defects qty:1206

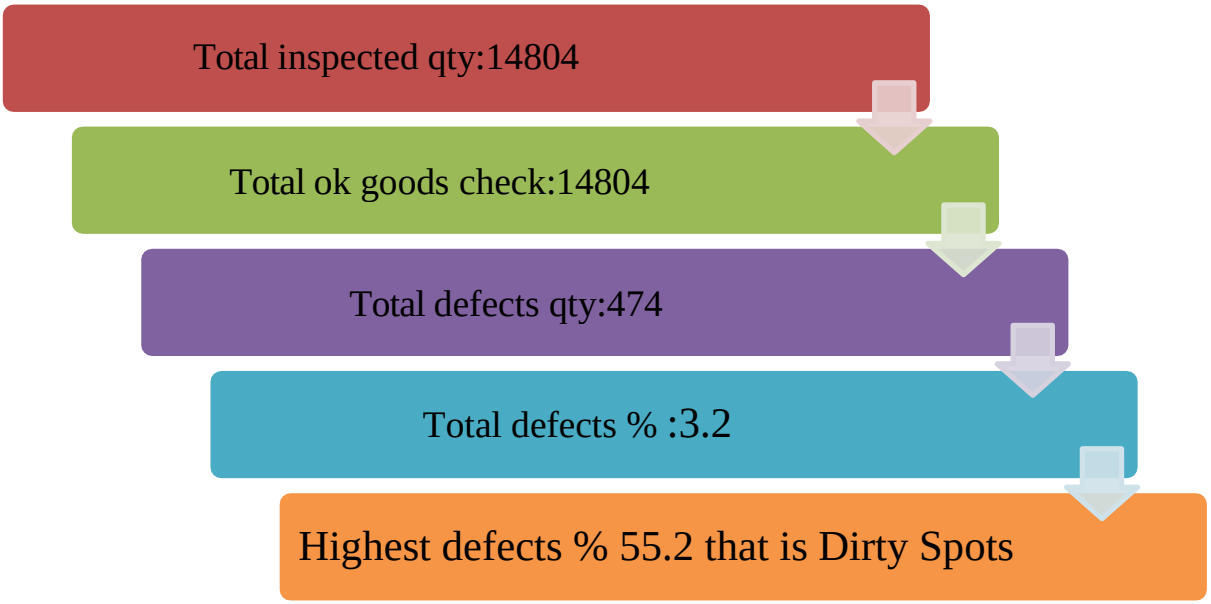
Total defects % :11.81

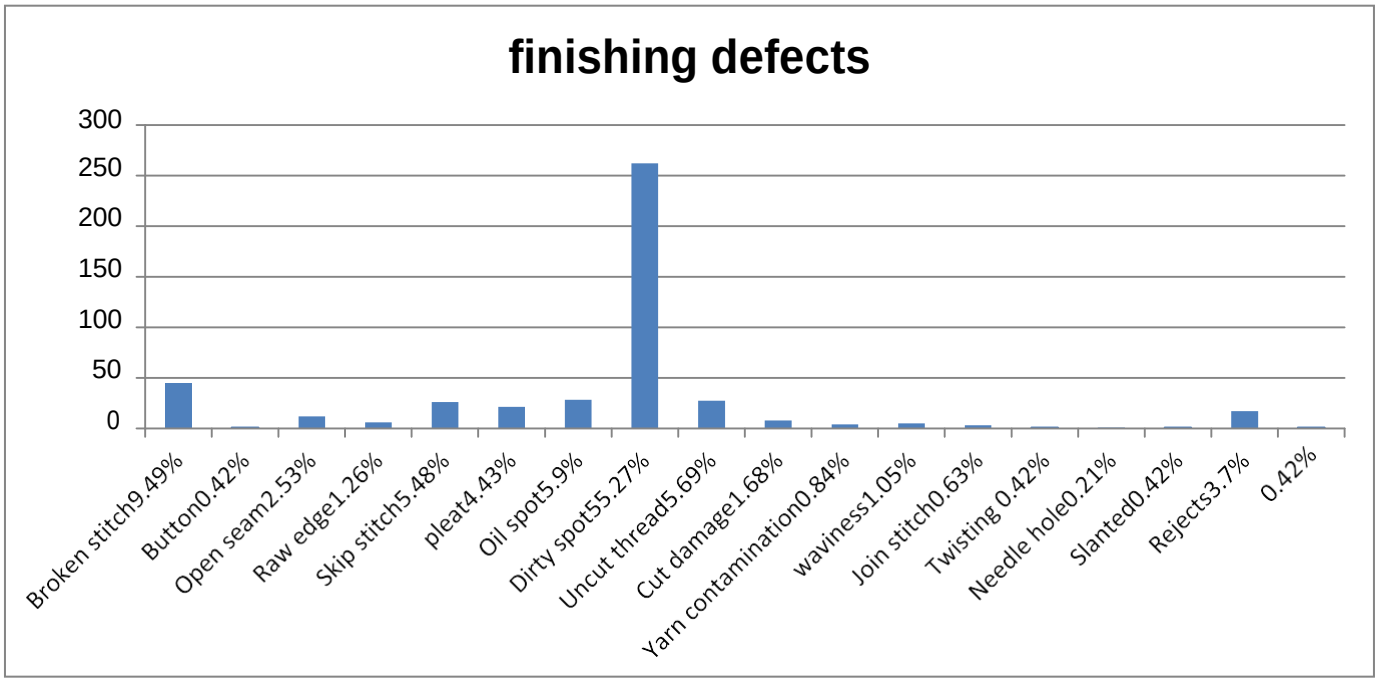
Highest defects % 20.32 that is Up Down



In finishing section:

a) Impress Newtex Composite Textiles Ltd





b) AmanGrapgics& Design Ltd

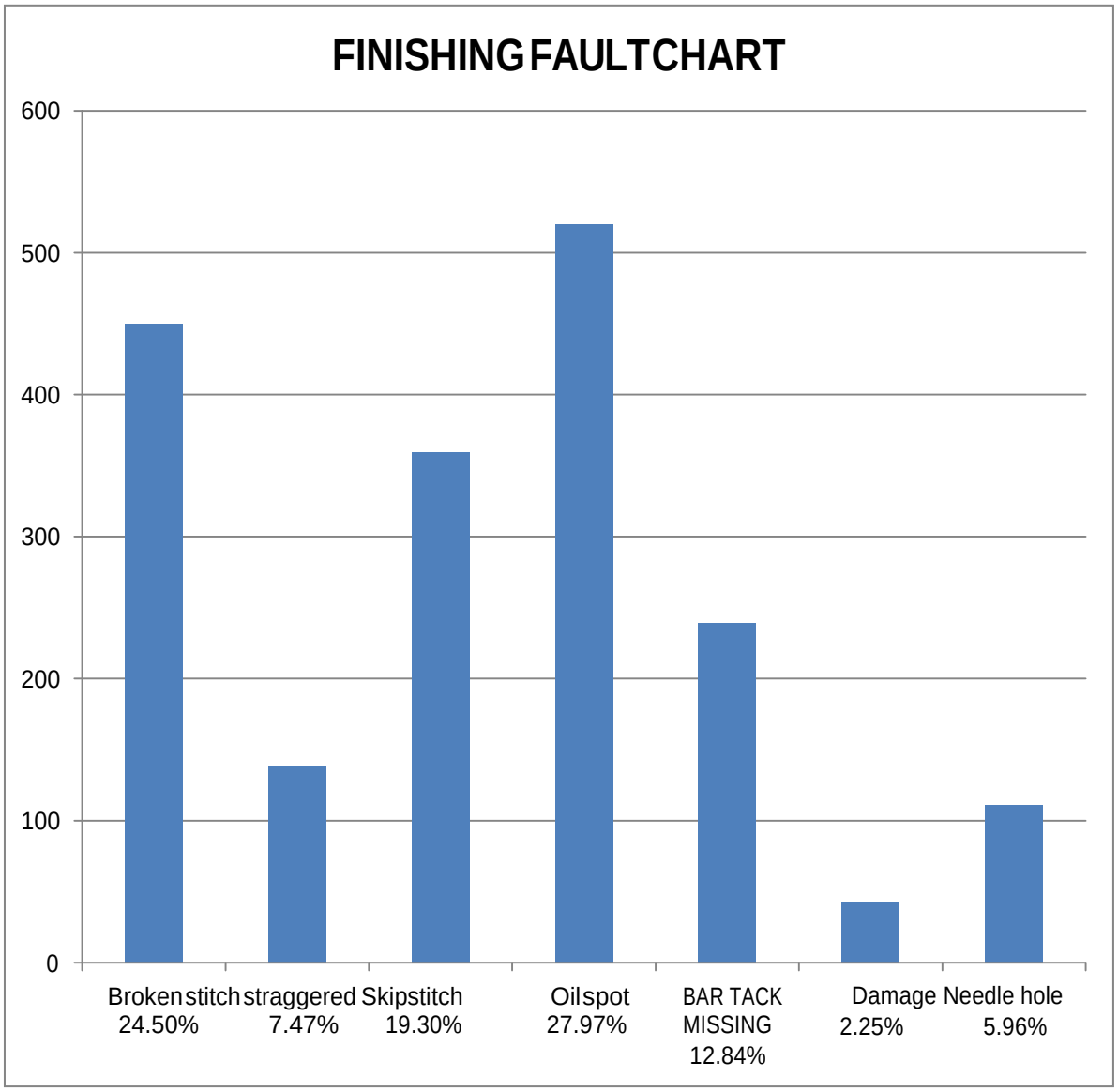
Total imspected qty:24089

Total ok goods check: 23786

Total defects qty: 1860

Total defects % 7.72

Highest defects % 27.97 that is oilspot



4.2 Discussion:

In stitching Section

b) In AmanGrapgics& style Ltd. we have a tendency to additionally ascertained and picked up knowledge for six operating days in several line. during this trade we have a tendency to additionally observe that, altogether 6456 items clothes are inspected, and located that ok product are 6452 items, defective product found 516 items, , which might be rectify

a) In honest Trade cluster we have a tendency to observant & collected knowledge for six operating days in several line. In there we have a tendency to ascertained that, altogether 6630 items clothes are inspected, in wherever ok product are 6628 items, defective clothes are 276 items, it'll berecoverable.

In Finishing section :

a) In AmanGrapgics& style Ltd. we have a tendency to additionally ascertained andcollected knowledge for six operating days in several line. during this trade we have a tendency to additionally observe that, altogether 14804 items clothes are inspected, and located that ok product are 17786 items, defectivegoods found 474 items, , which might berectify

b) In honest Trade cluster we have a tendency to observant & collected knowledge for six operating days in several line. In there we have a tendency to ascertained that, altogether 24089 items clothes are inspected, in whereok product are 23786 items, defective clothes are 1860 items, it'll berecoverable.

CHAPTER-5

5.1 FINDINGS:

- The uncut thread and loop slanted contribute concerning thirty four.64% and 19.92% of the whole defects supported the amount of defects of Knitting and woven garmentsinsewingsection
- The dirty oil and oil spot fifty five.27% contribute making and twenty seven.97 take advantage of the totaldefects supported the numberof defects of Knitting and woven clothes in

sewingsection

 regardless of knitting and woven defects aren't same. Nearly additional defects are occurring of Knitting clothes in sewingsection

 regardless ofknitting and woven defects aren't same. Nearlymore defects are occurring of woven clothes in finishingsection

 presently the whole defects margin is around seven.96,4.14,3.20 .7.96 of the complete production severally in stitching and finishing section . If will|we will|we are able to} bog down the highest three defects from the complete method it can bring down the whole defects underneath normal acceptable defects

 margin. the whole defects margin can return down that is below the quality acceptable defects margin.

Therefore,wecanproducedqualitygoodstoeliminatetop3defectsTo eliminating defects given below somesuggestion

 Formachineriesandequipment'scontinuousassssmentandmaintenanceisneeded.

 The technician may be appointed and he should keenly check the threads, needle,andtensionofthemachinefrequentlyaccordingtothefabrictexture

 Themachinesshouldbecleanedandmaintainedbythattechnicianfrequently

Conclusion

Fromthisstudy, the mostoccurringdefectsanditsfrequencyofoccurrencehavebeen known. it's recommended that the corporate will focus on these defects principally and take steps to bring down and this can pay manner for increasing the extent ofproductivityandsavethetime

Appendix

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