Faculty of Engineering Department of Textile Engineering

Study on Manufacturing Process of Ladies Shirt in Woven Garments Industry

Course title: Project (Thesis)

Course code: TE4214

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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

December, 2018

DECLARATION

We hereby declare that, this work has been done by us and not copied from elsewhere; we also declare that neither this project nor any part of this project has been submitted elsewhere for award of degree.

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LETTER OF APPROVAL

It is herewith certified that Asadullah, Risvi Ahmmed & Sumia Gulshan Mitu bearing ID respectively 151-23-4235, 151-23-4251 & 151-23-4253 Department of Textile Engineering, Daffodil International University, Dhaka, Bangladesh, has carried out their B.Sc. "postulation entitled "Concentrate on Manufacturing Process of Ladies Shirt in Woven Garments Industry" under my immediate supervision." They have successfully carried their research work and ready to present their dissertation, which is required in partial fulfillment of their B.Sc. degree. This is an original study of the author and no part of this thesis has been to any other university or institute for any degree. The thesis contains no materials previously published or written by any other person except reference is made in the text of the thesis.

I have gone through the final draft of the thesis and recommend its submission for the degree of Bachelor of Science in Textile Engineering.

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ACKNOWLEDGEMENT

First of all we would like to express our devotion to the most gracious and the most merciful Allah, Alhamdulillah, since we have been able to finish our thesis work after four months long hardworking.

We wish to express our gratitude to our supervisor, Mousumi Rahaman Hashi, Department of Textile Engineering, Daffodil International University, for giving us the opportunity, trust and freedom that allowed us to explore in the field of our research work. It is indeed a great pleasure for us to express our sincere and profound gratitude to her for her scholastic guidance, constructive suggestions and encouragement which we received from her in order to complete this research work and to write this dissertation.

A very special gratitude goes to Dr. S.M. Mahbub Ul Haque Majumder, Founder and Professor, Department of Textile Engineering, Daffodil International University.

We are indebted to Dr. Md. Mahbubul Haque, Professor & Head, Department of Textile Engineering, Daffodil International University for his unremitting and valuable guidance and suggestions.

We are also very much grateful to Ashraf Ahmed, IE Manager at Beximco Industrial Park for his suggestion and support. Many thanks for everything.

Our special thanks go to all production officers, supervisors and stuffs of The IE Department at Beximco Industrial Park for their helpful hands and cordial co-operation.

Finally, we are grateful to all of my teachers who have helped us all over the four years in this Textile Engineering Department.

Special Thanks to our family for their unconditional support, love and inspiration which gave us incentive to complete this research work successfully. We would like to thank all of our friends with whom we have worked and to all our well-wishers for their moral support throughout this research work.

DEDICATION

It is our genuine gratefulness and warmest regard that we dedicate this work to our beloved Parents & respected Teachers.

ABSTRACT

The report represents the manufacturing process of Ladies Shirt in Woven garments industry. The assessment is done in 'Ladies Shirt" which bearing style number is "803481". For assessment data has collected from cutting, Sewing and Finishing. From data it is seen that different type of Stitch, Specific component of ladies Shirt, Measurement, Accessories & Trims, fewer found. The variation in measurement was found on different sizes such as S, M, L, XL, XXL etc. It was occurred due to machine faults or carelessness of working operators. The problems were found such as uncut yarn from fabric, skip stitch, uneven stitch, puckering, label mistake and uneven joining and so on. To remove these problems the consciousness of operators and periodical inspection of machine is mandatory. The periodical training of the operator can also increase the concentration and consciousness of the operator. The inspection during Sewing and Finishing is also another possible solution to remove the faults and ensuring the quality of the product.

Contents

Chapter-I

INTRODUCTION

1.1 Objective:

- To know about different types of fabric which is appropriate for Ladies Shirt
- To know about different factors which is consider for Ladies Shirt
- To know about different parts of Ladies Shirt
- To know about the flow process of fabric cutting and marking process
- To know about the flow process of sewing operation
- To learn about different types of thread which used for sewing and accessories attaching
- To learn about different types of accessories which used for Ladies Shirt
- To learn about different types of sewing, finishing, packing and other reports
- To learn about different types of sewing faults, finishing faults, packing faults
- To learn about different types of test such as shrinkage test, wash test, color test, perspiration test etc.

1.2 Limitation:

- We are working as the buyer of Primark and style no 803481. This orders main raw fabric import from China. That's way we can't found this fabrics Woven, dyeing and other reports
- Two months wasn't enough time to complete thesis, if we get more time then we will know lot and complete more effectively
- Internet had not enough information about final table inspection and this speed was very low
- Electricity problem occurs in almost every day
- It was not possible to collect all data on specific date wise for specific order
- It has taken much time for collect different data or list from employees because they were very much busy every time from every individual department

We had not enough theoretical knowledge about final table inspection

Chapter-II

LITERATURE REVIEW

2.1 Woven Garments Industry:

Woven industry has great contribution to earn foreign currency in Bangladesh. It contains dyeing, finishing, garment manufacturing, garment washing unit. Woven wear firms in Bangladesh are mainly located in Narayanganj district. Plus, a couple of firms are likewise situated in Chittagong, Dhaka, and Gazipur regions. There is a demand of approximately three billion meters of woven fabric considering the current consumption for export per year. In context of that local mill can only produce around 45 million meters fabric which is around 14-15% of the demand. Consistently the nation is spending just about 4 billion USD to import texture. Among imports, Bangladeshi buys of blended woven textures (up 393.1%), and woven textures under 85% cotton (up 213.2%) developed at the quickest pace from 2011 to 2015. We can state still we require immense interest in the woven segment in Bangladesh as in reverse linkage of article of clothing industry to accomplish 50 billion USD by 2021. Without solid help of crude materials we can't accomplish this objective. Also, we have to put resources into enhanced items, not every person will put resources into same things and make unfortunate rivalry. We have to prepare up the labor to work in this part moreover. Also, to get by in the market we have to guarantee focused value, quality and astounding deals administration to RMG area. Lastly need to do great marking of Bangladeshi texture to the clients, so they utilize Bangladeshi texture to make articles of clothing in Bangladesh.. And that's we will achieve our goal of 50 billion.

2.2 About Shirt:

A shirt is a material article of clothing for the abdominal area (from the neck to the waist). Originally an underwear worn solely by men, it has progressed toward becoming, in American English, a catch-all term for a broad variety of stomach territory bits of attire and underwear. In British English, a shirt is all the more explicitly a piece of clothing with a neckline, sleeves with sleeves, and a full vertical opening with catches or snaps (North Americans would consider that a "dress shirt", an explicit sort of "captured shirt"). A shirt can likewise be worn with a bowtie under the shirt neckline.

There are two principle classes of strands utilized: characteristic fiber and man-made fiber (synthetics or oil based). Some common filaments are cloth, the principal utilized truly, hemp, cotton, most utilized fleece, silk. Some manufactured filaments are polyester, tencel, gooey, and so on. Polyester blended with cotton (poly-cotton) is regularly utilized. Textures for shirts are called shirting. The four fundamental weaves for shirting are plain weave, oxford, twill and silk. Broadcloth, poplin and end-on-end are varieties of the plain weave. In the wake of weaving, completing can be connected to the texture.

2.3 Components of Shirt:

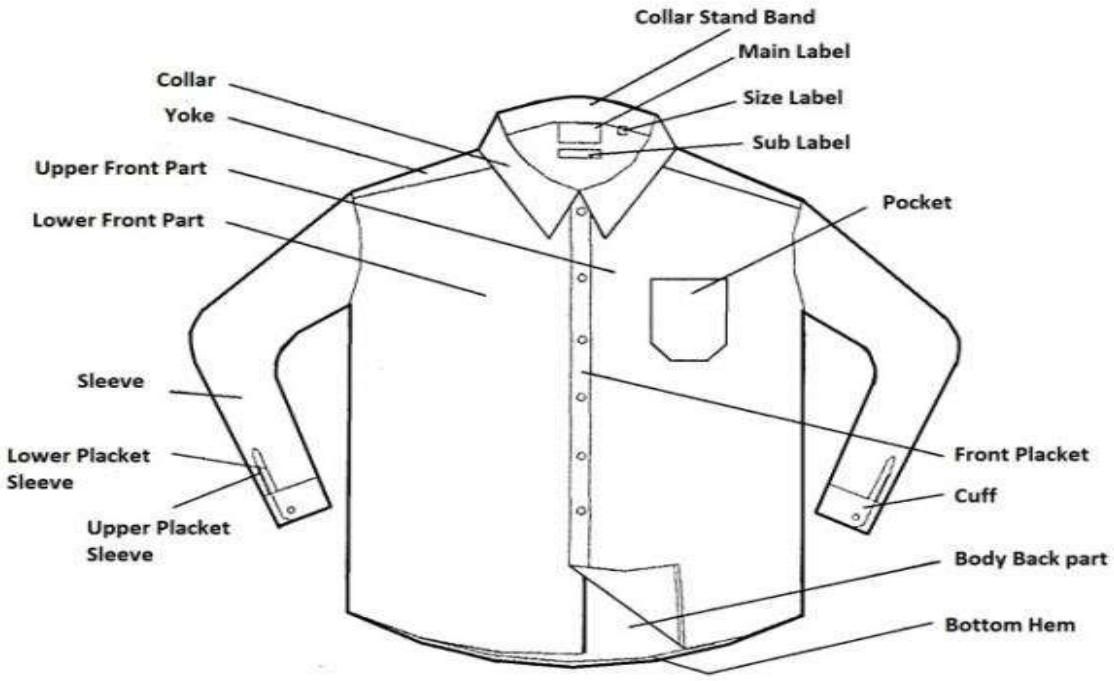

Figure 1: Components of Shirt

2.4 Woven Fabrics Type:

1. Denim fabric
2. Twill fabric.
3. Oxford fabric.
4. Poplin fabric.
5. Flannel fabric.
6. Printed fabric.
7. Grey fabric.
8. Y\D check fabric.
9. S\D sheeting fabric.
10. T\C fabric.
11. Solid fabric.
12. Dobby fabric.
13. Pocketing fabric.
14. Tappet fabric.
15. Brushed check fabric.

2.5 The Steps of Garments Manufacturing (Woven):

Figure 2: Steps of Garments Manufacturing

2.6 Fiber selection in garment manufacturing:

Fabric requirements can be classified into four categories: aesthetic (handle, drape, lustre, etc.); performance in use (easy-care, stretch, comfort, pilling tendency, abrasion resistance, etc.); image and cost, which can be subdivided into the fiber or yarn cost and the finished fabric processing cost. All of these factors have an influence based on the type of garment and its market position or price point. For example, a fabric to be used in a formal ladies' suit for a highly regarded brand house will have a high value placed on aesthetics and image, be less sensitive to performance in use, and will be largely insensitive to cost. On the other hand, a department store's own-brand jeans will be worth highly with respect to its durability and a low cost more than its aesthetics value and brand image.

Figure 3: Raw materials for garment manufacturing

Fabrics are the Centre of the analysis rather than fibers, yarns or garments because fabrics act as the crossroads in the apparel market. Yarns and fibers have a comparatively low range of variety but are difficult to interpret until they are transformed into fabric. Garments are an intricate mix of design and shape, which disguises the role played by the component materials. By contrast, fabrics are finite in number, visible from both ends of the supply chain and recognizable by all. The fiber performance in the clothing market is basically decided by

three factors:

- Inherent characteristics of the fibers itself matches with the aesthetic, cost and other needs of each fabric.
- How easily and economically the fiber's properties could be improved by processing in yarn or fabric form.
- How well the fiber blends with other fibers to enhance the overall fabric properties.

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Yarns:

Yarns are the immediate strand elements used to make woven and knitted fabrics. A yarn is a strand made from spun or twisted fibers or twisted filaments. Fibers are short lengths varying from 1/2 to 20″. The length and diameter of a fiber depends on its natural type and source.

Fabric:

Fabric is the basic raw material of the clothing industry. The quality of fabric not only influences the quality of the garment but also affects the smoothness of the production process. The production of garments from high-quality fabrics not only gives comfort to the wearer but also helps in the smooth working of manufacturing processes and leads to defect-free garments. Specifications for fabrics, and other raw materials used in apparel manufacturing, can be categorized into two groups: properties of fabrics and fabric characteristics. A fabric property represents physical dimensions like yards, pounds, etc., whereas a fabric characteristic refers to the response of the fabric when an external force is applied to it like elongation, elasticity, shrinkage, seam strength, etc. These are measures of reactions to dynamic conditions. Characteristics are physical or chemical changes in the fabric resulting from the application of outside forces. Stress and strain properties are another term used to denote characteristics. There are three perspectives for specifying the fabric requirements:

The consumer's viewpoint

The fabric producer's viewpoint

The garment producer's viewpoint

The consumer's importance lies exclusively in the visual appearance, aesthetics and wear ability properties of the fabric; the durability, utility and style values. The garment manufacturer is concerned with the garment production working characteristics of the fabric, and the cost of manufacturing a garment. If the garment manufacturer is a job worker or manufacturer who retails the garment directly or indirectly to consumers, then he will be concerned with all the consumer values. If the garment manufacturer is a contractor, then he is only concerned with the production cost. In case of a fabric manufacturer, he is concerned with the garment production work characteristics.

Trims and accessories:

Though fabrics are the main raw material for garment manufacturing. For making the garments aesthetic, functional and commercially required various types of trims and accessories are used. Apparel is an ensemble of fabric and accessories. Without trims and accessories, the garment remains incomplete. Swing thread is a must needed trimming which are significantly used in garments manufacturing. To make garments, sewing thread plays an important role in

readymade garments sector. Various kinds of accessories are used on garments; some are part of the garments such as buttons, zippers, and interlining, while others are used for decorating and enhancing the product appearance, such as sequins and embroidery. These accessories are considered as garment accessories as they form an integral part of the garment. Usually other than fabrics these material used for making garments are called trims and accessories.

2.7Cutting:

The cutting section receives fabrics from the store. After receiving fabrics they check fabric by inspection machine. The lay fabric on the table by spreader machine and lay the marker paper on the fabric which come from lectra section. After that the cut the fabric by cutting machine. Then they put number every part by numbering machine. The Shirt sections are cut to the dimensions of the patterns. The pieces consist of a tubed body, or separate front and back sections, sleeves, perhaps pockets, and trim.

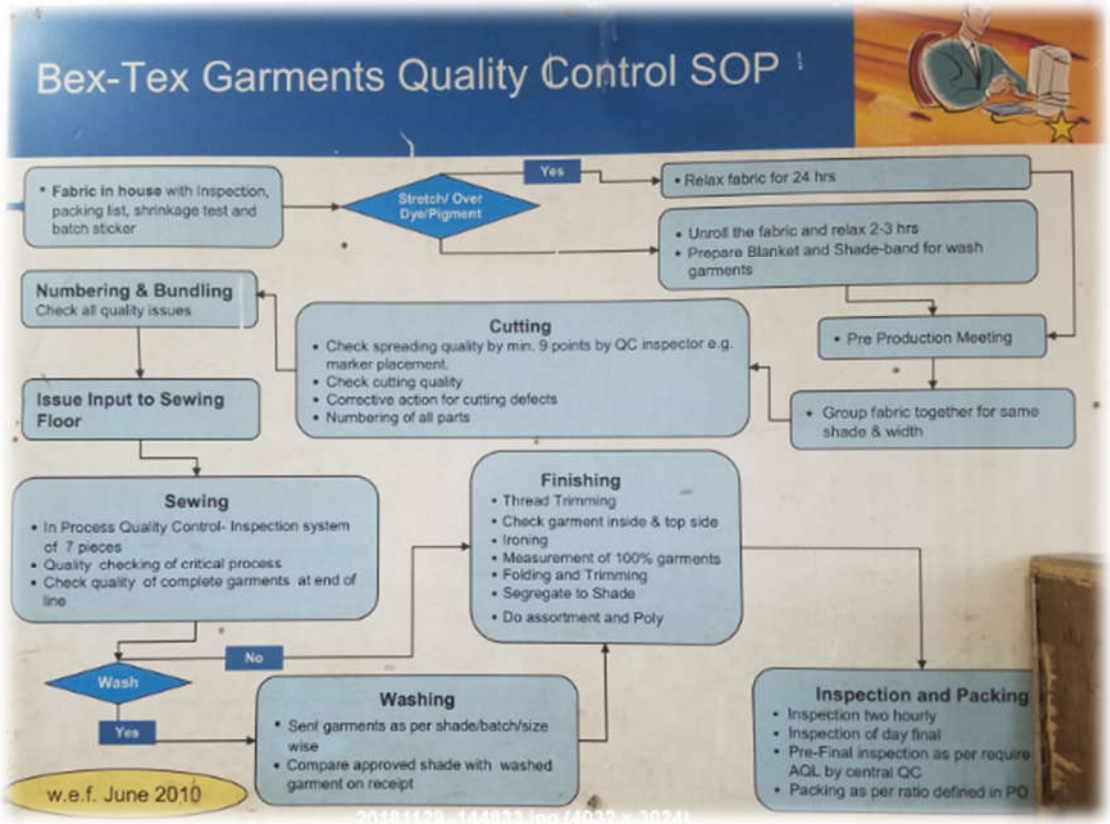


Figure 4: Garments Quality Control SOP

2.7.1 Cutting sequence:

Fabric received from store

Cutting 35inch fabric in every roll

Two piece blanket cutting 5*5inch

One piece shrinkage cutting 15*15inch

Length and width marking

Its send to washing by buyer requirement

After washing then back to cutting section

Measured length & width

Find out shrinkage

Shrinkage report send to CAD section

Then make pattern and marker

And send to cutting section

Fabric spreading

Marker set on the table

Fabric cutting

Numbering parts

Send to sewing section

2.7.2 Making Ladies shirt:

Style no: 2591
Buyer: M&S
Description: Long sleeve shirt, front pocket, ladies shirt
For line
Total line: 10 line
Target/hour: 104
SMV: 24.04
Helpers: 13
Operators: 43
DPI-802658

Total parts 11 piece. Such as

1. Back part – 1 piece
2. Front part - 2 piece
3. Sleeve – 2 piece
4. Back Yoke – 2 piece
5. Collar – 2 piece
6. Collar band – 2 piece
7. Cuff – 2 piece
8. Pocket – 2 piece
9. Sleeve placket – 2 piece
10. Gamble – 2 piece
11. Sleeve tep - 2 piece

Figure 5: Ladies shirt

2.7.3 Cutting machine:

Three type cutting machine are used in industry. Such as

1. Straight knife cutting machine

2. Round knife cutting machine

3. Band knife cutting machine

Figure 6: Round knife cutting machine

Figure 8: Straight knife cutting machine

Figure 7: Band knife cutting machine

2.8 Sewing:

This section gets input from cutting. In this section huge number of operators sewing one garment part by part using various kinds of machines. After completing one garment they send that in to washing section.

2.8.1 Machine of sewing:

1. Lock stitch machine
2. Double thread lock stitch machine
3. Chain stitch machine
4. Double thread chain stitch machine
5. Over lock machine
6. Three thread over lock machine
7. Four thread over lock machine
8. Five thread over lock machine
9. Kansai machine
10. Fed of the arm machine
11. Notcher machine
12. Eye let hole machine
13. Bar tack machine
14. Button hole machine
15. Button attaching machine
16. Multi thread chine stitch machine
17. Smoking machine

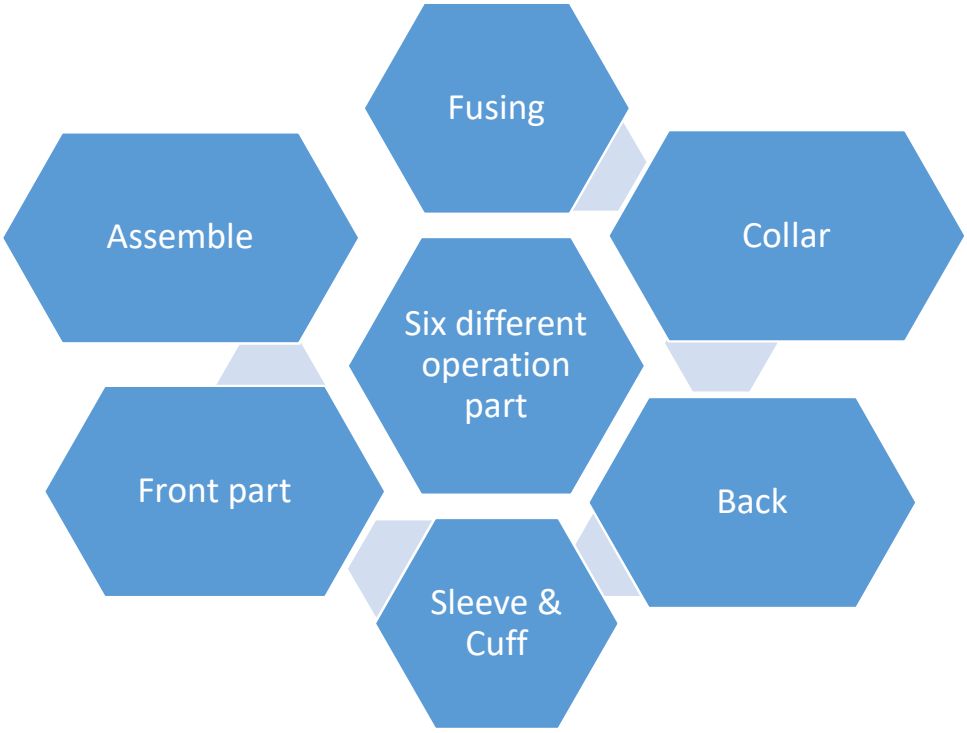
Figure 9: Garments Floor

2.8.2 Types of needle:

BDx1: lock stitch vertical m/c
BDx5: lock stitch double needle, button hole m/c
DPx17: bar tack m/c
DCx1: over lock m/c
UYx128: chain stitch m/c
QYx113: kansai m/c
DBx57: smoking m/c
LWx6T: Bland stitch m/c
DOx558: Eyelet hole m/c

Figure 10: type of needle

2.8.3 The Manufacturing Process (Ladies Shirt):



Fusing

1. Fuse lining collar, band by using iron
2. Fuse lining cuff by using iron
3. Re fuse by using machine

Collar

1. Make collar w/pattern by using lock stitch 1 vertical machine
2. Trim & turn collar & press by using turning machine
3. Topstitch collar ¼ by using lock 1 stitch machine
4. Iron hem collar band by using iron
5. Attach band to collar w/match by using lock 1 stitch machine
6. Turn & t/s collar band by using lock 1 stitch machine
7. Trim collar bottom edge & mark over lock 3

Back

1. Sew back plate & tack by using lock 1 stitch machine
2. Attach & topstitch back yoke by using lock 2 stitch machine
3. Attach label to back by using lock 1 stitch machine

Sleeve & Cuff

1. Sew hem cuff-2 by using lock 1 stitch machine
2. Make cuff by using lock 1 stitch machine vertical
3. Trim & turn cuff& press by using man
4. T/s cuff-2 by using lock 1 stitch machine
5. Attach piping to s/v slit-2 by using lock 1 stitch machine
6. Iron sleeve placket-2 by using man
7. Cut tack & Attach s/v placket w/ edge stc by using lock 1 stitch machine

Front part

1. Iron front yoke by using iron
2. Attach front yoke with shoulder tack by using lock 1 stitch machine
3. Top stitch front yoke by using lock 1 stitch machine
4. Sew box placket w/lining by using kansai machine
5. Press box placket by using man
6. Sew button placket by using kansai
7. Sew hem pocket-2 by using lock 1 stitch machine
8. Iron front pocket by using iron
9. Mark front pocket placement by using man
10. Attach front pocket w/ dcco stitch by using lock stitch one machine
11. Attach & top stitch shoulder by using lock 2 stitch machine
12. Tack label w/poly by using lock stitch 1 machine
13. Tack label to side by using lock stitch 1 machine

Assembly

1. Attach collar to body by using lock stitch 1 machine
2. Close collar by using lock stitch 1 machine
3. Attach s/v to body by using over lock 5 machine
4. T/s arm hole by using lock stitch 1 machine
5. Close side seam by using over lock 5 machine
6. Attach cuff to sly by using lock stitch 1 machine
7. Trim bottom by using over lock 3 machine
8. Sew bottom hem by using lock stitch 1 machine
9. Sew button hole-8 By using button hole machine
10. Attach button-8 by using attach button machine
11. Thread trimming & remove sticker by using man

2.8.4 The Measurement Process (Ladies Shirt):

Making shirts is a fairly simple and largely automated process. Specially designed machines integrate cutting, assembling, and stitching for the most efficient operations. The most commonly used stitch for shirts are lock stitch & chain stitch. Such as the process

1. Centre back neck to hem:
   At the back of the garment, measure ire from the Centre of the neckline straight down to the bottom of the hem.

2. Length from side neck point at back:
   Measure from the side neck point to the button of the hem.

3. Bust/Chest:
   With the garment closed measure across the front of the chest 2.Scm down from the armhole seam.

4. Across front (x-front):
   With the garment closed, 14 cm down from side neck point measure across the front between the armhole seams.

5. Across back (x-back):
   With the garment closed, 14 cm down from side neck point, measure across the back between the armhole seams.

6. Waist (Tops, Dresses & Jackets)
   With the garment relaxed measure straight across the waist seam. Refer to the garment spec for the specified distance down from the under arm, Centre back neck or side neck point.

7. Hem width:
   Measure straight across the bottom of the garment hem between the side seams. If the garment has side seam splits, a vent or shirt tail, measure straight across the bottom with the splits or vent closed and garment flat.

8. Across Shoulder:
   Measure straight across the back of the garment, shoulder point to shoulder point.

9. Armhole straight:
   Measure straight down from the top of the armhole /shoulder (on the natural shoulder position) to the bottom of the armhole.

10. Back Neck Width:
    Measure between the shoulder seams, from side neck point to side neck point. If the shoulder seam sits toward the front or back, measure on the natural shoulder crease line. Refer to the spec as to whether to include or exclude trims.

11. Front neck drop (from imaginary line to seam):
    Measure straight down the front neck from an imaginary line between the side neck points. Measure to the Centre front neck seam. Include neck trims.

12. Back Neck Drop (from imaginary line to seam):
    Measure straight down the back neck from an imaginary line between the side neck points. Measure to the Centre back neck seam. Include neck trims.

13. Sleeve length from shoulder:
    Measure from the shoulder seam along the top edge of the sleeve. Refer to the spec for details whether to exclude or include the cuff or trim.

14. Sleeve Bicep:
    Measure bicep 2.5cm down from the armhole straight across the width of the sleeve. Measure at right angles to the fold line. For knitwear, measure the bicep t the widest part down from the armhole.

15. Sleeve Opening:
    Measure along the finished edge of the sleeve,

16. Cuff Welt depth:
    Measure from the cuff opening edge to where the cuff or welt joins the sleeve.

2.8.5 Fabric quality:

Fabric quality is of utmost importance to the overall quality of apparel and textile products. Regardless of how well a product is designed or constructed, if the fabric is of poor quality, the product will most likely to fail with the consumer. Most fabric is comprised of fibers that are spun into yarns and then woven or knitted into fabric. Support materials like interlinings usually go from the fiber to the fabric stage. Since fibers are the building blocks of all apparel and textile products, it is important to start with quality fibers regardless if they are natural, manufactured, regenerated, or synthetic. Fabric should keep the following properties.

- Comfort: Comfort is very important fabric property. It Comfort is studied by looking at fabric in terms of elongation and elasticity, heat retention and conduction, moisture absorbency, water repellency, waterproofing, hand and skin contact, drape, and air permeability.
- Colorfastness: Colorfastness relates to appearance retention and can be described as “how consumers use textile products and includes factors that may cause colorants to change color or migrate from one material to another”. Colorfastness is considered by presenting the texture to various conditions

including acids and alkalis, crocking, environmental conditions, frosting, heat, light, perspiration, or water.

- Durability: Durability evaluates "how various materials used in a product perform when subjected to different conditions". Durability of a fabric is tested until it fails, and both warp and weft yarns are tested. There are many ways to assess fabric durability, including strength (tensile, tear, and bursting), abrasion, and pilling, snagging, and dimensional stability.

2.9 Garment Defects:

Garment defects is very important issue for the buyers. Generally defects signify lack of quality. During apparel manufacturing process various types of defects occur in garments like faulty zippers, irregular hemming, loose buttons, raw edges, improper button holes, uneven parts, inappropriate trimming, and difference in fabric colors.

2.9.1Common defects of fabric in cutting section:

1. Slub
2. Foreign yarn
3. Knot
4. Thick yarn
5. Missing yarn
6. Shading
7. Spot
8. Chain

Figure 11: Cutting Defects

2.9.2 Common defects noted during textile and garment inspections include:

- Defects in appearance, such as marks, fraying fabric or unfinished edges, etc.
- Defects with seams and stitching, including open seams, incorrect thread selection, skipped stitches, etc.
- Defects concerning color, such as dye spots and color fastness
- Defects concerning fabric, such as its material, fabric weight, cuts or tears, slubs or miss weaves, etc.
- Defects concerning sizing, labeling and packaging, such as labels missing or top/bottom sizes are mismatched
- Defects with polybags over 5″x7″ used that are not marked with applicable child suffocation warnings
- Defects concerning care label information, content label information, hang tag descriptions, correctness of components or trims, zip teeth smoothness, etc.
- Defects concerning measurement and fit
- Defects concerning loose snaps
- Defects concerning foul odors from dyes or other chemicals used in the process
- Defects concerning safety, such as pins, needles and staples not being removed

2.9.3 Remedies of garments defect:

- Pattern needs to be correct
- Reduction of feeder number.
- After cutting the garment parts must be kept in proper bundle with number.
- Better inspection of fabric and cut piece.
- Use a fabric fault detector.
- U**se** of yarn having lower hairiness
- Operator cleanliness and discipline.
- Iron should be regularly checked for dirt/impurities and malfunctions.
- Sewing thread must be selected properly.
- Needle-thread-fabric combination should be well judged.

- Washing parameters should be strictly followed
- Washing parameters should be strictly followed

When these defects starts to appear at close to 2% or 5 pieces, the production must be informed and the operator must re-trained in the proper usage of the machine.

Acceptable Quality limit (AQL)

The Acceptable Quality Limit, commonly referred to as AQL, is a method widely used to measure a production order sample to find whether or not the entire product order has met the client's specifications. The customer then has the data to make an informed decision to accept or reject the lot.

In practice, three types of defects are often distinguished. For most consumer goods, the limits are:

1. 0% for critical defects (totally unacceptable: a user might get harmed, or regulations are not respected).
2. 2.5% for major defects (these products would usually not be considered acceptable by the end user).
3. 4.0% for minor defects (there is some departure from specifications, but most users would not mind it).

These proportions vary in function of the product and its market. Components used in building an airplane are subject to much lower AQL limits.

Note that this tool is used mostly during final outgoing inspections (when the products are ready to be shipped out), and sometimes during production (when the number of products is sufficient to have an idea of the batch's average quality).

AQL Chart for Apparel industry:

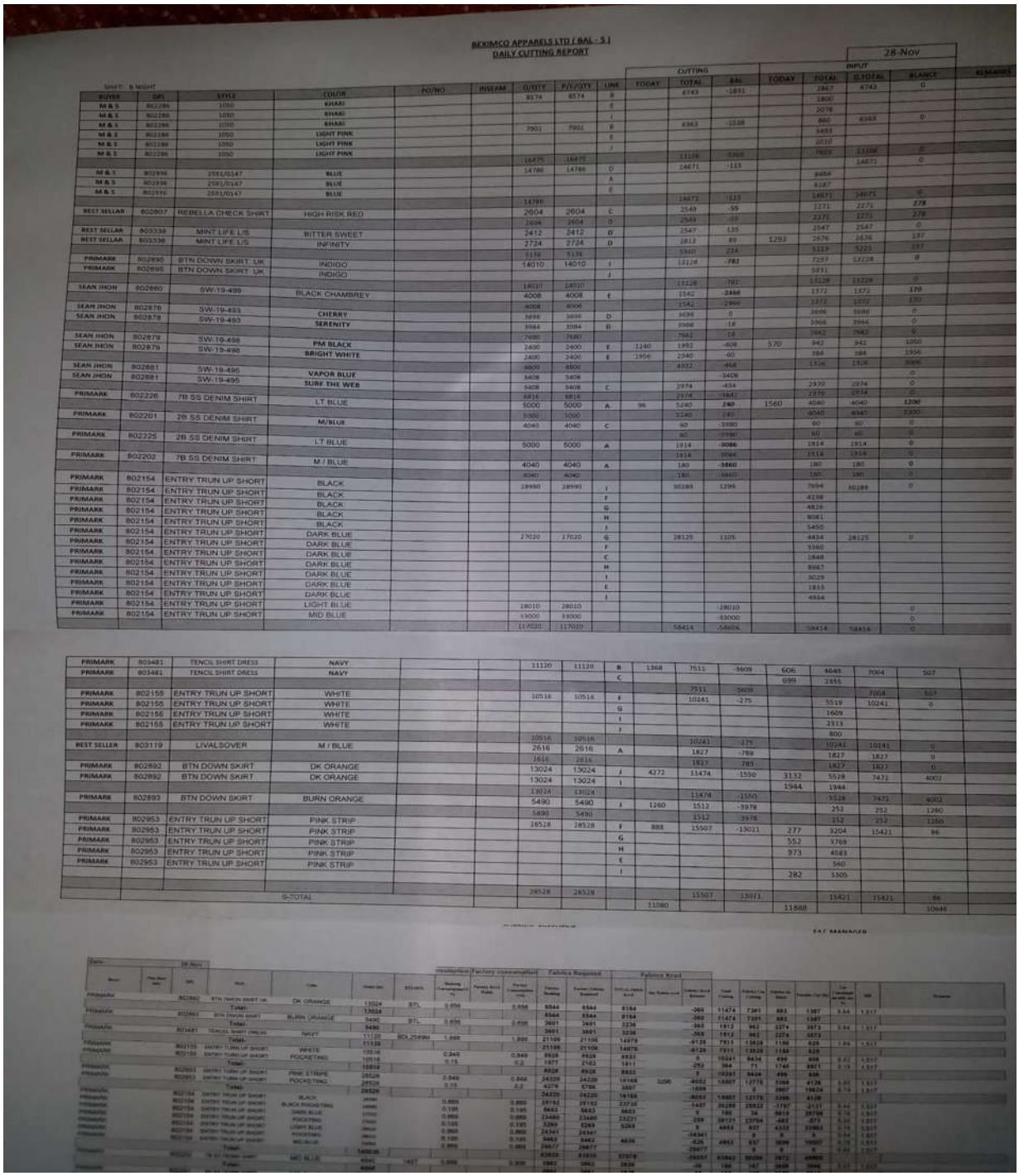
Consignment size (total number of pieces available for audit)	Sample size (pcs)	Normal Inspection Acceptable Quality Level (AQL)					
		AQL 1.5		AQL 2.5		AQL 4.0	
		Accept	*Reject*	*Accept*	*Reject*	*Accept*	*Reject*
51–90	13	0	1	1	2	1	2
91–150	20	1	2	1	2	2	3
151–280	32	1	2	2	3	3	4
281–500	50	2	3	3	4	5	6
501–1,200	80	3	4	5	6	7	8
1,201–3,200	125	5	6	7	8	10	11
3,201–10,000	200	7	8	10	11	14	15
10,001–35,000	315	10	11	14	15	21	22
35,001–150,000	500	14	15	21	22	21	22

Figure 12: AQL Chart

Chapter-III

EXPERIMENTAL DETAILS

3.1 Daily cutting report (industrial copy). Date: 28-11-2018



BEXIMCO APPARELS LTD (BAL - 5)
DAILY CUTTING REPORT

28-Nov

BUYER	DEPT.	STYLE	COLOR	PO/NO	INSEAM	O/QTY	P/C/QTY	LINE	CUTTING TODAY	CUTTING TOTAL	CUTTING BAL	INPUT TODAY	INPUT TOTAL	INPUT G.TOTAL	INPUT BLANCE	REMARKS
M & S	802286	1050	KHAKI			8574	8574	B		6743	-1831		2847	6743	0	
M & S	802286	1050	KHAKI					I					1800			
M & S	802286	1050	KHAKI					J					2076			
M & S	802286	1050	LIGHT PINK			7901	7901	B		6363	-1538		860	6363	0	
M & S	802286	1050	LIGHT PINK					E					3453			
M & S	802286	1050	LIGHT PINK					I					2010			
M & S	802286	1050	LIGHT PINK			16475	16475			13106	-3369		7903	13106	0	
						14780	14780	D		14671	-115			14671	0	
M & S	802936	2591/0147	BLUE					A					8484			
M & S	802936	2591/0147	BLUE					E					6187			
M & S	802936	2591/0147	BLUE													
						14780				14671	-110		14671	14671	0	
BEST SELLAR	802807	REBELLA CHECK SHIRT	HIGH RISK RED			2604	2604	C		2549	-55		1271	2271	278	
						2604	2604	D		2549	-55		2271	2271	278	
BEST SELLAR	803338	MINT LIFE L/S	BITTER SWEET			2412	2412	D		2547	135		2547	2547	0	
BEST SELLAR	803338	MINT LIFE L/S	INFINITY			2724	2724	D		2813	89	1293	2676	2676	137	
						5136	5136			5360	224		5223	5223	137	
PRIMARK	802895	BTN DOWN SKIRT UK	INDIGO			14010	14010	I		13228	-782		7297	13228	0	
PRIMARK	802895	BTN DOWN SKIRT UK	INDIGO					J					5931			
						14010	14010			13228	-782		13228	13228	0	
SEAN JHON	802880	SW-19-499	BLACK CHAMBREY			4008	4008	E		1542	-2466		1372	1372	178	
						4008	4008			1542	-2466		1372	1372	178	
SEAN JHON	802878	SW-19-493	CHERRY			3696	3696	D		3696	0		3696	3696	0	
SEAN JHON	802878	SW-19-493	SERENITY			3984	3984	D		3966	-18		3966	3966	0	
						7680	7680			7662	-18		7662	7662	0	
SEAN JHON	802879	SW-19-498	PM BLACK			2400	2400	E	1240	1932	-468	570	942	942	1050	
SEAN JHON	802879	SW-19-498	BRIGHT WHITE			2400	2400	E	1956	2340	-60		384	384	1956	
						4800	4800			4272	-468		1326	1326	3006	
SEAN JHON	802881	SW-19-495	VAPOR BLUE			3408	3408				-3408				0	
SEAN JHON	802881	SW-19-495	SURF THE WEB			3408	3408	C		2374	-434		2370	2374	0	
						6816	6816			2374	-3842		2370	2374	0	
PRIMARK	802226	7B SS DENIM SHIRT	LT BLUE			5000	5000	A	96	5240	240	1560	4040	4040	1200	
						5000	5000			5240	240		4040	4040	1200	
PRIMARK	802201	2B SS DENIM SHIRT	M/BLUE			4040	4040	C		60	-3980		60	60	0	
										60	-3980		60	60	0	
PRIMARK	802225	2B SS DENIM SHIRT	LT BLUE							1914	-3086		1914	1914	0	
						5000	5000	A		1914	-3086		1914	1914	0	
PRIMARK	802202	7B SS DENIM SHIRT	M / BLUE							180	-3860		180	180	0	
						4040	4040	A		180	-3860		180	180	0	
PRIMARK	802154	ENTRY TRUN UP SHORT	BLACK			4040	4040			180	-3860		180	180	0	
PRIMARK	802154	ENTRY TRUN UP SHORT	BLACK			28990	28990	I		30289	1299		7694	30289	0	
PRIMARK	802154	ENTRY TRUN UP SHORT	BLACK					F					4238			
PRIMARK	802154	ENTRY TRUN UP SHORT	BLACK					G					4839			
PRIMARK	802154	ENTRY TRUN UP SHORT	BLACK					H					8081			
PRIMARK	802154	ENTRY TRUN UP SHORT	BLACK					J					5450			
PRIMARK	802154	ENTRY TRUN UP SHORT	DARK BLUE			27020	27020	G		28125	1105		4434	28125	0	
PRIMARK	802154	ENTRY TRUN UP SHORT	DARK BLUE					F					5360			
PRIMARK	802154	ENTRY TRUN UP SHORT	DARK BLUE					C					1648			
PRIMARK	802154	ENTRY TRUN UP SHORT	DARK BLUE					H					8887			
PRIMARK	802154	ENTRY TRUN UP SHORT	DARK BLUE					I					3029			
PRIMARK	802154	ENTRY TRUN UP SHORT	DARK BLUE					E					1835			
PRIMARK	802154	ENTRY TRUN UP SHORT	LIGHT BLUE					J					4934			
PRIMARK	802154	ENTRY TRUN UP SHORT	MID BLUE			28010	28010				-28010				0	
						13000	13000				-13000				0	
						117030	117020			58414	-58606		58414	58414	0	

BUYER	DEPT.	STYLE	COLOR	PO/NO	INSEAM	O/QTY	P/C/QTY	LINE	CUTTING TODAY	CUTTING TOTAL	CUTTING BAL	INPUT TODAY	INPUT TOTAL	INPUT G.TOTAL	INPUT BLANCE	REMARKS
PRIMARK	803481	TENCIL SHIRT DRESS	NAVY			11120	11120	B	1368	7511	-3609	606	4648	7004	507	
PRIMARK	803481	TENCIL SHIRT DRESS	NAVY					C				699	2355			
										7511	-3609			7004	507	
PRIMARK	802155	ENTRY TRUN UP SHORT	WHITE			10516	10516	F		10241	-275		5519	10241	0	
PRIMARK	802155	ENTRY TRUN UP SHORT	WHITE					G					1609			
PRIMARK	802155	ENTRY TRUN UP SHORT	WHITE					I					2113			
PRIMARK	802155	ENTRY TRUN UP SHORT	WHITE					J					800			
						10516	10516			10241	-275		10241	10241	0	
BEST SELLER	803119	LIVALSOVER	M / BLUE			2616	2616	A		1827	-789		1827	1827	0	
						2616	2616			1827	-789		1827	1827	0	
PRIMARK	802892	BTN DOWN SKIRT	DK ORANGE			13024	13024	J	4272	11474	-1550	3132	5528	7472	4002	
PRIMARK	802892	BTN DOWN SKIRT	DK ORANGE			13024	13024	I				1944	1944			
						13024	13024			11474	-1550		5528	7472	4002	
PRIMARK	802893	BTN DOWN SKIRT	BURN ORANGE			5490	5490	J	1260	1512	-3978		252	252	1260	
						5490	5490			1512	-3978		252	252	1260	
PRIMARK	802953	ENTRY TRUN UP SHORT	PINK STRIP			28528	28528	F	888	15507	-13021	277	3204	15421	86	
PRIMARK	802953	ENTRY TRUN UP SHORT	PINK STRIP					G				552	3769			
PRIMARK	802953	ENTRY TRUN UP SHORT	PINK STRIP					H				973	4583			
PRIMARK	802953	ENTRY TRUN UP SHORT	PINK STRIP					E					560			
PRIMARK	802953	ENTRY TRUN UP SHORT	PINK STRIP					I				282	5305			
		G-TOTAL				28528	28528			15507	-13021		15421	15421	86	
									11080			11888			10646	

Table: Daily cutting report. Buyer: Primark style: Ladies Shirt

Daily cutting report. Date: 28-11-2018

BEXIMCO APPARELS LTD (BAL - 5)

DAILY CUTTING REPORT

28-Nov

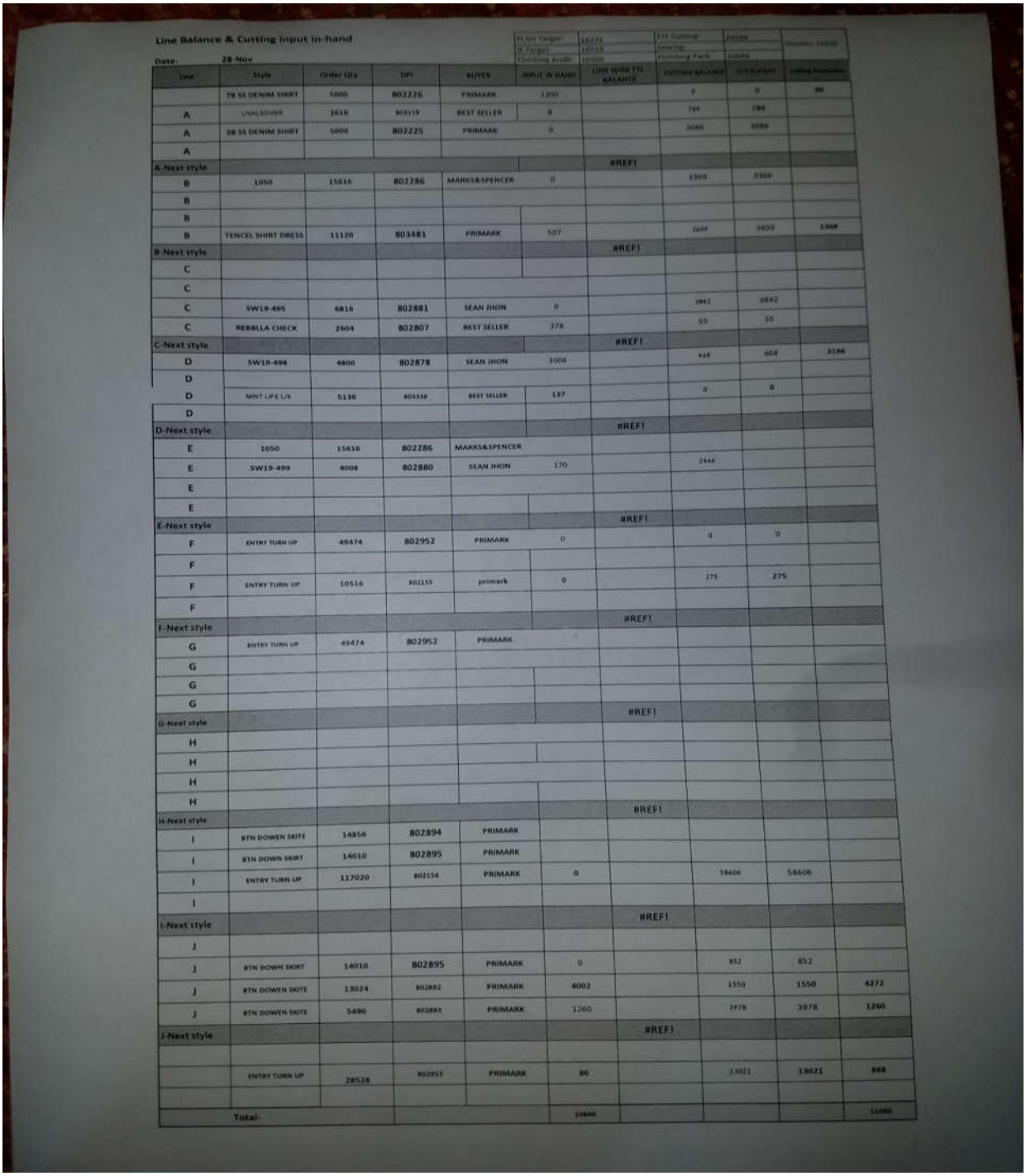
SHIFT: B NIGHT

							CUTTING			INPUT			
BUYER	DPI	STYLE	COLOR	O/QTY	P/C/QTY	LINE	TODAY	TOTAL	BAL	TODAY	TOTAL	G.TOTAL	BLANCE
PRIMARK	802154	Y TRUN UP S	DARK BLUE			E					1833		
PRIMARK	802154	Y TRUN UP S	DARK BLUE			J					4934		
PRIMARK	802154	Y TRUN UP S	LIGHT BLUE	28010	28010				-28010				0
PRIMARK	802154	Y TRUN UP S	MID BLUE	33000	33000				-33000				0
				61010	61010			0	-61010		6767	0	0
PRIMARK	803481	TENCIL SHIRT	NAVY	11120	11120	B	1368	7511	-3609	606	4649	7004	507
PRIMARK	803481	TENCIL SHIRT	NAVY			C				699	2355		
								7511	-3609			7004	507
PRIMARK	802155	Y TRUN UP S	WHITE	10516	10516	F		10241	-275		5519	10241	0
PRIMARK	802155	Y TRUN UP S	WHITE			G					1609		
PRIMARK	802155	Y TRUN UP S	WHITE			I					2313		
PRIMARK	802155	Y TRUN UP S	WHITE			J					800		
				10516	10516			10241	-275		10241	10241	0
BEST SELLER	803119	LIVALSOVER	M / BLUE	2616	2616	A		1827	-789		1827	1827	0
				2616	2616			1827	-789		1827	1827	0
PRIMARK	802892	N DOWN SKIF	DK ORANGE	13024	13024	J	4272	11474	-1550	3132	5528	7472	4002
PRIMARK	802892	N DOWN SKIF	DK ORANGE	13024	13024	I				1944	1944		
				13024	13024			11474	-1550		5528	7472	4002
PRIMARK	802893	N DOWN SKIF	URN ORANG	5490	5490	J	1260	1512	-3978		252	252	1260
				5490	5490			1512	-3978		252	252	1260
PRIMARK	802953	Y TRUN UP S	PINK STRIP	28528	28528	F	888	15507	-13021	277	3204	15421	86
PRIMARK	802953	Y TRUN UP S	PINK STRIP			G				552	3769		
PRIMARK	802953	Y TRUN UP S	PINK STRIP			H				973	4583		
PRIMARK	802953	Y TRUN UP S	PINK STRIP			E					560		
PRIMARK	802953	Y TRUN UP S	PINK STRIP			I				282	3305		
				28528	28528			15507	-13021		15421	15421	86
	G-TOTAL						7788			8465			#REF!

CUTTING INCHARGE CUTTING EXECUTIVE FA/ MANAGER

Table 1: Daily cutting report. Buyer: Primark style: Ladies Shirt

3.2 Line Balance & Cutting Input in-hand (Industry copy). Date: 28.11.18



Line Balance & Cutting Input in-hand

Date: 28-Nov

Line	Style	Order QTY	DPI	BUYER	INPUT IN HAND	LINE WISE TTL BALANCE	CUTTING BALANCE	SEW.FIN.QTY	Cutting Production
	28 SS DENIM SHIRT	5000	802226	PRIMARK	1395		0	0	86
A	LIVALSOVER	2616	801119	BEST SELLER	0		799	799	
A	28 SS DENIM SHIRT	5000	802225	PRIMARK	0		3086	3086	
A									
A-Next style						#REF!			
B	1050	15616	802286	MARKS&SPENCER	0		3369	3369	
B									
B									
B	TENCEL SHIRT DRESS	11120	803481	PRIMARK	507		3609	3609	1368
B-Next style						#REF!			
C									
C									
C	SW19-495	6816	802881	SEAN JHON	0		3842	3842	
C	REBELLA CHECK	2604	802807	BEST SELLER	278		55	55	
C-Next style						#REF!			
D	SW19-498	4800	802878	SEAN JHON	3006		468	468	2196
D									
D	MINT LIFE L/S	5136	803338	BEST SELLER	137		0	0	
D									
D-Next style						#REF!			
E	1050	15616	802286	MARKS&SPENCER					
E	SW19-499	4008	802880	SEAN JHON	170		2466		
E									
E									
E-Next style						#REF!			
F	ENTRY TURN UP	49474	802952	PRIMARK	0		0	0	
F									
F	ENTRY TURN UP	10516	802155	primark	0		275	275	
F									
F-Next style						#REF!			
G	ENTRY TURN UP	49474	802952	PRIMARK					
G									
G									
G									
G-Next style						#REF!			
H									
H									
H									
H									
H-Next style						#REF!			
I	BTN DOWEN SKITE	14856	802894	PRIMARK					
I	BTN DOWN SKIRT	14010	802895	PRIMARK					
I	ENTRY TURN UP	117020	802154	PRIMARK	0		58606	58606	
I									
I-Next style						#REF!			
J									
J	BTN DOWN SKIRT	14010	802895	PRIMARK	0		852	852	
J	BTN DOWEN SKITE	13024	802892	PRIMARK	4002		1550	1550	4272
J	BTN DOWEN SKITE	5490	802893	PRIMARK	1260		3978	3978	1260
J-Next style						#REF!			
	ENTRY TURN UP	28528	802953	PRIMARK	86		13021	13021	888
Total-					10646				11380

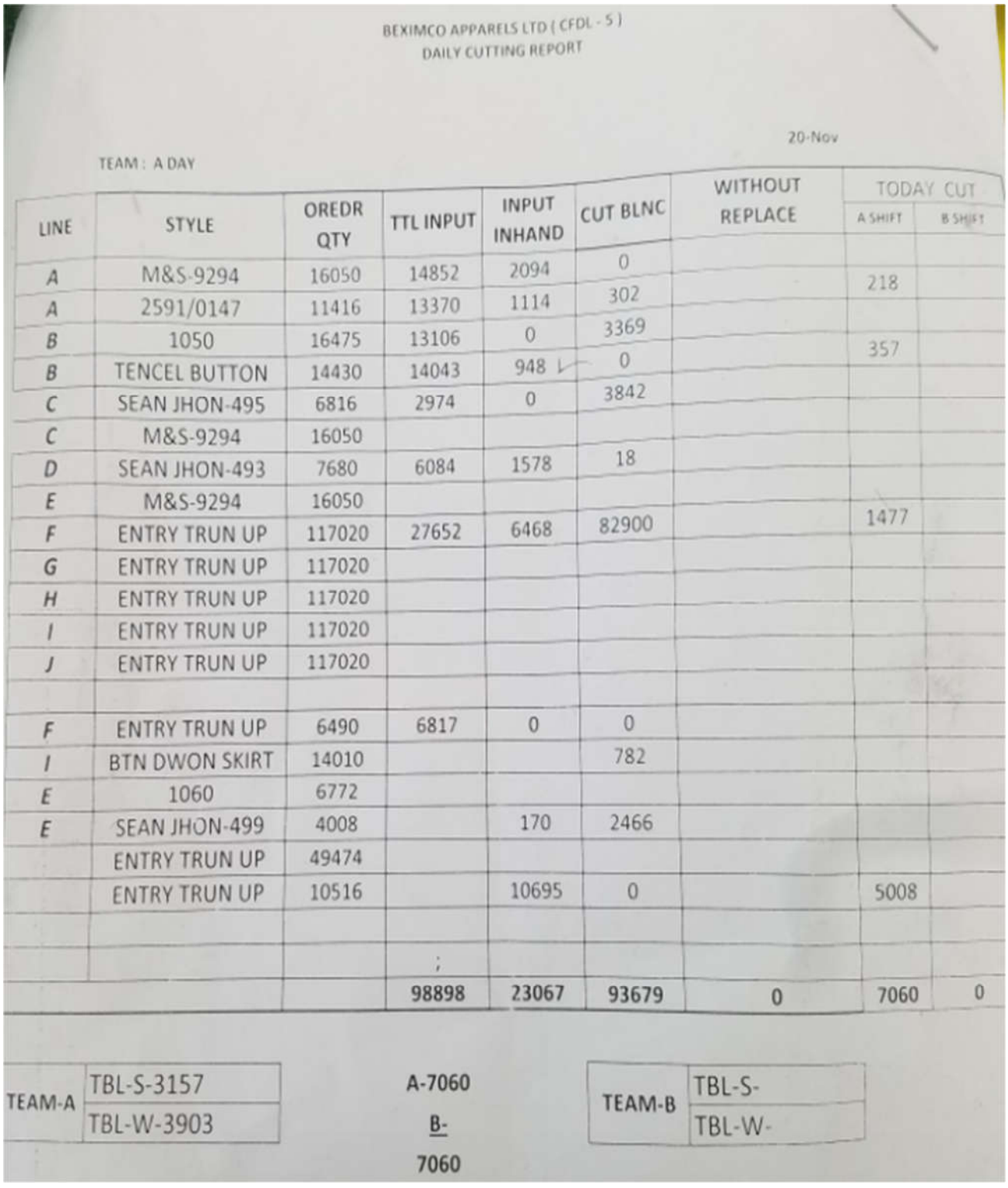
Table: Line Balance & Cutting Input in-hand. Buyer: Primark Style: Ladies Shirt

Line Balance & Cutting Input in-hand. Date: 28.11.18

Line Balance & Cutting input in-hand				PLAN Target-	TTL Cutting-	24599	Datatex-16430
				IE Target-	Sewing-		
Date-	28-Nov			Finishing Audit-	Finishing Pack-	10096	
Line	Style	Order Qty	BUYER	INPUT IN HAND	CUTTING BALANCE	CUT PLN DAY	Cutting Production
A	TENCEL SHIRT	5000	PRIMARK	1200	0	0	96
A	LIVALSOVER	2616	BEST SELLER	0	789	789	
A	TENCEL SHIRT	5000	PRIMARK	0	3086	3086	
A							
A-Next style							
B	1050	15616	RKS&SPENC	0	3369	3369	
B							
B							
B	TENCEL SHIRT	11120	PRIMARK	507	3609	3609	1368
B-Next style							
C							
C							
C	SW19-495	6816	SEAN JHON	0	3842	3842	
C	REBBLLA CHECK	2604	BEST SELLER	278	55	55	
C-Next style							
D	SW19-498	4800	SEAN JHON	3006	468	468	3196
D							
D	MINT LIFE L/S	5136	BEST SELLER	137	0	0	
D							

Table 2: Line Balance & Cutting Input in-hand. Buyer: Primark Style: Ladies Shirt

3.3 Daily cutting Report line wise (Industry copy).
Date: 28.11.18



BEXIMCO APPARELS LTD (CFDL - 5)
DAILY CUTTING REPORT

20-Nov

TEAM : A DAY

LINE	STYLE	OREDR QTY	TTL INPUT	INPUT INHAND	CUT BLNC	WITHOUT REPLACE	TODAY CUT A SHIFT	TODAY CUT B SHIFT
A	M&S-9294	16050	14852	2094	0			
A	2591/0147	11416	13370	1114	302		218	
B	1050	16475	13106	0	3369			
B	TENCEL BUTTON	14430	14043	948	0		357	
C	SEAN JHON-495	6816	2974	0	3842			
C	M&S-9294	16050						
D	SEAN JHON-493	7680	6084	1578	18			
E	M&S-9294	16050						
F	ENTRY TRUN UP	117020	27652	6468	82900		1477	
G	ENTRY TRUN UP	117020						
H	ENTRY TRUN UP	117020						
I	ENTRY TRUN UP	117020						
J	ENTRY TRUN UP	117020						
F	ENTRY TRUN UP	6490	6817	0	0			
I	BTN DWON SKIRT	14010			782			
E	1060	6772						
E	SEAN JHON-499	4008		170	2466			
	ENTRY TRUN UP	49474						
	ENTRY TRUN UP	10516		10695	0		5008	
			98898	23067	93679	0	7060	0

TEAM-A	TBL-S-3157	A-7060	TEAM-B	TBL-S-	
	TBL-W-3903	B-7060		TBL-W-	

Table 3: Daily cutting Report line wise Buyer: Primark Style: Ladies Shirt

3.4 Operation Bulletin Tencel Ladies shirt (Industry copy). Date: 27.09.18

Operation Bulletin-BGD

Style No:	TENCEL SHIRT DRESS	Target/Hr:	100	Tar/10hrs:	1000	Date:	
Buyer:	PRIMARK	SMV:	25.05	Helpers:	13	Rev #:	9-Aug-18
Description:	Long sleeve shirt, 2 pocket tencel fab non fuse 2sleeve tab	R-SMV:	33.60	Operators:	43	Rev #:	27-Sep-18
		Utilization:	75%	Ttl MP:	56		

S/N	M/C	Attachment	Operation	SMV	Tar/Hr	Reqd W place		REQUIRED Operator	REQUIRED Helper	REMARKS
			Collar							
1	LS1-V	vertical trimmer	Make collar with match	0.617	97	1.03	1	1		
2	MAN		Trim & Turn Main Collar	0.187	321	0.31	1		1	
3	MAN		Press collar	0.184	326	0.31				
4	LS1	CR-1/4	T/S main collar +	0.386	155	0.64	1	1		
5	Iron	T/L guide	Iron Hem stand collar *	0.249	241	0.42	1		1	
6	LS1-V	vertical trimmer	Attach band to collar with match	0.619	97	1.03	1	1		
7	LS1	CR-1/16	Turn / Topstitch stand collar *	0.342	175	0.57	1	1		
8	OL3	T/L guide	Trim stand collar bottom edge & mark	0.314	191	0.52	1	1		
9			**CUFF & SLEEVE**							
10	Iron	Folder	Iron Hem cuff*	0.335	179	0.56	1		1	
11	LS1-V	vertical trimmer	Make cuff	0.528	114	0.88	1	1		
12	MAN		Trim/ turn cuff	0.187	321	0.31	1		1	
13	MAN		Press cuff	0.220	273	0.37				
14	LS1	folder	Attach piping to slv slit	0.460	130	0.77	1	1		
15	Iron	Table	Iron sleeve placket	0.751	80	1.25	1		1	
16	LS1	CR-1/16	Cut tack & attach placket to sleeve	1.016	59	1.69	2	2		
17	Iron	Table	Iron tab	0.512	117	0.85	1		1	
18	LS1	CR-1/16	Center tack & topstitch tab	0.962	62	1.60	2	2		
19	MAN	Table	Mark tab placement	0.398	151	0.66	1		1	
20	LS1	Reg foot	Attach tab at sleeve	0.700	86	1.17	2	2		
21			**Back**							
22	LS1	T/L guide	Attach back yoke	0.444	135	0.74	1	1		
23	LS1	T/L guide	Topstitch back yoke	0.372	161	0.62	1	1		
24			**Front pkt**							
25	KAN	F-201	Sew box placket	0.52	115	0.87	1	1		
26	LS1	F-201	Fold & stitch button placket	0.333	180	0.56	1	1		
27	LS1	T/L guide	Sew pleat at pocket	0.381	157	0.64	1	1		
28	Iron	Table	Press pleat	0.488	123	0.81	1		1	
29	LS1	Folder	Attach ban at pocket	0.600	100	1.00	1	1		
30	LS1	R-1/16	Edge stitch band	0.300	200	0.50	1	1		
31	MAN	Scissor	Trim excess band	0.300	200	0.50	1		1	
32	Iron	Table	Iron pocket	0.751	80	1.25	1		1	
33	LS1	CR-1/16	Attach pocket at front	0.860	70	1.43	2	2		
34	BT		Bt pocket	0.280	214	0.47	1	1		
35	LS1	Folder	Attach shoulder	0.652	92	1.09	1	1		
36	LS1		Topstitch shoulder	0.410	146	0.68	1	1		
37	LS1	Reg foot	Cut & tack label with poly	0.285	211	0.48	1	1		
38	LS1	T/L guide	Attach label	0.260	231	0.43				
39			**Assembly**							
40	LS1	t/l guide	Attach collar to body	0.452	133	0.75	1	1		
41	LS1		Tack label togather	0.200	300	0.33	1	1		
42	LS1		Attach label	0.285	211	0.48				
43	LS1	CR-1/16	Close collar	0.599	100	1.00	1	1		
44	OL5	f-217	Attach sleeve to body	0.685	88	1.14	2	2		
45	LS1		Topstitch armhole	0.620	97	1.03	2	2		
46	OL5	f-242	Close side seam	0.860	70	1.43	2	2		
47	LS1	f-224 (705)	Att. Cuff to sleeve	0.784	77	1.31	2	2		
48	LS1	CR-1/4	Topstitch cuff x 2	0.524	115	0.87	1	1		
49	MAN	Table	Trim Bottom hem	0.285	211	0.48	1		1	
50	LS1	F 503-p 733	Sew bottom hem	0.591	102	0.99	1	1		
51	BH	Gauge	Sew button hole	1.293	46	2.15	2	2		
52	BS	Gauge	Attach button	1.170	51	1.95	2	2		
53	MAN	Cutter	Thread trim & remove sticker & btn cls	0.500	120	0.83	2		2	
			SUM	25.05		41.8	56	43	13	

Machine Requirement:

LS1	29	BS	2	FL	
LS1-V	3	BH	2	WELT	
OL3	1	KAN	1	FUSE	
LS2		BT	1	WB	
OL5	4	BTM-T		IRON	6
CS1		FOA		MAN	7
CS2		ZZ			

Table: Operation Bulletin Tencel Ladies shirt Buyer: Primark Style: Ladies Shirt

Operation Bulletin Tencel Ladies shirt. Date: 27.09.18

Style No:	TENCEL SHIRT DRESS	**Target/Hr:**	100
Buyer:	PRIMARK	**SMV:**	25.05
Description:	Long sleeve shirt, 2 pocket tencel fab non fuse 2sleeve tab	**R-SMV:**	33.60
		Utilization:	75%

S/N	M/C	Attachment	Operation	SMV	Tar/Hr
			Collar		
1	LS1-V	vertical trimmer	Make collar with match	0.617	97
2	MAN		Trim & Turn Main Collar	0.187	321
3	MAN		Press collar	0.184	326
4	LS1	CR-1/4	T/S main collar +	0.386	155
5	Iron	T/L guide	Iron Hem stand collar *	0.249	241
6	LS1-V	vertical trimmer	Attach band to collar with match	0.619	97
7	LS1	CR-1/16	Turn / Topstitch stand collar *	0.342	175
8	OL3	T/L guide	Trim stand collar bottom edge &	0.314	191
9			**CUFF & SLEEVE**		
10	Iron	Folder	Iron Hem cuff	0.335	179
11	LS1-V	vertical trimmer	Make cuff	0.528	114
12	MAN		Trim/ turn cuff	0.187	321
13	MAN		Press cuff	0.220	273
14	LS1	folder	Attach piping to slv slit	0.460	130
15	Iron	Table	Iron sleeve placket	0.751	80
16	LS1	CR-1/16	Cut tack & attach placket to sleeve	1.016	59
17	Iron	Table	Iron tab	0.512	117
18	LS1	CR-1/16	Center tack & topstitch tab	0.962	62
19	MAN	Table	Mark tab placement	0.398	151
20	LS1	Reg foot	Attach tab at sleeve	0.700	86
21			**Back**		
22	LS1	T/L guide	Attach back yoke	0.444	135
23	LS1	T/L guide	Topstitch back yoke	0.372	161
24			**Front,pkt**		
25	KAN	F-201	Sew box placket	0.52	115
26	LS1	F-201	Fold & stitch button placket	0.333	180
27	LS1	T/L guide	Sew pleat at pocket	0.381	157
28	Iron	Table	Press pleat	0.488	123
29	LS1	Folder	Attach ban at pocket	0.600	100
30	LS1	R-1/16	Edge stitch band	0.300	200
31	MAN	Scissor	Trim excess band	0.300	200
32	Iron	Table	Iron pocket	0.751	80
33	LS1	CR-1/16	Attach pocket at front	0.860	70
34	BT		Bt pocket	0.280	214
35	LS1	Folder	Attach shoulder	0.652	92
36	LS1		Topstitch shoulder	0.410	146
37	LS1	Reg foot	Cut & tack label with poly	0.285	211
38	LS1	T/L guide	Attach label	0.260	231
39			**Assembly**		
40	LS1	t/l guide	Attach collar to body	0.452	133
41	LS1		Tack label togather	0.200	300
42	LS1		Attach label	0.285	211
43	LS1	CR-1/16	Close collar	0.599	100
44	OL5	f 217	Attach sleeve to body	0.685	88
45	LS1		Topstitch armhole	0.620	97
46	OL5	f-242	Close side seam	0.860	70
47	LS1	f-224 (705)	Att. Cuff to sleeve	0.784	77
48	LS1	CR-1/4	Topstitch cuff x 2	0.524	115
49	MAN	Table	Trim Bottom hem	0.285	211
50	LS1	F 503-p 733	Sew bottom hem	0.591	102
51	BH	Gauge	Sew button hole	1.293	46
52	BS	Gauge	Attach button	1.170	51
53	MAN	Cutter	Thread trim & remove sticker &	0.500	120
			SUM	**25.05**	

Table 4: Operation Bulletin Tencel Ladies shirt Buyer: Primark Style: Ladies Shirt

3.5 Thread consumption report for Ladies Shirt:

Style	8034	DVF-511	Size	L
Buyer:	primark	P&B		
Thread consumption				
Sl no	M/C	**Operation**	40/2	20/2
			Inche	Inche
		Collar		
1	LS1	Make collar	74	
2	LS1	Topstitch collar-		74
3	LS1	Attach band to collar	60	
4	LS1	Turn & topstitch collar band		50
		Front & bk		
5	OL5	Sew bk centre seam-	140	
6	LS1	Ts bk centre seam		140
7	KAN	Sew box placekt		280
8	KAN	Sew btn placket		280
9	OL5	Sew shoulder seam	50	
10	LS1	Topstich shoulder seam		46
11	LS1	Tack label to front		20
		Bottom part		
12	OL5	Clsoe side seam	236	
13	OL5	OL arm edge	144	
14	LS1	Atc binding to arm		142
15	LS1	Tack binding ends		15
16	LS1	Ts binding to arm		142
17	LS1	Atc collar	60	
18	LS1	Tack label to neck		12
19	LS1	Clsoe collar		76
20	LS1	Sew btm hem		215
21	FL	Make loop & cut	120	120
22	LS1	Atc loop	50	
23	BT	BT loop	10	
24	BH	Sew btn hole-14	14	

40/2 LS1	244	854				
OL5	630	14490				
FL	120	480				
BT	10	250				
BH	28	448				
	1032	**16522**	**165**	**Mitre**	**Booking**	**144 Mitre**
20/2 LS1	1395	4883				
KAN	560	4480				
FL	120	960				
	2075	**10323**	**103**	**Mitre**	**Booking**	**123 Mitre**
		Total	**268**	**Mitre**	**Booking**	**267 Mitre**

3.6 Sewing Section monitoring sheet for input (Industry copy). Date.28.11.18

BEXIMCO FACTORY NAME .....

Sl. No. 69

SECTION MONITORING SHEET (SUPERVISOR)

Date: 28.11.2018

INPUT Buyer: Primark P/O-Style 5820200 Line No D

SL	OPERATION NAME	OPERATOR	C.F (TARGET)	1ST	2ND	3RD	4TH	5TH	6TH	7TH	8TH	9TH	10TH
1	BOX PLAT LAILINE		100	75	80	80	80	80	80	80	80		
2	BANE LAILINE		100	55	55	55	55	55	55	55	55		
3	COFF UL			60	75	70	75	80	80	90	20		
4	BANE IRON			75	75	75	70	75	60	75	70		
5	BANE JANE			75	75	75	75	75	60	75	70		
6	COFF MAEK			50	60	70	70	70	70	70	70		
7	GAMBOL/P			50	70	70	70	68	70	70	70		
8	TAF T.S			50	50	50	60	70	70	70	60		
9	TAF JANE			60	80	70	60	70	80	80	60		
10	BOX PLAT			60	80	80	60	30	50	100	100		
11	BATTN PAT			60	80	140 80	220 60	330 30	110 40	150	150		
12	BOD MAR			60	80	70	60	30	50	100	100		
13	POCTK IRON			50	60	70	70	30	50	75	75		
14	POCTK JANE			40 30	45 33	45 35	45 35	50 35	50 30	45 30	75		
	SOLDCR JANE			30 20	75 140	30 110	20 80	70 330	70 220	80	80 220		

Supervisor

Prep. By I. E Dept.

Line Chief

Sec Mon

Floor Incharge

Floor Format

Table: Sewing Section Monitoring sheet for input. Buyer: Primark Style: Ladies Shirt

Sewing Section Monitoring sheet for input. Date.28.11.18

LINE NO --D		Team--	BUYER:	Primark		STYLE: 803481		
SL	OPERATION NAME	OPERATOR NAME	Target	1hr	2hr	3hr	4hr	5hr
1	Box plat laining		100	75	80	80	80	80
2	Bane lining		100	55	55	55	55	55
3	Cuff lining			60	75	70	75	80
4	Bane iron			75	75	75	70	75
5	Bane joint			75	75	75	75	75
6	Cuff make			50	60	70	70	70
7	Gamble			50	70	70	70	60
8	Tap T/S			30	50	50	60	70
9	Tap joint			60	80	70	60	70
10	Box plaket			60	80	80	60	30
11	botton plat			60	80	80	60	30
12	body mark			50	80	80	70	30
13	Pocket iron			40	70	70	45	50
14	Pocket joint			70	45	45	70	70

Table 5: Sewing Section Monitoring sheet for input. Buyer: Primark Style: Ladies Shirt

3.7 Sewing Section monitoring sheet for output (Industry copy). Date: 28.11.18

BEXIMCO FACTORY NAME: ..... Sl. No. 69

SECTION MONITORING SHEET (SUPERVISOR) Date : 28-11-18

Buyer : PRIMARK P/O-Style : 7B, 5820200 Line No : A

SL	OPERATION NAME	OPERATOR	C.F (TARGET)	1ST	2ND	3RD	4TH	5TH	6TH	7TH	8TH	9TH	10TH
1	Collar make	Fulzan		120	130	140	140	140	140	140	140		
2	Band @	Sukima		120	130	140	140	140	140	140	140		
3	Jauk @	Hasina	18	120	130	140	140	140	140	140	140		
4	" @	Lazifa		120	130	140	140	140	140	140	140		
5	Box plat	Nasima		120	130	140	130	140	130	130	130		
6	Button plat	Fazuk		120	120	125	140	140	125	125	125		
7	Bone @	Nasrin		120	120	120	130	140	130	130	130		
8	paket @	Bagdata		110	120	120	130	140	130	130	130		
9	Bone Tack	Lovely		100	120	120	130	140	130	130	130		
10	" @	Rupaly		100	120	120	130	140	130	130	130		
11	paket @	Sumi		60	60	70	70	60	80	90	60		
12	Bone @	Beauty		60	60	70	70	70	80	100	100		
13	paket @	Sukima		100	120	120	130	140	130	130	130		
14	Solden @	Rima		100	120	120	130	140	130	130	130		
	" @	Rebeka		100	120	120	130	140	130	130	130		

Supervisor
Prep. By I. E Dept.
Line Chief
Sec Mgr
Floor Incharge
Floor Format

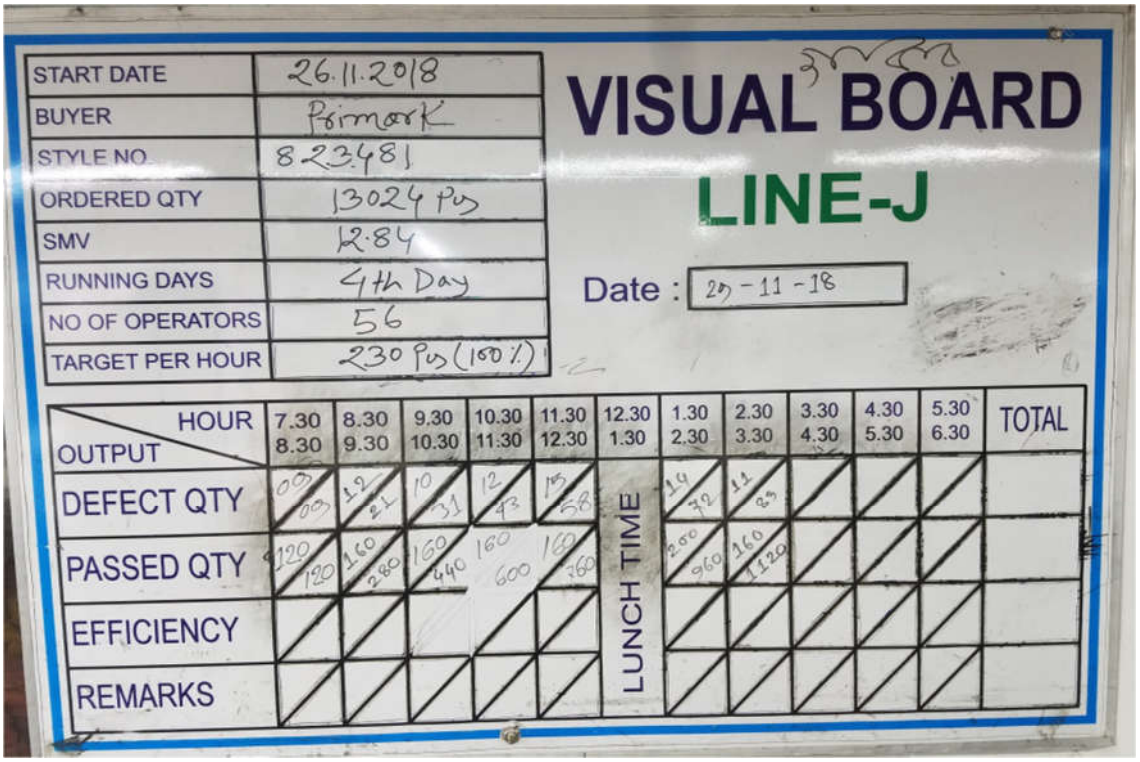
Table: Sewing Section Monitoring sheet for output. Buyer: Primark Style: Ladies Shirt

Sewing Section Monitoring sheet for output. Date: 28.11.18

LINE NO --D		Team--	BUYER	primark		STYLE:803481		
SL	OPERATION NAME	OPERATOR NAME	M/C	1hr	2hr	3hr	4hr	5hr
1	Coller Make	fulzan		120	130	140	140	140
2	band joint	subina		120	130	140	140	140
3	yoke joint	aslam		120	130	130	130	130
4	box plete	layla		140	130	130	130	130
5	bone joint	faruk		120	140	140	130	130
6	pocket joint	ausha		110	120	125	130	130
7	bone tack	aysha		110	120	120	130	125
8	pocket joint	beauty		100	120	130	130	130
9	sholder joint	sahina		100	120	130	130	130
10	sholder t/s	rina		100	120	130	130	130

Table 6: Sewing Section Monitoring sheet for output. Buyer: Primark Style: Ladies Shirt

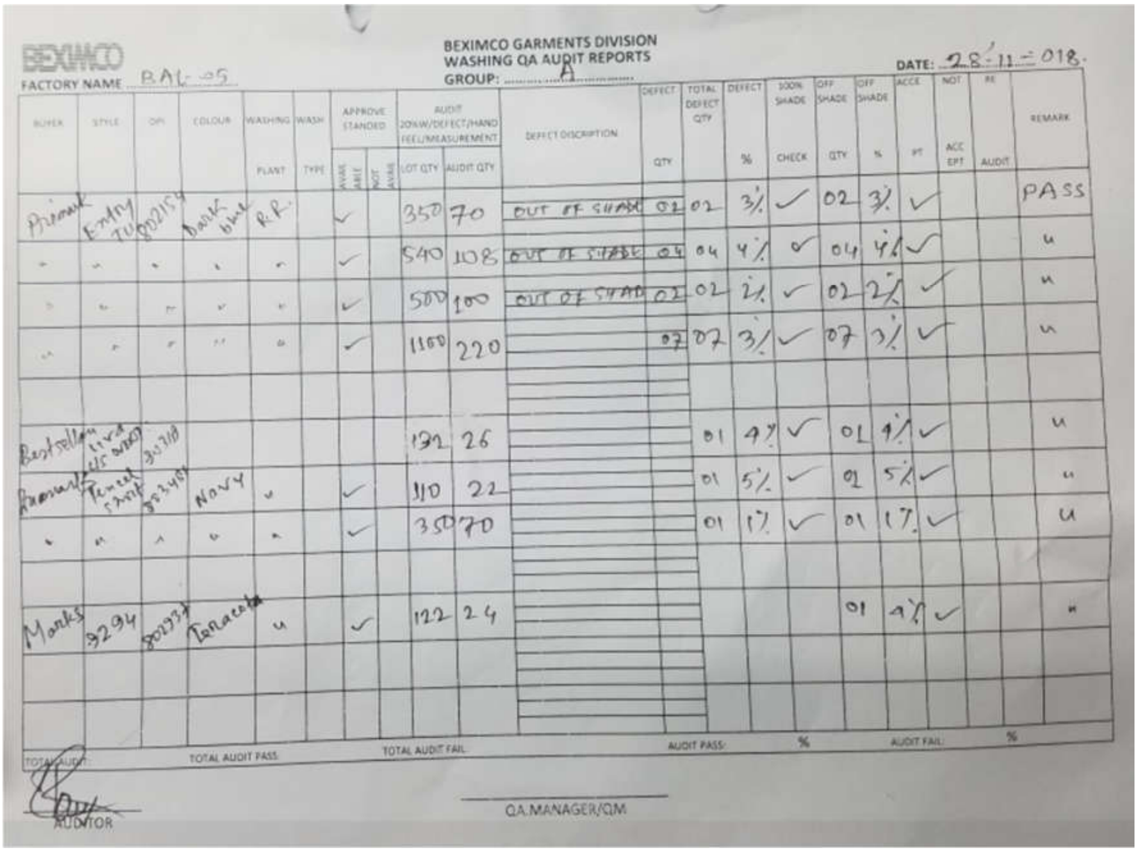
3.8Hourly Production report (Industry copy).
Date: 29.11.18



Output\hr	7:30 8:30	8:30 9:30	9:30 10:30	10:30 11:30	11:30 12:30	12:30 1:30	1:30 2:30	2:30 3:30	total
DEFF.QTY	9/9	12/21	10/31	12/43	13/58	14/72	11/83	10/93	93
PASS.QTY	120/120	160/280	160/440	160/600	160/760	200/960	160/1120	200/1320	1320

Table 7: Hourly Production report. Buyer: Primark Style: Ladies Shirt

3.9Washing QA Audit Report (Industry copy).
Date: 28.11.18



BEXIMCO
BEXIMCO GARMENTS DIVISION
WASHING QA AUDIT REPORTS
FACTORY NAME: BAL-05
GROUP: A
DATE: 28-11-018.

BUYER	STYLE	OPI	COLOUR	WASHING PLANT	WASH TYPE	APPROVE STANDED AVAILABLE	APPROVE STANDED NOT AVAILABLE	AUDIT 20%W/DEFECT/HAND FEEL/MEASUREMENT LOT QTY	AUDIT QTY	DEFECT DISCRIPTION	DEFECT QTY	TOTAL DEFECT QTY	DEFECT %	100% SHADE CHECK	OFF SHADE QTY	OFF SHADE %	ACCEPT	NOT ACCEPT	RE AUDIT	REMARK
Primark	Entry TU	802159	Dark blue	R.P.		✓		350	70	OUT OF SHADE	02	02	3%	✓	02	3%	✓			PASS
"	"	"	"	"		✓		540	108	OUT OF SHADE	04	04	4%	✓	04	4%	✓			"
"	"	"	"	"		✓		500	100	OUT OF SHADE	02	02	2%	✓	02	2%	✓			"
"	"	"	"	"		✓		1100	220		07	07	3%	✓	07	3%	✓			"
Bestseller	[illegible]	30718						132	26			01	4%	✓	01	4%	✓			"
Primark	Pencil Skirt	[illegible]	Navy	"		✓		110	22			01	5%	✓	01	5%	✓			"
"	"	"	"	"		✓		350	70			01	1%	✓	01	1%	✓			"
Marks	9294	802937	Teracotta	"		✓		122	24						01	4%	✓			"

TOTAL AUDIT: TOTAL AUDIT PASS: TOTAL AUDIT FAIL: AUDIT PASS: % AUDIT FAIL: %

AUDITOR QA.MANAGER/QM

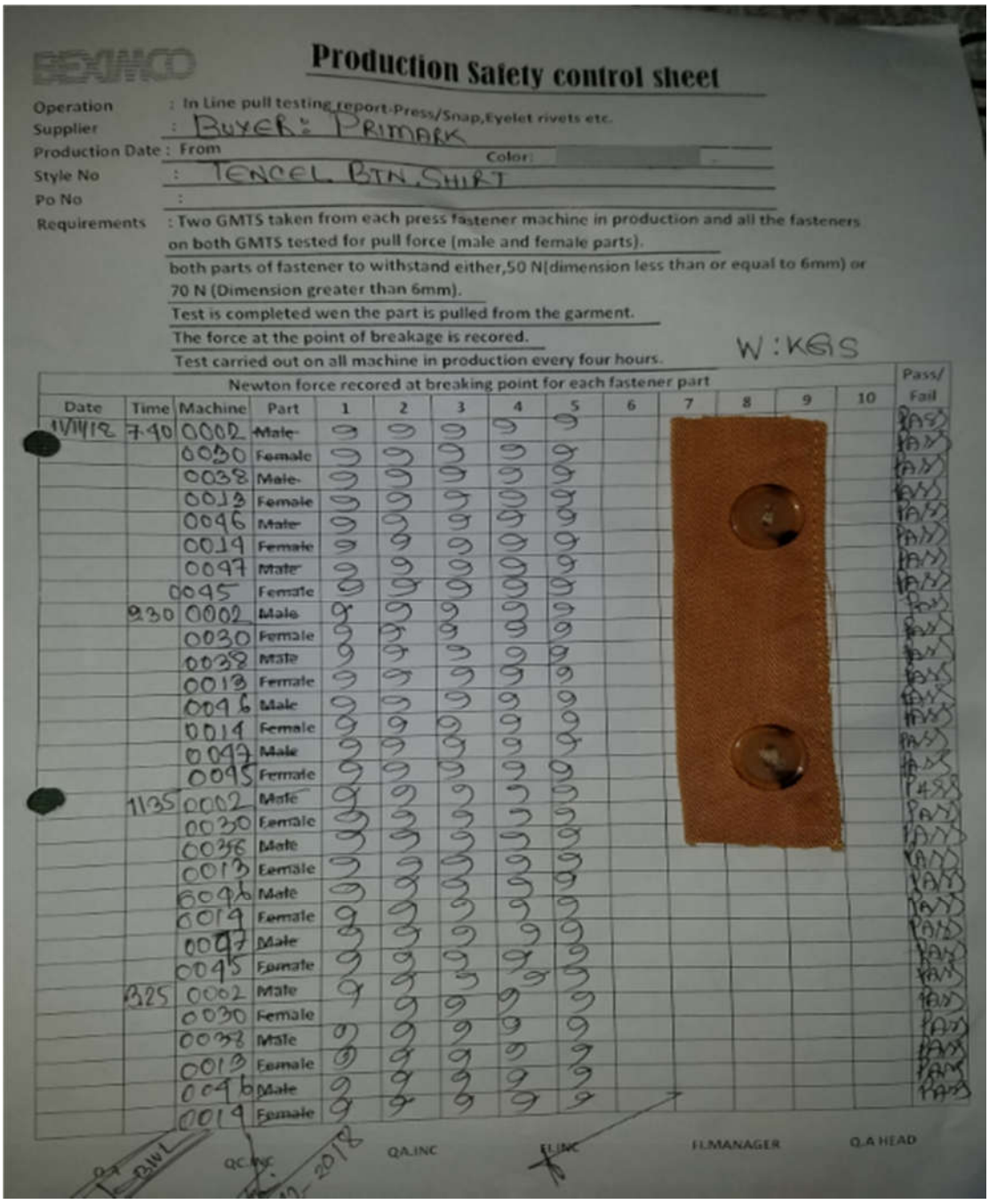
Table: Hourly Production report. Buyer: Primark Style: Ladies Shirt

Washing QA Audit Report. Date: 28.11.18

BUYER	STYLE	DPI	COLOUR	WASHING PLANT	WASH TYPE	APPROVE STANDED AVAILABLE	APPROVE STANDED NOT AVAIL	AUDIT 20%W/DEFECT/HANDFEEL/MEASUREMENT LOT QTY	AUDIT Q	DEFECT DISCRIPTIO	DEFECT QTY	TOTAL DEFECT QTY	DEFECT %	100% SHADE CHECK	OFF SHADE QTY	OFF SHADE %	ACCE PT	NOT ACCEPT	RE AUDIT	REMARK
primark	Tencel shirt	80348	Navy	R.R				110	22	out of shade	1	1	5%		1	5%				pass
primark	Tencel shirt	80348	Navy	R.R				350	70	out of shade	2	2	3%		2	3%				pass
primark	Tencel shirt	80348	Navy	R.R				500	100		2	2	3%		2%	3%				pass
primark	Tencel shirt	80348	Navy	R.R				110	22		1	1	5%		1	5%				pass
TOTAL AUDIT:			TOTAL AUDIT PASS:				TOTAL AUDIT FAIL:				AUDIT PASS:			%		AUDIT FAIL:			%	
AUDITOR									QA.MANAGER/QM											

Table 8: Hourly Production report. Buyer: Primark Style: Ladies Shirt

3.10 Production Safety control sheet Report (industry copy). Date: 28.11.18



Production Safety control sheet

Operation : In Line pull testing report-Press/Snap,Eyelet rivets etc.
Supplier : BUYER: PRIMARK
Production Date : From Color:
Style No : TENCEL BTN.SHIRT
Po No :
Requirements : Two GMTS taken from each press fastener machine in production and all the fasteners on both GMTS tested for pull force (male and female parts).
both parts of fastener to withstand either,50 N(dimension less than or equal to 6mm) or 70 N (Dimension greater than 6mm).
Test is completed wen the part is pulled from the garment.
The force at the point of breakage is recored.
Test carried out on all machine in production every four hours. W:KGS

Newton force recored at breaking point for each fastener part

Date	Time	Machine	Part	1	2	3	4	5	6	7	8	9	10	Pass/ Fail
11/11/18	7.40	0002	Male	9	9	9	9	9						PASS
		0030	Female	9	9	9	9	9						PASS
		0038	Male	9	9	9	9	9						PASS
		0013	Female	9	9	9	9	9						PASS
		0096	Male	9	9	9	9	9						PASS
		0014	Female	9	9	9	9	9						PASS
		0097	Male	9	9	9	9	9						PASS
		0095	Female	9	9	9	9	9						PASS
	9.30	0002	Male	9	9	9	9	9						PASS
		0030	Female	9	9	9	9	9						PASS
		0038	Male	9	9	9	9	9						PASS
		0013	Female	9	9	9	9	9						PASS
		0096	Male	9	9	9	9	9						PASS
		0014	Female	9	9	9	9	9						PASS
		0097	Male	9	9	9	9	9						PASS
		0095	Female	9	9	9	9	9						PASS
	11.35	0002	Male	9	9	9	9	9						PASS
		0030	Female	9	9	9	9	9						PASS
		0038	Male	9	9	9	9	9						PASS
		0013	Female	9	9	9	9	9						PASS
		0096	Male	9	9	9	9	9						PASS
		0014	Female	9	9	9	9	9						PASS
		0097	Male	9	9	9	9	9						PASS
		0095	Female	9	9	9	9	9						PASS
	3.25	0002	Male	9	9	9	9	9						PASS
		0030	Female	9	9	9	9	9						PASS
		0038	Male	9	9	9	9	9						PASS
		0013	Female	9	9	9	9	9						PASS
		0096	Male	9	9	9	9	9						PASS
		0014	Female	9	9	9	9	9						PASS

QA.INC FLMANAGER Q.A HEAD

Table: Production Safety control sheet Report. Buyer: Primark Style: Ladies Shirt

Production Safety control sheet Report. Date: 28.11.18

Production Safety control sheet

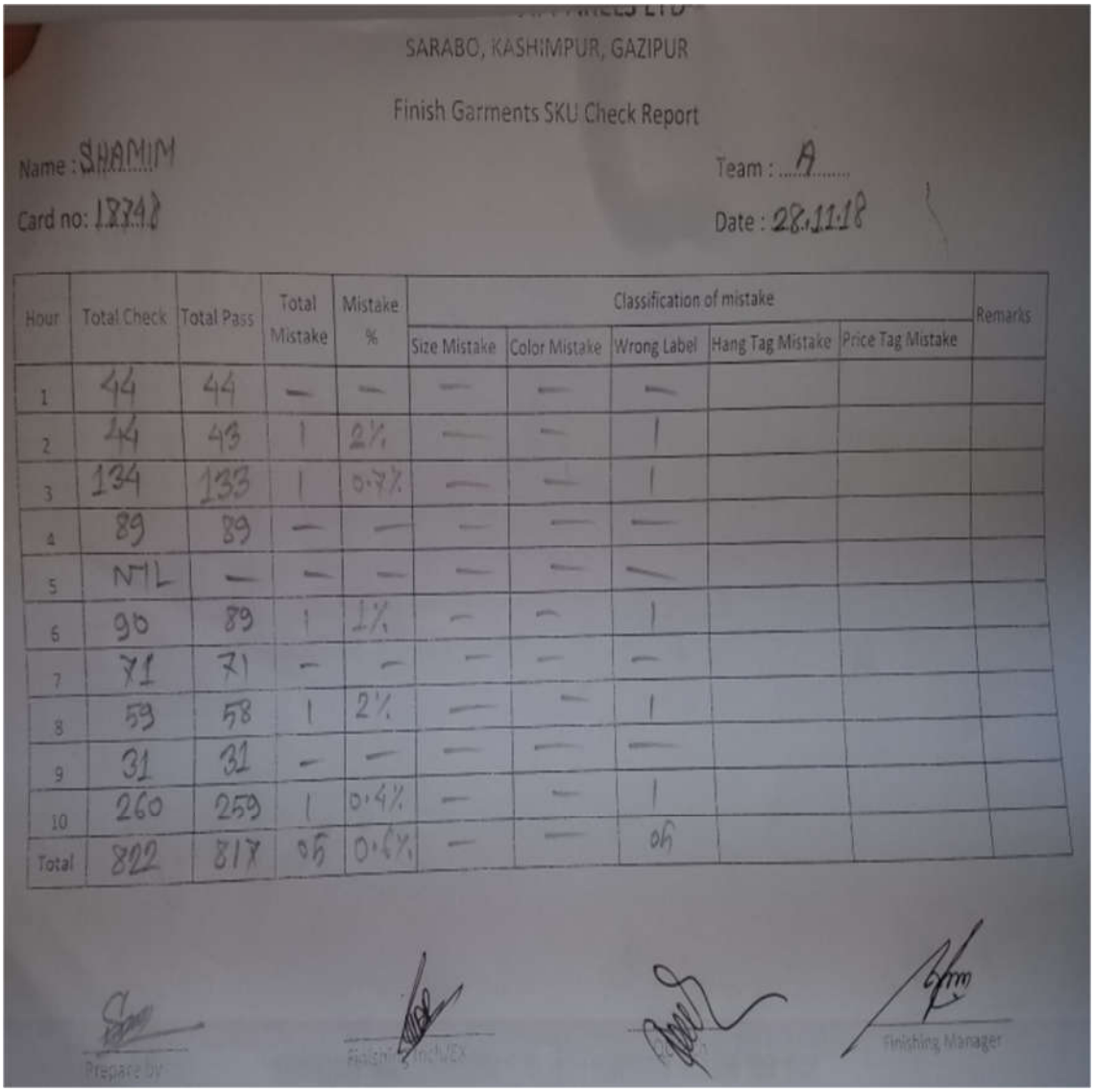
Operation	: In Line pull testing report-Press/Snap,Eyelet rivets etc.													
Supplier	:	Buyer: primark												
Production Date	: From						Color: Navy							
Style No	:	tencel ladies	shirt											
Po No	:													
Requirements	: Two GMTS taken from each press fastener machine in production and all the fasteners													
	on both GMTS tested for pull force (male and female parts).													
	both parts of fastener to withstand either,50 N(dimension less than or equal to 6mm) or													
	70 N (Dimension greater than 6mm).													
	Test is completed wen the part is pulled from the garment.													
	The force at the point of breakage is recored.													
	Test carried out on all machine in production every four hours.													

				Newton force recored at breaking point for each fastener part										Pass/
Date	Time	Machine	Part	1	2	3	4	5	6	7	8	9	10	Fail
11.11.18	7.4	2	Male	9	9	9	9	9	9	9	9	9	9	Pass
		30	Female	9	9	9	9	9	9	9	9	9	9	pass
		38	Male	9	9	9	9	9	9	9	9	9	9	pass
		13	Female	9	9	9	9	9	9	9	9	9	9	pass
		46	Male	9	9	9	9	9	9	9	9	9	9	pass
		47	Female	9	9	9	9	9	9	9	9	9	9	pass
		45	Male	9	9	9	9	9	9	9	9	9	9	pass
	9.3	2	Female	9	9	9	9	9	9	9	9	9	9	pass
		30	Male	9	9	9	9	9	9	9	9	9	9	pass
		38	Female	9	9	9	9	9	9	9	9	9	9	pass
		13	Male	9	9	9	9	9	9	9	9	9	9	pass
		46	Female	9	9	9	9	9	9	9	9	9	9	pass
		14	Male	9	9	9	9	9	9	9	9	9	9	pass
		47	Female	9	9	9	9	9	9	9	9	9	9	pass
		45	Male	9	9	9	9	9	9	9	9	9	9	pass
	11	2	Female	9	9	9	9	9	9	9	9	9	9	pass
		30	Male	9	9	9	9	9	9	9	9	9	9	pass
		38	Female	9	9	9	9	9	9	9	9	9	9	pass
		13	Male	9	9	9	9	9	9	9	9	9	9	pass
		46	Female	9	9	9	9	9	9	9	9	9	9	pass
		47	Male	9	9	9	9	9	9	9	9	9	9	pass
		45	Female	9	9	9	9	9	9	9	9	9	9	pass
	3.3	2	Male	9	9	9	9	9	9	9	9	9	9	pass
		30	Female	9	9	9	9	9	9	9	9	9	9	pass
		38	Male	9	9	9	9	9	9	9	9	9	9	pass
		13	Female	9	9	9	9	9	9	9	9	9	9	pass
		46	Male	9	9	9	9	9	9	9	9	9	9	pass
		47	Female	9	9	9	9	9	9	9	9		9	pass
		45	Male	9	9	9	9	9	9	9	9	9	9	pass
			Female	9	9	9	9	9	9	9	9	9	9	pass

Q.A	QC.INC	FI.INC	QA.INC	FI.MANAGER	Q.A HEAD

Table 9: Production Safety control sheet Report. Buyer: Primark Style: Ladies Shirt

3.11 Finish Garments SKU Report (Industry copy).
Date: 28.11.18



SARABO, KASHIMPUR, GAZIPUR

Finish Garments SKU Check Report

Name : SHAMIM Team : A

Card no: 18348 Date : 28.11.18

Hour	Total Check	Total Pass	Total Mistake	Mistake %	Classification of mistake					Remarks
					Size Mistake	Color Mistake	Wrong Label	Hang Tag Mistake	Price Tag Mistake	
1	44	44	—	—	—	—	—			
2	44	43	1	2%	—	—	1			
3	134	133	1	0.7%	—	—	1			
4	89	89	—	—	—	—	—			
5	NIL	—	—	—	—	—	—			
6	90	89	1	1%	—	—	1			
7	71	71	—	—	—	—	—			
8	59	58	1	2%	—	—	1			
9	31	31	—	—	—	—	—			
10	260	259	1	0.4%	—	—	1			
Total	822	817	05	0.6%	—	—	05			

Prepare by Finishing Manager

Table: Finish Garments SKU Report. Buyer: Primark Style: Ladies Shirt

Finish Garments SKU Report. Date: 28.11.18

BEXIMCO APPARELS LTD

SARABO, KASHIMPUR, GAZIPUR

Finish Garments SKU Check Report

Name : Shamim — Team : A

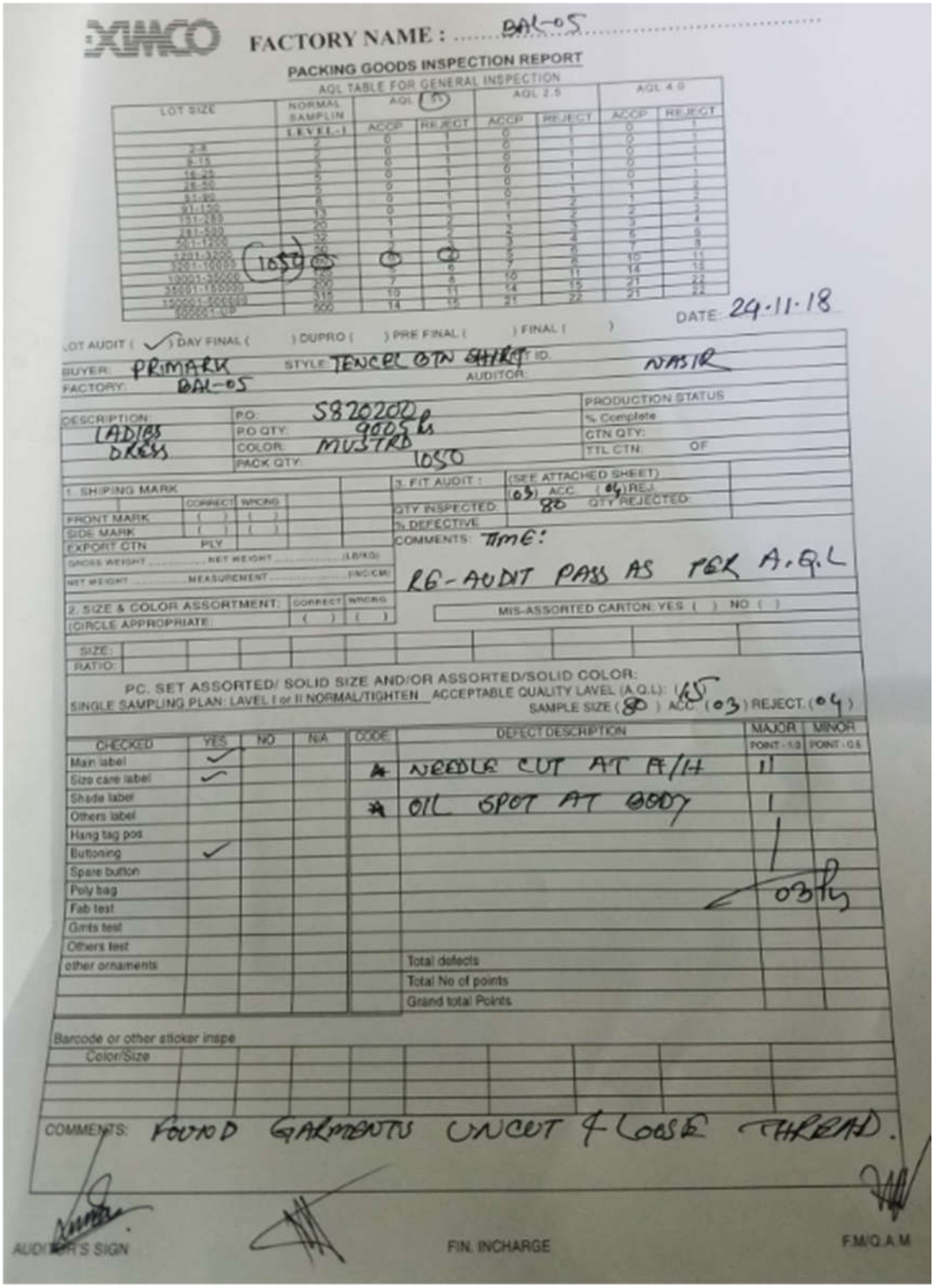
Card no: 18748 — Date : 28-11-18

Hour	Total Check	Total Pass	Total Mistake	Mistake %	Classification of mistake					Remarks
					Size Mistake	Color Mistake	Wrong Label	Hang Tag Mistake	Price Tag Mistake	
1	44	44								
2	44	43	1	2%			1			
3	134	133	1	0.70%			1			
4	89	89								
5	N/L									
6	90	89	1	1%			1			
7	71	71								
8	59	58	1	2%			1			
9	31	31								
10	260	259	1	0.40%			1			
total	822	817	5	0.60%			5			

Prepare by — Finishing Inch/EX — QC Inch — Finishing Manager

Table 10: Finish Garments SKU Report. Buyer: Primark Style: Ladies Shirt

3.12 Two Hours Audit Report (Industry copy).
Date: 24.11.18



FACTORY NAME : DAL-05

PACKING GOODS INSPECTION REPORT

AQL TABLE FOR GENERAL INSPECTION

LOT SIZE	NORMAL SAMPLIN LEVEL-I	AQL 1.5 ACCP	AQL 1.5 REJECT	AQL 2.5 ACCP	AQL 2.5 REJECT	AQL 4.0 ACCP	AQL 4.0 REJECT
2-8	2	0	1	0	1	0	1
9-15	3	0	1	0	1	0	1
16-25	5	0	1	0	1	0	1
26-50	5	0	1	0	1	1	2
51-90	8	0	1	0	1	1	2
91-150	13	0	1	1	2	2	3
151-280	20	1	2	2	3	3	4
281-500	32	1	2	3	4	5	6
501-1200	50	2	3	5	6	7	8
1201-3200	80	3	4	7	8	10	11
3201-10000	125	5	6	7	8	14	15
10001-35000	200	7	8	10	11	21	22
35001-150000	315	10	11	14	15	21	22
150001-500000	500	14	15	21	22		
500001-UP							

(1050) 0 0

LOT AUDIT (✓) DAY FINAL ( ) DUPRO ( ) PRE FINAL ( ) FINAL ( )

DATE: 24-11-18

BUYER: PRIMARK STYLE: TENCEL GTN SHIRT AUDIT ID:

FACTORY: DAL-05 AUDITOR: NASIR

DESCRIPTION: LADIES DRESS P.O: S820200 P.O QTY: 9005 pcs COLOR: MUSTRD PACK QTY: 1050

PRODUCTION STATUS: % Complete GTN QTY: TTL CTN: OF

1. SHIPING MARK

	CORRECT	WRONG
FRONT MARK	( )	( )
SIDE MARK	( )	( )
EXPORT CTN	PLY	

GROSS WEIGHT ..... NET WEIGHT ..... (LB/KG)

NET WEIGHT ..... MEASUREMENT ..... (INCH/CM)

2. SIZE & COLOR ASSORTMENT: (CIRCLE APPROPRIATE) CORRECT ( ) WRONG ( )

SIZE:

RATIO:

3. FIT AUDIT : (SEE ATTACHED SHEET) (03) ACC (04) REJ.

QTY INSPECTED: 80 QTY REJECTED:

% DEFECTIVE

COMMENTS: TIME: LG-AUDIT PASS AS PER A.Q.L

MIS-ASSORTED CARTON: YES ( ) NO ( )

PC. SET ASSORTED/ SOLID SIZE AND/OR ASSORTED/SOLID COLOR:

SINGLE SAMPLING PLAN: LAVEL I or II NORMAL/TIGHTEN ACCEPTABLE QUALITY LAVEL (A.Q.L): 4.5

SAMPLE SIZE (80) ACC. (03) REJECT. (04)

CHECKED	YES	NO	N/A	CODE	DEFECT DESCRIPTION	MAJOR POINT-1.0	MINOR POINT-0.5
Main label	✓			A	NEEDLE CUT AT F/H	11	
Size care label	✓			A	OIL SPOT AT BODY	1	
Shade label						1	
Others label							
Hang tag pos							
Buttoning	✓						
Spare button							
Poly bag							
Fab test							
Gmts test							
Others test							
other ornaments							
					Total defects		
					Total No of points		
					Grand total Points		

03 Ply

Barcode or other sticker inspe

Color/Size

COMMENTS: FOUND GARMENTS UNCUT & LOOSE THREAD.

AUDITOR'S SIGN FIN. INCHARGE F.M/Q.A.M

Table: Two Hours Audit Report. Buyer: Primark Style: Ladies Shirt

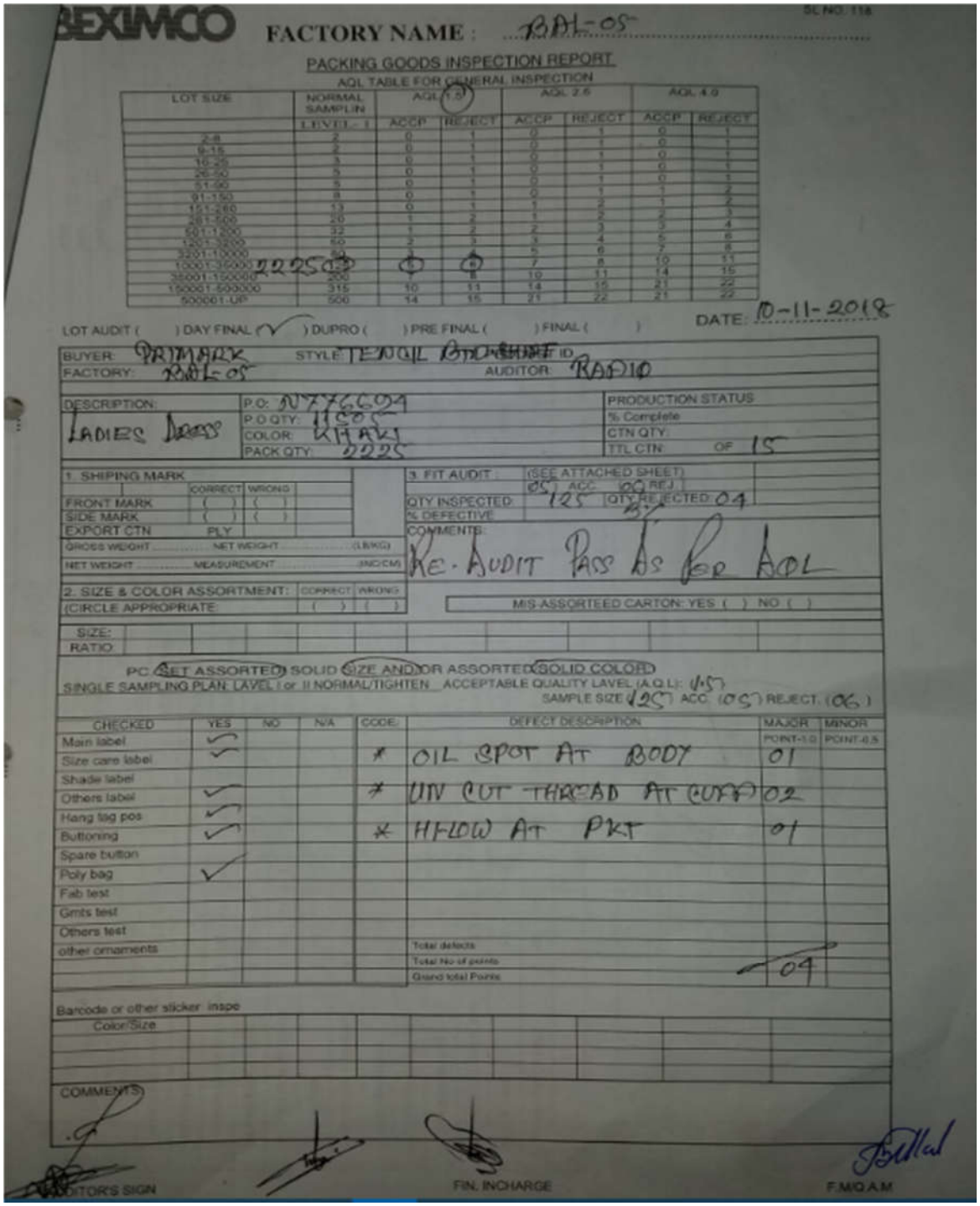
Two Hours Audit Report Date: 28.11.18

BEXIMCO	TWO HOURS SUMMERY									
FACTORY NAME:	BAL-05									
SHIF A								DATE: 28 / 11 /18		
LOT NO:										
BUYER:	primark									
STYLE NO:	80348									
PO NO:	5820200									
COLOR:	navy									
ORDER QTY:	1170									
TWO HOURS QTY:										
AUDIT QTY:	80									
AQL:(INTERNAL)										
ACCEPT QTY:	3									
FOUND DEFECT:	3									
RESULT:	pass									
MAJOR DEFECTS ARE AS FOLLOWS										

SER	DESCRIPTION OF DEFECT	BUYER WISE DEFECT QTY				
1	when size care label attach then needle cut	2				
2	oil sport inbody	1				
3		total=3				
	BUYER WISE DEFECT PCS					
	TOTAL DEFECT PCS- 3				#NAME?	

Table 11: Two Hours Audit Report. Buyer: Primark Style: Ladies Shirt

3.13 Day Final Summary (Industry copy). Date: 10.11.18



EXIMCO

FACTORY NAME : BAL-05

PACKING GOODS INSPECTION REPORT

AQL TABLE FOR GENERAL INSPECTION

LOT SIZE	NORMAL SAMPLIN LEVEL - II	AQL 1.5 ACCP	AQL 1.5 REJECT	AQL 2.5 ACCP	AQL 2.5 REJECT	AQL 4.0 ACCP	AQL 4.0 REJECT
2-8	2	0	1	0	1	0	1
9-15	3	0	1	0	1	0	1
16-25	5	0	1	0	1	0	1
26-50	5	0	1	0	1	0	1
51-90	5	0	1	0	1	1	2
91-150	8	0	1	0	1	1	2
151-280	13	0	1	1	2	2	3
281-500	20	1	2	1	2	3	4
501-1200	32	1	2	2	3	5	6
1201-3200	50	2	3	3	4	7	8
3201-10000	80	3	4	5	6	10	11
10001-35000	125	5	6	7	8	14	15
35001-150000	200	7	8	10	11	21	22
150001-500000	315	10	11	14	15	21	22
500001-UP	500	14	15	21	22	21	22

2225

LOT AUDIT ( ) DAY FINAL (✓) DUPRO ( ) PRE FINAL ( ) FINAL ( )

DATE: 10-11-2018

BUYER: PRIMARK STYLE: TENCIL SHIRT ID

FACTORY: BAL-05 AUDITOR: RAFIQ

DESCRIPTION: LADIES DRESS

P.O: 1177604

P.O QTY: 11505

COLOR: KHAKI

PACK QTY: 2225

PRODUCTION STATUS

% Complete

CTN QTY:

TTL CTN: OF 15

1. SHIPING MARK

	CORRECT	WRONG
FRONT MARK	( )	( )
SIDE MARK	( )	( )
EXPORT CTN	PLY	

GROSS WEIGHT ..... NET WEIGHT ..... (LB/KG)

NET WEIGHT ..... MEASUREMENT ..... (INCH/CM)

2. SIZE & COLOR ASSORTMENT: (CIRCLE APPROPRIATE) CORRECT ( ) WRONG ( )

3. FIT AUDIT : (SEE ATTACHED SHEET) ACC: 05 REJ: 00

QTY INSPECTED: 125 QTY REJECTED: 04

% DEFECTIVE:

COMMENTS: RE-AUDIT PASS AS PER AQL

MIS-ASSORTEED CARTON: YES ( ) NO ( )

SIZE:									
RATIO									

PC SET ASSORTED SOLID SIZE AND/OR ASSORTED SOLID COLOR

SINGLE SAMPLING PLAN LAVEL I or II NORMAL/TIGHTEN ACCEPTABLE QUALITY LAVEL (A.Q.L): 4.0

SAMPLE SIZE 125 ACC: 05 REJECT: 06

CHECKED	YES	NO	N/A	CODE:	DEFECT DESCRIPTION	MAJOR POINT-1.0	MINOR POINT-0.5
Main label	✓						
Size care label	✓			*	OIL SPOT AT BODY	01	
Shade label							
Others label	✓			*	UN CUT THREAD AT CUFF	02	
Hang tag pos	✓						
Buttoning	✓			*	HELOW AT PKT	01	
Spare button							
Poly bag	✓						
Fab test							
Grnts test							
Others test							
other ornaments							
					Total defects		
					Total No of points		
					Grand total Points	04	

Barcode or other sticker inspe

Color/Size									

COMMENTS:

AUDITOR'S SIGN FIN. INCHARGE F.MGR.A.M

Table: Day Final Summary. Buyer: Primark Style: Ladies Shirt

Day Final Summary. Date: 24.11.18

BEXIMCO

FACTORY NAME:BAL-05		DAY FINAL SUMMERY				
SHIFT:	A				DATE:	10/11/18
BUYER:	Primark					
STYLE:	803481					
PO NO:	N776694					
COLOR:	Navy					
DPI:						
DISPO:						
ORDER QTY:	2225					
DAY PRODUCTION QTY:						
AUDIT QTY:	125					
AQL:(INTERNAL)						
ACCEPT QTY:	5					
FOUND DEFECT:	4					
RESULT:	pass					

MEJOR DEFECTS ARE AS FOIIOWS

SER	DESCRIPTION OF DEFECT	BUYER WISE DEFECT QTY				
1	oil sport in body	1				
2	un cut thread at cuff	2				
3	high-low at pocket	1				
4		total=4				
	BUYER WISE DEFECT PCS					
	TOTAL DEFECT PCS-4					#NAME?

Table 12: Day Final Summary. Buyer: Primark Style: Ladies Shirt

3.14 End line inspection for defect checking Report (industry copy).Date: 29.11.18

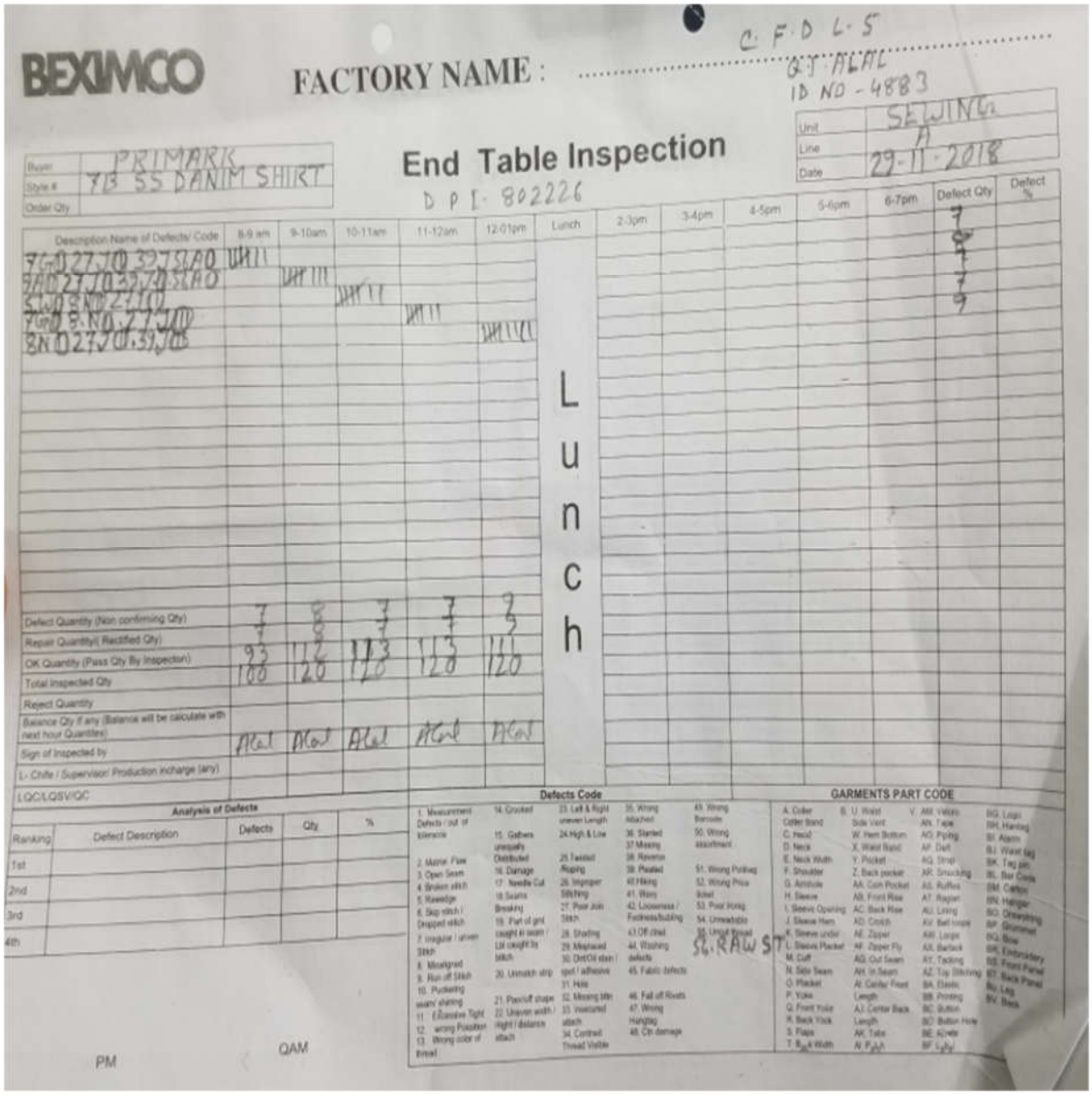


Table: End line inspection for defect checking Day Final Summary. Buyer: Primark Style: Ladies Shirt

End line inspection for defect checking Report. Date: 29.11.18

MEJOR DEFECTS ARE AS FOIIOWS					
SER	DESCRIPTION OF DEFECT	Before Lunch				
		8-9am	9-10am	10-11am	11-12am	12-01am
1	7 G 2 , 27 J 1, 39 J 2, 56 A 2	7				
2	7 A 2, 27 J 2, 39 J 2, 56 A 2		8			
3	5 W 2, 8 N 2, 27 J 3			7		
4	7 G 2, 8 N 2, 27 J 3				7	
5	8 N 3, 27 J 3, 39 J 3					9
6						
7	Defect quantity	7	8	7	7	9
8	Repair quantity	7	8	7	7	9
9	ok quantity pass	93	112	113	113	111
10	total inspection qantity	100	120	120	120	120
11						
12						
	BUYER WISE DEFECT PCS					
	TOTAL DEFECT PCS-	38				

Defects Code

1. Measurement Defects / out of tolerace
2. Matrial Flaw
3. Open Seam
4. Broken stitch
5. Rawedge
6. Skip stitch / Dropped stitch
7. Irregular / unven Stitch
8. Misaligned
9. Run off Stitch
10. Puckering seam/ shirring
11. Excessive Tight
12. wrong Possition
13. Wrong color of thread
14. Crooked
15. Gathers unequally Distributed
16. Damage
17. Needle Cut
18. Seams Breaking
19. Part of gmt caught in seam / Lbl caught by btitch
20. Unmatch strip
21. Poor/off shape
22. Uneven width / Hight / distance attach
23. Left & Right uneven Length
24. High & Low
25. Twisted /Roping
26. Improper Stitching
27. Poor Join Stitch
28. Shading
29. Misplaced
30. Dirt/Oil stain / spot / adhesive
31. Hole
32. Missing bttn
33. Insecured attach
34. Contrast Thread Visible
35. Wrong Attached
36. Slanted
37. Missing
38. Reverse
39. Pleated
40. Hiking
41. Wavy
42. Looseness / Foolness/bubling
43. Off ctred
44. Washing defects
45. Fabric defects
46. Fall off Rivets
47. Wrong Hangtag
48. Ctn damage
49. Wrong Barcode
50. Wrong assortment
51. Wrong Polibag
52. Wrong Price ticket
53. Poor Ironig
54. Unreadable
55. Uncut thread

GARMENTS PART CODE

A. Coller
B. U. Waist
V. AM. Velcro
BG. Logo
Coller Band
Side Vent
AN. Tape
BH. Hantag
C. Hood
W. Hem Bottom
AO. Piping
BI. Alarm
D. Neck
X. Waist Band
AP. Dart
BJ. Waist tag
E. Neck Width
Y. Pocket
AQ. Strap
BK. Tag pin
F. Shoulder
Z. Back pocket
AR. Smocking
BL. Bar Code
G. Armhole
AA. Coin Pocket
AS. Ruffles
BM. Carton
H. Sleeve
AB. Front Rise
AT. Raglan
BN. Hanger
I. Sleeve Opening
AC. Back Rise
AU. Lining
BO. Drawstring
J. Sleeve Hem
AD. Crotch
AV. Belt loops
BP. Grommet
K. Sleeve under
AE. Zipper
AW. Loops
BQ. Bow
L. Sleeve Placket
AF. Zipper Fly
AX. Bartack
BR. Embroidery
M. Cuff
AG. Out Seam
AY. Tacking
BS. Front Panel
N. Side Seam
AH. In Seam
AZ. Top Stitching
BT. Back Panel
O. Placket
AI. Center Front
BA. Elastic
Bu. Leg
P. Yoke
Length
BB. Printing
BV. Back
Q. Front Yoke
AJ. Center Back
BC. Button
R. Back Yock
Length
BD. Button Hole
S. Flaps
AK. Tabs
BE. Rivets
T. Back Width
Al. Patch
BF. Label

Table 13: End line inspection for defect checking Day Final Summary. Buyer: Primark Style: Ladies Shirt:

Chapter-IV

Result and Discussion

4.1 Discussion on Cutting for Ladies Shirt:

Shirt is made by different parts joining such as Front and Back Part, Sleeve and other parts. Actual garments size have to need actual size of every (cutting) parts. If any wrong selection occurred due to garments cutting then this parts reject. For the shirts every parts have to need specific length and width. Advantage of this cutting table is there was no objection from buyer. Some of deviation which occurred in some measuring point but it was obeyed the AQL from the buyer. When we cut the garments parts then some of deviation occurred. Acceptable deviation is not same for every parts. It is varied on buyers. Form the cutting table we seen that, for medium (M) size Body length deviation average 3.3 cm, Chest deviation average 4.4 cm, Waist deviation 3.2 cm and Bottom deviation 1.5 cm. For Large (L) size Body length deviation average 4.4 cm, Chest deviation average 3.8 cm, Waist deviation

1.2 cm and Bottom deviation 2.4 cm. L size parts Body length and Bottoms deviation is higher than Medium size garments parts and Medium size garments Chest and Waist deviation is higher than large size garments Chest and Waist parts

4.2 Summery Table of SMV

Time	Minimum Time (0-0.14)min	Average Time (0.15-0.29)min	Maximum Time (0.3-0.44)min
Operation Name	Rib cutting Neck piping, All parts loading, O/L Attach 1st Shoulder without tape, FTLK Piping neck, STS Attach 2nd shoulder{point tack}, O/L Attach 2nd shoulder after point tack, STS back tack neck {chap tack}, Trimming Thread sleeve hem(Turnover body), Trimming Thread at bottom hem	STS Attach Care Label x2, Mark at the center back, STS Attach main label(chap) + trimming, FTLK Hemming bottom(2-2.5cm)	O/L attach sleeve (adult), O/L close side seam short sleeve, FTLK Hemming sleeve (circuler) without

Different types of sewing machine have different working process. Some of process are easy and some of process are critical. Ladies shirt SMV is 2.83min. This Ladies Shirt all operation distribution by calculated SMV. Every working area of garments aren't same. That's way all individual process divided three types based on time. Minimum, average and maximum. This Critical process have to need higher time than medium (average) and normal process. Some of process are easy and operation happened on small area this process have to needed minimum time (0-0.14)min. Average time (0.15-0.29) min and Critical process have to needed higher time for operation. This process working area (sewing area) or sewing curve area are higher and much critical than other process. That's way required maximum time (0.3- 0.44) min.

4.3 Discussion on SMV Report:

Reason	SMV	
	Over SMV	Less SMV
1	At the begging of the order	After some days when the order is running and operators practiced.
2	Critical parts are joining	Normal parts are joining
3	Non experienced operator	Experienced operator
4	Improper selection of operator	Proper operator selection
5	boring feel for long time worked continuously (if over-time present then it happen more)	In pick hours (8-11 AM), operator have better energy.
6	Carelessness of floor In-charge, QI and other	Proper guideline and careful of floor In-charge, production Manager, Industrial Engineers.
7	Sickness problem of operator.	Strong, hardworking operator
8	Mechanical and maintained problem occurred during production time.	New machine, Machines service ability efficiency higher.

SMV variation occurred during the sewing operation. When the buyer have to required sample of garments then SMV is higher. When the order is passed and start to bulk operation then required higher time. At the begging of operation the operator dose not clearly obey how to work and how to production time reduction. In the morning the operator have enough energy to work then SMV less. At a certain time they filling bore and then they talked story each other. Then production reduction and increase defects of quality. On the other hand if the machines efficiency higher, proper guideline, and careful for working hour then production increase.

4.4 Summery of Hourly Production Report from Table

Name of Operator	Target (Per Hr)	Total Operation (Pcs)	AVG (Per Hr)	Efficiency (Target Achieve) %
Aklima	120	790	113	94
Salma	120	560	80	67
Shohel	120	245	35	29
Rita	120	560	80	67
Montu	120	790	113	94
Laili	120	755	108	90
Lucky	120	100	100	83
Nasir	120	740	106	88
Khuku Moni	120	720	103	86
Mintu	100	560	80	80
Iub	80	230	38	48
Rokeya	70	437	62	89
Ataur	70	316	45	64
Rotna	120	710	101	84
Hasem	120	680	97	81
Munni	120	80	80	67
Morjin	120	80	80	67

Garments every parts joining required time is not same. Some process are easy some are critical. Easy or basic process target is higher than critical process. From this table higher efficiency 94% and lowest efficiency 29%. Average efficiency 75%. If the garments authority take proper decision to select proper operator for proper machine operation, take care operators health, machine servicing in proper time, provide proper guideline and training then the efficiency of production increase.

4.5 Discussion on In-Line Inspection Report:

In this inspection garments every parts Style, Sewing Quality, Trims and Accessories, and Measurement are checked by Q.C. Trims and Accessories faults such as Label, Zipper, Button, Elastic, Rib missing. Critical sewing check point are Neck shape, Side joint, Arm hole up-down Point. Garments parts measurements if deviation is higher than buyer requirements then this garments will be rejects.

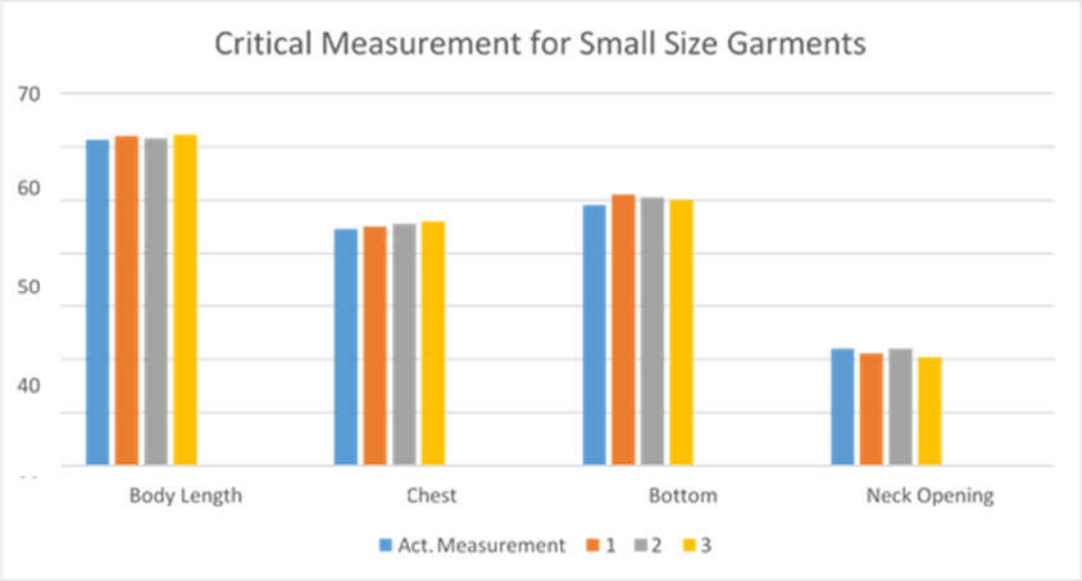


Figure 13: In Line Inspection

In this chat included critical measurement after sewing of garments. Here Green color line show every parts actual/required measurement. From this chart three garments measurement. After sewing garments body length every time higher than required measurement for the Body length, Chest & Bottom measurement. But Neck opening deviation decrease.

4.6 Discussion on Getup Check:

This inspection is done by visualization. Ironing quality poor or good, poor ironing rectify or not rectify spot rectify or not rectify, broken, drop, shade and other parameter check by getup. From the table-3.9, shown the garments getup check report. Total inspection quantity 893pcs,

Q.C pass 868, No of defect or alter found 13pcs. 1pcs reject. Spot is found higher than other alters. When found alter then it send for solution this alters in specific area of alter reduction zone. After final getup check the product send to adding accessories and carton and ready for shipment.

4.7 Summery Table of Hourly Finishing Quality Inspection Report from Table:

Hour	Total Quantity	Q.C Pass (%)	Rework (%)	Spot (%)	Rejection (%)
8-9	207	77	12	10	1
9-10	205	83	12	5	0.4
10-11	217	85	12	5	0.4
11-12	236	84	11	5	0
12-01	226	86	9	4	0.4
02-03	238	84	11	5	0.4
03-04	234	81	12	6	0.9
04-05	243	82	11	6	0.4
05-06	242	83	10	6	0.4
06-07	246	87	8	4	0.4

By this inspection find out Total Q.C Pass, Rework, Spot and Rejection Percentage. From this table, Q.C pass less (77%), which happen in morning starting hour and Highest Q.C pass 87 percent. Average Q.C pass in this day is 83%. In this day rework 11%, Spot fund 5.6% and reject 0.5%.

Chapter-V

CONCLUSION

Conclusion:

The report represents manufacturing process of ladies Shirt in Beximco apparel industry. The assessment is done by the PRIMARK buyers, which style no 803481, Color Navy. XS, S, XL, XXL and XXXL is included. This main fabric is import from own industry for buyer requirements, that's way cutting, sewing and finishing happened for this order. Ladies Shirt manufacturing process is much critical for its different parts. Garments every parts attach carefully with actual size wise actual color. Every individual line have Quality Inspector, they are checking garments and insure its quality. From the data of SMV found that minimum-maximum time required for different types of basic and critical process. From the end line inspection report found that maximum defect zone. Ironing process gives extra outlook and better hand fell. Measurement variable for garments from sewing to after finishing. The defects were found such as uncut yarn from fabric, skip stitch, uneven stitch, puckering, and uneven joining and so on. To remove these problems the consciousness of operators and periodical inspection of machine have to do. Acceptable deviation given by buyer. Different types of faults occurred during cutting, sewing and finishing section. Improper selection of machine and operator carelessness occurred this faults. During the production time mistake garments parts exact size wise exact parts. Sometime label missing, Just missing from garments parts. If the industry insuring operators proper guide line and trained then production is increase and defects quantity reduces.

Reference:

2.1https://www.textiletoday.com.bd/woven-fabric-sector-bangladesh-opportunities-challenges-techniques/

2.4 https://apparelbrief.wordpress.com/textile-term/different-types-of-knit-woven-fabric/

2.5.1https://clothingindustry.blogspot.com/2017/12/raw-materials-used-garment-industry.html