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REPORT ON

Analysis of top most defects in cutting department to ensure the quality of readymade garments in the apparel industry.

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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

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DECLARATION

We hereby declare that, this project has been done by us and under the supervision of **Mousumi Rahaman Hashi**, Lecturer, Department of Textile Engineering and Daffodil international University. This report is not copied from elsewhere, we also declare that neither this project nor any part of this project has been submitted elsewhere for award of any Bachelor Degree.

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LETTER OF APPROVAL

It is herewith certified that **Md. Morshed Alam** and **Md. Mokhlesur Rahaman** bearing ID: 151-23-4240 and 151-23-4136, Department of Textile Engineering, Daffodil International University, Dhaka, Bangladesh, has carried out their B.Sc. thesis entitled "**Analysis of top most defects in Cutting department to ensure the quality of readymade garments in the apparel industry**" under my direct supervision. They have successfully carried out 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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DEDICATION

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

ABSTRACT

This project is analysis of top most defects in cutting department to ensure the quality of readymade garments in the apparel industry. Defects of fabric in cut parts can reduce the quality of garments. So it is necessary to control defect % of cut parts. These defects persist despite of several visual inspections and intensive efforts to replace defective parts in replacement table. The increased use of automation in assembly steps will intensify the problem of detection and removal of fabric defects in cut-parts. Workers of QC table in cutting room always try to detect and replace the defective cut-parts from the same fabric role and after replaced this cut part, it's placed in the particular bundle according to serial number of cut part. Different types of defects (like as, Hole, Slub, Knot, Thick yarn, Spot, Dye effect etc.) are found in fabric cut parts by QC workers, then replace the defective cut parts and send the acceptable bundle of fabric to the sewing section. The workers records hourly cut part inspection data after every hour and estimated the defect percentages, So that it could be known about quality of fabric and this calculation help to maintain quality of cut part fabric. All collected data of fabric cut part are inputted on this report and show also number of defects for every particular defect with calculated of defect percentages. For this research we are collected 26 days data of top most defect in cutting department from "Goldtex garments Ltd." Which is located at Old EPZ, Savar, Dhaka.

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Chapter-1 Introduction

1.1 Introduction

Now a days Textile and apparel industry obtained a remarkable position to enhance the industrial growth and economic prosperity. This industry plays a significant role to increase the employment potential as well as to earn foreign currency. Bangladesh is considered as one of the economic competitor in garments manufacturing. A variety of garments products are exported from Bangladesh to all over the world as it is considered as a 100 percent export oriented sector. More than 70 percent of foreign earnings are obtained by readymade garment. Low labour cost is one of the greatest great advantages of this industry. As the global economic condition has changed rapidly, apparel manufacturers has given more focus on customer demand for high quality product and improved productivity. The demand for higher quality product at lower price is increasing. To survive in an increasingly competitive apparel industry, apparel manufacturers need to improve the quality as well as productivity of the garments operations through defects minimization. The biggest and the most essential segment in an article of apparel industry is its cutting segment. In this work we collected the data of cutting departments for 26 days i.e. total number of inspected body, no of defective body and finally defect percentage is calculated from different types of defects found in cutting department. After the end of this investigation we are able to know the defect percentage of this each type of defects. The point of the examination is to research how to control quality in piece of clothing generation and make proposals for enhancing the quality control.

1.2 Background of the Study:

A thesis paper referred to as research paper that provides the reader with sufficient information about particular topic “**Analysis of top most defects in cutting department to ensure the quality of readymade garments in the apparel industry.**” Thesis is a document that submitted to support of candidate an academic degree or professional qualification presenting the author's research and findings. Our thesis paper introduced as “Top most fault in Garments Cutting room”. We realized that it is too much important to maintain quality of a garments in textile sector, so we choice this type of topic and try how to reduce garments cutting fault. We worked in a woven garment manufacturing industry “**Goldtex Garments Ltd.**” that is 100% export and import woven industry. One of the preliminary steps to completing a thesis is the background study for it. The background study for a thesis includes a review of the area being researched, current information surrounding the issue. The purpose of a background study is to help to prove the relevance of thesis question and to further develop thesis.

1.3 Objective for this project:

1. To analysis the percentage of fabric faults in cutting room for specific products;
2. To way to reduce fabric faults in cutting room;
3. To analysis the cutting fault data;
4. How many time required repairing them;
5. Economical effect due to fabric faults.

1.4: Importance of the Study:

The assignment has a great importance in our study and work life. By doing this we can learn about “Commonly found faults and remedies in cutting room.” that will help us in our future job life. By doing this we can also enhance our knowledge.

1.5: Limitations of the study:

During our thesis period we have faced some problem in cutting room due to some restriction, that's why we can't collect all data which are needed. Without permission of higher authority, we can't collect some necessary papers. Time was also limited for collecting data. So, it was as tough job to gather information during working time.

Chapter- 2 Literature Review

2.1 Quality control of garments cutting department:

A quality control operation is performed after the components are cut and fused. The replacement of faulty components is more convenient at this stage as it does not affect the previously finished cutting process, or the forthcoming sewing process. All the cut components are inspected and the following quality parameters are controlled: fabric quality; check miscut, the conformity of the size and shape of cut components to their pattern pieces. The entire consumer wants to get a product which is free of any types of defect for this reason manufacturer be aware about defect of product. Fabric quality of the cut components is inspected visually. If textile or garment faults arising from the cutting or fusing processes are found, the component is taken out of the bundle and sent to be recut.

2.2 Defects in Cutting department:

The defect is the common term in the cutting department. Defects item are also well known as reject the item. Maximum defects item are replaced in cutting department. Different types of defects are found in the cutting department. In garments industry these defects are dependent upon the classification of defects and an inspector's ability to make decisions. Creating a list of every defect that might be encountered during a quality inspection is not realistic. Having said that, the tables which follow do provide details of the majority of defects.

2.3 Some are top most defects in cutting department:

1. Slub
2. Knot
3. Hole
4. Thick yarn
5. Miss yarn
6. Crease mark
7. Colour spot
8. Dye defect
9. Spot (dirt or grease)
10. Oil satin
11. Shading
12. Ink spot
13. End out
14. Fly yarn
15. Pen mark
16. Stop mark

2.3.1 Slub:

Slub refers to thick or heavy places in the yarn or flying waste yarn getting into yarn feeds during the spinning process.



Figure -1: SLUB

2.3.2 Knots:

Knots are caused by tying spools of yarn together.



Figure -2: KNOT

2.3.3 Hole:

A fabric imperfection in which one or several yarns are sufficiently damaged to create an opening.



Figure -3: HOLE

2.3.4 Thick yarn:

It can be identified as the warp end having larger diameter than the other warps.



Figure -4: THICK YARN

2.3.5 Missing Yarn:

Caused by one end of yarn missing from feed and machine continuing to run.

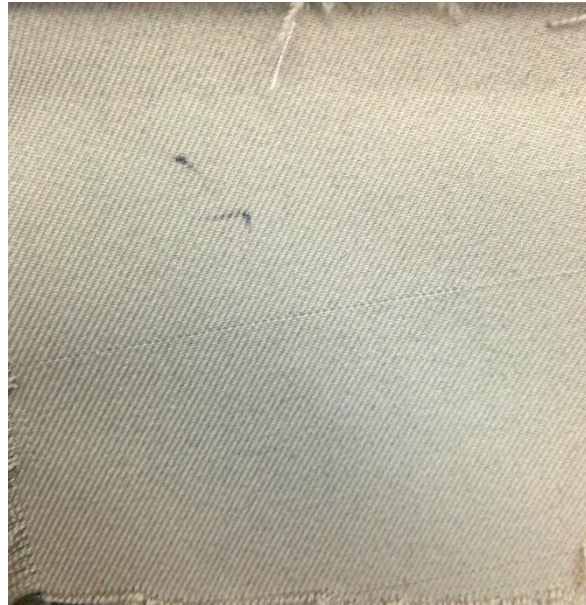


Figure -5: MISSING YARN

2.3.6 Crease Mark:

Crease mark appears when creases are caused by fabric folds in the finishing process.



Figure -6: CREASE MARK

2.3.7 Colour spot:

It is the stain of another colour on colored fabric.

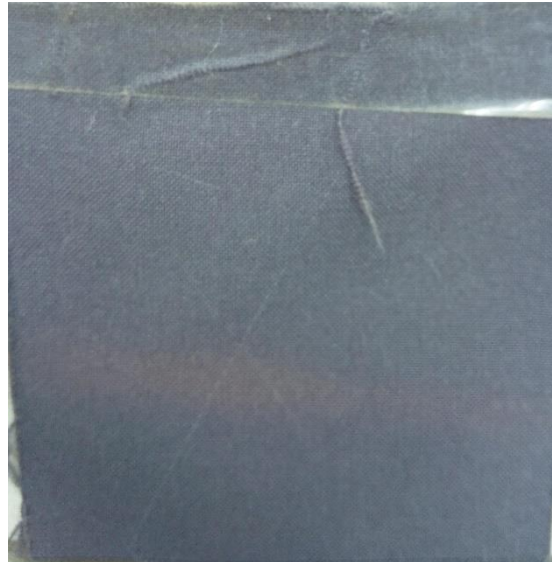


Figure -7: COLOUR SPOT

2.3.8 Dye defect:

Missing of dye in dyed fabric.



Figure -8: DYE DEFECT

2.3.9 Spot (dirt or grease):

It indicates a discoloration caused by dirt or grease.

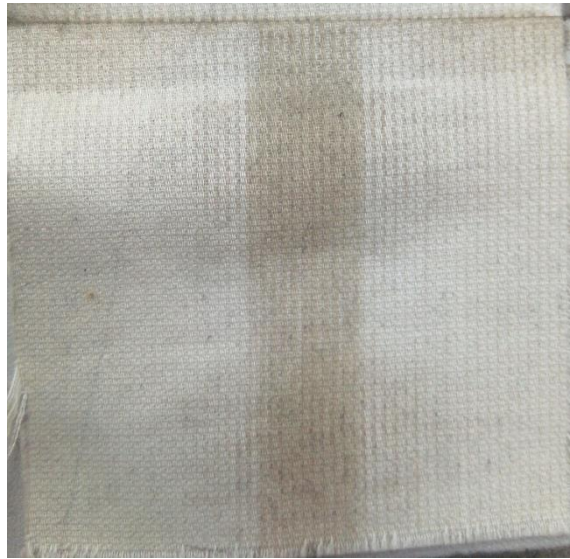


Figure -9: SPOT

2.3.10 Oil spot or stain:

It occurs during spinning, weaving or finishing. It is also often seen in the woven fabric. It is also produced in woven fabric if too much oiling has done on the loom parts.

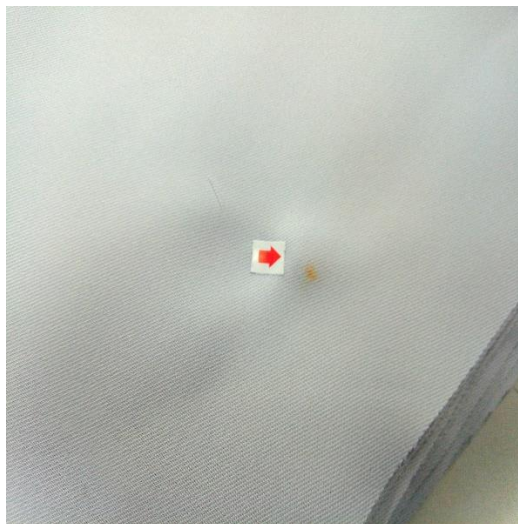


Figure-10: Oil spot or stain

2.3.11 Shading:

Shading is a common problem for dyed fabric. When color variation occurs from wrong handling of fabric. It is a variation in color tone either horizontally or vertically. It is generally due to uneven tension on the fabric.



Figure -11: SHADE VARIATION

2.3.12 Ink spot:

Stain of ink on fabrics.



Figure -12: INK SPOT

2.3.13 End out:

Caused by yarn breaking and loom continuing to run with the missing end. Major Jerk-in caused by an extra piece of filling yarn being jerked part way into the fabric by the shuttle. The defect will appear at the selvage.



Figure -13: END OUT

2.3.14 Fly yarn:

This is due to different color of yarn contamination with the fabric.

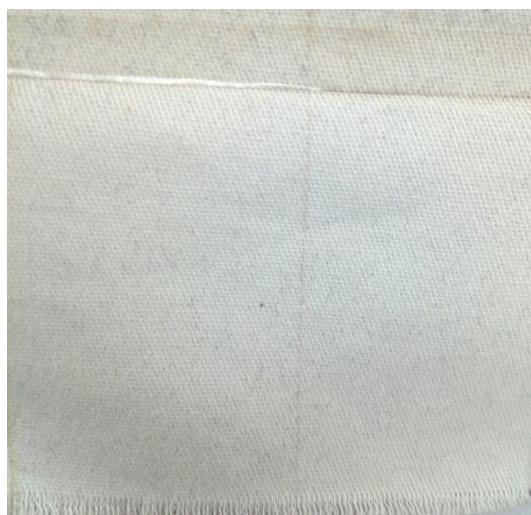


Figure -14: FLY YARN

2.3.15 Pen mark:

It is the stain on fabric, which is caused by dragging pen on fabric.



Figure -15: PEN MARK

2.3.16 Stop Mark:

Stop mark occurs when the loom is stopped, the yarn elongates under tension. When the loom starts again, the slack is woven into the fabric.



Figure-16: STOP MARK

Chapter 3 Methodology

3.1 Data Collection:

We have collected for 26 days data and finally calculated defect percentage from different types of defects found in cutting department. A factory should set different modern quality procedures and quality management technique for the betterment of RMG sector. Slub, Knot, Hole, Thick yarn, Miss Yarn, Crease mark, Colour spot, Dye defect, Spot (dirt or grease), Oil satin, Shading, Ink spot, End out, Fly yarn, Pen mark, Stop mark etc. are the most common defects found in cutting section.

3.2 Data Table Analysis:

Topmost Defects in cutting Department for woven bottom has been analyzed. We have worked at “Goldtex Garments Ltd.” Here the others defect is “Fly yarn, Pen mark, Stop mark.” In below we have given different data in the table of the factory.

The analysis is called DHU analysis. DHU stands for “Defect per Hundred Units”. It means number of defeats found or detected per 100 garments cutting parts.

$DHU = \text{Total Defects found} * 100 / \text{Total checked quantity}$

3.2.1 Cutting inspection report (Day 1)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|-----------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 7 | 8 | 9 | 5 | 5 | | | 2 | | | | | | | 5000 | 36 | 4964 | .72 |
| 2 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | 5 | 10 | 8 | | 6720 | 96 | 6624 | 1.42 |
| 3 | 5 | 9 | 8 | 11 | 9 | | 5 | | 8 | | | | | 5 | 6480 | 60 | 6420 | 0.92 |
| 4 | 12 | 7 | 11 | 9 | 7 | | | | | | | | | 2 | 6020 | 48 | 5972 | 0.79 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | 2 | | | | | | | 5240 | 36 | 5204 | 0.68 |
| 6 | 9 | 4 | 8 | 7 | 4 | | | 4 | | | | | | | 5120 | 36 | 5084 | 0.70 |
| 7 | 12 | 11 | 9 | 12 | 8 | | | 11 | | | | | | 9 | 6240 | 72 | 6168 | 1.15 |
| 8 | 13 | 13 | 14 | 11 | 12 | | | 7 | | 7 | | 8 | 5 | 6 | 6500 | 84 | 6416 | 1.2 |
| 9 | 12 | 11 | 8 | | | | | 5 | | | | | | | 4920 | 36 | 4884 | 0.73 |
| 10 | 10 | 13 | 12 | 11 | 10 | | 8 | 8 | | | | 8 | 5 | 5 | 6050 | 90 | 5966 | 1.3 |
| Ttl. | 97 | 89 | 98 | 80 | 55 | 11 | 13 | 21 | 41 | 7 | 5 | 26 | 18 | 27 | 58290 | 588 | 57702 | 1.00 |

3.2.2 Cutting inspection report (Day 2)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 5 | 9 | 8 | 11 | 9 | | 5 | | 8 | | | | | 5 | 6040 | 60 | 5980 | 0.99 |
| 2 | 9 | 4 | 8 | 7 | 4 | | | | 4 | | | | | | 4800 | 36 | 4764 | 0.75 |
| 3 | 12 | 14 | 10 | 10 | 11 | | 8 | | 11 | | | | | 8 | 6660 | 84 | 6576 | 1.23 |
| 4 | 15 | 12 | 14 | 13 | 15 | 10 | | 7 | | 10 | | | | | 6780 | 96 | 6684 | 1.41 |
| 5 | 10 | 12 | 11 | 10 | 14 | | | | | | | | | 3 | 6540 | 60 | 6480 | 0.91 |
| 6 | 12 | 11 | 4 | | 10 | | 10 | | 5 | | | 10 | | | 5020 | 60 | 4960 | 1.11 |
| 7 | 10 | 10 | 12 | 8 | | | | | | | | | | 6 | 5100 | 48 | 5052 | 0.99 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5680 | 48 | 5632 | 0.84 |
| 9 | 10 | 12 | 11 | 8 | | 12 | | 11 | | | | 4 | 12 | | 5860 | 72 | 5788 | 1.22 |
| 10 | 14 | 13 | 12 | 12 | | 12 | | | 9 | | | | | | 6220 | 72 | 6148 | 1.15 |
| Ttl. | 85 | 108 | 102 | 92 | 50 | 13 | 23 | 18 | 37 | 10 | | 14 | 12 | 22 | 58700 | 636 | 58064 | 1.08 |

3.2.3 Cutting inspection report (Day 3)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 7 | 8 | 9 | 5 | 5 | | | 2 | | | | | | | 4820 | 36 | 4784 | 0.74 |
| 2 | 14 | 12 | 12 | 12 | 14 | | | 9 | 5 | | | | | 6 | 6520 | 72 | 6448 | 1.10 |
| 3 | 12 | 11 | 9 | 12 | 8 | | | 11 | | | | | | 9 | 6640 | 72 | 6568 | 1.08 |
| 4 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6040 | 48 | 5992 | 0.89 |
| 5 | 9 | 4 | 8 | 7 | 4 | | | 4 | | | | | | | 5200 | 36 | 5164 | 0.63 |
| 6 | 5 | 9 | 8 | 11 | 9 | | 5 | 8 | | | | | | 5 | 6150 | 60 | 6090 | 0.97 |
| 7 | 10 | 12 | 12 | 11 | 10 | | | | | | | 5 | | | 6380 | 60 | 6323 | 0.94 |
| 8 | 11 | 13 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6720 | 84 | 6636 | 1.25 |
| 9 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6833 | 84 | 6749 | 1.22 |
| 10 | 13 | 13 | 12 | 12 | 15 | | 8 | 6 | 9 | | | | | 8 | 6952 | 96 | 6856 | 1.28 |
| Ttl. | 106 | 106 | 112 | 107 | 89 | | 13 | 23 | 31 | 14 | | 21 | 10 | 28 | 62255 | 648 | 61607 | 1.04 |

3.2.4 Cutting inspection report (Day 4)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6830 | 96 | 6734 | 1.40 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6690 | 84 | 6606 | 1.25 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6530 | 84 | 6446 | 1.20 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6256 | 72 | 6184 | 1.14 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4910 | 36 | 4874 | 0.73 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5670 | 36 | 5634 | 0.64 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5889 | 48 | 5841 | 0.81 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 6235 | 48 | 6187 | 0.76 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6678 | 72 | 6606 | 1.07 |
| Ttl. | 108 | 106 | 103 | 112 | 58 | 11 | | 20 | 46 | | | 16 | 18 | 34 | 62010 | 648 | 61452 | 1.05 |

3.2.5 Cutting inspection report (Day 5)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 14 | 8 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6550 | 72 | 6478 | 1.09 |
| 2 | 11 | 11 | 7 | 14 | 8 | | | | 9 | | | | | 11 | 6438 | 72 | 6366 | 1.11 |
| 3 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 5848 | 48 | 5800 | 0.82 |
| 4 | 14 | 12 | 11 | 13 | 15 | | 8 | | 6 | 9 | | | | 8 | 6734 | 96 | 6638 | 1.42 |
| 5 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6633 | 84 | 6549 | 1.32 |
| 6 | 14 | 10 | 12 | 11 | 12 | | | 11 | | | | 8 | 5 | | 6317 | 84 | 6233 | 1.32 |
| 7 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5010 | 36 | 4974 | 0.71 |
| 8 | 9 | 13 | 7 | 14 | 8 | | | | 9 | | | | | 11 | 6324 | 72 | 6252 | 1.13 |
| 9 | 10 | 14 | 13 | 13 | 15 | | 8 | | 6 | 9 | | | | 8 | 6838 | 96 | 6742 | 1.40 |
| 10 | 4 | 8 | 11 | 5 | 3 | | | | 4 | | | | | | 5200 | 36 | 5164 | 0.99 |
| Ttl. | 103 | 108 | 99 | 115 | 86 | | 16 | 18 | 47 | 18 | | 16 | 10 | 54 | 61892 | 696 | 61196 | 1.12 |

3.2.6 Cutting inspection report (Day 6)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5830 | 48 | 5782 | 0.82 |
| 2 | 10 | 9 | 12 | 10 | | | | 5 | | | | | 2 | | 5850 | 48 | 5802 | 0.82 |
| 3 | 14 | 14 | 13 | 9 | 15 | | 8 | 6 | 9 | | | | | 8 | 6830 | 96 | 6734 | 1.40 |
| 4 | 7 | 8 | 9 | 5 | 5 | | | 2 | | | | | | | 5064 | 36 | 5028 | 0.70 |
| 5 | 5 | 8 | 9 | 7 | 5 | | | 2 | | | | | | | 5244 | 36 | 5208 | .68 |
| 6 | 14 | 12 | 12 | 12 | 14 | | | 9 | | 5 | | | | 6 | 6670 | 72 | 6598 | 1.07 |
| 7 | 13 | 10 | 12 | 12 | 14 | 3 | | 9 | | 5 | | | | 6 | 6322 | 72 | 6250 | 1.13 |
| 8 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6689 | 84 | 6605 | 1.25 |
| 9 | 11 | 12 | 13 | 11 | 14 | | | 9 | | | | 8 | 5 | | 6711 | 84 | 6627 | 1.16 |
| 10 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5678 | 48 | 6530 | 0.84 |
| Ttl. | 111 | 108 | 118 | 103 | 79 | 3 | 8 | 34 | 15 | 19 | | 16 | 10 | 22 | 60988 | 624 | 60364 | 1.02 |

3.2.7 Cutting inspection report (Day 7)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 9 | 13 | 7 | 14 | 8 | | | | 9 | | | | | 11 | 6530 | 72 | 6458 | 1.10 |
| 2 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5290 | 36 | 5254 | 0.68 |
| 3 | 10 | 14 | 13 | 13 | 15 | | 8 | | 6 | 9 | | | | 8 | 6840 | 96 | 6744 | 1.40 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6580 | 72 | 6508 | 1.08 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4987 | 36 | 4951 | .72 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5210 | 36 | 5174 | 0.69 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6089 | 48 | 6041 | 0.78 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 6035 | 48 | 5987 | 0.80 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6578 | 72 | 6506 | 1.09 |
| Ttl. | 96 | 104 | 83 | 108 | 62 | | 8 | | 54 | 9 | | | | 53 | 60461 | 588 | 59873 | 0.97 |

3.2.8 Cutting inspection report (Day 8)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6746 | 96 | 6650 | 1.42 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6537 | 84 | 6453 | 1.12 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6442 | 84 | 6358 | 0.68 |
| 4 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5253 | 36 | 5217 | 0.69 |
| 5 | 5 | 8 | 11 | 4 | | | 3 | | | | | | 5 | | 5110 | 36 | 5074 | 0.70 |
| 6 | 7 | 9 | 5 | 7 | 5 | | | | 2 | | | | | | 4970 | 36 | 4934 | 0.72 |
| 7 | 9 | 13 | 7 | 14 | 8 | | | | 9 | | | | | 11 | 6522 | 72 | 6472 | 0.73 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6089 | 48 | 6041 | 0.78 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | 7 | | 6135 | 48 | 6087 | 0.79 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6578 | 72 | 6506 | 1.09 |
| Ttl. | 99 | 105 | 99 | 108 | 50 | | 3 | 20 | 33 | | | 16 | 18 | 32 | 60382 | 612 | 59770 | 1.01 |

3.2.9 Cutting inspection report (Day 9)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 4950 | 36 | 4914 | 0.72 |
| 2 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6170 | 48 | 6122 | 0.77 |
| 3 | 11 | 12 | 11 | 9 | | | | | | | | | 5 | 6062 | 48 | 6014 | 0.79 | |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6356 | 72 | 6284 | 1.13 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4912 | 36 | 4876 | 0.73 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5070 | 36 | 5034 | 0.96 |
| 7 | 11 | 12 | 9 | 12 | 8 | | 2 | | 11 | | | | | 9 | 6550 | 72 | 6478 | 1.12 |
| 8 | 14 | 14 | 13 | 9 | 15 | | 8 | | 6 | 9 | | | | 8 | 6987 | 96 | 6891 | 1.37 |
| 9 | 12 | 14 | 13 | 11 | 13 | | 11 | | 7 | 8 | | | | 8 | 6853 | 96 | 6787 | 1.40 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6650 | 72 | 6578 | 1.08 |
| Ttl. | 102 | 107 | 101 | 99 | 67 | | 21 | | 52 | 17 | | | | 48 | 60360 | 615 | 59748 | 1.02 |

3.2.10 Cutting inspection report (Day 10)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 11 | 12 | 13 | 11 | 14 | | | 9 | | | | 8 | 5 | | 6530 | 84 | 6446 | 1.29 |
| 2 | 9 | 14 | 12 | 12 | 12 | | | 11 | | | | 7 | 6 | | 6290 | 84 | 6206 | 1.33 |
| 3 | 11 | 12 | 10 | 11 | | | | | | | | | | 4 | 6130 | 48 | 6082 | 0.78 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 5538 | 72 | 5464 | 1.20 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 6353 | 36 | 3617 | 0.56 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 4945 | 36 | 4909 | 0.72 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6453 | 72 | 6381 | 1.11 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6289 | 48 | 6241 | 0.76 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 6435 | 48 | 6387 | .745 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 4578 | 72 | 4506 | 1.57 |
| Ttl. | 101 | 107 | 98 | 110 | 60 | | | 20 | 37 | | | 15 | 11 | 38 | 59541 | 600 | 58941 | 1.00 |

3.2.11 Cutting inspection report (Day 11)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6737 | 96 | 6641 | 1.42 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6645 | 84 | 6561 | 1.2 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6739 | 84 | 6655 | 1.2 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6345 | 72 | 6272 | 1.13 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5210 | 36 | 5174 | 0.69 |
| 6 | 3 | 10 | 7 | 5 | | | 8 | | | | | | | 3 | 4870 | 36 | 4834 | 0.75 |
| 7 | 8 | 7 | 4 | 6 | | 3 | | | | 3 | | 2 | | 2 | 5122 | 36 | 5086 | 0.72 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6289 | 48 | 6241 | 0.76 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | 7 | | 6035 | 48 | 5987 | 0.86 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6796 | 72 | 6724 | 1.05 |
| Ttl. | 103 | 103 | 96 | 104 | 45 | 14 | 8 | 20 | 33 | 3 | | 18 | 18 | 30 | 60789 | 612 | 60177 | 1.00 |

3.2.12 Cutting inspection report (Day 12)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6530 | 84 | 6482 | 1.18 |
| 2 | 8 | 12 | 11 | 12 | 10 | 5 | | 7 | | 5 | | 7 | 6 | | 6290 | 84 | 6206 | 1.22 |
| 3 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6877 | 96 | 6781 | 1.39 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6197 | 72 | 6125 | 1.16 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5194 | 36 | 5158 | 0.69 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5058 | 36 | 5022 | 0.71 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 8 | 7 | 5 | 8 | | | 3 | | | | | 4 | | 2 | 5289 | 36 | 5253 | 0.68 |
| 9 | 12 | 11 | 12 | 10 | | 5 | | | 8 | | | | 2 | | 6435 | 60 | 6375 | 0.93 |
| 10 | 11 | 13 | 10 | 9 | | | | 5 | 9 | | | | 3 | | 6067 | 60 | 6007 | 0.98 |
| Ttl. | 99 | 106 | 100 | 100 | 48 | 21 | 3 | 25 | 52 | 5 | | 19 | 24 | 20 | 60259 | 636 | 59623 | 1.06 |

3.2.13 Cutting inspection report (Day 13)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6897 | 96 | 6801 | 1.39 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6734 | 84 | 6650 | 1.25 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6545 | 84 | 6461 | 1.28 |
| 4 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6256 | 72 | 6184 | 1.15 |
| 5 | 9 | 15 | 12 | 7 | | | | 5 | 9 | | | | 3 | | 6384 | 60 | 6324 | .94 |
| 6 | 11 | 13 | 10 | 9 | | | | 5 | 9 | | | | 3 | | 6059 | 60 | 5999 | .99 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.14 |
| 8 | 7 | 8 | 6 | 5 | | | | 3 | | | 6 | | | | 5289 | 36 | 5253 | .68 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 6035 | 48 | 5987 | .80 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6578 | 72 | 6506 | 1.09 |
| Ttl. | 112 | 113 | 99 | 110 | 48 | 11 | | 33 | 62 | | 6 | 16 | 24 | 34 | 63089 | 624 | 62465 | 0.99 |

3.2.14 Cutting inspection report (Day 14)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 5 | 11 | 4 | 9 | | | 2 | | | | | | | 5 | 4873 | 36 | 4837 | 0.73 |
| 2 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 4974 | 36 | 4938 | 0.72 |
| 3 | 9 | 15 | 12 | 7 | | | | 5 | 9 | | | | 3 | | 6094 | 60 | 6034 | 0.98 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6356 | 72 | 6281 | 1.12 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5110 | 36 | 5074 | 0.70 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | | | | | | | 5270 | 36 | 5234 | 0.68 |
| 7 | 11 | 12 | 9 | 12 | 8 | | 2 | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.12 |
| 8 | 11 | 11 | 13 | 8 | | | | 6 | 11 | | | | 1 | | 6048 | 60 | 5988 | 0.99 |
| 9 | 11 | 13 | 10 | 9 | | | | 5 | 9 | | | | 3 | | 5807 | 60 | 5747 | 1.03 |
| 10 | 9 | 10 | 11 | 13 | | 2 | | | | | 2 | | | | 5890 | 48 | 5842 | 0.81 |
| Ttl. | 85 | 107 | 95 | 89 | 31 | 2 | 4 | 16 | 55 | | 2 | | 7 | 23 | 56743 | 408 | 56335 | 0.72 |

3.2.15 Cutting inspection report (Day 15)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|-----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | 6 | | 8 | 6 | 6783 | 96 | 6687 | 1.41 |
| 2 | 12 | 11 | 10 | 10 | 12 | | 10 | | 10 | 9 | | 11 | | | 6907 | 96 | 6711 | 1.38 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6734 | 84 | 6650 | 1.24 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | 4 | | | 5 | 6356 | 72 | 6284 | 1.13 |
| 5 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5910 | 48 | 5862 | 0.81 |
| 6 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5070 | 36 | 5034 | 0.71 |
| 7 | 14 | 12 | 12 | 14 | 12 | | 10 | | | 10 | | | 10 | 2 | 6747 | 96 | 6651 | 1.47 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6057 | 48 | 6009 | 0.79 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | 7 | | 5890 | 48 | 5842 | 0.81 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6645 | 72 | 6573 | 1.08 |
| Ttl. | 103 | 106 | 105 | 117 | 57 | 11 | 20 | 13 | 43 | 19 | 10 | 19 | 23 | 29 | 62099 | 696 | 61403 | 1.12 |

3.2.16 Cutting inspection report (Day 16)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 9 | 15 | 12 | 7 | | | | 5 | 9 | | | | 3 | | 6173 | 60 | 6113 | 0.97 |
| 2 | 11 | 13 | 10 | 9 | | | | 3 | 11 | | | | | 3 | 6045 | 60 | 5985 | 0.99 |
| 3 | 10 | 12 | | | 8 | 8 | | | | 2 | | 6 | | 2 | 5884 | 48 | 5836 | 0.84 |
| 4 | 5 | 9 | 3 | 8 | | | 5 | | | | | | | 6 | 5324 | 36 | 5288 | 0.67 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5050 | 36 | 5014 | 0.71 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5172 | 36 | 5136 | 0.69 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6874 | 96 | 6778 | 1.39 |
| 9 | 13 | 11 | 13 | 12 | | | 11 | | 8 | | 1 | 7 | | 8 | 6983 | 96 | 6887 | 1.37 |
| 10 | | 5 | 9 | 3 | 8 | | | 5 | | | | | | | 5394 | 36 | 5358 | 0.66 |
| Ttl. | 86 | 103 | 86 | 75 | 34 | 19 | 16 | 29 | 52 | 2 | 1 | 13 | 11 | 28 | 58221 | 576 | 57645 | 0.99 |

3.2.17 Cutting inspection report (Day 17)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% | |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|-------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6830 | 96 | 6734 | 1.40 | |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6690 | 84 | 6606 | 1.25 | |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6748 | 84 | 6664 | 1.2 | |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6084 | 72 | 6012 | 1.18 | |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4843 | 36 | 4807 | 0.74 | |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 4948 | 36 | 4912 | 0.72 | |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6638 | 72 | 6566 | 1.38 | |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6289 | 48 | 6241 | 0.76 | |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | 7 | | 6035 | 48 | 5987 | 0.79 | |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6586 | 72 | 6514 | 1.93 | |
| Ttl. | 108 | 106 | 103 | 112 | 58 | 11 | | 20 | 46 | | | | 16 | 28 | 34 | 61691 | 648 | 61043 | 1.05 |

3.2.18 Cutting inspection report (Day 18)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|-----------|-----------|---------------|--------------|----------------|----------------|---------------|------|--------------|----------|-------------|------------|--------------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 5 | 8 | 9 | 7 | 5 | | | 2 | | | | | | | 5230 | 36 | 5194 | 0.68 |
| 2 | 10 | 10 | 12 | 13 | | 5 | | 5 | | | | | 5 | 6290 | 60 | 6230 | 0.95 | |
| 3 | 12 | 12 | 11 | 13 | | | 5 | | | | 7 | | | 6130 | 60 | 6070 | 0.97 | |
| 4 | 12 | 11 | 9 | 12 | 8 | | | 11 | | | | | 9 | 6556 | 72 | 6484 | 1.98 | |
| 5 | 7 | 8 | 9 | 5 | 5 | | | 2 | | | | | | 4910 | 36 | 4874 | 0.733 | |
| 6 | 5 | 8 | 9 | 7 | 5 | | | 2 | | | | | | 5270 | 36 | 5234 | 0.68 | |
| 7 | 13 | 9 | 7 | 14 | 8 | | | 11 | | | | | 9 | 6637 | 72 | 6565 | 1.08 | |
| 8 | 10 | 12 | 10 | 11 | | 8 | | | | 11 | | 9 | | 6773 | 72 | 6701 | 1.06 | |
| 9 | 7 | | 6 | 7 | | | 6 | 5 | | | | | 5 | 4728 | 36 | 4692 | 0.76 | |
| 10 | 12 | 11 | 9 | 8 | | 10 | | | | 10 | | | 9 | 6638 | 72 | 6566 | 1.08 | |
| Ttl. | 86 | 89 | 85 | 90 | 31 | 23 | 5 | 33 | | 21 | 7 | 9 | 32 | 59162 | 444 | 58718 | 0.75 | |

3.2.19 Cutting inspection report (Day 19)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% | |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|-------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6640 | 96 | 6544 | 1.44 | |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6290 | 84 | 6206 | 1.33 | |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6130 | 84 | 6046 | 1.27 | |
| 4 | | | | | | | | | | | | | | | 6756 | 96 | 6660 | 1.42 | |
| 5 | 11 | 11 | 13 | 8 | | | | 6 | 11 | | | | 1 | | 6564 | 60 | 6504 | 0.91 | |
| 6 | 11 | 13 | 10 | 9 | | | | 5 | 9 | | | | 3 | | 6433 | 60 | 6573 | 0.93 | |
| 7 | 9 | 11 | 13 | | | 12 | 2 | | | 11 | | | | 2 | 6344 | 60 | 6284 | 0.94 | |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6289 | 48 | 6205 | 0.76 | |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 4835 | 48 | 4787 | 0.99 | |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6078 | 72 | 6006 | 1.18 | |
| Ttl. | 104 | 102 | 103 | 93 | 32 | 23 | 2 | 31 | 40 | 11 | | | 16 | 22 | 18 | 62356 | 708 | 61648 | 1.14 |

3.2.20 Cutting inspection report (Day 20)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|-----------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 8 | 9 | 3 | | | | 8 | | | | | 4 | | 4 | 4930 | 36 | 4894 | 0.73 |
| 2 | 8 | 8 | 10 | | 6 | | | | 4 | | | | | | 5290 | 36 | 5254 | 0.68 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6130 | 84 | 6046 | 1.37 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6256 | 72 | 6184 | 1.15 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5910 | 36 | 5874 | 0.60 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 4970 | 36 | 4934 | 0.72 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6747 | 72 | 6675 | 1.06 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5674 | 48 | 6526 | 0.84 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 5973 | 48 | 5925 | 0.80 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6360 | 72 | 6288 | 1.13 |
| Ttl. | 99 | 89 | 90 | 87 | 52 | | 8 | 7 | 37 | 4 | | 12 | 5 | 38 | 58240 | 540 | 57700 | 0.93 |

3.2.21 Cutting inspection report (Day 21)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------|------|---------------|--------------|----------------|----------------|---------------|------|--------------|---------|-------------|------------|--------|--------------|---------------|--------------|--------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 11 | 11 | 13 | 8 | | | | 6 | 11 | | | | 1 | | 5869 | 60 | 5909 | 1.02 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6038 | 84 | 5854 | 0.79 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6839 | 84 | 6755 | 1.22 |
| 4 | 9 | 15 | 12 | 7 | | | | 5 | 9 | | | | 3 | | 6354 | 60 | 6294 | 0.944 |
| 5 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5910 | 48 | 5862 | 0.81 |
| 6 | 9 | 9 | 4 | 8 | | | | | | | | | 6 | | 4870 | 36 | 4814 | 0.73 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6289 | 48 | 6241 | 0.76 |
| 9 | 13 | 12 | 10 | 14 | | 10 | | 7 | 10 | | | | 7 | | 6435 | 96 | 6339 | 1.49 |
| 10 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6578 | 96 | 6483 | 1.45 |
| Ttl. | 115 | 105 | 98 | 97 | 32 | 21 | | 38 | 50 | | | 16 | 29 | 15 | 61404 | 684 | 60720 | 1.11 |

3.2.22 Cutting inspection report (Day 22)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|-----------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 9 | 11 | 13 | | | 12 | 2 | | 11 | | | | | 2 | 5783 | 60 | 5723 | 1.03 |
| 2 | 8 | 7 | | 8 | | | 9 | | 5 | | | 7 | | 4 | 5847 | 48 | 5799 | 0.82 |
| 3 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6686 | 72 | 6614 | 1.07 |
| 4 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6443 | 72 | 6371 | 1.11 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4910 | 36 | 4874 | 0.68 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5270 | 36 | 5234 | 0.68 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6189 | 48 | 6141 | 0.77 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 6035 | 48 | 5987 | 0.79 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6578 | 72 | 6906 | 1.94 |
| Ttl. | 98 | 99 | 85 | 96 | 42 | 12 | 11 | | 53 | 11 | | 7 | | 49 | 60063 | 564 | 59499 | 0.94 |

3.2.23 Cutting inspection report (Day 23)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|-----------|-----------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6748 | 96 | 6652 | 1.42 |
| 2 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 4865 | 36 | 4829 | 0.72 |
| 3 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5037 | 36 | 5001 | 0.71 |
| 4 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | 9 | | 5843 | 72 | 5771 | 1.23 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 5910 | 36 | 5874 | 0.60 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5670 | 36 | 5634 | 0.63 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | 9 | | 6322 | 72 | 6250 | 1.13 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5889 | 48 | 5841 | 0.81 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | 7 | | 5735 | 48 | 5687 | 0.83 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | 9 | | 6578 | 72 | 6506 | 1.94 |
| Ttl. | 116 | 96 | 93 | 100 | 44 | 11 | | 6 | 50 | | | | 8 | 34 | 58597 | 552 | 58045 | 0.94 |

3.2.24 Cutting inspection report (Day 24)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6530 | 96 | 5434 | 1.47 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6290 | 84 | 6206 | 1.33 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 5637 | 84 | 5553 | 1.49 |
| 4 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 5736 | 72 | 5664 | 1.25 |
| 5 | 9 | 9 | 10 | 12 | 8 | | 12 | | | | 6 | | | 6 | 6736 | 72 | 6664 | 1.06 |
| 6 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4833 | 36 | 4797 | 0.744 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 6289 | 48 | 6241 | 0.76 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | 7 | | 6435 | 48 | 6387 | 0.74 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6578 | 72 | 6506 | 1.94 |
| Ttl. | 111 | 108 | 104 | 117 | 41 | 11 | 12 | 20 | 44 | | 6 | 16 | 18 | 40 | 61286 | 684 | 61970 | 1.12 |

3.2.25 Cutting inspection report (Day 25)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|----------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6730 | 96 | 6634 | 1.42 |
| 2 | 10 | 14 | 14 | 13 | 12 | | | 7 | | | | 8 | 5 | | 6390 | 84 | 6306 | 1.31 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6530 | 84 | 6446 | 1.28 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6256 | 72 | 6184 | 1.15 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4910 | 36 | 4874 | 0.73 |
| 6 | 5 | 8 | 9 | 7 | 5 | | | | 2 | | | | | | 5670 | 36 | 5637 | 0.63 |
| 7 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6322 | 72 | 6250 | 1.13 |
| 8 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6749 | 96 | 6653 | 1.42 |
| 9 | 13 | 12 | 12 | 12 | | 11 | | 6 | 7 | | 2 | | 6 | 2 | 6847 | 96 | 6751 | 1.40 |
| 10 | 8 | 10 | 8 | 13 | | | | | | | | | | 2 | 5168 | 48 | 5120 | 0.92 |
| Ttl. | 109 | 108 | 108 | 109 | 50 | 33 | | 32 | 41 | | 2 | 16 | 31 | 22 | 61572 | 720 | 60852 | 1.17 |

3.2.26 Cutting inspection report (Day 26)

| Hrs. | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-------------|--------------|------------|------------|---------------|--------------|----------------|----------------|---------------|-----------|--------------|---------|-------------|------------|-----------|--------------|---------------|--------------|-------------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 9 | 11 | 13 | | | 12 | 2 | | | 11 | | | | 2 | 6006 | 60 | 5946 | 0.99 |
| 2 | 11 | 12 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6468 | 72 | 6396 | 1.11 |
| 3 | 13 | 13 | 14 | 11 | 12 | | | 7 | | | | 8 | 5 | | 6530 | 84 | 6446 | 1.28 |
| 4 | 12 | 11 | 9 | 12 | 8 | | | | 11 | | | | | 9 | 6656 | 72 | 6584 | 1.08 |
| 5 | 7 | 8 | 9 | 5 | 5 | | | | 2 | | | | | | 4910 | 36 | 4874 | 0.73 |
| 6 | 15 | 10 | 12 | 12 | | 11 | | 6 | 9 | | | | 8 | | 6799 | 96 | 6703 | 1.47 |
| 7 | 13 | 12 | 10 | 14 | | 10 | | 7 | 10 | | | | 7 | | 6879 | 96 | 6783 | 1.39 |
| 8 | 12 | 11 | 12 | 13 | | | | | | | | | | | 5289 | 48 | 5241 | 0.90 |
| 9 | 10 | 10 | 8 | 13 | | | | | | | | | | 7 | 5335 | 48 | 5287 | 0.89 |
| 10 | 13 | 9 | 7 | 14 | 8 | | | | 11 | | | | | 9 | 6578 | 72 | 6506 | 1.09 |
| Ttl. | 115 | 107 | 103 | 106 | 41 | 33 | 2 | 20 | 54 | 11 | | 8 | 20 | 36 | 61460 | 681 | 60779 | 1.12 |

3.2.27 Summary of 26 days cutting inspection report:

| DAY | DEFECTS NAME | | | | | | | | | | | | | | TOTAL | | | DEFECT% |
|-----|--------------|------|------|------------|-----------|-------------|-------------|------------|------|-----------|---------|----------|---------|--------|-----------|------------|----------|---------|
| | SLUB | KNOT | HOLE | THICK YARN | MISS YARN | CREASE MARK | COLOUR SPOT | DYE DEFECT | SPOT | OIL SATIN | SHADING | INK SPOT | END OUT | OTHERS | CHECK QTY | DEFECT QTY | PASS QTY | |
| 1 | 97 | 89 | 98 | 80 | 55 | 11 | 13 | 21 | 41 | 7 | 5 | 26 | 18 | 27 | 58290 | 588 | 57702 | 1.00 |
| 2 | 85 | 108 | 102 | 91 | 50 | 13 | 23 | 18 | 37 | 10 | | 14 | 12 | 22 | 58700 | 636 | 58064 | 1.08 |
| 3 | 106 | 106 | 112 | 107 | 89 | | 13 | 23 | 31 | 14 | | 21 | 10 | 28 | 62255 | 648 | 61452 | 1.04 |
| 4 | 108 | 106 | 103 | 112 | 58 | 11 | | 20 | 46 | | | 16 | 18 | 34 | 62010 | 648 | 61452 | 1.05 |
| 5 | 103 | 108 | 99 | 115 | 86 | | 16 | 18 | 47 | 18 | | 16 | 10 | 54 | 61892 | 696 | 61196 | 1.12 |
| 6 | 111 | 108 | 118 | 103 | 79 | 3 | 8 | 34 | 15 | 19 | | 16 | 10 | 12 | 60998 | 624 | 60364 | 1.02 |
| 7 | 96 | 104 | 83 | 108 | 62 | | 8 | | 54 | 9 | | | | 53 | 60461 | 588 | 59873 | 0.97 |
| 8 | 99 | 105 | 99 | 108 | 50 | | 3 | 20 | 33 | | | 16 | 18 | 32 | 60382 | 612 | 59770 | 1.01 |
| 9 | 102 | 107 | 101 | 99 | 67 | | 21 | | 52 | 17 | | | | 48 | 60360 | 615 | 58748 | 1.02 |
| 10 | 101 | 107 | 98 | 110 | 60 | | | 20 | 37 | | | 15 | 11 | 38 | 59542 | 600 | 58941 | 1.00 |
| 11 | 103 | 103 | 96 | 104 | 45 | 14 | 8 | 20 | 33 | 3 | | 18 | 18 | 30 | 60789 | 612 | 60177 | 1.00 |

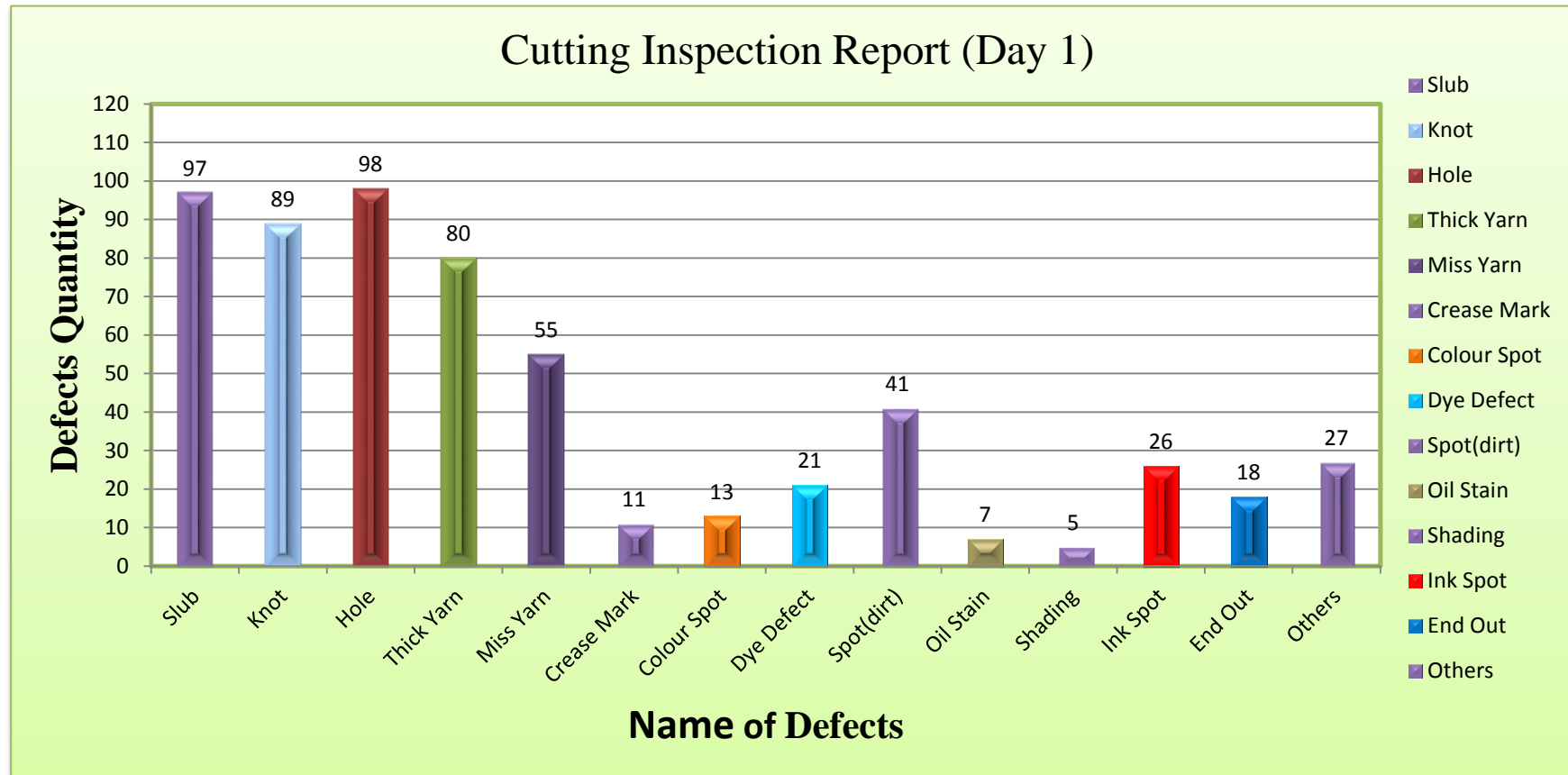
| | | | | | | | | | | | | | | | | | | |
|-------------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------------------------|--------------|----------------|-------------|
| 12 | 99 | 106 | 100 | 100 | 48 | 21 | 3 | 25 | 52 | 5 | | 19 | 24 | 20 | 60259 | 636 | 5962 | 1.06 |
| 13 | 112 | 113 | 99 | 110 | 48 | 11 | | 33 | 62 | | 6 | 16 | 24 | 34 | 63089 | 624 | 62465 | 0.99 |
| 14 | 85 | 107 | 95 | 89 | 31 | 2 | 4 | 16 | 55 | | 2 | | 7 | 23 | 56743 | 408 | 56335 | 0.72 |
| 15 | 103 | 106 | 105 | 117 | 57 | 11 | 20 | 13 | 43 | 19 | 10 | 19 | 23 | 29 | 62099 | 696 | 61403 | 1.12 |
| 16 | 86 | 103 | 86 | 75 | 34 | 19 | 16 | 29 | 52 | 2 | 1 | 13 | 11 | 28 | 58221 | 576 | 57645 | 0.99 |
| 17 | 108 | 106 | 103 | 112 | 58 | 11 | | 20 | 46 | | | 16 | 28 | 34 | 61691 | 648 | 61043 | 1.05 |
| 18 | 86 | 89 | 85 | 90 | 31 | 23 | 5 | | 33 | | 21 | 7 | 9 | 32 | 59162 | 444 | 58718 | 0.75 |
| 19 | 104 | 102 | 103 | 93 | 32 | 23 | 2 | 31 | 40 | 11 | | 16 | 22 | 18 | 62356 | 708 | 61648 | 1.14 |
| 20 | 99 | 89 | 90 | 87 | 52 | | 8 | 7 | 37 | 4 | | 12 | 5 | 38 | 58240 | 540 | 57700 | 0.93 |
| 21 | 115 | 105 | 98 | 97 | 32 | 21 | | 38 | 50 | | | 16 | 29 | 15 | 61404 | 684 | 60720 | 1.11 |
| 22 | 98 | 99 | 85 | 96 | 42 | 12 | 11 | | 53 | 11 | | 7 | | 49 | 60063 | 564 | 59499 | 0.94 |
| 23 | 116 | 96 | 93 | 100 | 44 | 11 | | 6 | 50 | | | | 8 | 34 | 58597 | 552 | 58045 | 0.94 |
| 24 | 111 | 108 | 104 | 117 | 41 | 11 | 12 | 20 | 44 | | 6 | 16 | 18 | 40 | 61286 | 684 | 61970 | 1.12 |
| 25 | 109 | 108 | 108 | 109 | 50 | 33 | | 32 | 41 | | 2 | 16 | 31 | 22 | 61572 | 720 | 60852 | 1.17 |
| 26 | 115 | 107 | 103 | 106 | 41 | 33 | 2 | 20 | 54 | 11 | | 8 | 20 | 36 | 61460 | 681 | 60779 | 1.12 |
| Ttl. | 2657 | 2695 | 2572 | 2635 | 1354 | 293 | 196 | 487 | 1139 | 163 | 53 | 339 | 355 | 846 | 1571921 | 16032 | 1555889 | 1.02 |
| Dft. % | 0.17 | 0.17 | 0.16 | 0.17 | 0.09 | 0.02 | 0.01 | 0.03 | 0.07 | 0.01 | 0.00 | 0.02 | 0.02 | 0.05 | =Defect% of each defect. | | | |

Chapter 4: Results & Discussion

4.1 Analysis data table by graph:

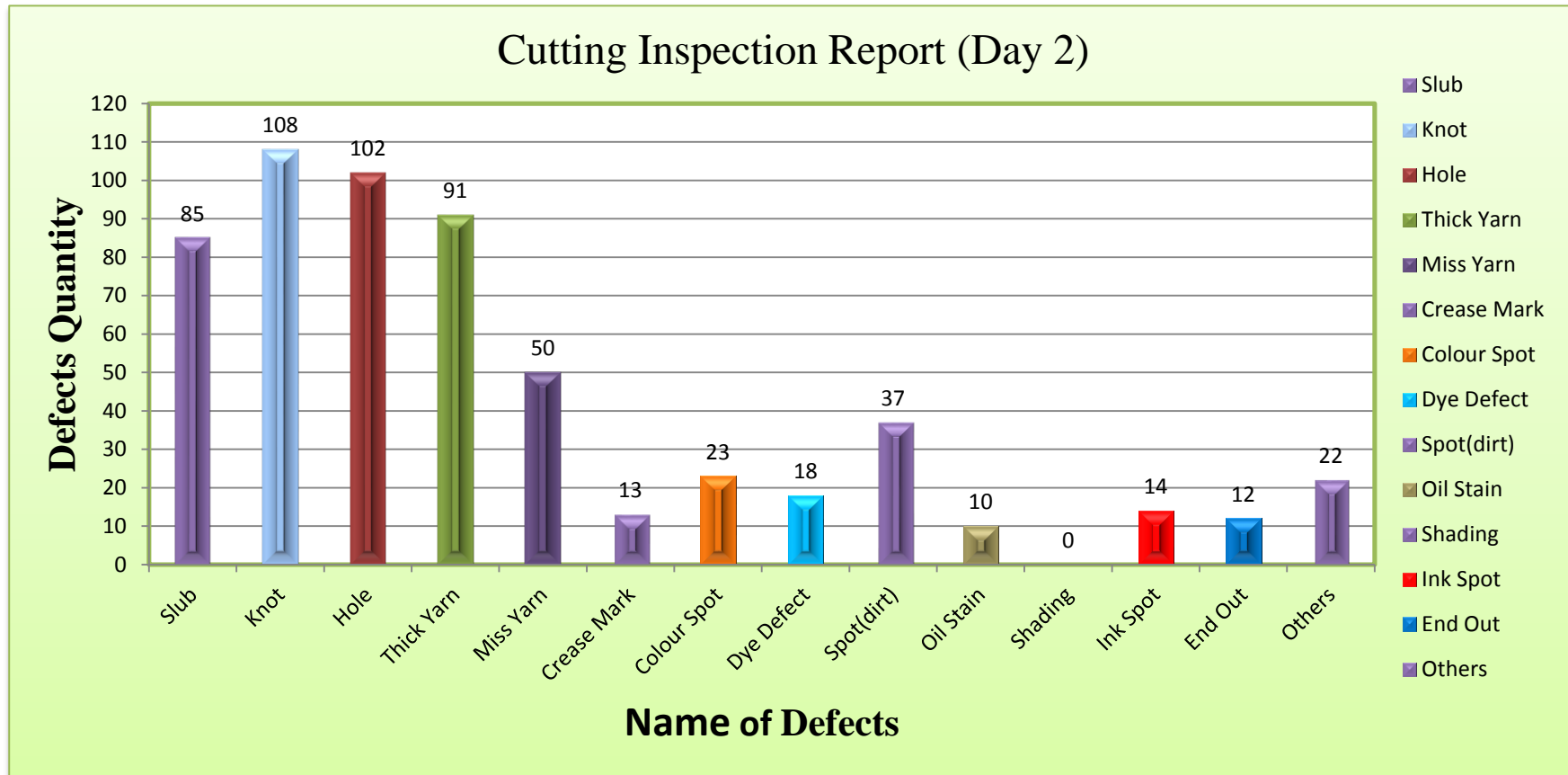
Here the others defect is “Fly yarn, Pen mark, Stop mark”

Graph-1: Cutting Inspection Report (Day 1):



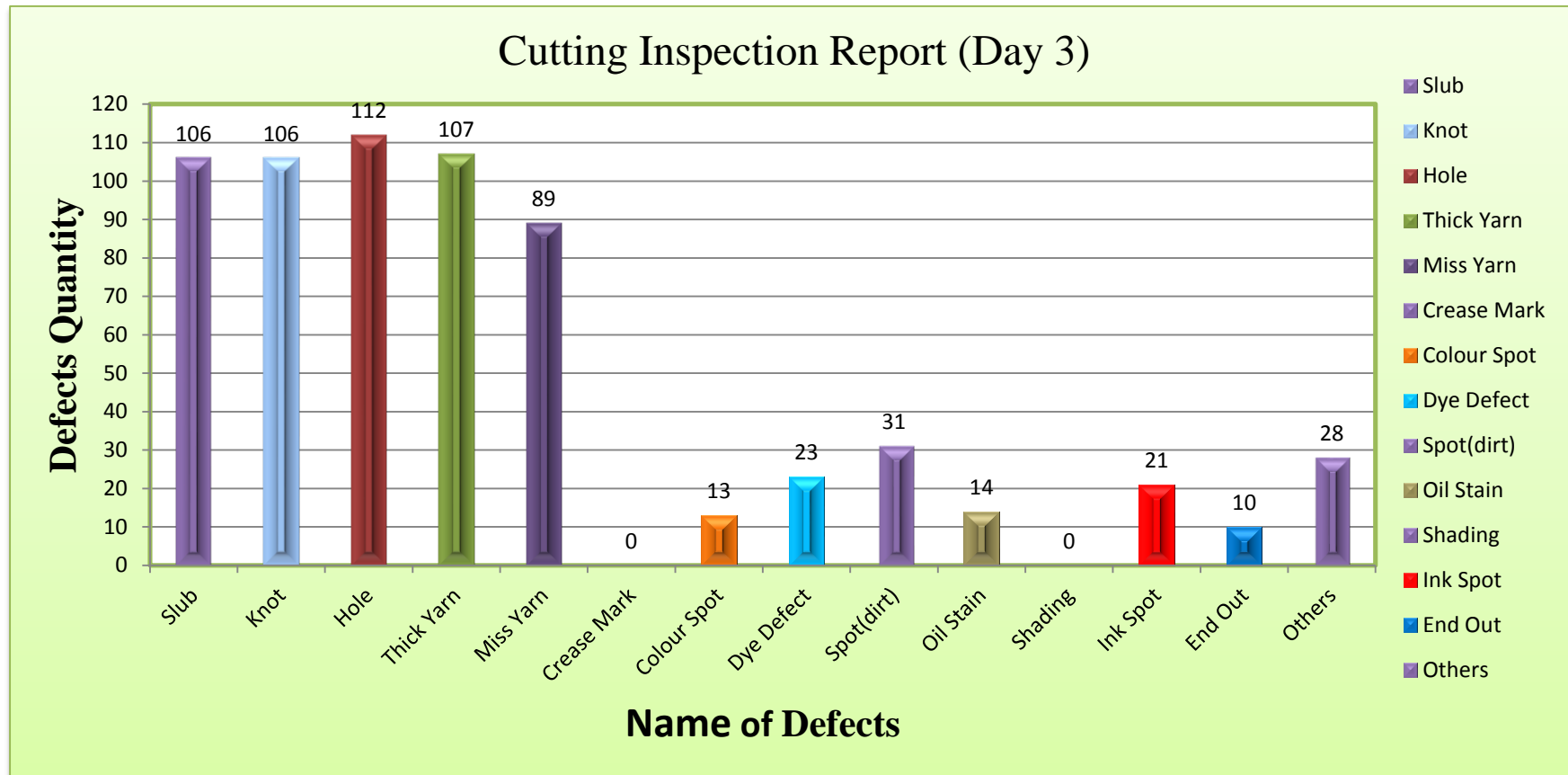
In this graph, Cutting quality report of day 1 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn.

Graph-2: Cutting Inspection Report (Day 2):



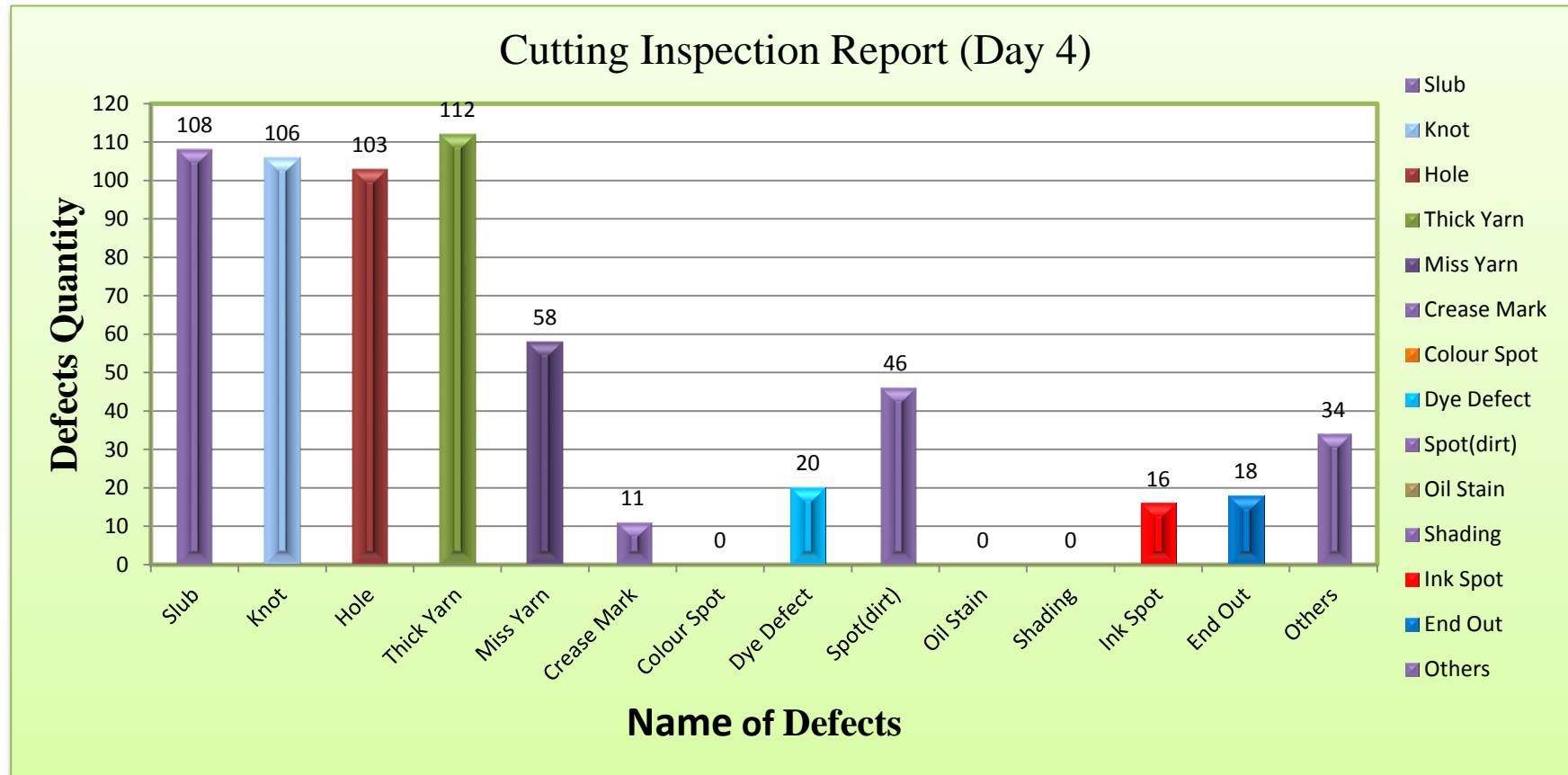
In this graph, Cutting quality report of day 2 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn. And no defect is shading.

Graph-3: Cutting Inspection Report (Day 3):



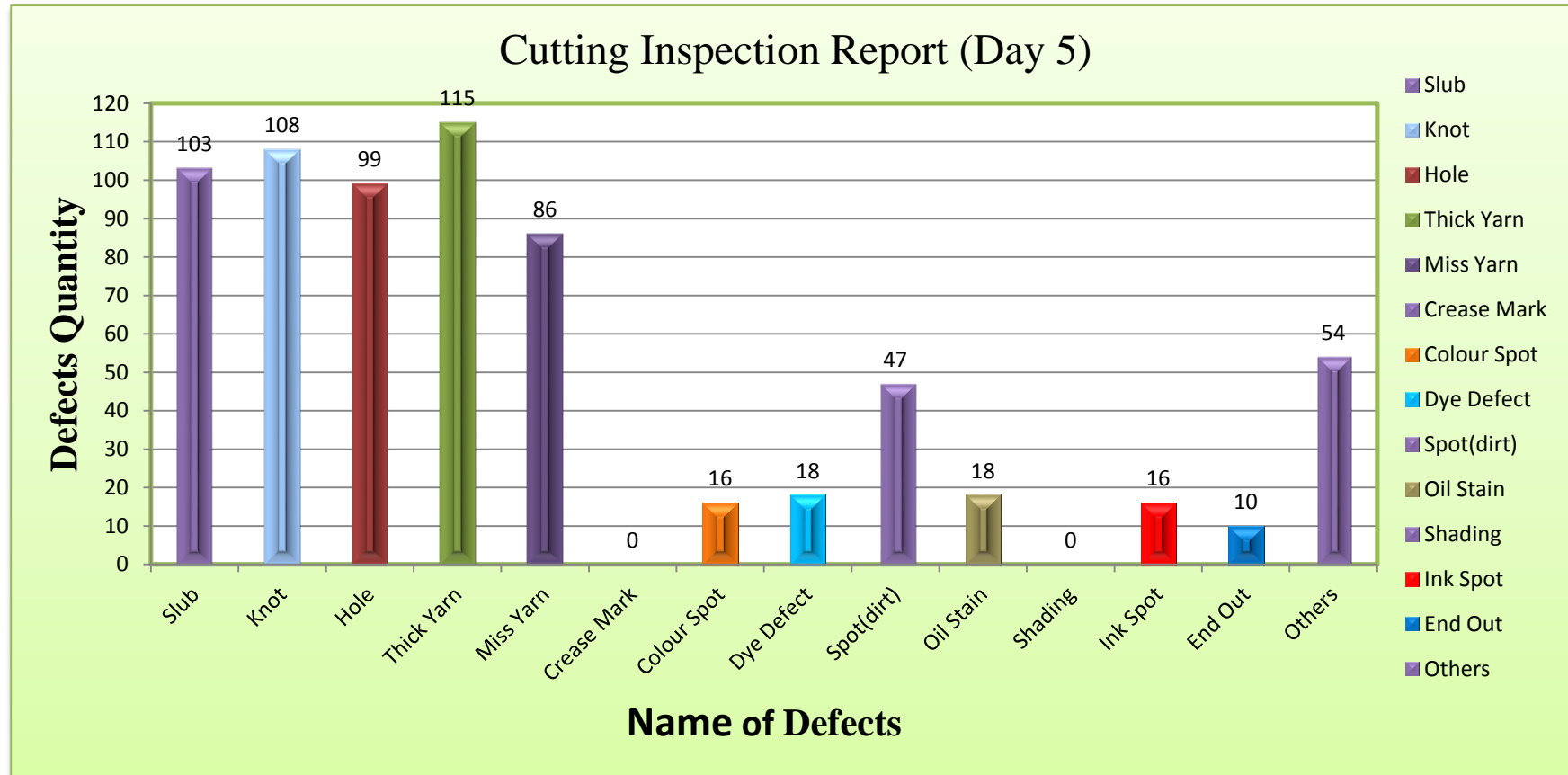
In this graph, Cutting quality report of day 3 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn. And no defect is crease mark, shading.

Graph-4: Cutting Inspection Report (Day 4):



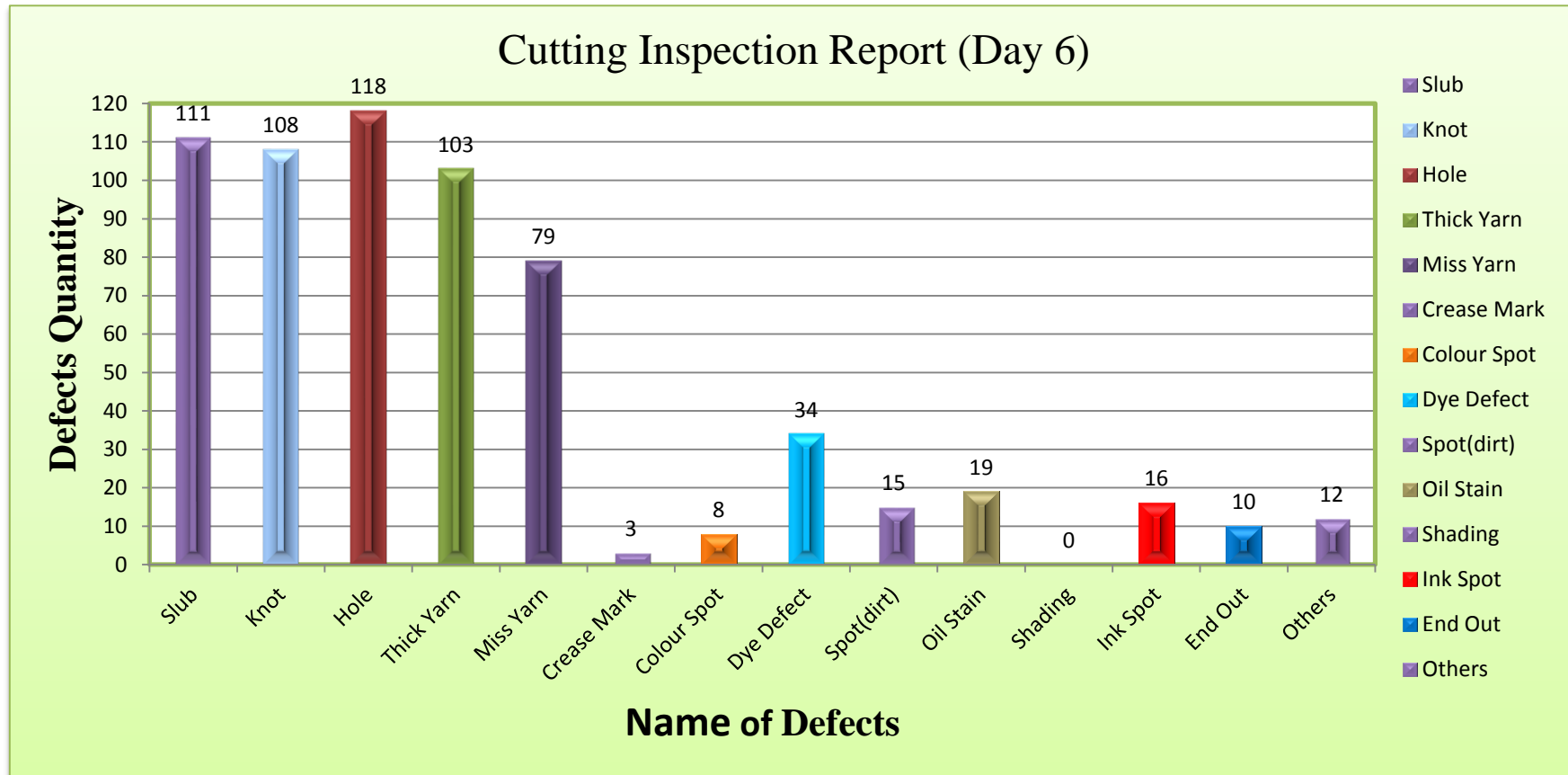
In this graph, Cutting quality report of day 4 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn and spot (dirt). And no defect is colour spot, oil stain, and shading.

Graph-5: Cutting Inspection Report (Day 5):



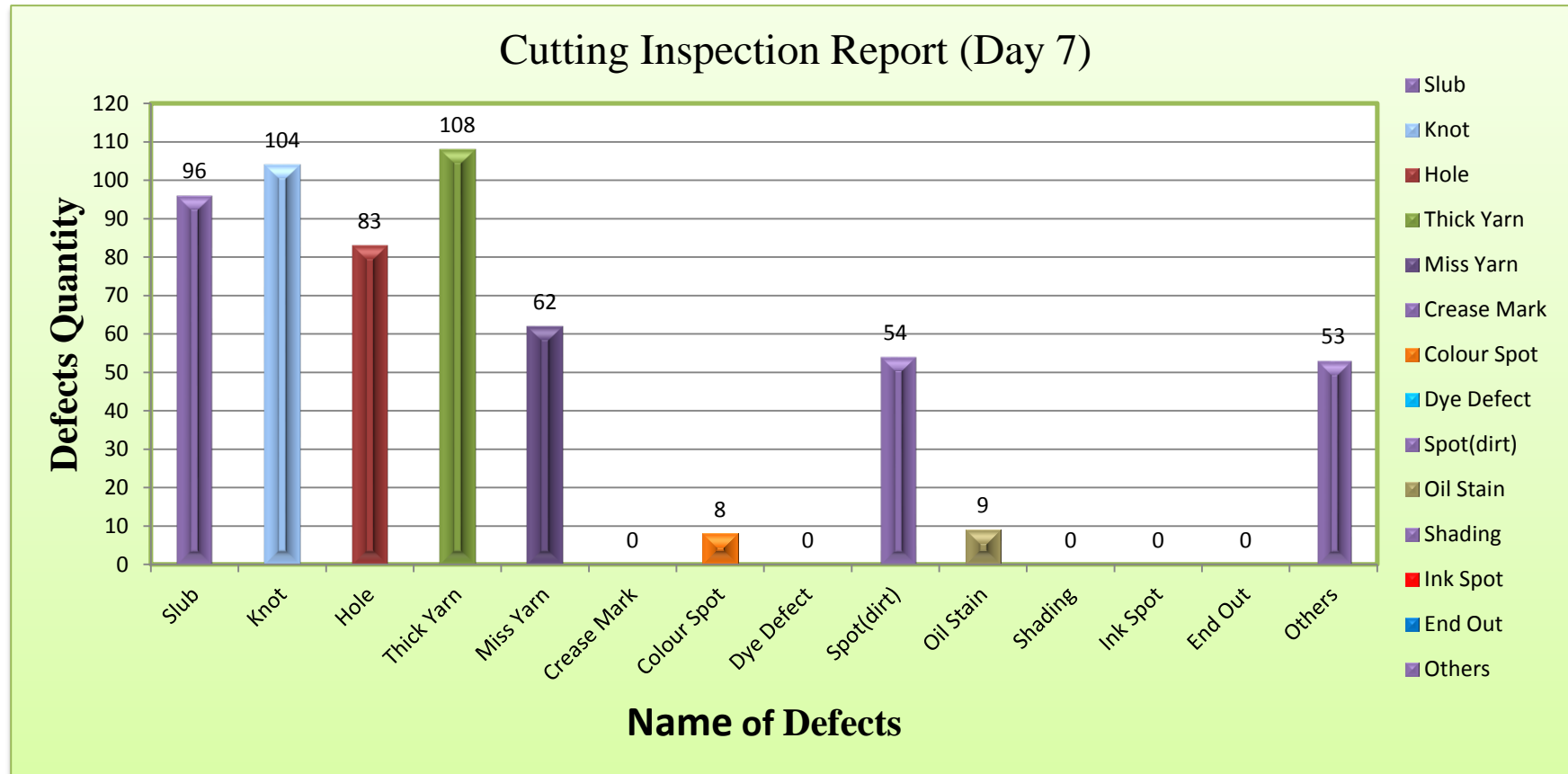
In this graph, Cutting quality report of day 5 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn, spot (dirt) and others. And no defect is crease mark, shading.

Graph-6: Cutting Inspection Report (Day 6):



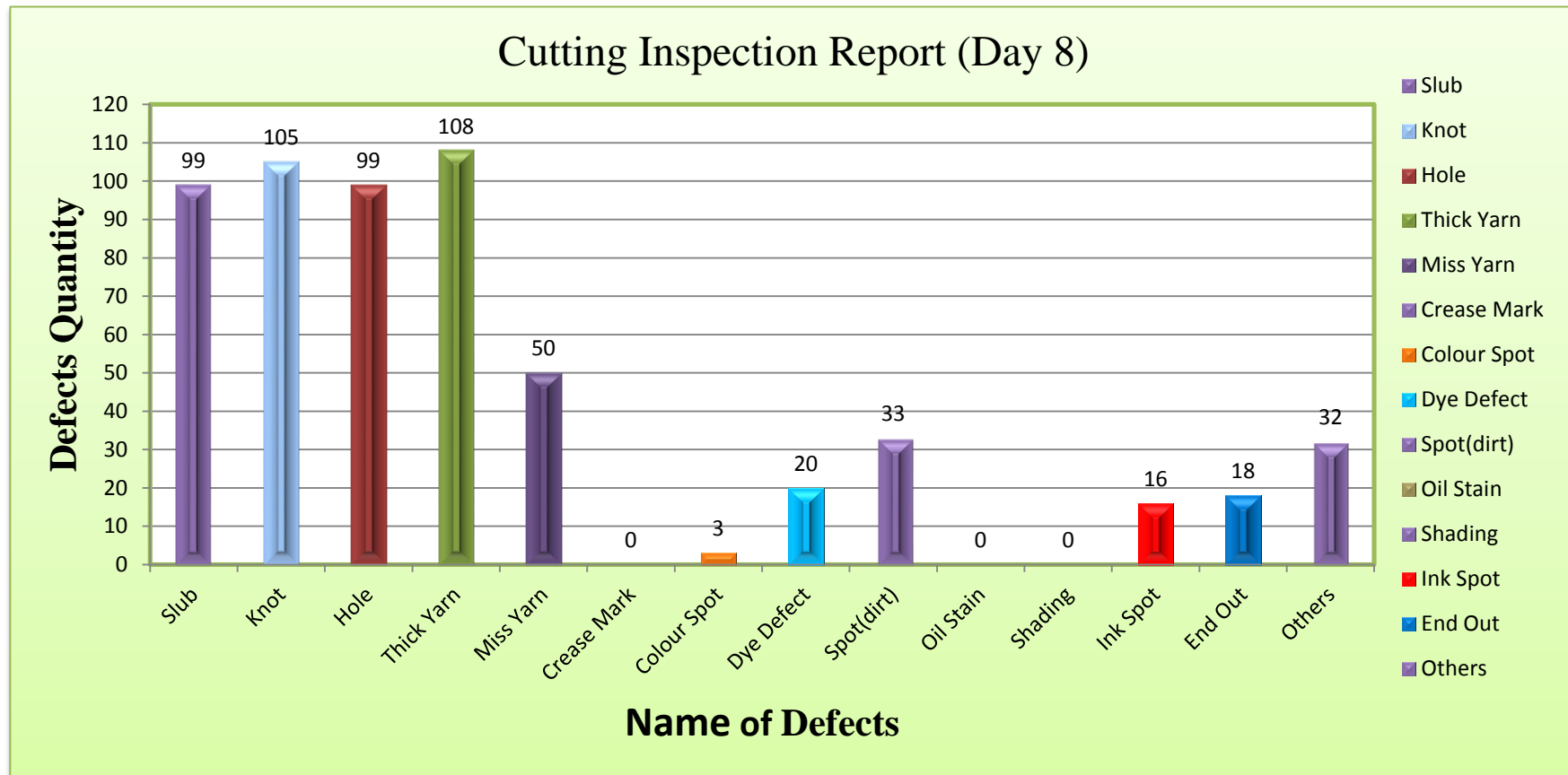
In this graph, Cutting quality report of day 6 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn and no defect is shading.

Graph-7: Cutting Inspection Report (Day 7):



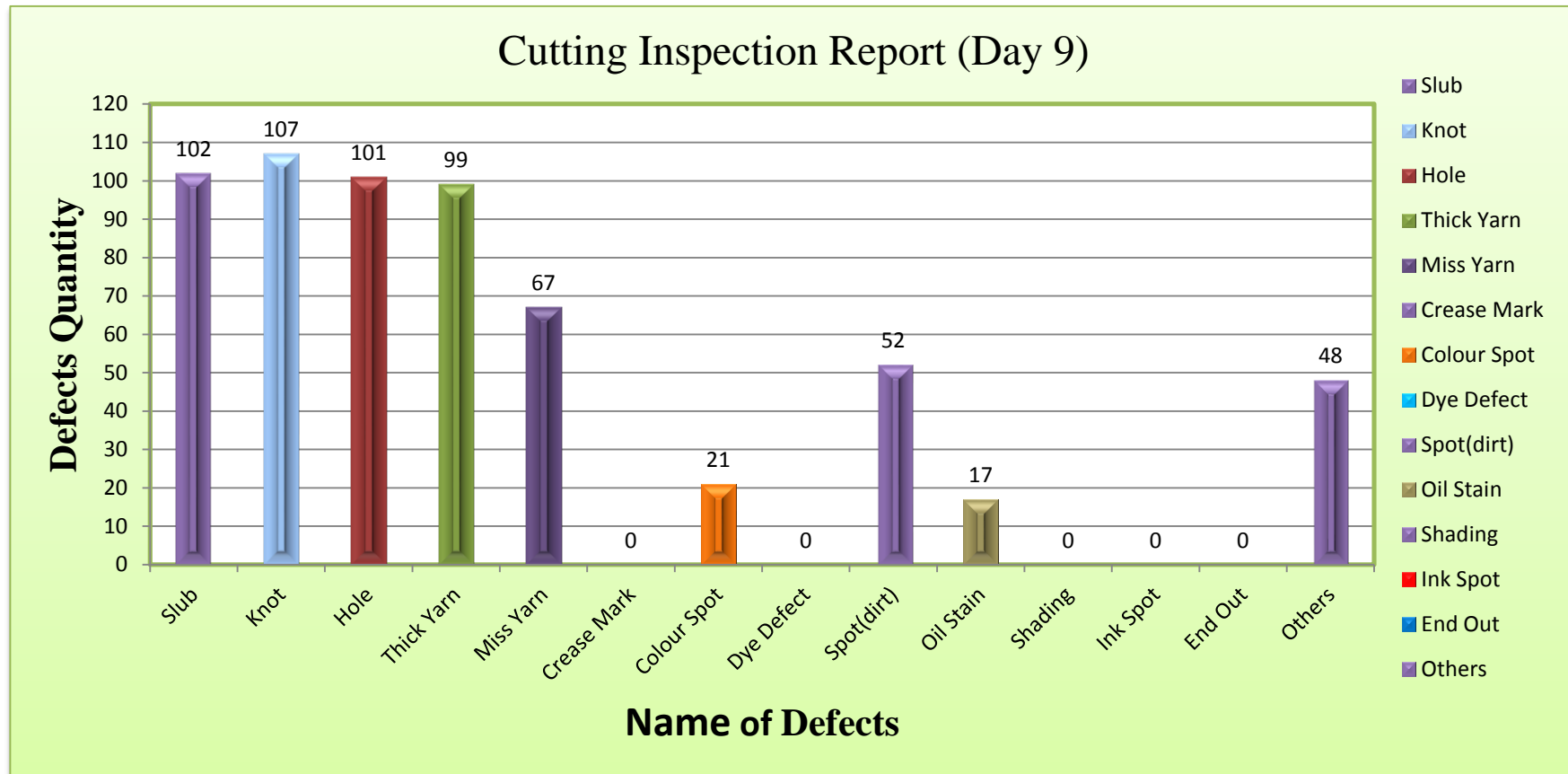
In this graph, Cutting quality report of day 7 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn and others. And no defect is crease mark, dye defect, shading, ink spot, end out.

Graph-8: Cutting Inspection Report (Day 8):



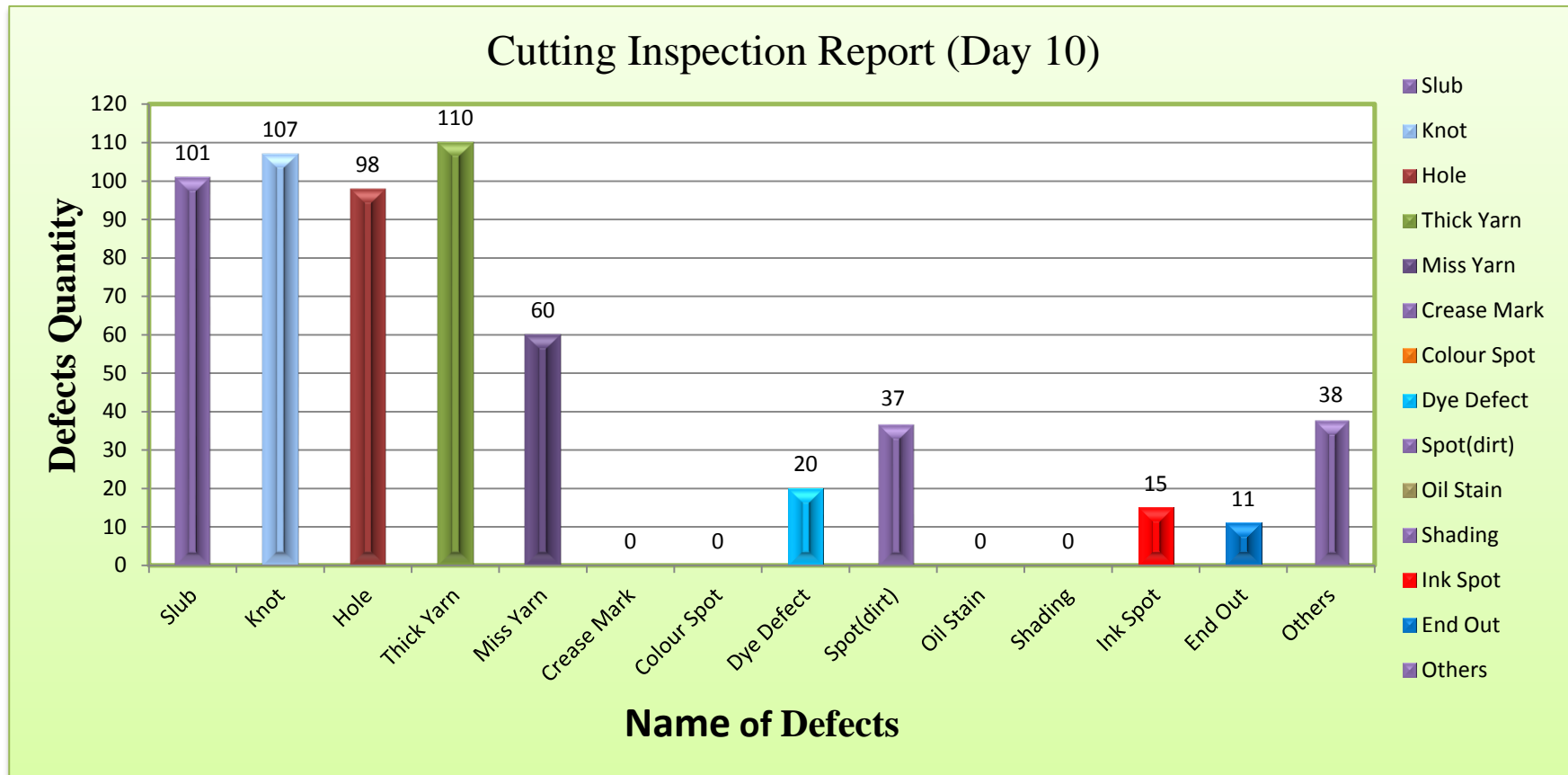
In this graph, Cutting quality report of day 8 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn and no defect is crease mark, oil stain, shading.

Graph-9: Cutting Inspection Report (Day 9):



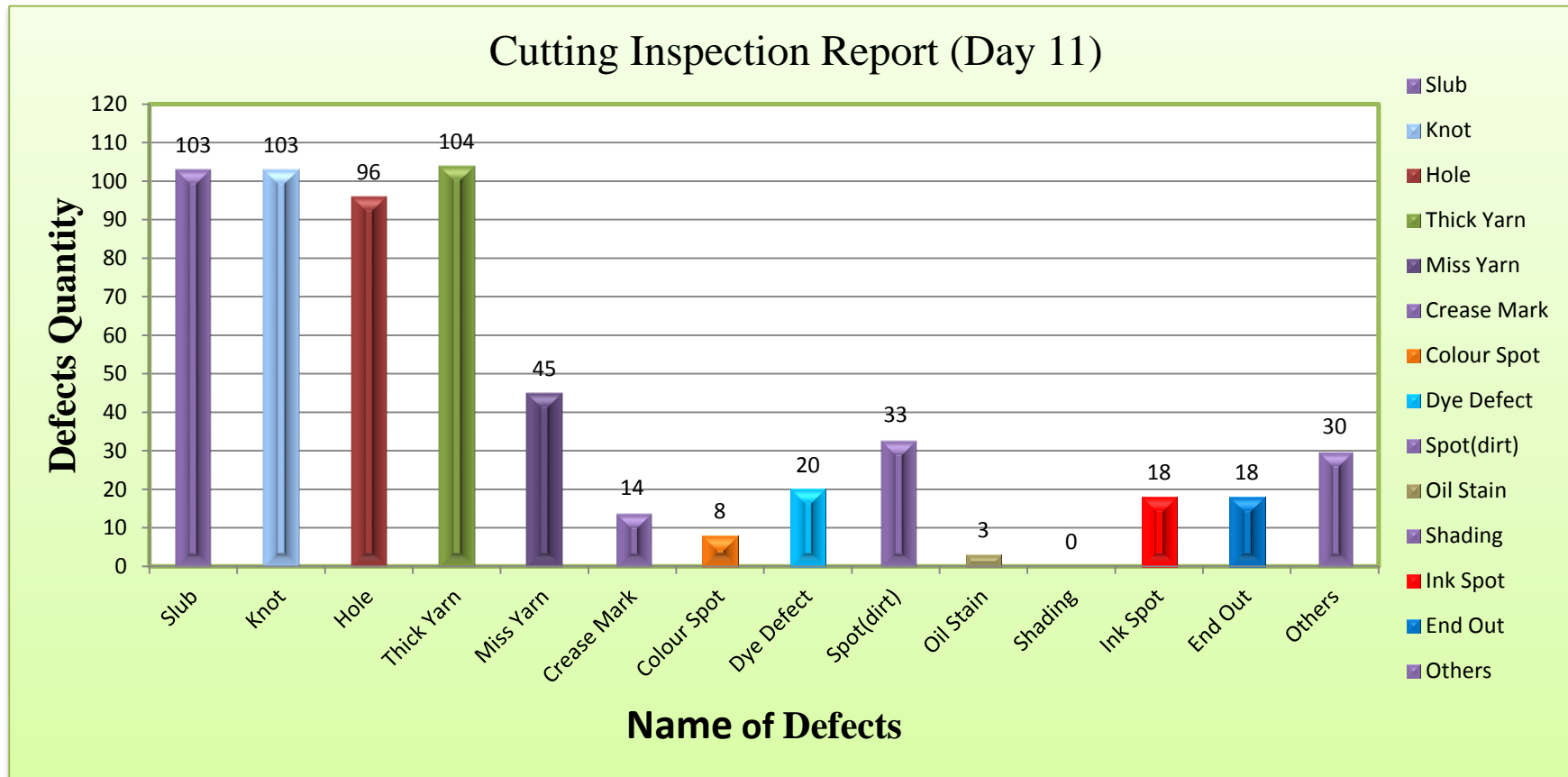
In this graph, Cutting quality report of day 9 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn and spot (dirt). And no defect is crease mark, dye defect, shading, ink spot, end out.

Graph-10: Cutting Inspection Report (Day 10):



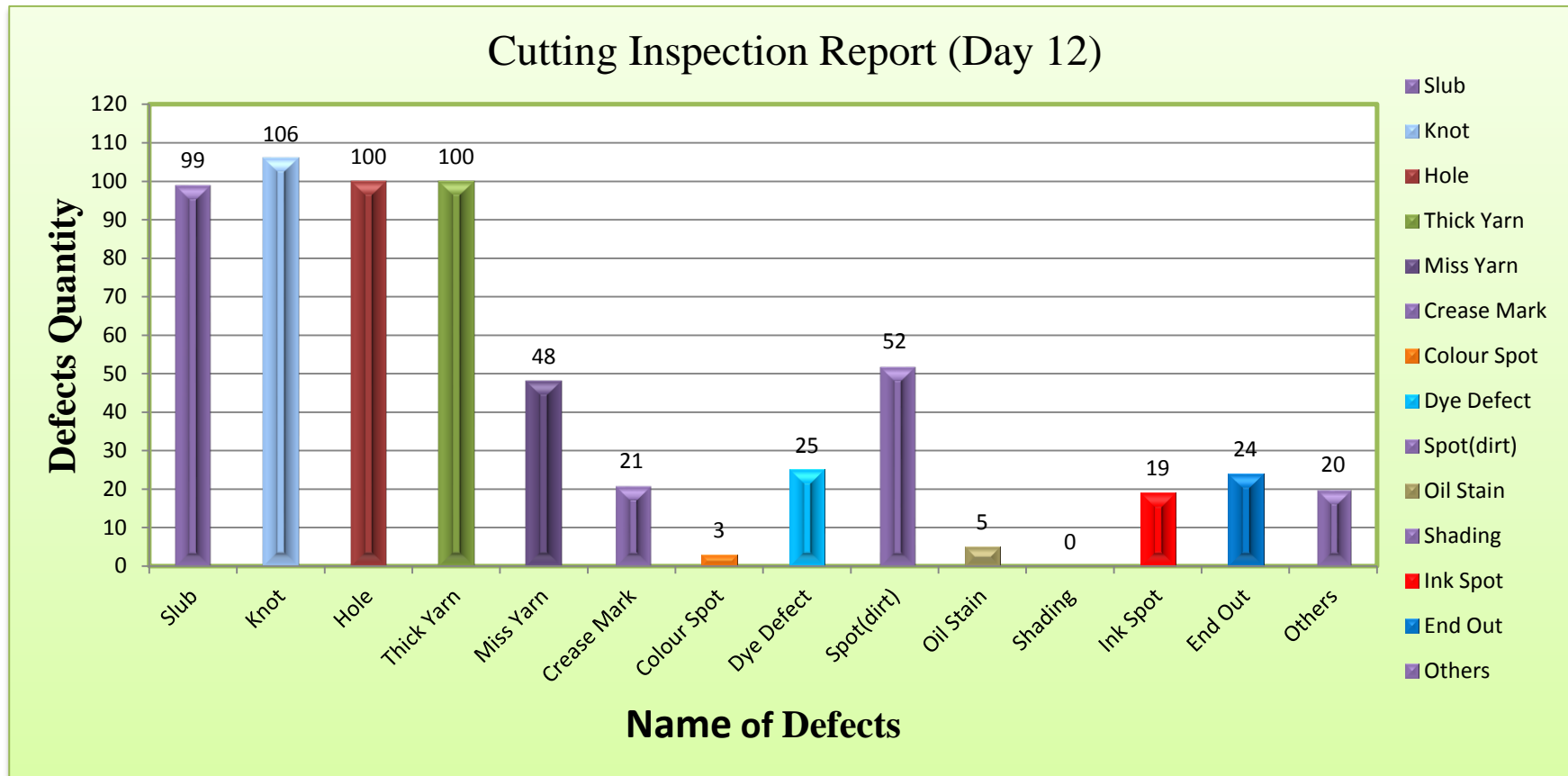
In this graph, Cutting quality report of day 10 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn and no defect is crease mark, colour spot, oil stain, shading.

Graph-11: Cutting Inspection Report (Day 11):



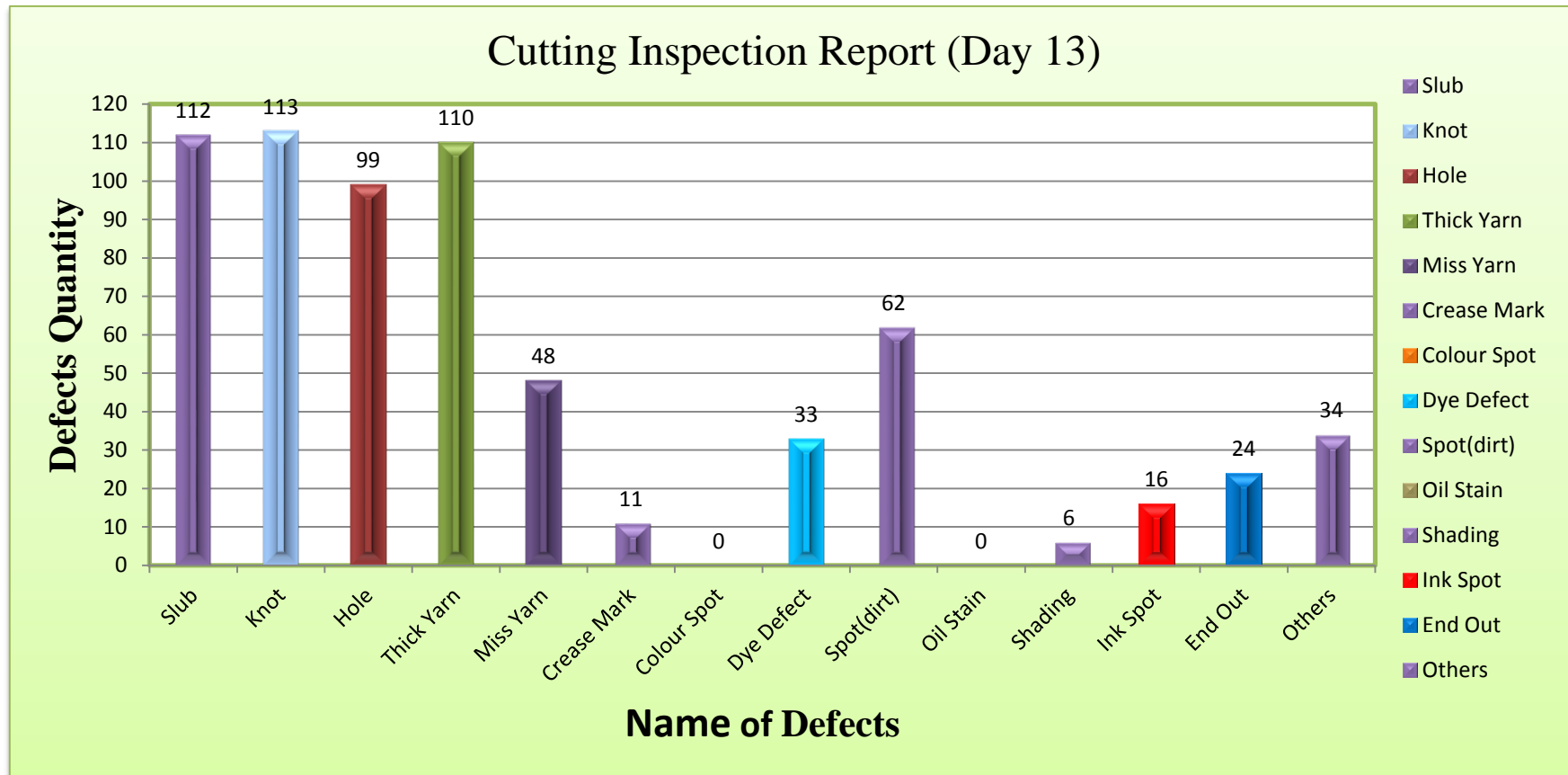
In this graph, Cutting quality report of day 11 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn and no defect is shading.

Graph-12: Cutting Inspection Report (Day 12):



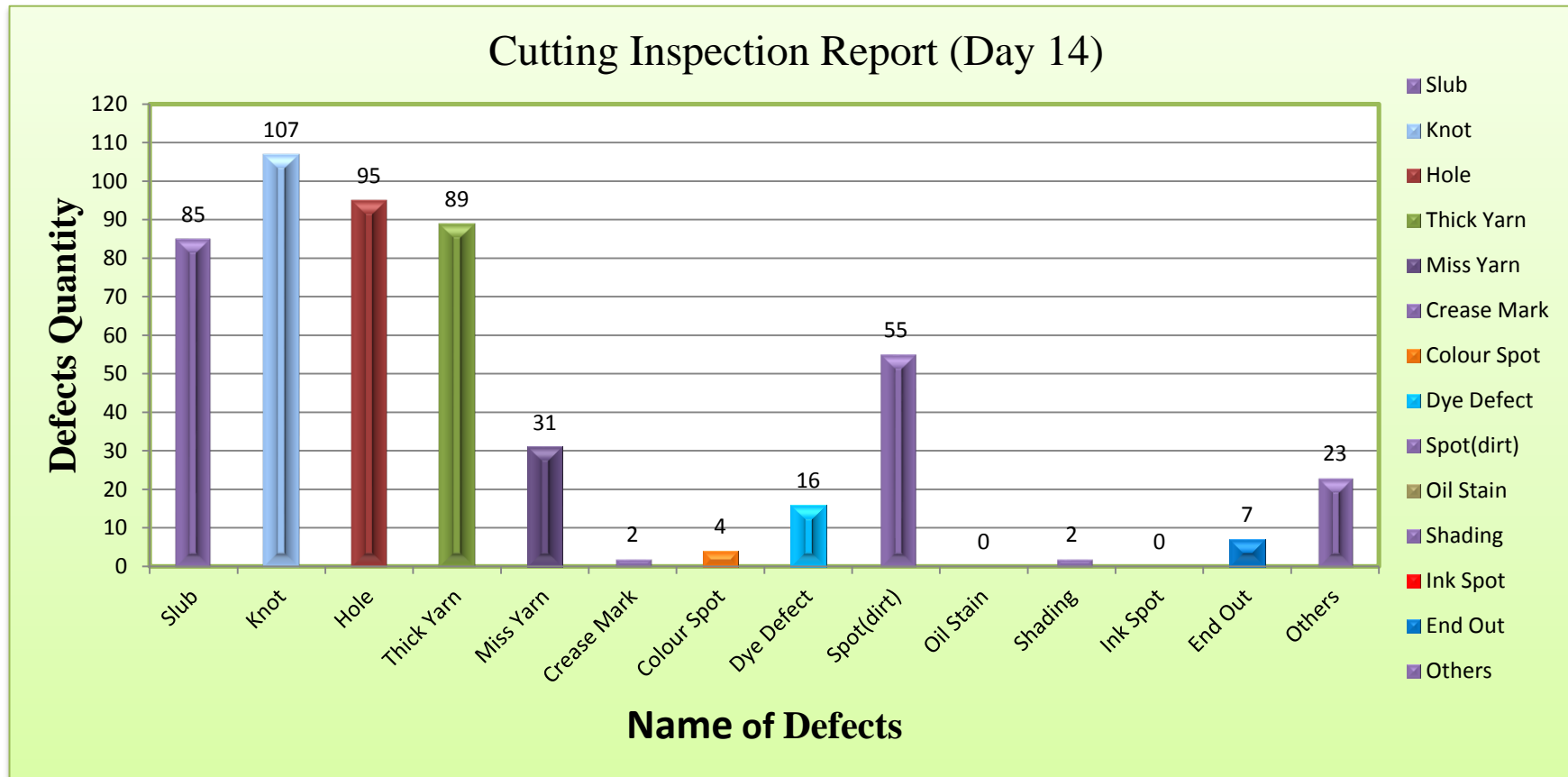
In this graph, Cutting quality report of day 12 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn, spot (dirt) and no defect is shading.

Graph-13: Cutting Inspection Report (Day 13):



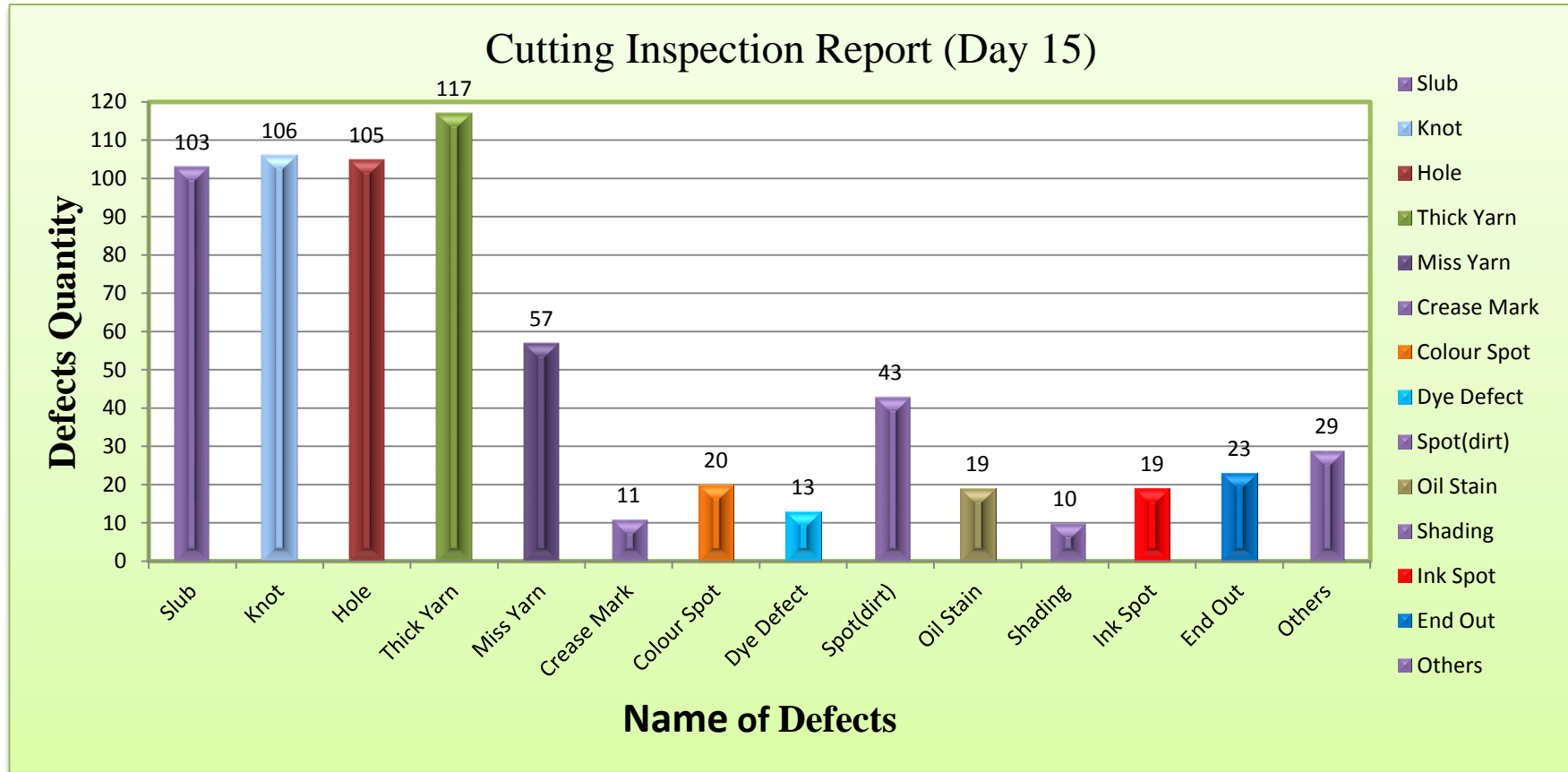
In this graph, Cutting quality report of day 13 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn, spot (dirt) and no defect is colour spot, oil stain.

Graph-14: Cutting Inspection Report (Day 14):



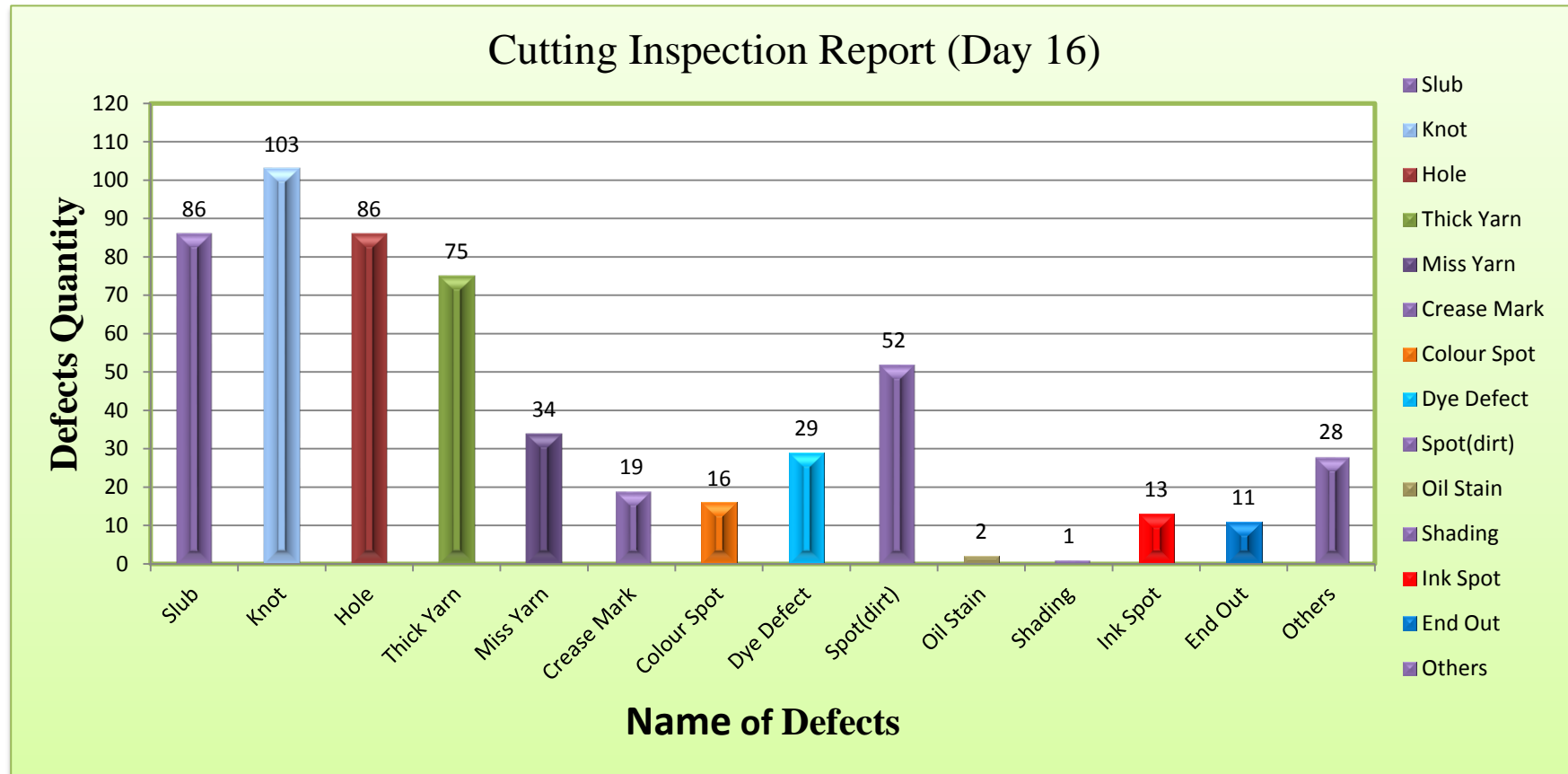
In this graph, Cutting quality report of day 14 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn, spot (dirt) and no defect is oil stain, ink spot.

Graph-15: Cutting Inspection Report (Day 15):



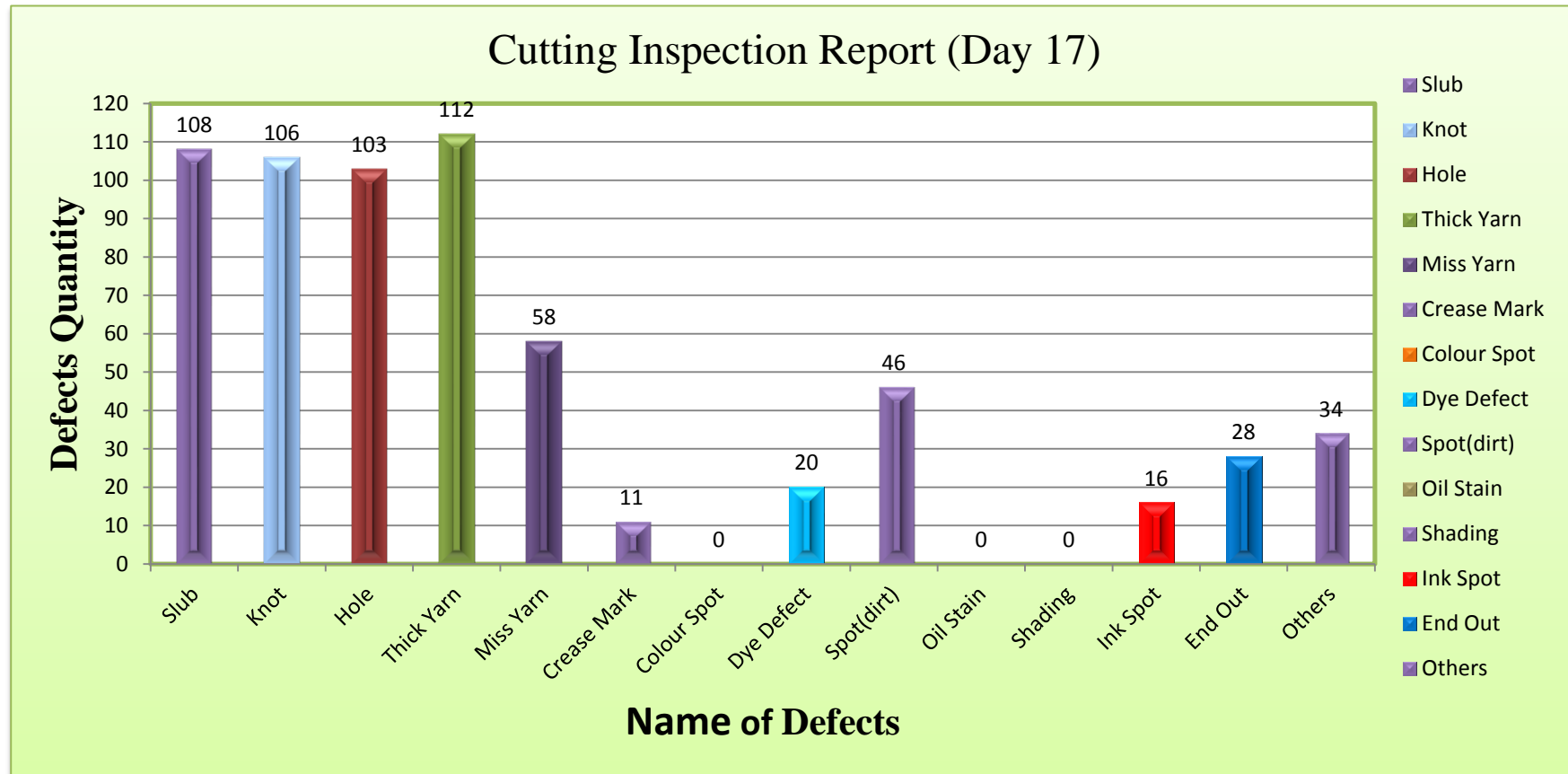
In this graph, Cutting quality report of day 15 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn.

Graph-16: Cutting Inspection Report (Day 16):



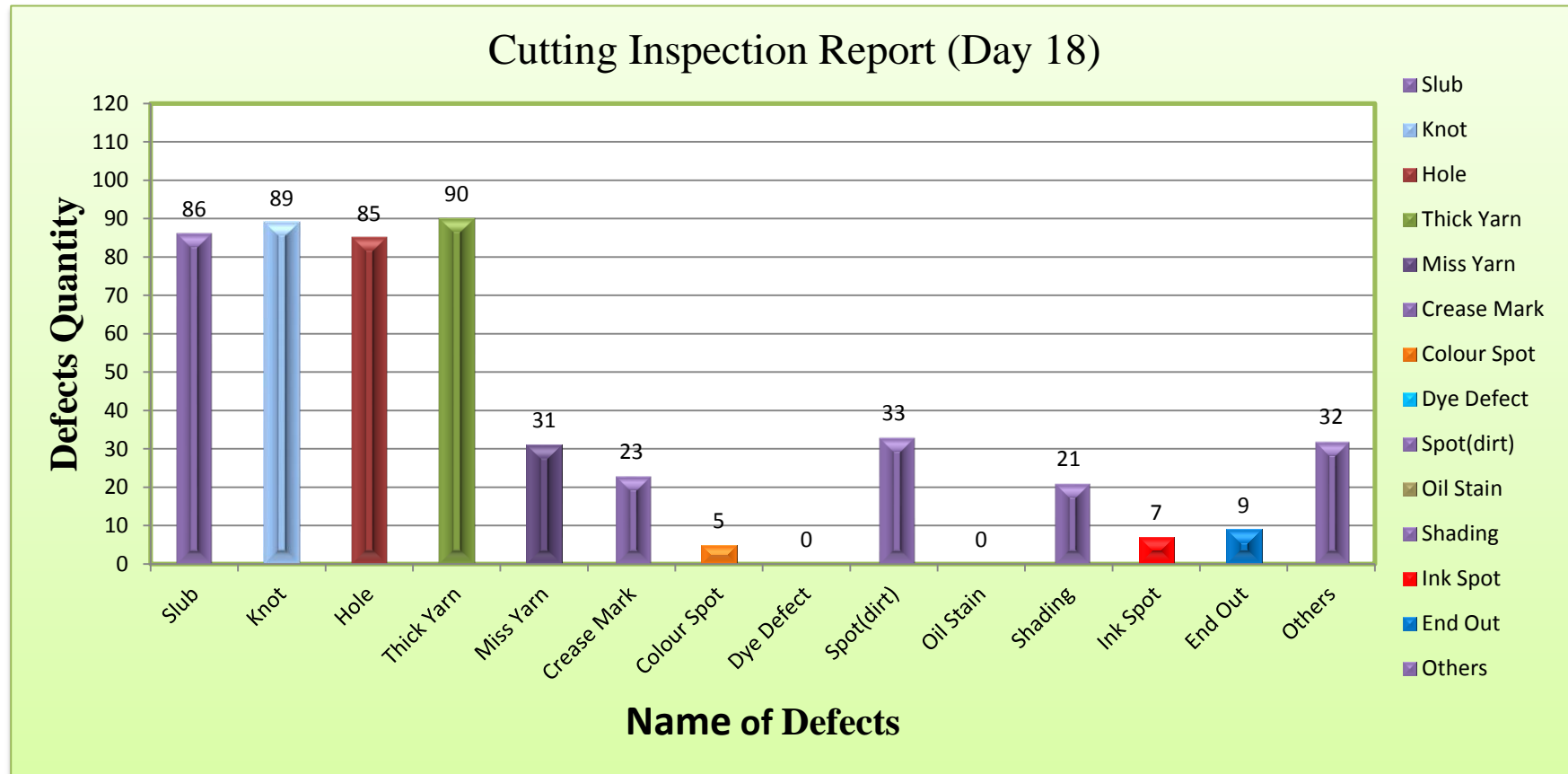
In this graph, Cutting quality report of day 16 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn, spot (dirt).

Graph-17: Cutting Inspection Report (Day 17):



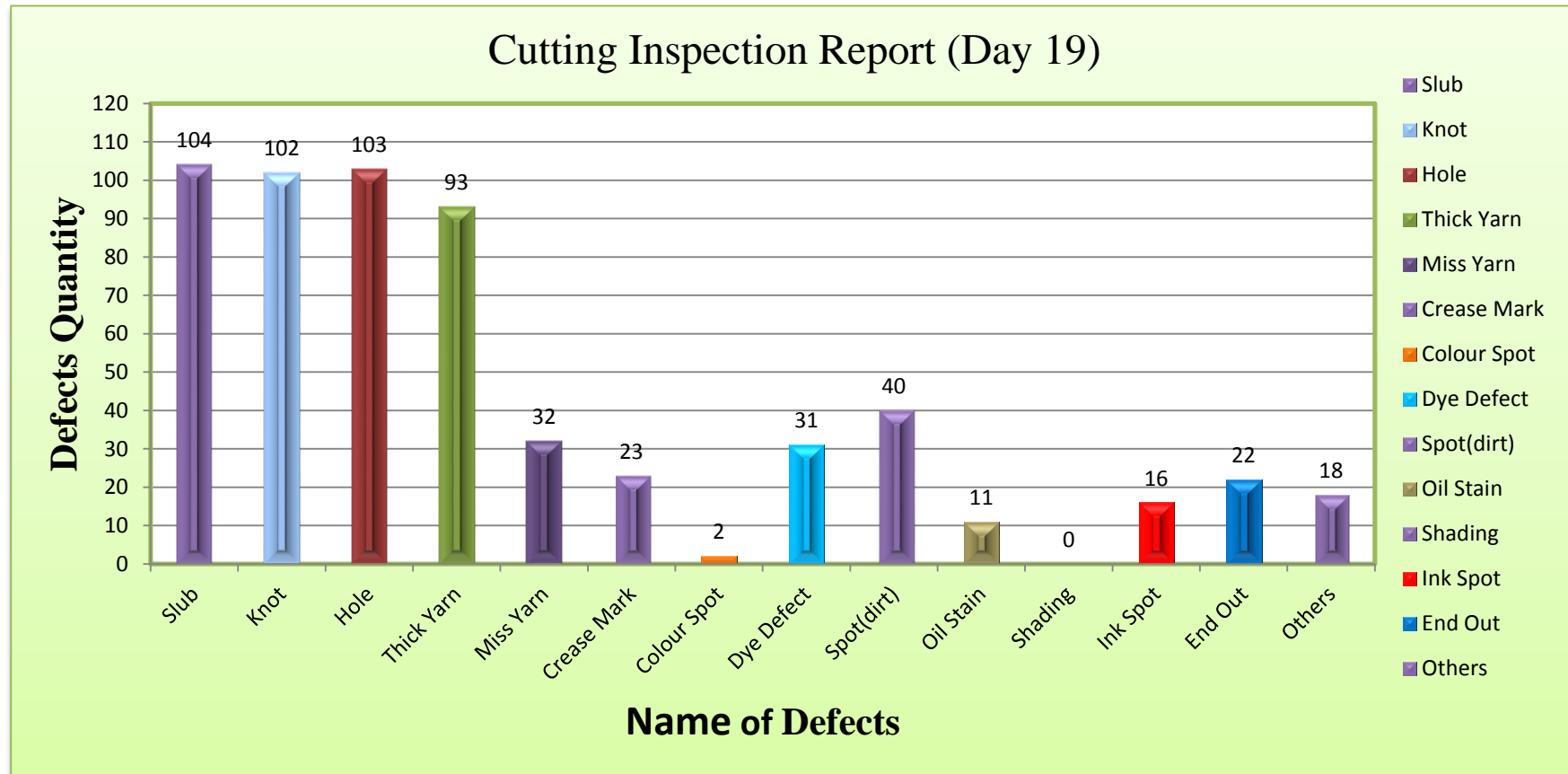
In this graph, Cutting quality report of day 17 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, Miss Yarn, spot (dirt) and no defect is colour spot, oil stain, shading.

Graph-18: Cutting Inspection Report (Day 18):



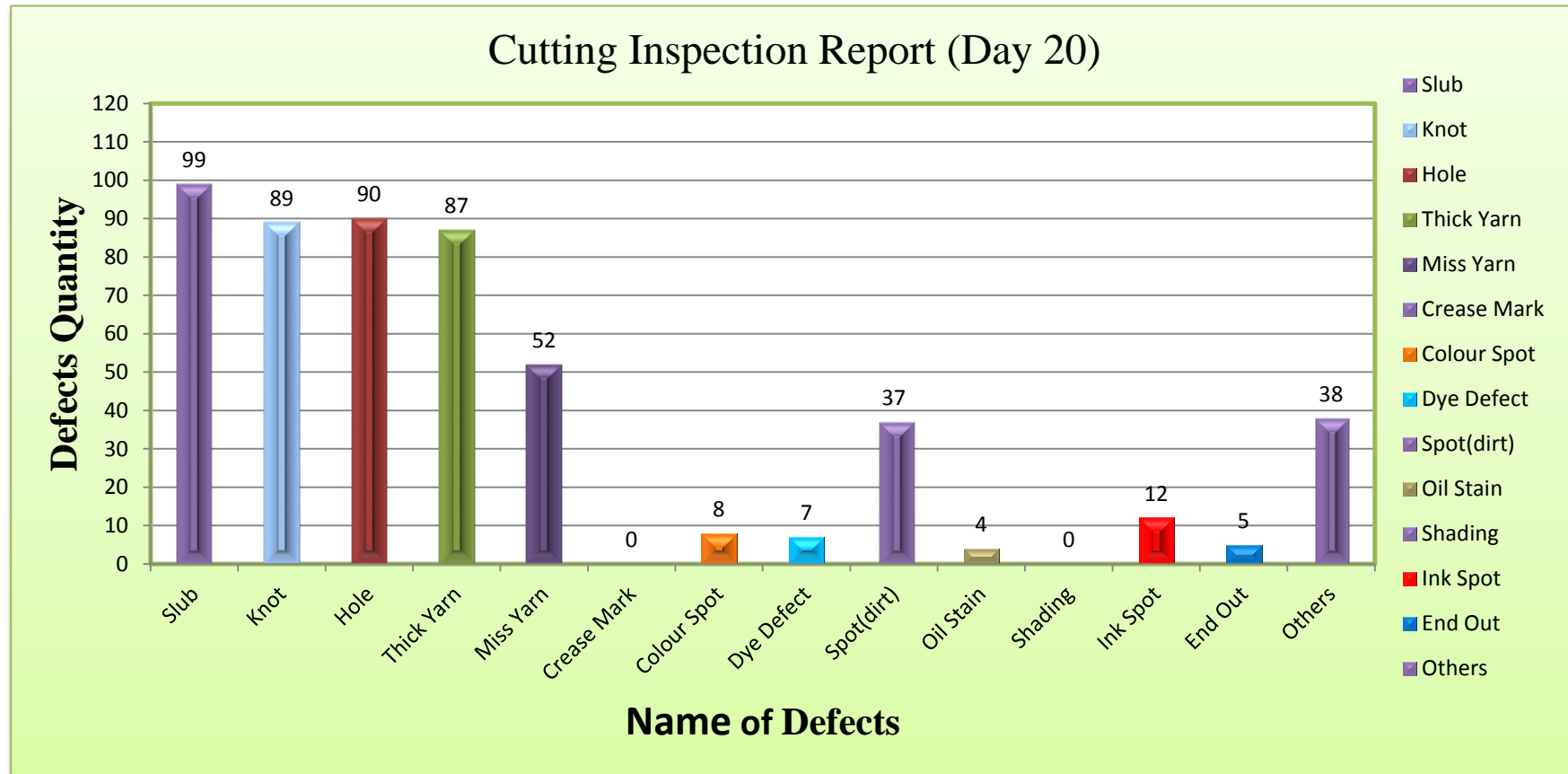
In this graph, Cutting quality report of day 18 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn. And no defect is dye defect, oil stain.

Graph-19: Cutting Inspection Report (Day 19):



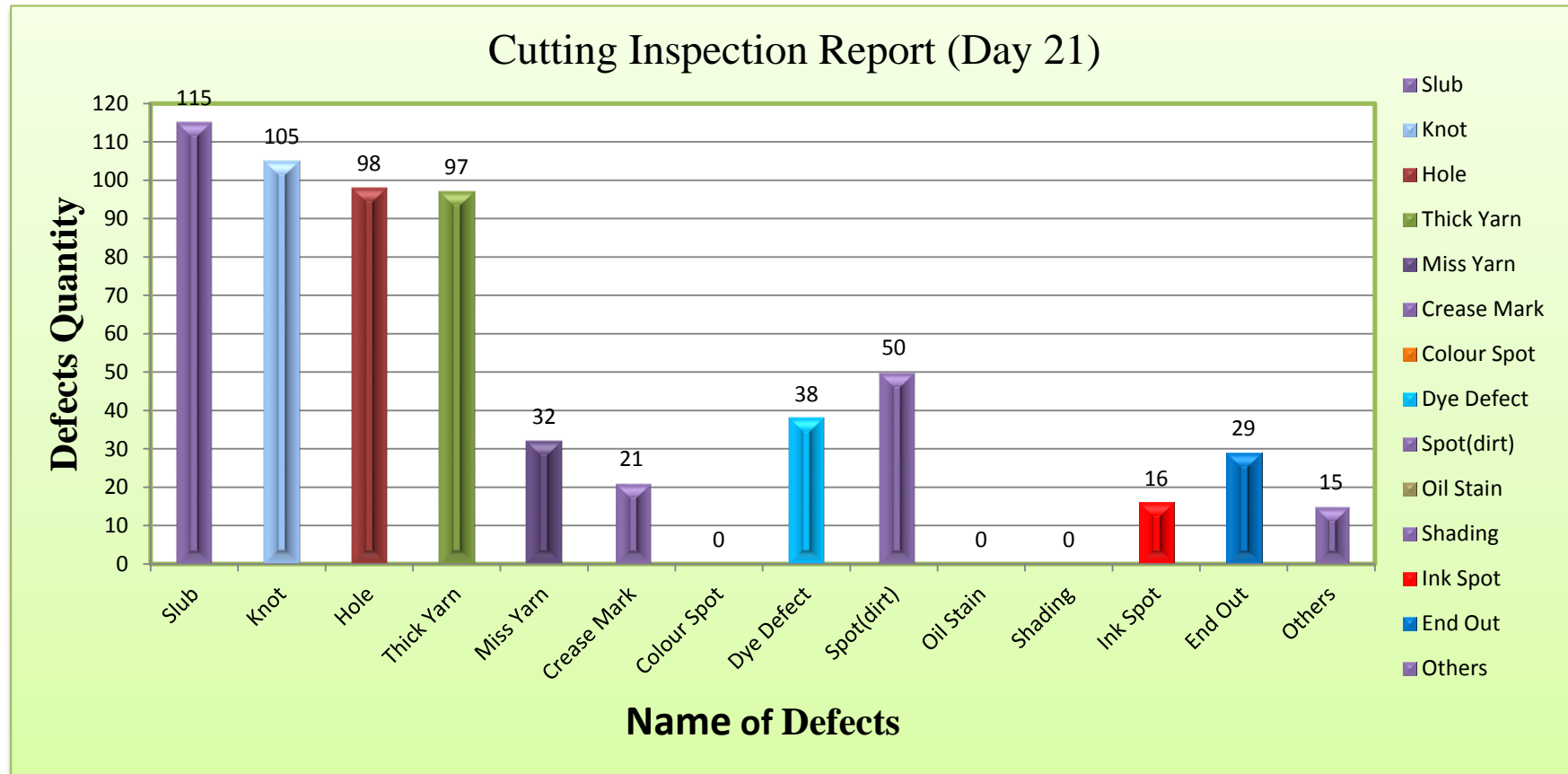
In this graph, Cutting quality report of day 19 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and no defect is shading.

Graph-20: Cutting Inspection Report (Day 20):



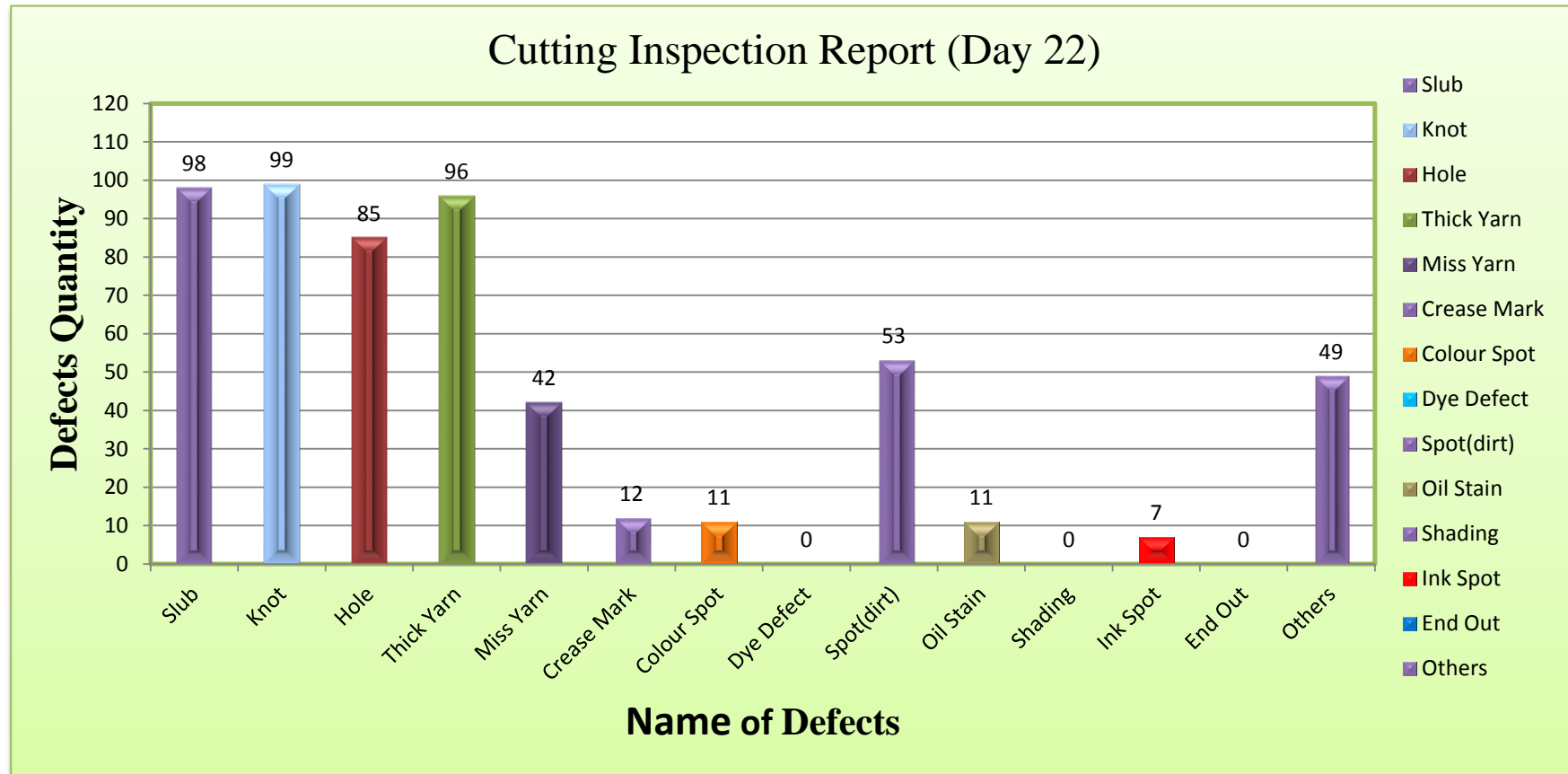
In this graph, Cutting quality report of day 20 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn and no defect is crease mark, shading.

Graph-21: Cutting Inspection Report (Day 21):



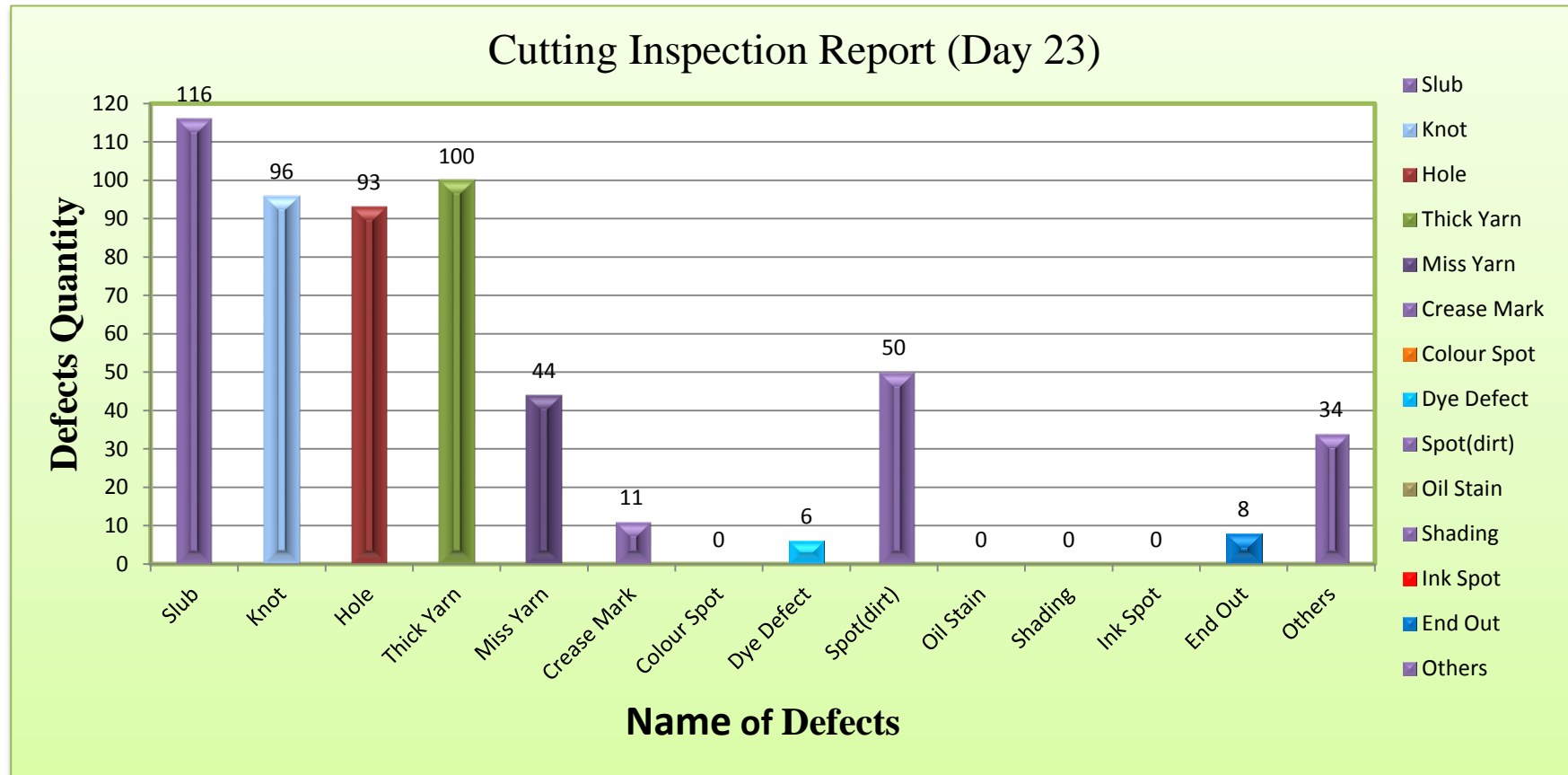
In this graph, Cutting quality report of day 21 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and spot (dirt) and no defect is colour spot, oil stain, shading.

Graph-22: Cutting Inspection Report (Day 22):



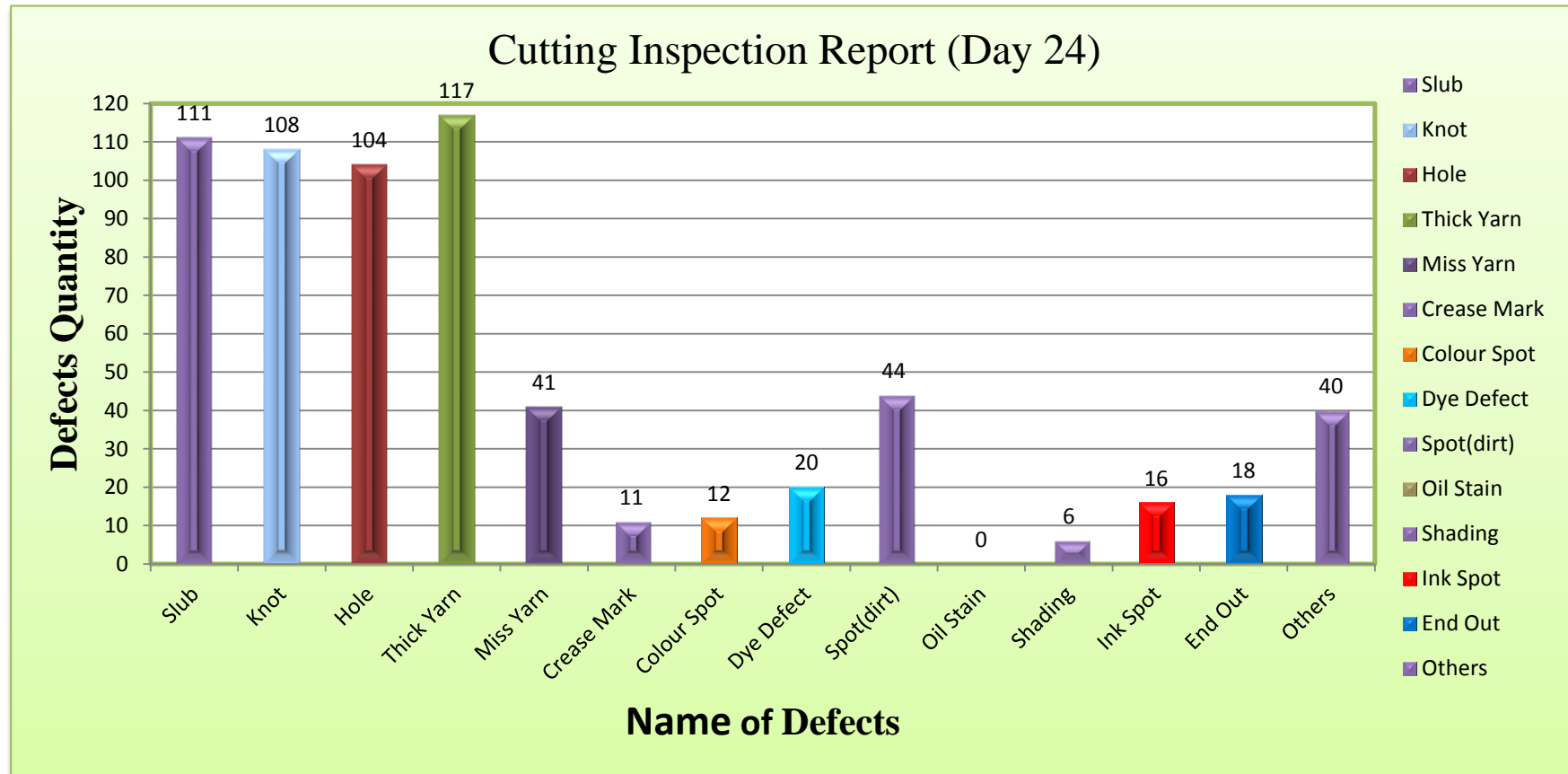
In this graph, Cutting quality report of day 22 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn, spot (dirt) and others. And no defect is dye defect, shading and end out.

Graph-23: Cutting Inspection Report (Day 23):



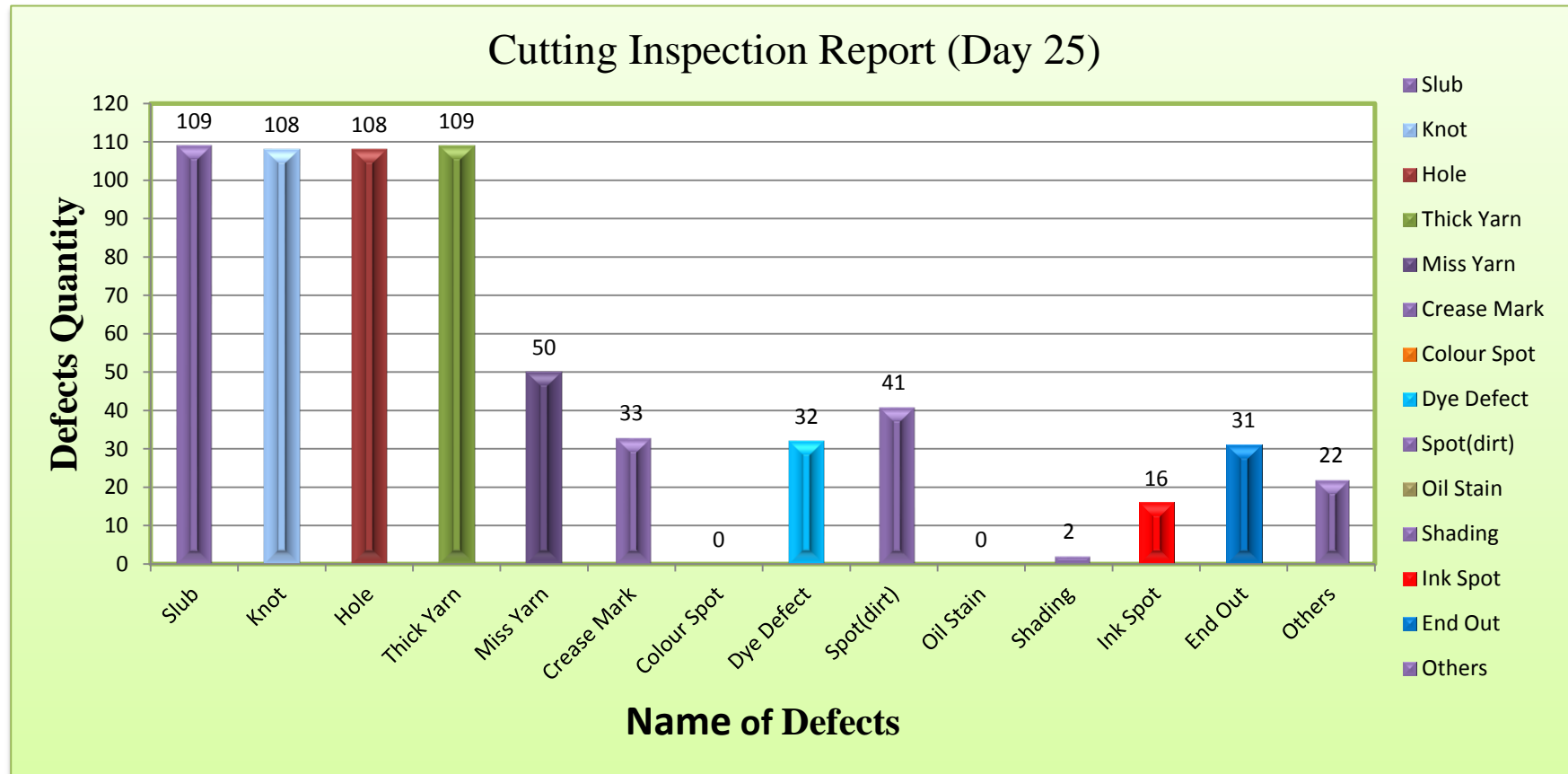
In this graph, Cutting quality report of day 23 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and spot (dirt) and no defect is colour spot, oil stain, shading, ink spot.

Graph-24: Cutting Inspection Report (Day 24):



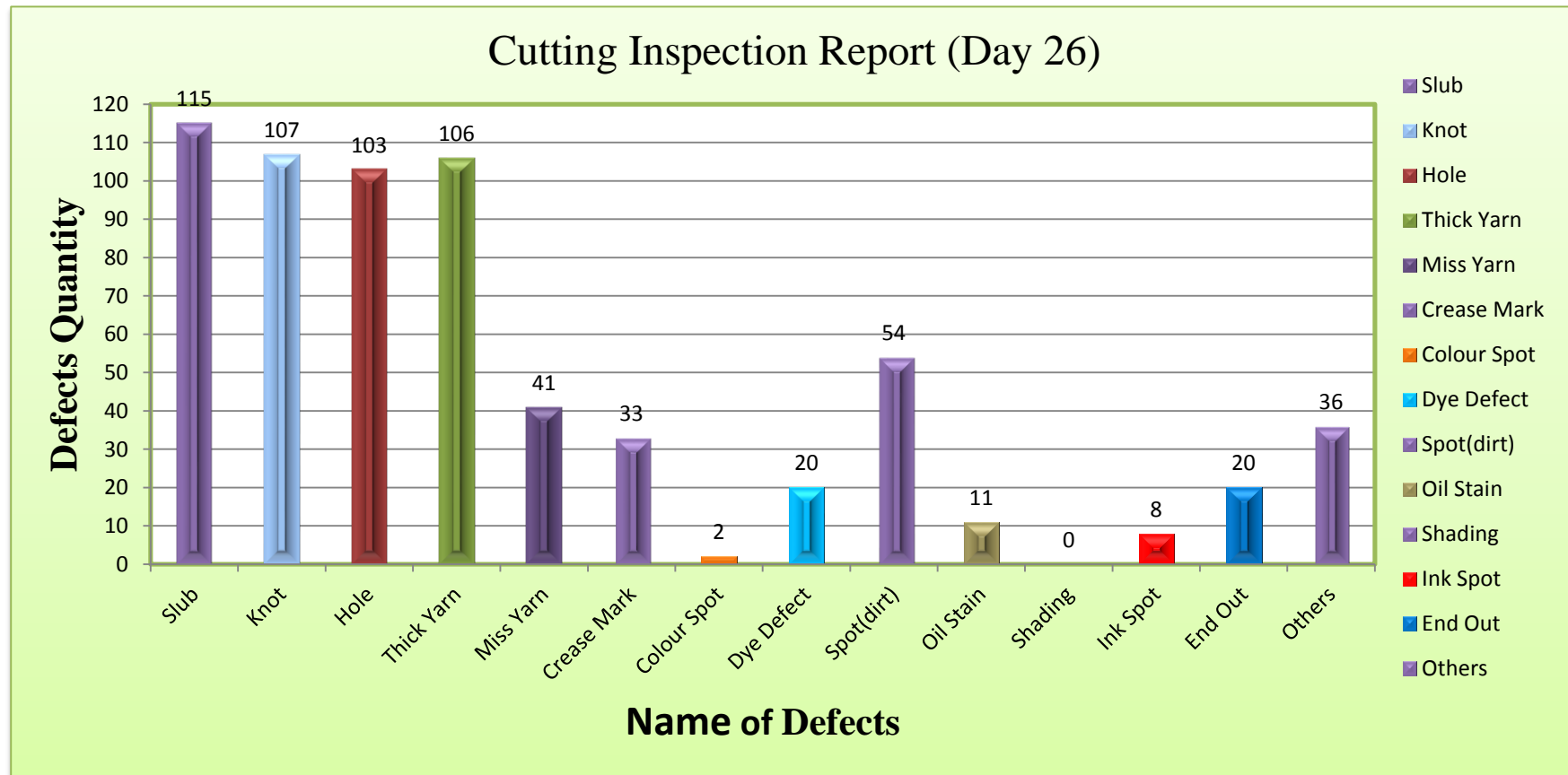
In this graph, Cutting quality report of day 24 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and no defect is oil stain.

Graph-25: Cutting Inspection Report (Day 25):



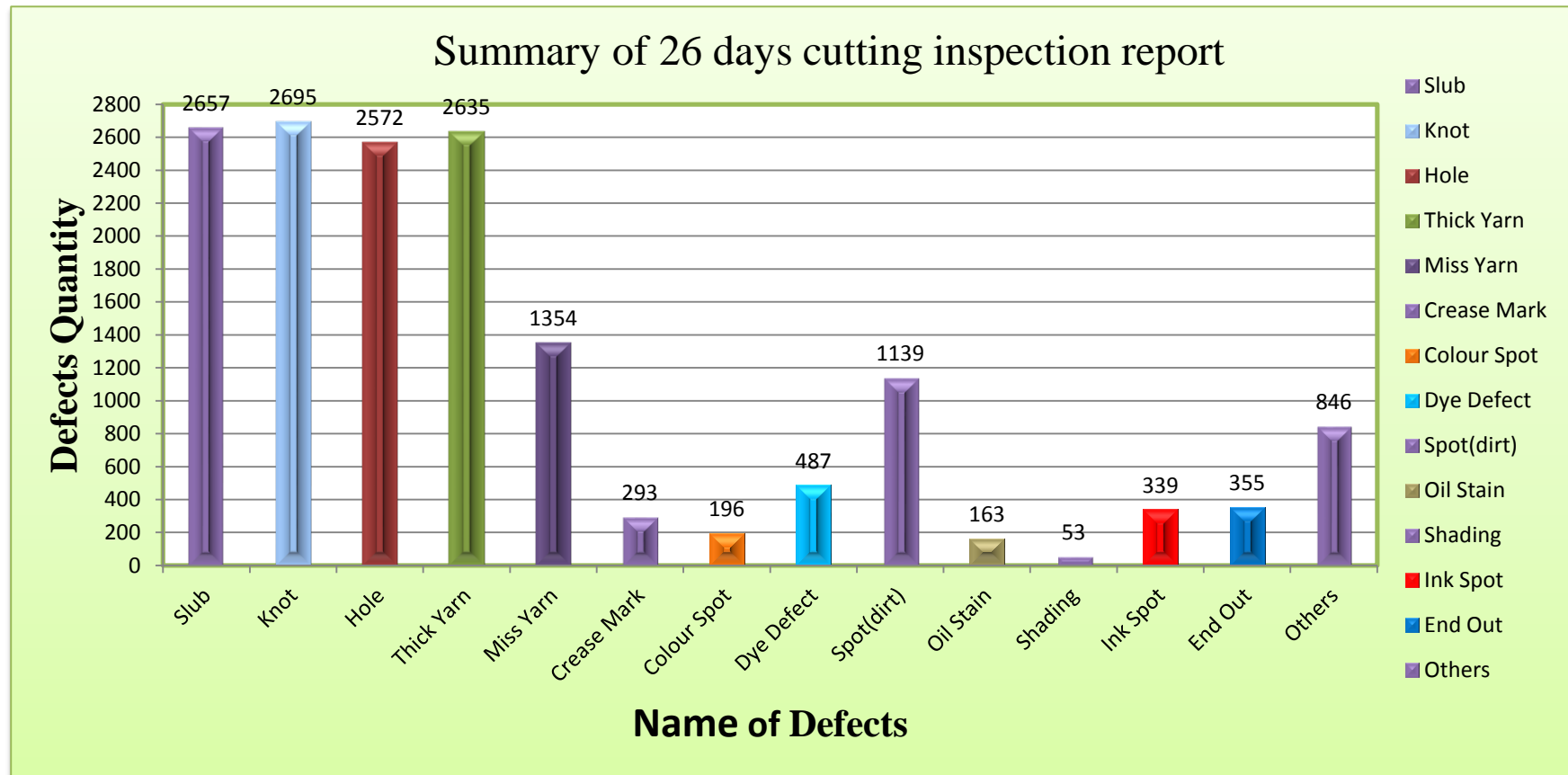
In this graph, Cutting quality report of day 25 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and Miss Yarn and no defect is colour spot, oil stain.

Graph-26: Cutting Inspection Report (Day 26):



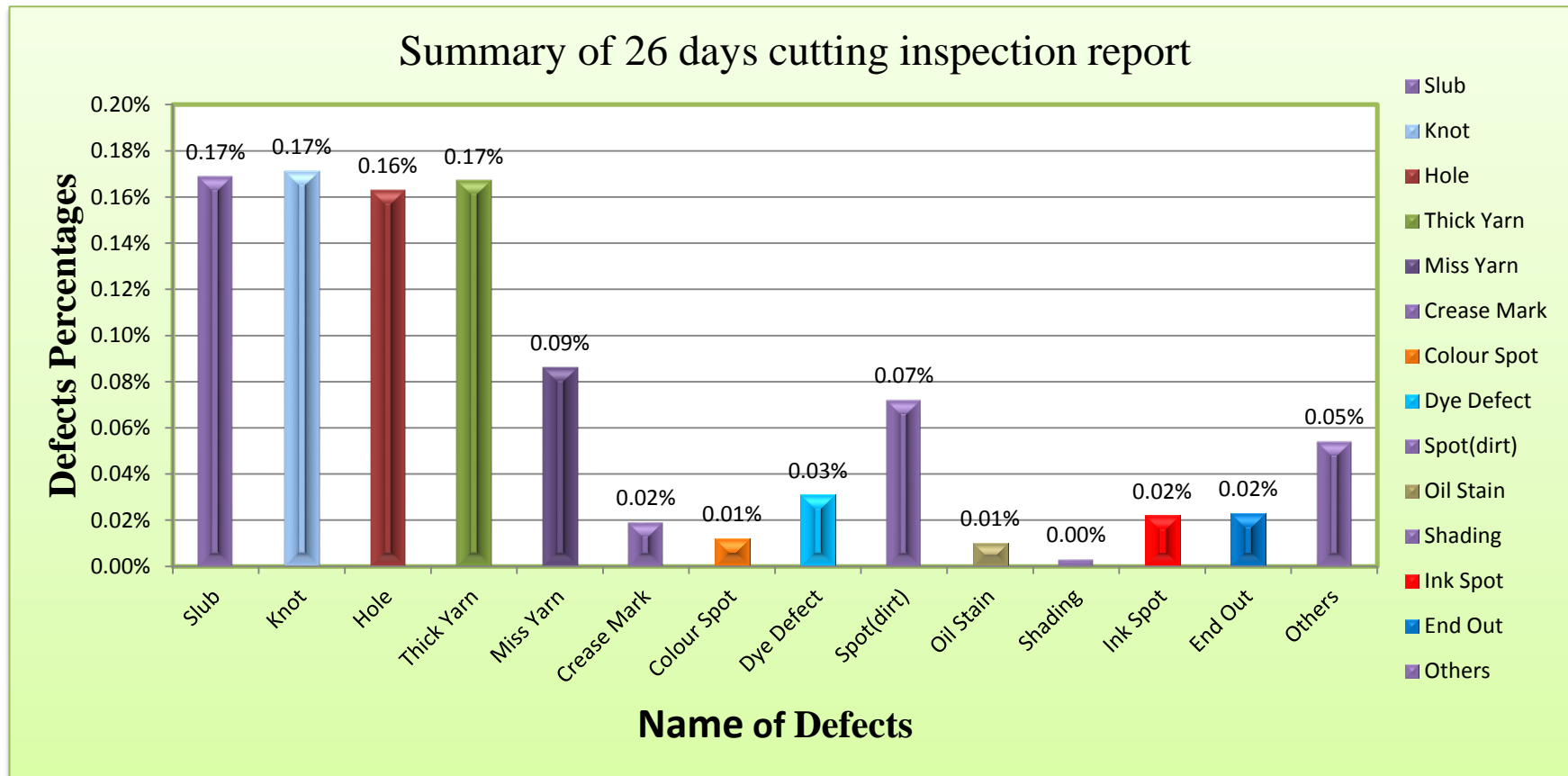
In this graph, Cutting quality report of day 26 is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “No of defects”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Spot, Dye Defect, Spot, Oil stain, Shading, Ink Spot, End Out, and others .The maximum no. of defects is Slub, Knot, Hole, Thick Yarn and spot (dirt) and no defect is shading.

Graph-27: Summary of 26 days cutting inspection report:



In this graph, summary of 26 days cutting quality report is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “Defects Quantity”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Sport, Dye Defect, Sport, Oil stain, Shading, Ink Sport, End Out, and others. The maximum defects quantity is found in knot, which is 2695 & the minimum defects percentage is found due to Shading, oil satin which is 53 and 163.

Graph-28: Summary of 26 days cutting inspection report (percentages):



In this graph, summary of 26 days cutting quality report is analyzed. The horizontal axis indicates the “Name of defects in Cutting department” and the vertical axis indicates the “defects percentages”. Almost 13 types of cutting defects is observed here. They are: Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Sport, Dye Defect, Sport, Oil stain, Shading, Ink Sport, End Out, and others. The maximum defects percentage is found in knot, which is 0.171% & the minimum defects percentage is found due to Shading, oil satin which is 0.003% and 0.010%.

Chapter 5: Conclusion

5.0 Conclusion:

Finally, we have accomplished our thesis after plenty of inspection, test & discussion. We have gathered a large experience about this project. We have increased our information about how cutting process is accomplished for making a Garments, problems of cutting & how those problems are minimized. The most common defects found in cutting department is Slub, Knot, Hole, Thick Yarn, Miss Yarn, Crease mark, Colour Sport, Dye Defect, Sport, Oil stain, Shading, Ink Sport, End Out, and others. Among all of these defects some are major and some are non-major defects. Major defects are Slub, Knot, Hole, Thick Yarn, Miss Yarn and Spot (dirt) etc. Non major defects are dye defect, shading, end out, ink spot, oil stain, colour spot etc. If cutting quality inspectors are careful during checking cut parts, then it is possible to minimize the number of percentage of the defects in cutting department in the garments. Training for the inspector is an important factor to minimize the defects. We should be aware that 1% defective product for an organization is 100% defective for the customer who buys that defective product. By accessing the quality of cutting parts of fabric, unskilled operator may be trained or removed from the factory to maintain the quality of the readymade garments.

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