



Daffodil
International
University

Faculty of Engineering
Department of Textile Engineering

REPORT ON

Industrial Attachment

At

Divine Textile Ltd.

Chandra, Kaliakoir, Gazipur, Bangladesh

Course Title: Industrial Attachment

Course Code: TE-410

Submitted By

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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

Duration: From 08th October'18 to 03rd December'18.

LETTER OF APPROVAL

December 13, 2018

To

The Head

Department of Textile Engineering

Daffodil International University

102, Shukrabad, Mirpur Road, Dhaka 1207

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

Dear Sir

I am just writing to let you know that this report titled as “**Industrial Attachment at Divine Textile Ltd**” has been prepared by the student bearing ID 151-23-4197 is completed for final evaluation. The whole report is prepared based on the factory data with required belongings. The students were directly involved in their industrial attachment activities and the report become vital to spark of many valuable information for the readers.

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

Yours Sincerely

Md. Mominur Rahman

Assistant Professor

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

DECLARATION

I hereby declare that the work which is being presented in this report entitled, “Industrial Attachment at Divine Textile Ltd.” Is original work of our own, has not been presented for a degree of any other university and all the resources of collected information for this report have been duly acknowledged.

Name	ID	Signature
Md. Mehedi Hasan Rion	151-23-4197	

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

Supervisor:

Md. Mominur Rahman

Assistant Professor

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

ACKNOWLEDGEMENT

First of all, I am grateful to Allah who gives me sound mind & sound health to accomplish **Industrial Attachment at Divine Textile Ltd.** successfully.

I am also grateful to my supervisor **Mominur Rahman**, Assistant Professor, Department of Textile Engineering, Faculty of Engineering, Daffodil International University. His endless patience, scholarly guidance, continual encouragement, energetic supervision, constructive criticism, valuable advice, reading many inferior draft and correcting these at all stages have made it possible to complete this project.

I would like to give special thanks to the supervisors, technicians, operators and all other staffs of **Divine Textile Ltd.** who were most cordial and helpful to us during internship.

I am also thankful to my all teachers, lab assistant, register sir, coordinators and all the employees of Daffodil International University. I am highly delighted to express my regards & gratitude to honorable Head **Prof. Dr. Md. Mahbubul Haque** for providing his best support to us.

Finally, I would like to express a sense of gratitude to my beloved parents and friends for their mental support, strength and assistance throughout completing industrial attachment.

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Chapter-1 Executive Summary

1.1 Executive Summary

This report presents a conception of Textile sector especially of a knit garments industry and tries to clarify the overall processes required to complete a garment. Two months long training is not enough to capture all the information related to but it is possible to overview three departments cutting, sewing and finishing. “Poem Fashion Ltd” in where we try to gather information about those three departments. The factory has some limitation for the internship students that are the training schedule provided by the authority. There are only three departments in “Divine Textile Ltd”. It describes about the activities of each departments and the relation among the departments. Training schedule is prepared in such a way that helps a learner to know that to produce a garment which department works first and correspondingly which works at last. This paper includes from where order is received and to where it is supplied and how a large scale of products is produced within a very short period of time. Different types of order are running on the same time on a same floor with different types of garments from several buyers. But there is no miss match of any product except some cases which are removed by inspection. This paper concludes by identifying some important information about different department that help the factory to grow up quickly with large amount of profit with environment friendly technologies. We have started our 2 months’ internship at 10th October and have successfully completed in 1th December.

Chapter-2 Information about the Factory

2.1 Introduction:

In the backdrop of a mercurial, ever-changing fashion world, Divine Group of Industries Ltd. considers its prime mission to suit every new taste, whim and demand of customers from around the world and all strains of human culture.

Divine Group acts on the basic premise that ‘fashion’ is an exploration into the images people seek to convey about themselves and the way they live.

So, in dealing with its target consumers, Divine Group mainly aims to know their perception about themselves and translates those into Garments. Doing that, over the years, Divine Group designers have acquired an almost telepathic understanding of the customer’s needs.

Divine Group has started manufacture and export of garments since late 1997. Its mission is to produce the latest design, quality knit fabrics and apparels for international markets.

Divine Group is one of the few elite private sector business groups, which contributed wealth as well as welfare to the struggling economy of Bangladesh.

As time is essential to space so is taste to its products. The secret is love-which, paired with meticulous efficiency and a keen sensitivity to style, makes Divine Group an emerging brand destined to light up horizon of fashion.

Divine Group has team of skilled and dedicated technocrats backed by adequate number of modern USA and European machinery and equipments to match international standard of all kinds of knitwear products.

2.2 Basic Information

Name of the factory:	Divine Textile Ltd.
Address:	Chandra, Kaliakoir, Gazipur, Dhaka, Bangladesh
Phone:	06822-51229
Head office:	House No: 348, Road No: 26, New DHOS, Mohakhali, Dhaka-1206, Bangladesh.
Fax Number:	+88-02-9885032

2.3 History of the factory:

After successful operation in Divine Textile Limited, the owner had decided to start a fully information & technology based along with the social accountability and quality controlled modern readymade composite knit garments industry in large scale. In this connection Mr. Salim.

Reza had decided in a resolution to start a company in Chandra, Kaliakoir, Gazipur in the year 1997 to manufacture knitwear garments for the international market. Right from inception the policy of the company has been to provide total customer satisfaction by offering quality knitwear in time. To meet the commitments of quality and prompt delivery, Divine Textile Limited Decided to integrate the manufacturing process in a planned manner. Over the years the entire process has been integrated by importing sophisticated machinery from world-renowned manufacturers.

Working on new concepts in styling & content of the knitwear is a continuous activity in Divine Textile Limited with an objective to up the quality and the value of merchandise. In 1997, the year in which International business was started; Divine Textile Limited concentrated all its strengths and resources in developing a wide range of knitwear for the in the international market.

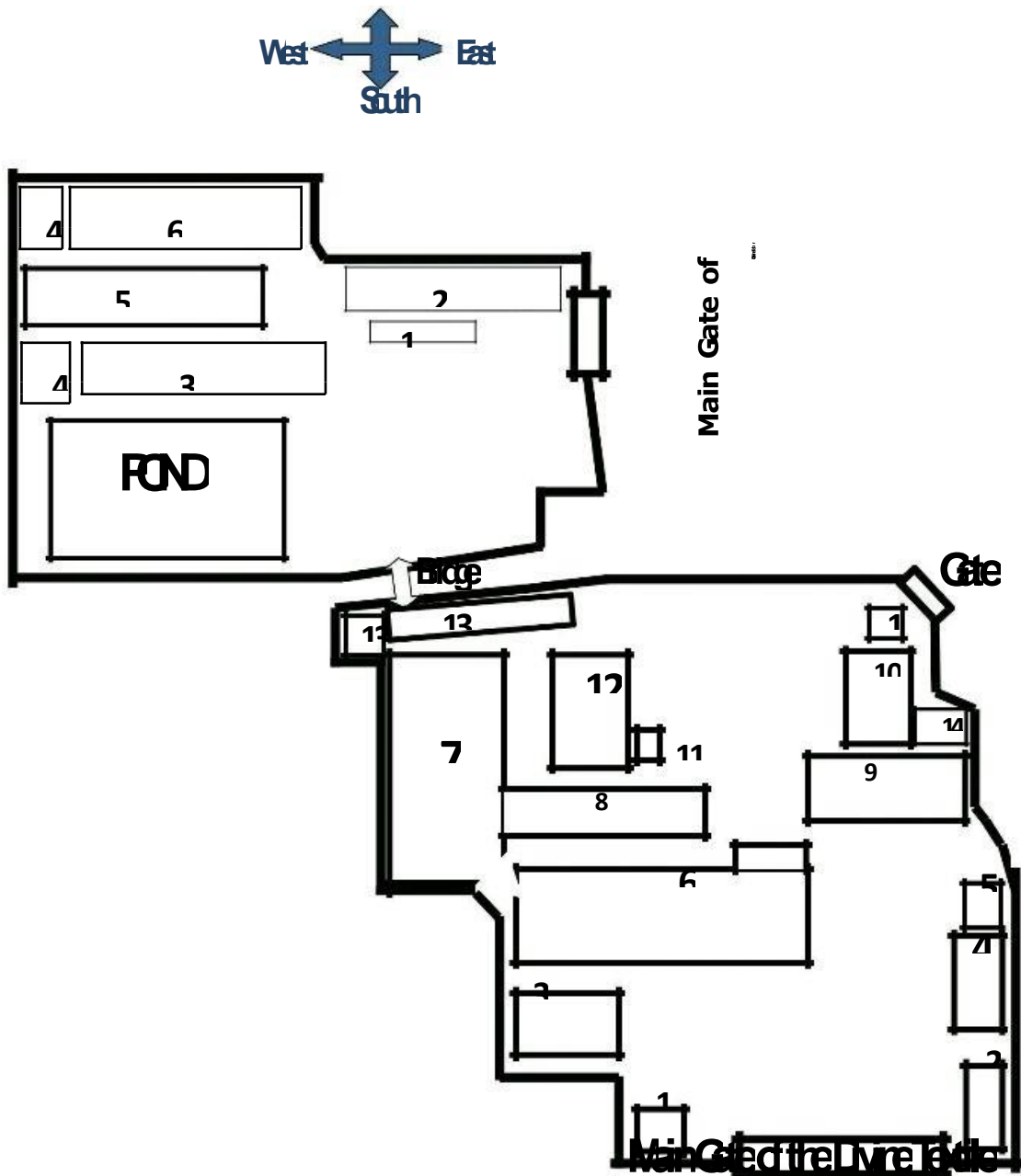
2.4 Founder and directors:

Mrs. Fatema Zaman	Chairman
Mr.Md. Hasanuzzaman	Managing Director
Md. Saif Hassan	Director
Md. Salim Reza	Executive Director

2.5 General Information about factory:

Factory Type:	:100% Export Oriented Knit Composite Industry
Year of Establishment:	:1997
Investor:	:Mr. Hasanuzzaman
Location:	:Chandra, Kaliakoir, Gazipur
Annual Turnover:	:Tk. 10,00,00,000 to 12,00,00,000
Certification & Awards:	IS 9001:2000 & WRAP
Production Capacity:	:knitting: 15.5 tons/day (Average) :Dyeing: 15.5 tons/day (Average) :Sewing: 100000 pcs/day (Average)
Main Production:	:Basic T- Shirt, Tank top, Long Sleeve, T-Shirt, Polo Shirt, Shorts, Pajama, Set, Ladies, Kids Knitwear & all kinds of Knit garments &Knit fabrics.

2.6 Layout of the factory



2.6.1 Divine Textile

1. Security office
2. Gas Pump
3. Knitting section Unit - I & Air Compressor Room (1st Floor) + Garment section (2rd -4th Floor)
4. Color Store (1st Floor) + Medical Care (2nd Floor) + Quarter (3rd Floor)
5. Chemical Store
6. Fabric dyeing (Unit - I) & Tube finishing section + Boiler Room
7. Dyeing Lab + Open Finishing Section
8. Fabric Dyeing Unit - II +Boiler Room
9. Generator
10. Yarn & Hanger Store
11. WTP Plant
12. Dyes & Chemical Store (Under Ground) + Kniting & Fabric Inspection Section & Air Compressor Room (1st Floor) + Garment Section (2nd - 6th Floor) + Garment Printing Section (&th Floor) + Office Room, Mercendiser Section, HR Department (8th Floor)
13. ETP Plant
14. Under Constructed Building.

2.6.2 Divine Fabrics

1. Under Constructed Building.
2. Garment Section (Which Construction is also running)
3. Grey Fabric Store + Printing Section + Knitting Section (2nd Floor)
4. ETP & WTP Plant
5. Fabric Dyeing & Open Finishing Section & Dyes, Chemical Store (1st Floor) + Dyeing & QC Lab (2nd Floor)
6. Yarn Dyeing + Yarn Dyeing Lab + Dyes & Chemical Store + Generato.

2.7 Organogram

Divine Group Management

Divine Group believes in consistently improved quality production. To stand on it Divine Group combined the whole family in single work-frame, where everyone is equally responsible for their job. Let us look at Divine Group Ltd family.



Md. Hasanuzzaman
Managing Director

NO
IMAGE

Fatema Zaman
Chairman



Salf Hassan
Director



Salim Reza
Executive Director



Imad-Ud-Doula
Head of Finance



Md Aslam Khan
Factory Manager



Alimur Rahman
Head Of Marketing



ASM Ahsanul Habib
Head of Commercial

2.8 Buyers Name of the Company

Divine Group can produce wide range of products and they deal with some renowned buyers from Europe and USA market some of those are with whom they worked and those whom they are still working. Main buyers name of the company are given below-

1. Target Australia
2. Carrefour
3. Lindex
4. Charles Vogele
5. Calvin Klien
6. TCHIBO
7. H & M (Hennes & Mauritz)

2.9 Raw Materials

Raw material is a unique substance in any production oriented textile industry. It plays a vital role in continuous production and for high quality fabric.

Types of Raw Materials:

- Yarn
- Grey
- Dyes
- Chemical

Yarn

PARTYNAME	YARNCATEGORY	RATE\$ (KG)	RATE (Tk. / KG)	QUANTITY(KGS)
Shameem Spinning	20s/1 CVC	2.70	158	400.00
Shameem Spinning	30s/1 CVC	2.80	163	500.00
Padma Textile Mills	30s/1 CVC	3.00	175	3628.80
Square Textile Mills	24s/1 Comb	2.95	172	850.00
Square Textile Mills	12s/1 Card	2.05	120	500.00
Square Textile Mills	10s/1 Card	1.65	96	1850.00
Prime Composite Mills	32s/1 Comb	2.95	172	2550.00
Pacific Textile Mills ltd.	20s/1 Card	2.58	151	2000.00
Luksme Textile Mills ltd.	26s/1 Card	2.62	153	2000.00
Mosharaf Textile Mills ltd.	30s/1 Card	2.62	153	3250.00
Prime Composite Mills	32S/1 Comb	2.95	172	22500.00
PHP Textile Mills ltd.	24S/1 Comb	3.02	176	10000.00
Badsha Textile Mills ltd.	34S/1 Comb	3.25	190	20000.00

Grey

Following types of grey fabrics are dyed-

- Single jersey
- Double jersey
- Single jersey with lycra
- Interlock
- Single Lacoste
- Double Lacoste
- Rib
- Lycra rib
- 1 x 1 rib & others
- Collar & cuff
- Polyester fabrics
- Single Pique
- Double Pique
- Terry Fleece
- Fleece

Chemicals

Chemicals	Rate per kg
01.Soda ash light	13
02.Caustic Soda	30
03.Common salt	7
04.Glauber Salt	9
05. H ₂ O ₂	28
06.Acetic Acid	12
07.Oxalic Acid	44
08.Bleaching Powder	22
09.Hydrose	48
10. Leuphore BMB	520
11. Uvtex BHT	309
12. Uvtex BHV	289
13. Uvtex BAM	310
14. Syno White 4BK	340
15. Uvtex BFE	919
16.Albatex FFC	344
17. CHTE nt. K50	249
18.Invadine Lun	136
19.Felson NOF	174
20.Invadine DA	180
21.Invatex CS	74
22.Cibacel DBC	107
23.Sarbid LDR	150

Dyes

Dyes	Rate per kg
01. Solazol Black sp GRI	300
02. Reactofix Red ME4BL	262
03. Cottofix Red ME4BL	262
04. Reactofix Orange ME2RL	294
05. Reactofix N.ME2GL	354
06. Reactive Yellow H4GL	500
07. Reactive Deep Black N	200
08. Cottofix Black B	141
09. Reactive Blue R(SP)	950
10. Remazol Red RR	1080
11. Remazol Yellow RR	746
12. Remazol Blue RR	908
13. Remazol Blue BB NEW	2280
14. Remazol T. Blue G	344
15. Remazol B Yellow 3GL	1167
16. Remazol Red RGD	725
17. Cibacron Red FN2BL	1488
18. Cibacron Red FB	918
19. Cibacron Red FN3G	1018
20. Cibacron Red WB	542
21. Cibacron Blue FNR	1488
22. Cibacron Blue FGFN	1540
23. Cibacron Navy WB	323
24. Drimarin Yellow CL2RL	510

2.10 Certification



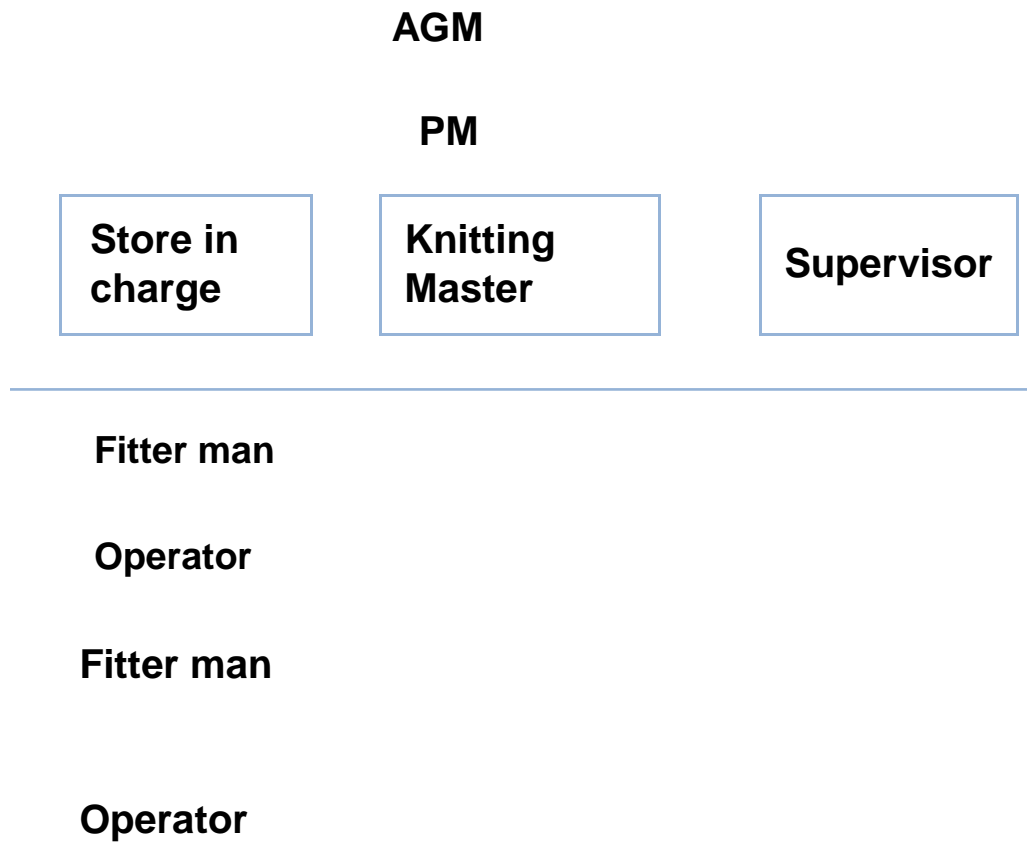
2.11 Remarks

The Divine Composite Knitting Ind. Ltd uses best quality raw materials. It produces fabrics from best quality yarn. They use the best quality dyes like REMAZOL, REACTRON, REACTIVE, TERACIL etc. During the time of using dyestuff they give importance upon the quality of dyes than the price of the dyes and chemicals.

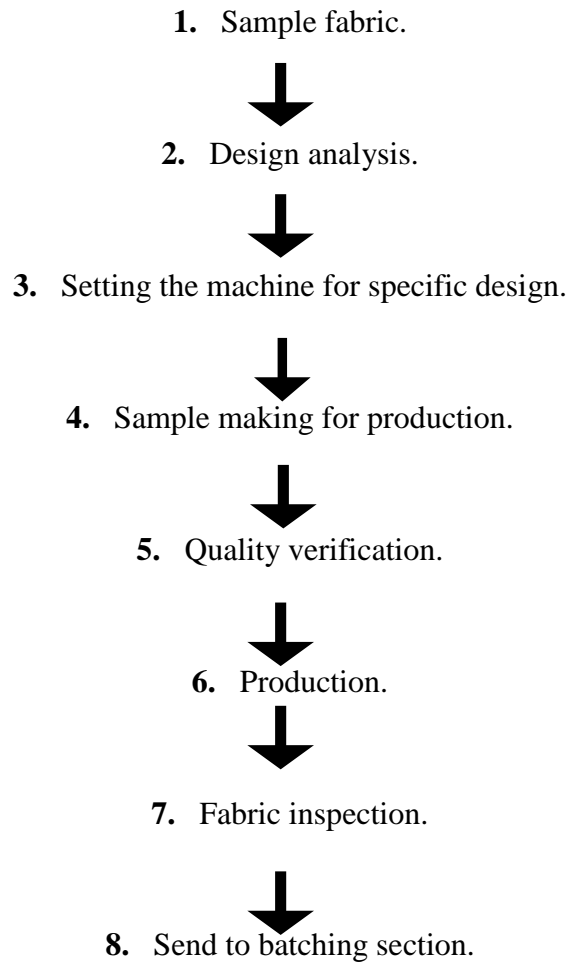
Chapter-3 Description of the Attachment

3.1 KNITTING SECTION

3.1.2 Organogram



3.1.3 Process Flow Chart of Knitting Section



3.1.4 Machine Specifications

Serial No.	1	2	3
Cylinder dia	42	40	38
Feeders	84F	80F	76F
Gauge	24G	24G	24G
Model	PL-KS3B-VI/A/CE	PL-XR2B/CE	PL-XR2B/CE
Needles	3168	3000	2856
Net wet(KGs)	3300	3200	3200
Safety rpm	21	22	23
M/C no.	A1100483	485	A1100479
Date	2011.05	2011.05	2011.05
Serial No.	4	5	6
Cylinder dia	36	34	28
Serial No.	8	10	11
Cylinder dia	32	36	34
Feeders	96F	108F	102F
Gauge	24G	24G	24G
Model	PL-3B-VI/AC/E	PL-3B-VI/AC/E	PL-3B-VI/AC/E
Needles	2400	2712	2544
Net wet(KGs)	2950	3100	2950
Safety rpm	26	23	25
M/C no.	A1100484	A1100481	A090584
Date	2009.05	2009.05	2009.05

3.1.5 Production Parameter

- Machine Diameter
- Machine rpm (revolution per minute);
- No. of feeds or feeders in use;
- Machine Gauge
- Count of yarn

3.1.6 Production Calculation

Production/shift in kg at 100% efficiency:

$$= \frac{\text{RPM} \times \text{No. of Feeder} \times \text{No. of Needle} \times \text{SL(mm)}}{3527.80 \times \text{Yarn count}}$$

Production/shift in meter:

Course/ min

Course / cm

$$= \text{RPM} \times \text{No. of Feeder} \times 60 \times 8 \times \text{Efficiency}$$

Course / cm $\times 100$

Fabric width in meter:

Total no. of wales

Wales / cm $\times 100$

Total no. of Needles used in knitting

Wales / cm $\times 100$



Fig: Fabric Inspection m/c

3.1.7 Knitting Faults & Remedies

1. Hole Mark:

Causes:

- Holes are the results of yarn breakage or yarn cracks.
- During loop formation the yarn breaks in the rejoin of the needle hook.
- If the yarn count is not correct on regarding structure, gauge, course and density.
- Badly knot or splicing.
- Yarn feeder badly set.

Remedies:

- Yarn strength must be sufficient to withstand the stretch as well as uniform.
- Use proper count of yarn.
- Correctly set of yarn feeder.
- Knot should be given properly.

2. Star Mark.

Causes:

- When sinker corrode due to abrasion then sometimes cannot hold a new loop as a result sinker mark comes.
- If sinker head bend, then sinker mark comes.

Remedies:

- Sinker should be changed.

3. Star Mark:

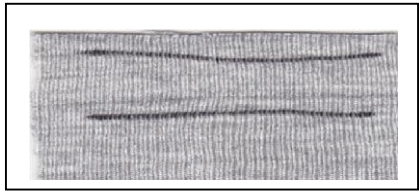
Causes:

- Yarn tension variation due to production.
- Buckling of the needle latch.
- Low G.S.M fabric production.

Remedies:

- Needle should be straight & well.
- Proper feeding of yarn during loop formation.
- Yarn tension should be properly.

Some fault of knit fabric:



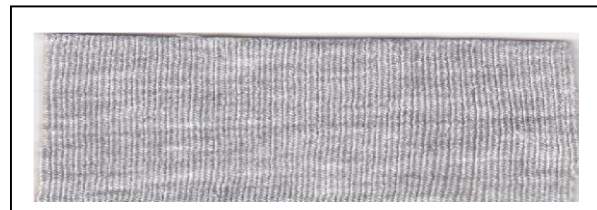
Thick & Thin



Color spot



Oil stain Lycra out



Color mark



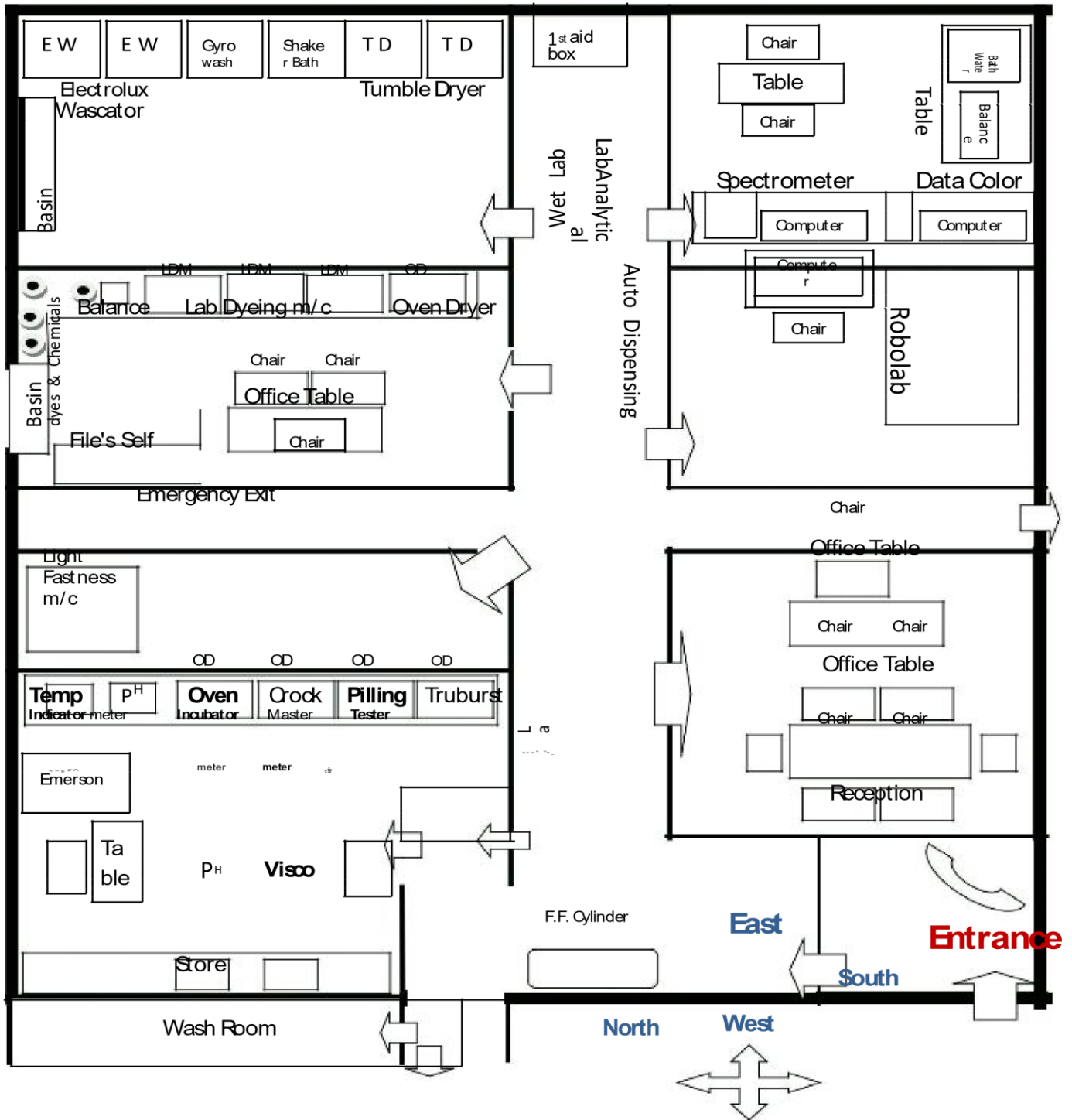
Needle drop



3.2 Laboratory

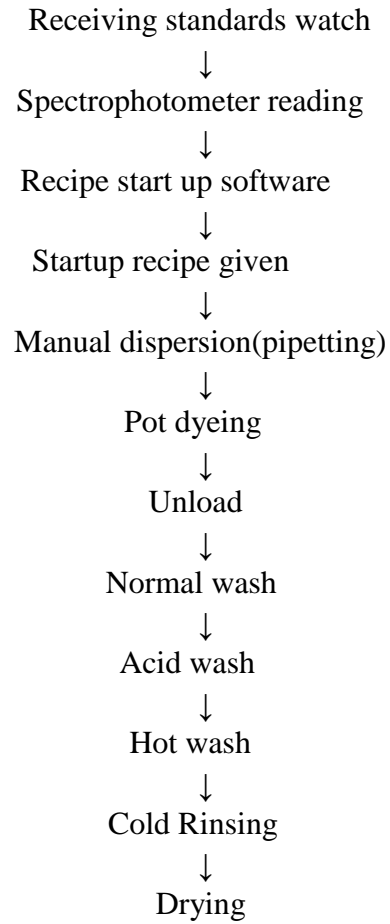
3.2.1 Layout

Lay out of Dyeing & QC lab in Divine Fabrics



3.2.2 Process Flow Chart

Development of lab



3.2.3 Specifications of Machineries

1. Name: Auto Dispenser

Brand: Talos Robotics

Type: Robolab

Mfg.: Talos – 66100 Drama GR

Origin: Greece.

Price: 35000 Uro

Mfg. Year: 2011

Total Weight: 800 Kg

2. Name: Lab Dyeing m/c

Brand: Data color (AHIBA IR™)

Origin: Germany



3. Name: Lab Dyeing m/c
Brand: Fong's
Origin: Hong Kong

4. Name: Lab Dyeing m/c
Brand: Infra Red Pyrojec (2000 series)
Origin: England

5. Name: Lab Dyeing m/c (High Temp- 140⁰C)
Brand: Daclim Starlet
Mfg.: Daclim Starlet Co., Ltd.
Origin: Korea



6. Name: Oven Dryer m/c
Brand: Daclim Starlet
Mfg.: Daclim Starlet Co. Ltd.
Origin: Korea



7. Name: Digital Balance

Brand: Dhaus

8. Name: Tumble Dryer

Brand: SDL Atlas

Origin: England



9. Name: Fume Hood

10. Gyro Wash



11. Light Fastness Machine

Brand: Atlas Ci 3000+

12. Name: Strength Tester

Brand: Truburst²

13. Name: Oven Dryer

14. Name: Oven Incubator

Type: Perspiration, Celebra Testing

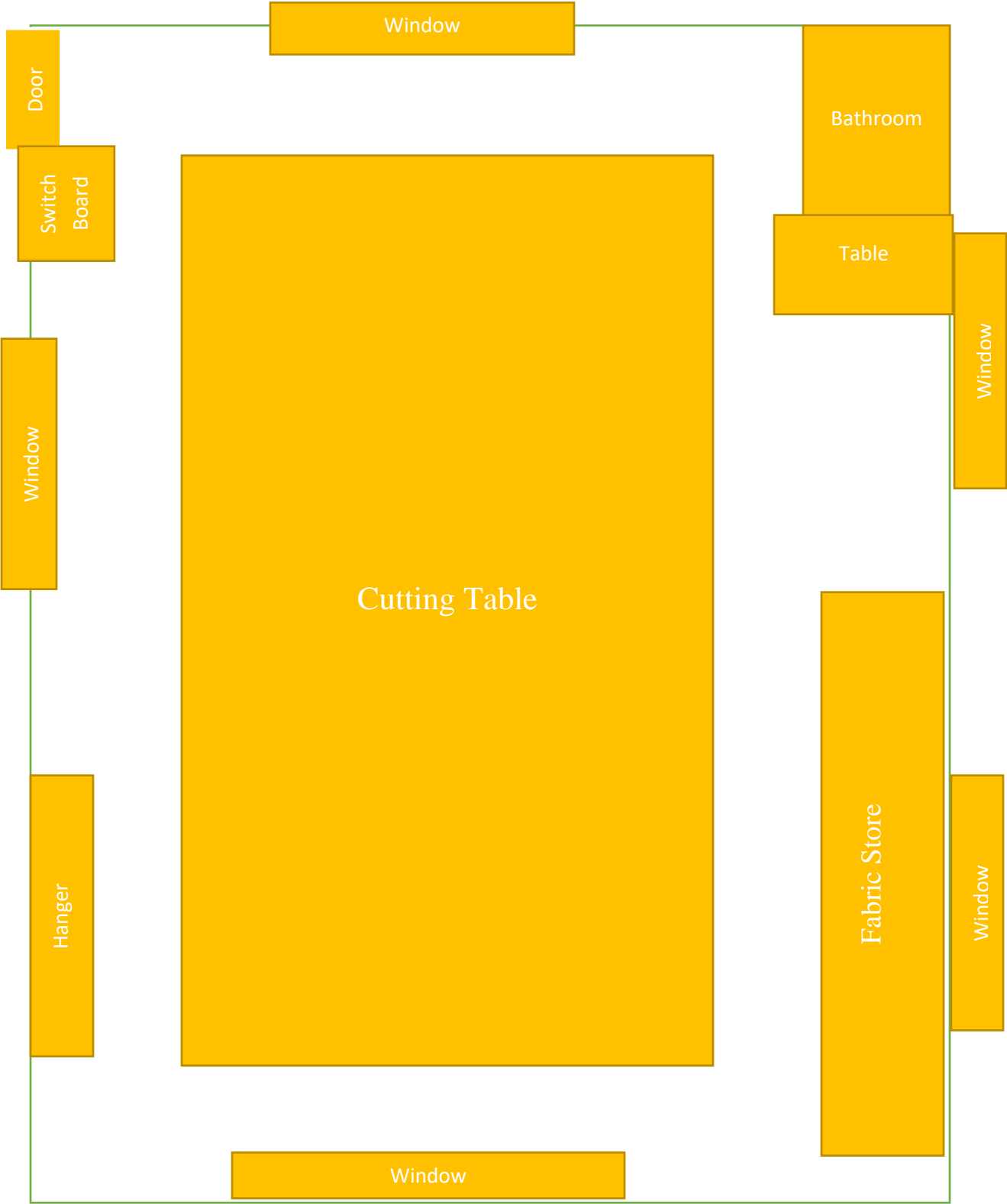
15. Name: Electrolux – Wascator

Brand: SDL Atlas



3.3 Cutting

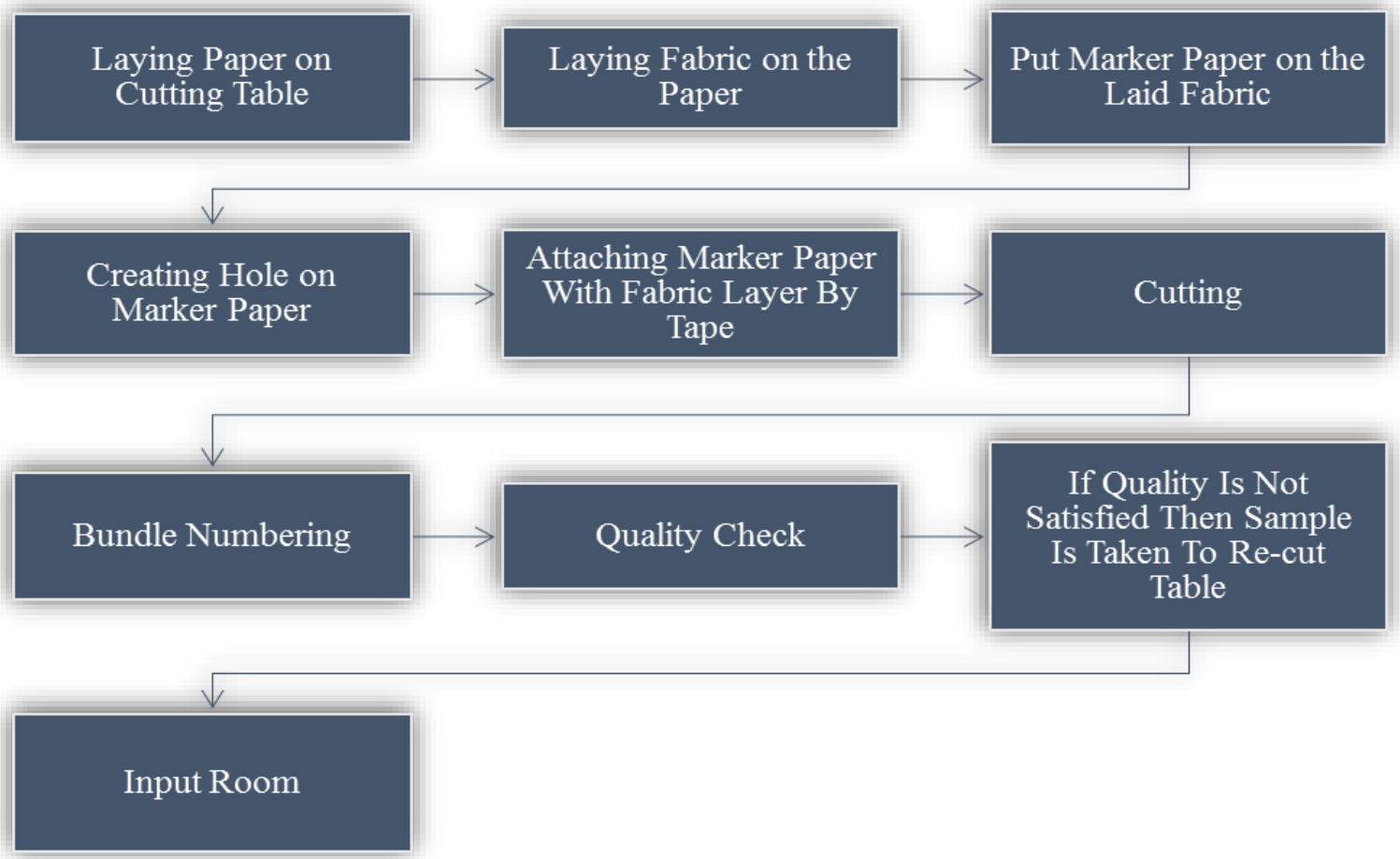
3.3.1 Layout



3.3.2 Organogram



3.3.3 Process of Cutting



3.3.4 Cutting Machine

Name: Fabric Relaxing Machine

Brand Name: WinDa

Model No: WD-RX84

Origin: China

Voltage: 220V, 50-60 Hz

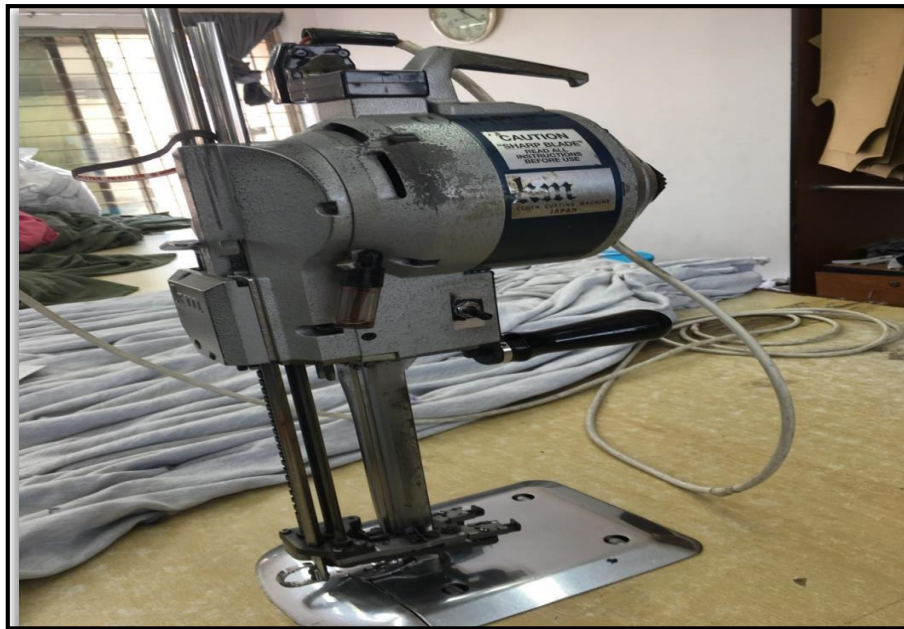


Figure : Straight Knife Cutting Machine

3.3.5 Major operations

- Spreading
- Marker Placing
- Cutting
- Sorting
- Numbering and checking

3.3.6 Quality Control Process

Quality Inspection for Marker

- Every parts Measurement check,
- Calculate the total no. of parts of each Garments,
- Marker length & width determined.

Fabrics Roll Spreading Inspection:

- Roll number,
- GSM,
- Shade number,
- No. of lays
- Ends of Bits

During Cutting Quality Control

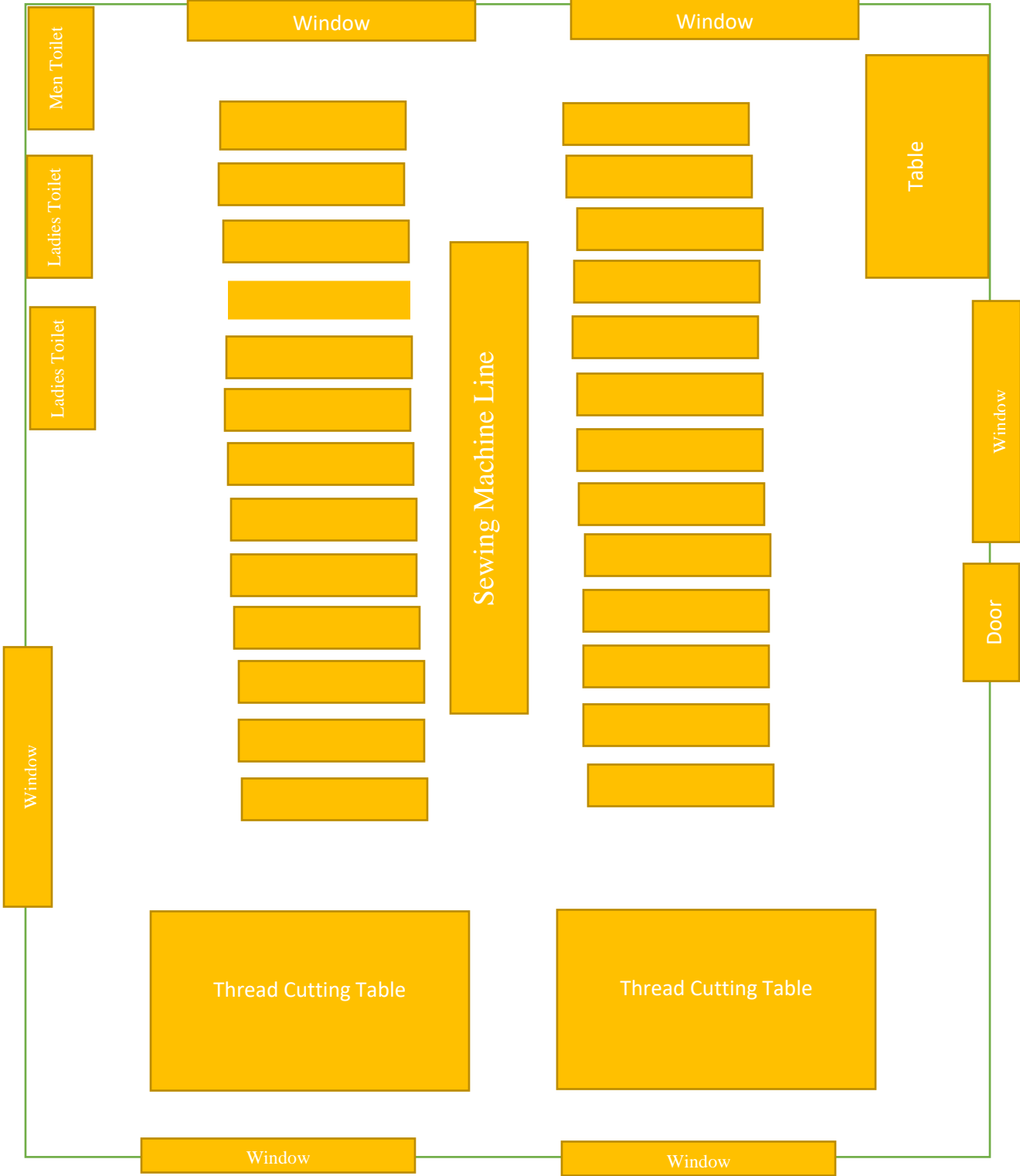
- Miss Cut
- Machines plies
- Ragged Cutting
- Notches
- Pattern Check

After Cutting

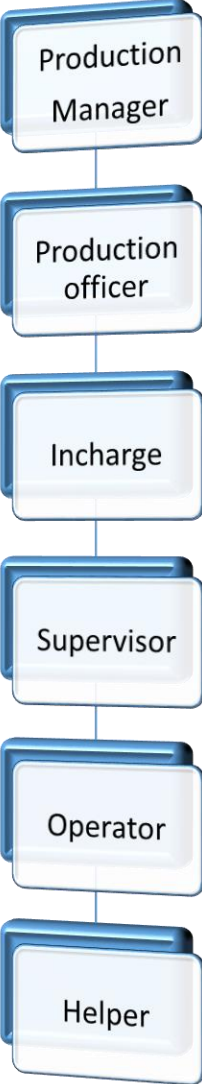
- 100 % part Checking
- Numbering & Bundle Control
- Reject Panel Replacement

3.4 Sewing Section

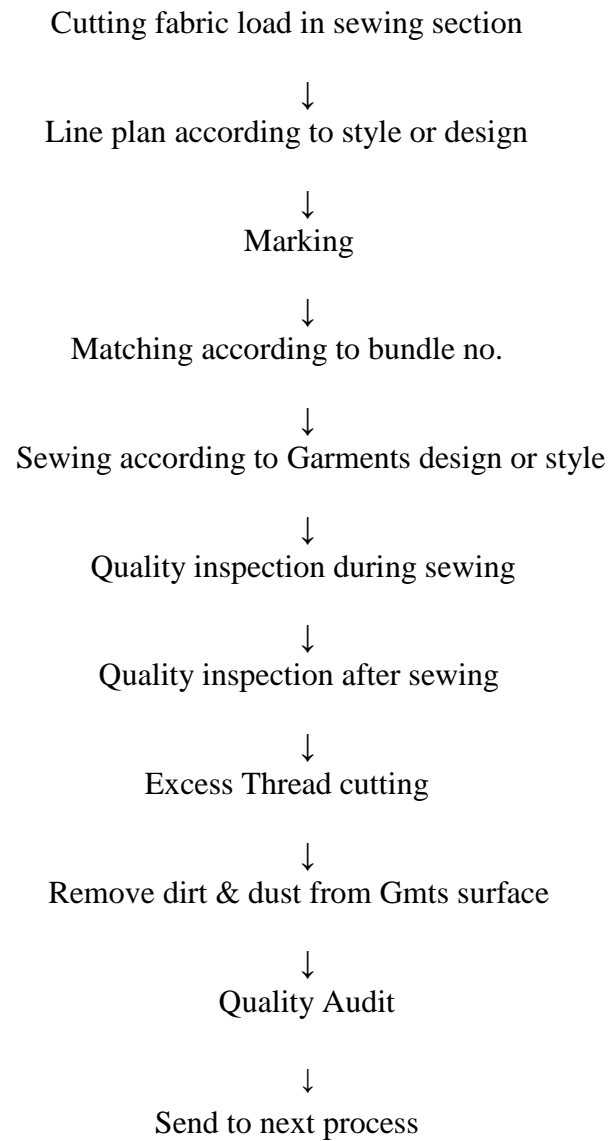
3.4.1 Layout of Sewing Section



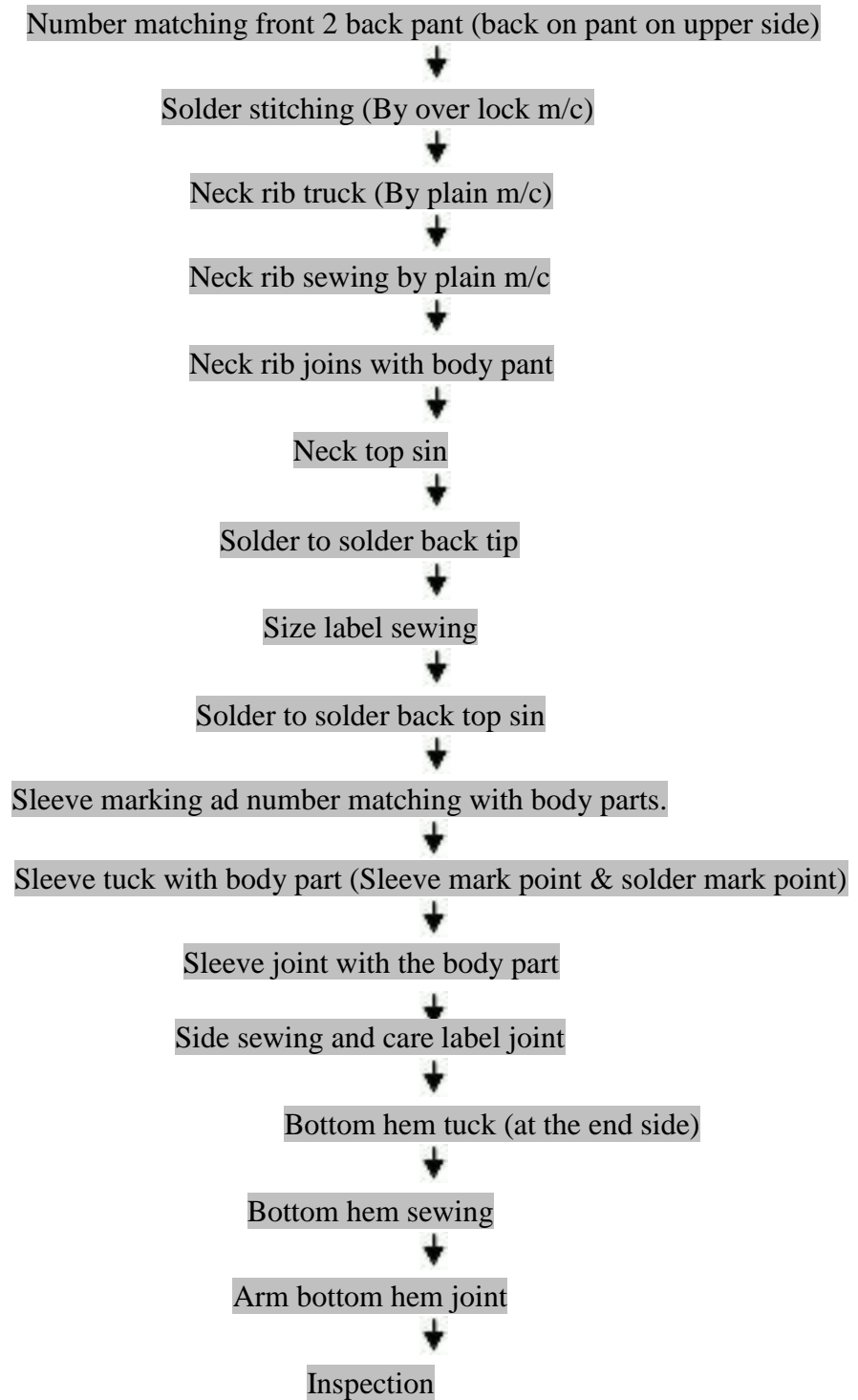
3.4.2 Organogram of Sewing Section



3.4.3 Flow Chart of Sewing Section



3.4.4 Flow Chart of Sewing Sequence of T-Shirt



3.4.5 Different types of Machines

1. Over Lock Machine:



Fig: Over lock machine

Application:

- Neck piping
- Sleeve piping
- Sleeve joint
- Side seam etc.

2. Plain Machine



Fig: Plain Machine

Application:

- Bottom hemming
- Belt making
- Loop tack stitch
- Pocket joint stitch
- Zipper joint etc.

3. Flat Lock Machine



Application:

- Belt top seam
- Back tape joint

4. Button hole Machine



Application:

- To create a hole for button

5. Button Attaching Machine



Application:

- To attached button in garment

6. Feed off the Arm



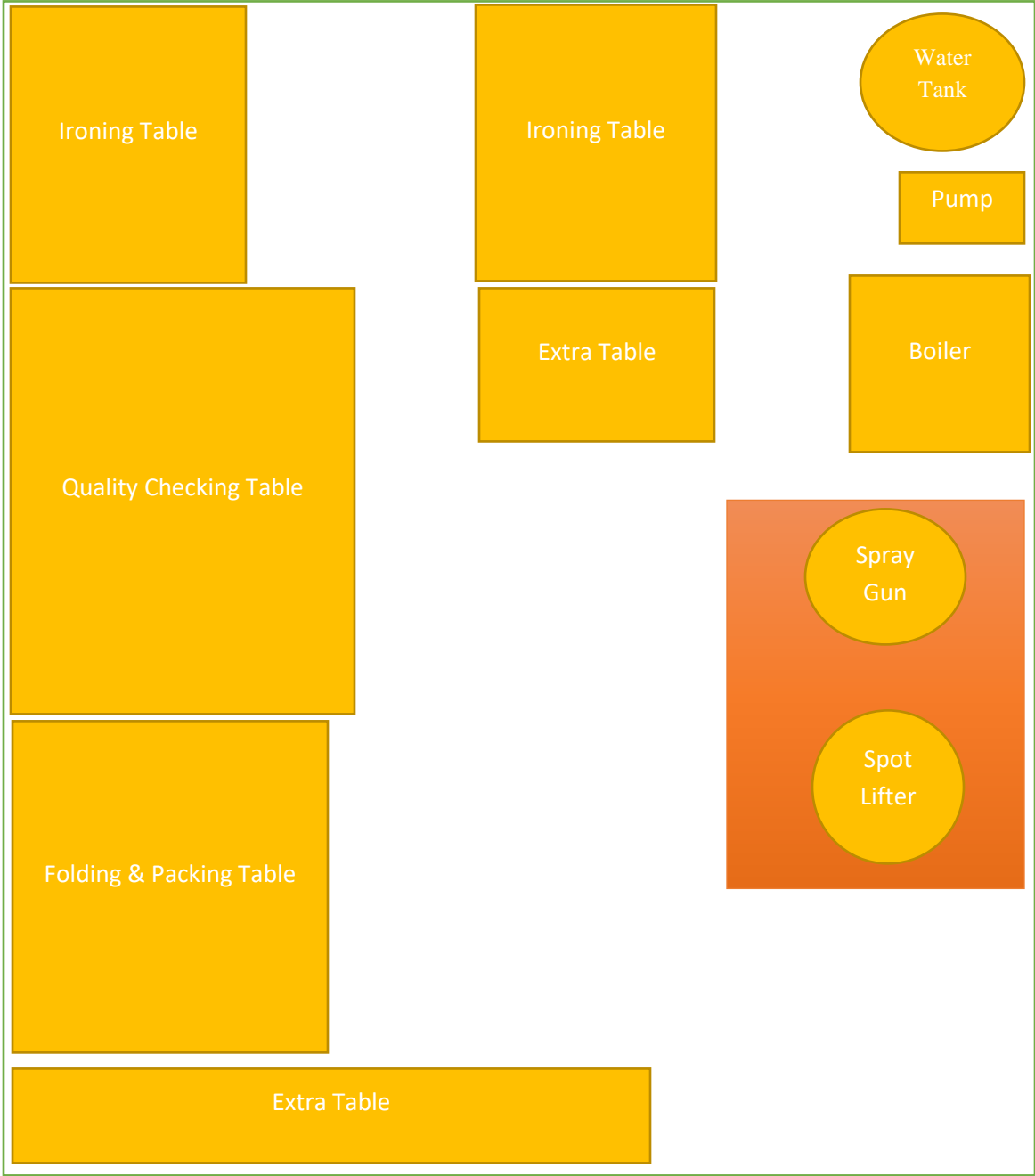
3.4.6 Quality Control in Sewing Section

Sewing Defects:

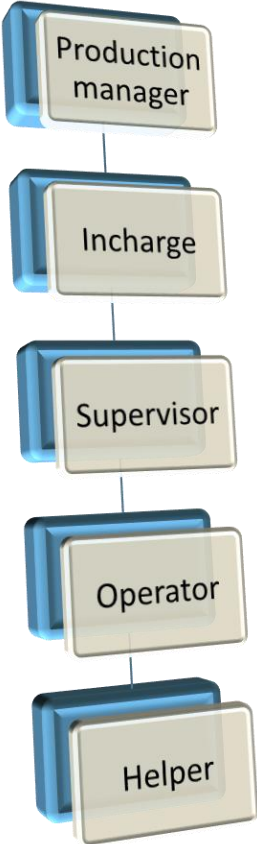
- Needle damage
- Skipped stitch
- Seam pucker
- Wrong stitch density
- Uneven stitch
- Defected stitch
- Oil spot
- Staggered stitch
- Uneven width
- Uneven seam line
- Not secured by back stitch
- No matching of check or stripe
- No matching of seam
- Seam Grin

3.5 Finishing section

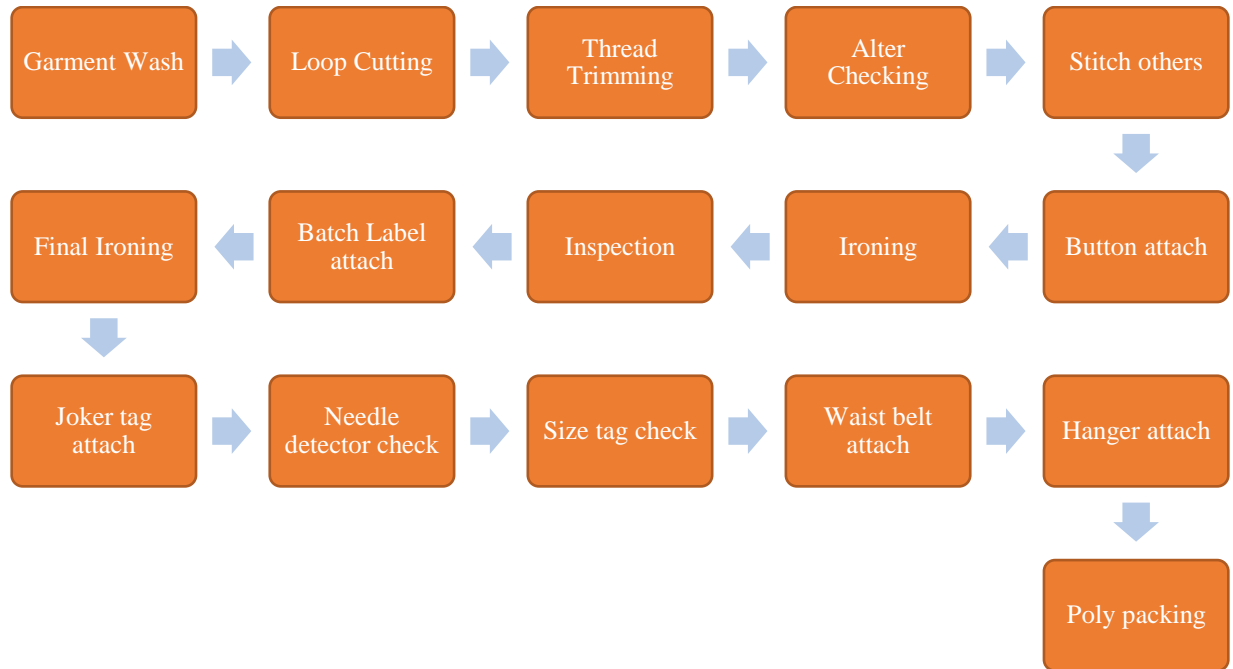
3.5.1 Layout of Finishing Section



3.5.2 Organogram



3.5.3 Flow Chart of Finishing Section



3.5.4 Different types of Machines

1. Spot Removing Gun



Fig: Remove the spot by using chemical

2. Ironing



Fig: Ironing

3. Hang tag attach



Fig: Attached the tack pack

4. Inspection



Fig: Final inspection

5. Folding



Fig: Folding

6. Cartooning



Fig: Cartooning

3.5.5 Process and Function

Process	Function
Inside Check	Check defect in inner part of garments. Like missed stitch, uneven seam.
Thread checker	Remove loose thread from garments part.
Ironing	Create a shape of garments.
Top side Check	Check defect in top part of garments Like, Uncut thread, Skipped stitch, Open seam
Get-up check	Check Cutting small thread Check Spot in garments
Hang tag attach	Hang tags are attached with a garment, such as, a) Price tag b) Tag of garment type These hang tags are attached with garment either by hand or by hang tag machine.
Folding	Pressed garments are folded in a specific dimension. This work is usually done by women labors.
Poly	In this section garments are packed in poly.
Carton	Poly is filled in carton.

3.5.6 Quality control in Finishing section (Faults & Remedies)

Various type of garment faults are detect in this section. Some of them are given below:

1. Wrong Side Chap Tuck:

When chap tuck is done in wrong side of a garments is known as wrong side chap tuck. Actually chap tuck is done to secure the seam line.



Figure: Wrong Side Chap Tuck

Causes:

- Negligence of the operator.
- Unskilled worker.

Remedies:

- Operator should be work carefully.
- Operation should be done again.

2. Raw Edge:

After sewing, if the fabric raw edge is unexpectedly shown on sewing area of the garments then the problem is refers as raw edge problem.



Figure: Raw Edge

Causes:

- Lack of fabric handling by worker.
- Stickiness of presser foot.

Remedies:

- Worker should be well trained.
- Use appropriate needle plate, presser foot and feed dog height.
- Cut the raw edge part precisely.

3. Seam Puckering:

The gathering of a seam due to sewing or laundering causing an unacceptable seam appearance to the garments is known as seam puckering.



Figure: Seam Puckering

Chapter 4 Impact of Internship

4.1 Knitting Section:

In cutting section we have learned about-

- Different types of machines and specifications
- Knitting process.
- Production parameter.
- How Production calculation is done.
- Different types faults and their remedies.’

4.2 Laboratory Section:

- Different types of machines and their specifications
- Process flow chart

4.3 Cutting Section:

In cutting section we have learned about-

- Different types of fabric and their cutting process.
- Marker making.
- How to make marker for production.
- How to improve marker efficiency.
- Fabric spreading procedure.
- Cutting machine and function.
- How different types of fabric cutting is done.

4.4 Sewing Section:

In sewing section, we have learned about:

- Different types of sewing machine.
- Different types of sewing machine function.
- Different type of stitch.
- Maintenance section working process.

4.5 Finishing Section:

In Finishing section, we have learned about:

- Different types of finishing process.
- Different types of machines and accessories used in finishing.
- How the processes are done.
- What kinds of faults are found in finishing and their remedies.

Chapter-5 Conclusion

Conclusion:

Industrial training sends us to the expected destiny of practical life. We have gathered some knowledge about garments cutting, sewing & finishing process in our 8 weeks' internship in Poem Fashion Ltd. We are very fortunate that we have got a chance to carry our industrial visit at such an industry. During this internship period, we have gained practical knowledge which has enabled us to compare with our theoretical knowledge in our academic period. In our training period, we have learned many things, such as different types of machines and their functions, techniques of productions and management system. Besides, we got an idea about the responsibility of different department of the factory. During our industrial training we have almost covered most of the section of the industry. However, highest effort has been given to achieve the objectives of the industrial training program. This industrial training will be very effective and blissful in our professional life. The management system of Poem Fashion Ltd. is very organized and the authority, officers and workers of the industry were very helpful so it was much easier for us to carry on our training successfully. We are showing our ultimate gratitude to poem Fashion Ltd. and our respective teachers for giving us such a wonderful opportunity.