

Study on Finishing Faults in Garments Industry



Daffodil
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Department of Textile Engineering

Study on Finishing Faults in Garments Industry

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Submitted by :

Salah Mohammad Santo	151-23-4103
Md.Rasel Ahmed Tuhin	151-23-4246

Supervised by:

Mst. Murshida Khatun

Senior Lecturer

Department of Textile Engineering

Daffodil International University

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Mst. Murshida Khatun Sr. Lecturer, Department of Textile Engineering, Daffodil International University, our supervisor, to whom we are extremely grateful for his tremendous support and guidance throughout our project.

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DECLARATION

We hereby declare that, this project has been done by us under the supervision of **Mst. Murshida Khatun**, Senior Lecturer, Department of Textile Engineering, Faculty of Engineering, Daffodil International University. We also declare that, neither this project nor any part of this project has been submitted elsewhere for award of any degree or diploma.

Name:	ID:	Signature
Salah Mohammad santo	151-23-4103	_____
Md.Rasel Ahmed Tuhin	151-23-4246	_____

LETTER OF APPROVAL

December 09, 2018

To

The Head

Department of Textile Engineering

102, Shukrabad, Mirpur Road, Dhaka 1207

Subject: Approval of Project Report of B.Sc. in TE Program.

Dear Sir,

I am just writing to let you know that this project report titled as “**Study on Finishing Faults in Garments Industry**” has been prepared by the student bearing ID’s 151-23-4103 and 151-23-4246 are completed for final evaluation. The whole report is prepared based on the proper investigation and interruption through critical analysis of empirical data with required belongings. The student were directly involved in their project 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 project report and consider it for final evaluation.

Yours Sincerely



.....
Mst. Murshida Khatun

Senior Lecturer

Department of Textile Engineering

Daffodil International University

ABSTRACT

This report presents the **Study on Finishing Faults in Garments Industry**. Quality may be defined as the level of acceptance of good or service and this quality depends in every section of an industry such as cutting section, sewing section, finishing section. We work specially in finishing section of Poem Fashion Ltd. In our this thesis report we describe five chapters. The theoretical part of the project provides basic information about finishing and finishing section, firstly we describe about introduction of finishing. In chapter one we totally describe about finishing section what types of work is done in finishing section, objective of finishing and limitation of finishing section, we tried to all basic things about finishing in introduction. What is finishing what types of work is done in finishing section, how many sectors or how many work is done in finishing such as pressing, checking, folding, packing etc., which we are tried to describe in literature review. In experimental details chapter we told about cutting data, production data and finishing data. Although we work in finishing section so we specially look after in finishing section. We inspected fabric/garments ten days every day three hours and find some defects and how they solved the problem etc. In chapter four all the data describe into bar chart and we describe about their faults their causes and remedies. If we ensure high quality inspection system then buyers will be motivated and quality products can be possible to produce. For the betterment of RMG sector, we should need to introduce modern quality inspection systems and quality management techniques.

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CHAPTER –I
INTRODUCTION

1.1 Background of the Study

The first step of a student in professional life is project, especially in technical side. A practically running processing technology of an industrial unit is an essential part of study for a student. In our university, processing machines are not in continuous running condition, so it would only provide demonstration of mechanical features & processing technology of the material in accomplishment of the theory but not of the situational variables to achieve practical knowledge.

It is important to maintain a different faults in every industry or business to get increased sales and better name amongst consumers and fellow companies. Especially for the business engaged in export business has to sustain a high level of quality to ensure better business globally. Companies who are into export business hold the prestige of the country, and due to this generally quality control standards for export are set accurately. It becomes mandatory to have good quality like different faults control their products as export houses earn foreign exchange for the country. In the garment industry quality control is practiced right from the initial stage to the stage of final finished garment.

A thesis paper is known as a research paper that provides sufficient information about particular topics. Our thesis paper contains “**Study on Finishing Faults in Garments Industry**”

Finishing and washing fault is one of the most important factors in Textile sector. So different faults control is required to make quality full products in this competitive world market. It is important to maintain quality in textile sector as well as garments production. So we have selected this topic. Therefore, a study was carried out in the garment industry named **POEAM FASHION LTD, Dhaka, Bangladesh** at finishing section to identify faults so as to eliminate them for maintaining

1.2 Objectives of the Study

Objectives of this study are given below:

- ✓ To improve all kinds of garments product
- ✓ To know about the reasons of defects washing and knitting section
- ✓ To redact technical solution

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- ✓ To know which fault can be highly occur in washing and knitting section
- ✓ To identify the faults which faults are occurred in different section of a garments industry
- ✓ To increase efficiency and productivity
- ✓ Addressing the issue of packing & packaging leading to defects.
- ✓ To promote indigenous manufacturing of high quality trims and accessories

1.3 Significance of the Study

Every study has some significance. Some significance of this study is given like-

- ✓ During our internship we have gathered practical knowledge about finishing and washing faults
- ✓ Beside this we have learned about different types of faults in garments section
- ✓ From this report we can learned which step should be taken or should not be taken on the basis of faults.
- ✓ It helps us to learn various fault occur daily in cutting, sewing, finishing, washing

1.4 Limitations

Our thesis period we have faced some problem. Those are given below:

- ✓ We can't collect all data due to some restriction
- ✓ Without permission of higher authority, we can't bring some necessary papers.
- ✓ Some section still following old QC system.
- ✓ Time was also a limitation
- ✓ Information gather during working was a tough job [1].

CHAPTER-II
LITERATURE REVIEW

2.1 Garments Finishing:

Finishing is very important section in the garments. In this sector we take the finished goods from sewing section and keep records, then after suckering it we send to iron section. Then the ironman irons these as per buyer instructions. The thread is sucking, fusing machine, metal detector, vacuum table, Steam Iron, Table grinding machine, Stan drill machine etc. are used in the finishing process. Let's see the steps of garments finishing with brief descriptions [2]

Process Sequence of Finishing Section

Finishing input (style, color & size wise)



Initial quality check



Spot Removing



Ironing/Pressing



Inspection



Hang tag



Get up change



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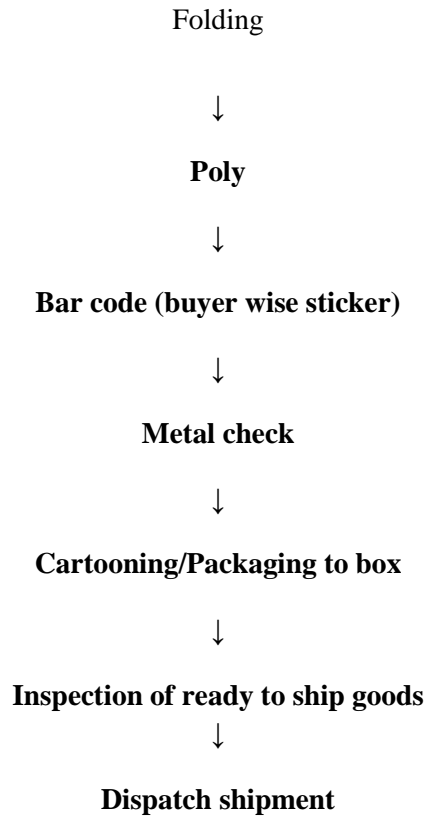


Figure 2.1: Finishing section of poem fashion ltd

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Finishing department play the vital role for producing complete garments. After completing the sewing performance, garments are passing to the finishing section / department to get the finishing touch, defects free and high quality garment due to inspection.

Finishing and packaging is an important contributing to the position of a product in the market.

Presentation of the product by packaging is becoming a distinctive marketing instrument.

Finishing and packaging could be considered as the silent salesman of the product [2].

2.2 Total finishing room management process in apparel industry:

When the garments are exported to the international market, different types of finishing instructions should have to be followed by the manufacturer [2].

2.2.1. Washing:

After passing the complete garment by the sewing room, if there has any spots like, oil mark, stain marks then it remove bywashing.

2.2.2 Pressing:

The process by which the unwanted creases and wrinkles are removed from the garments and the outlook of the garments is improved as well is termed as pressing. It is also known as ironing.

Pressing is an important finishing process of garments .In garments industries there is a separate section for ironing the products. It is generally done by heated plates and electric irons in moist condition of garments.



Figure 2.2.2: pressing section of poem fashion ltd

Objectives of Garment Pressing:

The main object of pressings to improve the outer appearance of the garments. However, the objects of pressing include much more:

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- **Removal of unwanted creases and wrinkles:** During garments manufacturing, creasing occurs in garments due to operator's handling and for tying up garments tightly in boxes. To remove these creases and unwanted wrinkles pressing is to be done.
- **Hiding imperfections:** Pressing can hide a multitude (huge number) of garment's imperfections and faults such as puckered seam and naps.
- **To apply creases where necessary:** Sometimes in garment we may need to apply some permanent creases such as pleats in shirts and for that purpose we have to apply creases or folds by pressing. Sometimes the pressing is done before sewing though after sewing it is also common.
- **Shaping:** Dart and seam are used to make garments properly fit with the shape of human body. To make these darts more attractive, pressing is applied which is known as shaping. The part of garment may have to be shrunk or stretched for shaping.
- **Under pressing:** For sewing easily and properly pressing is done on some parts of garments before sewing, which is called under pressing. Under pressing is done in manufacturing jackets, trousers, coats, etc. They also require final pressing.
- **Final pressing:** The pressing which is done before packing the garments is known as final pressing. By final pressing the garments become glossy (silky).

Pressing and folding instruction:

Get proper knowledge about, how a product is to be pressed and folded.

Different types of pressing instruction:

- Hot pressing
- Medium pressing
- Light pressing
- Do not press and steam etc.

Types of folding methods:

There are two types of folding methods. They are

- Flat pack folding
- Hanger pack folding

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2.2.3 Packaging:

There are two types of packaging are used in apparel industry. They are

merchandising packing:

A **merchandising** packing must be designed to meet the needs of the retailer and the desires of the customer.

Shipment packing:

The shipment packing performs the distribution function. It should be in a position to protect and preserve the quality of the product.

*****Specification of poly-bag:**

- Poly-bag size: length and width. 12-200 Gauge or 30-50 micron
- Thickness: 100 micron = 1 mm
- Type: Flop, self-seal, tubs etc.

Print: Warning for suffocation



Figure 2.2.3: packing section of poem fashion ltd.

2.2.4 Carton specifications:

Carton specifications are 3 types:

1. Carton dimension.
2. Carton material.
3. Making and labeling.

Carton dimensions:

- Length /width/height = 30*30*5

Carton material:

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- Liner board must be wet strength.
- Telescopic carton must have a minimum of 175 pound per square inch bursting strength for the top, 120 pound per square inch for the bottom.
- Flutes per linear foot of corrugation must be 50 ± 3 with a height of 3/32 inches (0.238 cm)
- Metal staple should not be used in the formation of the box.

Carton marking & labeling:

Complete carton content, information to be located on slides in the carton.

Main mark:

- Address info.
- Number of carton.
- Quantity/ size and style
- Country name.
- Measurement of carton

Side mark:

- Name of color.
- Gross weight
- Net weight

Carton security:

- Strapping
- Taping...



Figure 2.2.4: Carton specifications.

2.2.5 Inspection:

Inspection is the function to judge the quality product. Inspection is the process of measuring the quality of a product or service in terms of established standards.

Pressing and packaging inspection:

1. Some objectives of pressing and packaging inspections are in below:
2. To ensure that garments measure the buyer's specifications within the allowed tolerance after pressing.

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3. To ensure finished garments have to no loose threads or blemishes and are press to give an acceptable appearance according to the customer specifications.
4. To ensure the garments are folded and packaged to the customer's specifications.
5. To ensure the correct packaging items have been used.
6. To ensure the garment is an acceptable appearance after packaging.
7. To ensure all inner boxes contain the correct quality per size & color and that the boxes contain the correct number of cartons and display the correct marking.

Inspection procedure:

1. Select at random from the packaging section a quantity of shirt as per the sample plan.
2. Remove the shirt from the polybag and measure to ensure it is the correct folded size & tie-space is the correct width.
3. From the P.O or the packaging specification chart, unfold the garment and check that all the packaging items have been used as specified.
4. Record on the inspection from any items that are found missing.
5. Visually inspect the garment for its overall appearance, giving particular attention to the critical areas, i.e. collar, pocket and also the matching of stripes & plaid.
6. If any defect is found a green Q.C sticker must be put on the garment and the details recorded on the inspection form. The defective garment should then be passed to the pressing supervisor for corrective action.
7. After have unfolded the garment, measure it to ensure the size tolerance allowed after pressing. It is refer to buyer's specification for the measurement point.
8. If a garment is rendered as reject, then a red Q.C sticker must be put on the garment and the garment again passed to the pressing supervisor.
9. All details must be recorded on the inspection form.[3]

Final checking for pressing/ folding:

1. Burn or scorch mark checking.
2. Any shine surface checking.
3. Improperly pressed garment checking.
4. Size and folding method checking.
5. Loose threads and hanging
6. No proper drying prior to packaging.
7. Incorrect packaging products.

Final checking for packaging/labeling:

1. Check labels p.o number info.
2. Color/ style / size
3. Right poly..
4. P.O number.
5. Quantity.
6. UPC sticker.
7. International case marking.
8. Country.
9. (Address only)
10. Carton number.

Some common problems of packaging:

1. Incorrect barcode tickets attach to garments.

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2. Incorrect counting of garments.
3. Incorrect loading of garment on to containers.

2.3 Garments finishing faults:

Series of processing operations applied to gray fabrics to enhance their appearance and hand, properties and possible applications.

- Play a fundamental role for the commercial excellence of the results of textiles.
- The most simple form of finishing is the ironing or pressing on the fabric.
- In finishing, the fabric is subjected to mechanical and chemical treatment in which its quality and appearance are improved and its commercial value enhanced.
- Physical finishing techniques (dry finishing processes) or chemical finishing methods (wet finishing) are used.

Functional finish: Wear ability, Hand, Mechanical resistance, Easy care, Wet ability, Wash ability, Deformability, Anti-bacterial, Anti-fungal, Soil-proof and Fire-proof ability [4].

2.4 Finishing defects

1. Stitch missing
2. Printing spot
3. Chap tuck problem
4. Label missing
5. Oil spot
6. Raw edge
7. Improper joining
8. Fall of stitch
9. Seam pucker
10. Improper placket
11. Broken stitch
12. Hole
13. Pin hole
14. Open seam
15. Reject
16. Needle mark
17. Uncut thread
18. Uneven joining
19. Dirty spot

Here this types fault are shown during sewing and finishingsection

CHAPTER-III
EXPERIMENTAL DETAILLES

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3.1 Some picture of garments and defects:



Figure 3.1.1: HUDI and short sleeve polo-shirt.



Figure 3.1.2: Printing spot



Figure 3.1.3: Main Label missing



Figure 3.1.4: Stitch missing



Figure 3.1.5: Dirty spot

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Figure 3.1.6: Open seam



Figure 3.1.7: pin hole

3.2 Production Data

POEM Fashion Ltd

Production Report

BUYER NAME: **FASHION TEX** GARMENTS TYPES: **WOMEN SHORTS SLEEVE** ODR QTY: **2500 P**
 FABRIC TYPES: **LACOST [100% POLYESTER]**

LINE	STYLE	COLOR	TOTAL CUTTING	SEWING SECTION		FINISHING SECTION				Total Defectives	Remarks
				TOTAL INPUT	TOTAL OUTPUT	TOTAL INPUT	TOTAL OUTPUT	TOTAL POLY	CTN		
A+B	WMC=0FT	GREY	2550	1250	1250	1250	1225	1225	31	25	This 75 garments are resend in sewing section for solved the problem
C+D				1300	1300	1300	1250	1250	32	50	

Table 3.2.1 production data of poem fashion ltd

Study on Finishing Faults in Garments Industry

BUYER NAME: **FASHION TEX** GARMENTS TYPES : **WOMEN LONG SLEEVE** ODR QTY : **2500 P**
 FABRIC TYPES : **LACOST [100% POLYERSTER]**

LINE	STYLE	COLOR	TOTAL CUTTING	SEWING SECTION		FINISHING SECTION				Defects	Remarks
				TOTAL INPUT	TOTAL OUTPUT	TOTAL INPUT	TOTAL OUTPUT	TOTAL POLY	CTN		
A+B				1250	1250	1250	1235	1225	31	50	50 garments are resend in sewing section for solved the prob
C+D	WMC=L FT	BLACK	2550	1300	1300	1300	1265	1250	32		

Table 3.2.2 production data of poem fashion ltd

POEM Fashion Ltd

Production Report

BUYER NAME: **FASHION TEX** GARMENTS TYPES: **MEN SHORTS SLEEVE** ODR QTY: **2500 P**
 FABRIC TYPES: **LACOST [100% POLYERSTER]**

LINE	STYLE	COLOR	TOTAL CUTTING	SEWING SECTION		FINISHING SECTION				Defects	Remarks
				TOTAL INPUT	TOTAL OUTPUT	TOTAL INPUT	TOTAL OUTPUT	TOTAL POLY	CTN		
A+B				1250	1250	1250	1234	1234	31	49	This 49 garments are resend in sewing section for solved the problem
C+D	WML=0FT	GREY	2550	1300	1300	1300	1267	1267	32		

Table 3.2.3 production data of poem fashion ltd

Study on Finishing Faults in Garments Industry

BUYER NAME: **FASHION TEX** GARMENTS TYPES: **MEN LONG SLEEVE** ODR QTY: **2500 P**
 FABRIC TYPES : **LACOST [100% POLYERSTER]**

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B				1250	1250	1250	1245	1245	32	20	This 20 garments are resend in sewing section for solved the problem
C+D	WML =1FT	GRE Y	2550	1300	1300	1300	1285	1285	32		

Table 3.2.4 production data of poem fashion ltd

POEM Fashion Ltd

Production Report

BUYER NAME: **GOOD MAN** GARMENTS TYPES : **MEN LONG SLEEVE** ODR QTY : **1500 P**
 FABRIC TYPES : **S/J KNIT FABRIC 100% COTTON**

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B		Black and red		1550	1500	1500	1480	1480	37	20	This 20 garments are resend in sewing section for solved the problem
C+D	GM00 1	[sleeve]	1550								

Table 3.2.5 production data of poem fashion ltd

Study on Finishing Faults in Garments Industry

BUYER NAME: **GOOD MAN GARMENTS** TYPES : **MEN LONG SLEEVE** ODR QTY : **1000**
P FABRIC TYPES : S/J KNIT 100% COTTON

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B	GM 002	WHIT E AND BLAC K	1020							15	This 15 garments are resend in sewing section for solved the problem
C+D				1020	1010	1010	995	995	25		

Table 3.2.6 production data of poem fashion ltd

POEM Fashion Ltd

Production Report

BUYER NAME: **GOOD MAN GARMENTS** TYPES : **MEN LONG SLEEVE** ODR QTY : **1000P**
FABRIC TYPES : S/J KNIT FABRIC 100% COTTON

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B	GM00 3	FULL BLAC K	1010	1010	1005	1005	990	990	24	15	This 15 garments are resend in sewing section for solved the problem
C+D											

Table 3.2.7 production data of poem fashion ltd

Study on Finishing Faults in Garments Industry

BUYER NAME: **GOOD MAN GARMENTS** TYPES: **MEN LONG SLEEVE ODR** QTY: **500 P**
 FABRIC TYPES : **S/J KNIT 100% COTTON**

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B	GM 004	RED	510							13	This 13 garments are resend in sewing section for solved the problem
C+D				510	510	510	497	497	13		

Table 3.2.8 production data of poem fashion ltd

POEM Fashion Ltd

Production Report

BUYER NAME: **ARISTRO LIFE STYLE** GARMENTS TYPES: **HODI** ODR QTY: **1500P**
 FABRIC TYPES: **FLEECE FABRIC**

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B	ARI= H1	BLAC K	1510	800	800	800	787	787	19	17	This 17 garments are resend in sewing section for solved the problem
C+D				710	710	710	706	706	17		

Table 3.2.9 production data of poem fashion ltd

Study on Finishing Faults in Garments Industry

BUYER NAME: **ARISTRO LIFE STYLE** GARMENTS TYPES: **MEN LONG SLEEVE** ODR QTY:
3500 P FABRIC TYPES: **LYCRA FABRIC**

LINE	STYL E	COL OR	TOTAL CUTTI NG	SEWING SECTION		FINISHING SECTION				Defect s ps	Remarks
				TOTAL INPUT	TOT AL OUT PUT	TOTAL INPUT	TOTA L OUTP UT	TOTA L POLY	CT N		
A+B	ARIO 01	RED,B LACK ,BLUE WHIT E	3520	1750	1750	1750	1705	1705	27	45+25	This 70 garments are resend in sewing section for solved the problem
C+D				1770	1770	1770	1745	1745	44		

Table 3.2.10 production data of poem fashion ltd

3.3 Finishing section [sample]

After receiving the garments from sewing section, all the garments are sent to finishing section. For Ironing, Packing, Bar Code attaching etc. are done here. From this section we have collected some data and analyzed them to find how many faults are found in garments on finishing section in 3 hour. Those data are given below:

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Good Man

Day: 1

Style no: GM 001
180

Fabric Description: short sleeve t-shirt, Lacostfabric, GSM:

Color: Black

Odr/Qty: 3000

Study on Finishing Faults in Garments Industry

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing	1	1		2
Printing spot		2	1	3
Label missing	2		1	3
Oil spot	1		1	2
Raw edge				0
Improper joining		2		2
Fall of stitch				0
Improper placket				0
Broken stitch			2	2
Hole	1			1
Open seam		1		1
Reject				0
Uncut thread			2	2
Needle mark	2			2
Dirty spot	1			1

Total inspected Qty		250
Total passed Qty		229
Total Defective Qty		21
DHU% [Defect per 100 Unit]		8.4%

Table 3.3.1 finishing report of poem fashion ltd

DAY 1

Here in 3 hour they inspected 250 products and we found 21 defective ps and total passed qty is 229. Where the DHU% IS 8.4%

Study on Finishing Faults in Garments Industry

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Good Man

Day: 2

Style no: GM 001
180

Fabric Description: short sleeve t-shirt, Lacost fabric, GSM:

Color: Black

Odr/Qty: 3000

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing	1			1
Printing spot		2		2
Label missing		2	2	4
Oil spot			1	1
Raw edge				0
Improper joining		1	1	2
Fall of stitch				0
Improper placket				0
Broken stitch				2
Hole	1			1
Open seam		1		1
Reject		1		1
Uncut thread				0
Needle mark	2			2
Dirty spot	1			1

Total inspected Qty		231
Total passed Qty		213

Study on Finishing Faults in Garments Industry

Total Defective Qty		18
DHU% [Defect per 100 Unit]		7.79%

Table 3.3.3 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Good Man

Day: 3

Style no: GM 002
180

Fabric Description: Long sleeve t-shirt, Lacost fabric, GSM:

Color: RED

Odr/Qty: 2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing		2	1	3
Printing spot			2	2
Label missing	2	1	1	4
Oil spot				0
Raw edge				0
Improper joining		2	3	5
Fall of stitch		1	2	3
Improper placket				0
Broken stitch				0
Hole	1			1
Open seam		1		1
Reject				0
Uncut thread				0
Needle mark	2			2

Study on Finishing Faults in Garments Industry

Dirty spot				0
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Total inspected Qty		243
Total passed Qty		221
Total Defective Qty		22
DHU% [Defect per 100 Unit]		9.0%

Table 3.3.3 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Good Man

Day: 4

Style no: GM 002
180

Fabric Description: Long sleeve t-shirt, Lacost fabric, GSM:

Color: RED

Odr/Qty: 2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing				0
Printing spot		2	1	3
Label missing	2			2
Oil spot			1	1
Raw edge				0
Improper joining		2	1	3
Fall of stitch			2	2
Improper placket				0
Broken stitch	2			2
Hole	1	2		3

Study on Finishing Faults in Garments Industry

Open seam			0
Reject			0
Uncut thread			0
Needle mark	2		2
Dirty spot	1		1

Total inspected Qty		196
Total passed Qty		177
Total Defective Qty		19
DHU% [Defect per 100 Unit]		9.69%

Table 3.3.4 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Fashion Tex

Day: 5

Style no: wmc=0ft
[100% polyerster

Fabric Description: [women]short sleeve polo-shirt, Lacost fabric

Colo: grey

Odr/Qty:2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing				
Printing spot				
Label missing	2		1	3
Oil spot			1	1
Raw edge				0
Improper joining	1	2		3

Study on Finishing Faults in Garments Industry

Fall of stitch		3		3
Improper placket		2	3	5
Broken stitch			2	2
Hole			2	2
Open seam		1		1
Reject				0
Uncut thread				0
Needle mark	2			2
Dirty spot		1		1

Total inspected Qty		239
Total passed Qty		216
Total Defective Qty		23
DHU% [Defect per 100 Unit]		9.62%

Table 3.3.5 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Fashion Tex

Day: 6

Style no: WMC=0FT
fabric

Fabric Description:[women] short sleeve polo-shirt , Lacost

Color: grey

Odr/Qty: 2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing	1	1		2
Printing spot				0

Study on Finishing Faults in Garments Industry

Label missing		3	1	4
Oil spot				0
Raw edge				0
Improper joining		2	1	3
Fall of stitch				0
Improper placket		3		3
Broken stitch			2	2
Pin hole		2		2
Open seam		1		1
Reject				0
Uncut thread				
Needle mark	2			2
Dirty spot	1		1	2

Total inspected Qty		209
Total passed Qty		188
Total Defective Qty		21
DHU% [Defect per 100 Unit]		10%

Table 3.3.6 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report For Finishing Unit

Buyer: Fashion tex

Day: 7

Style no: WML=0FT Fabric Description: [MEN]short sleeve polo-shirt, Lacost fabric

Color: grey

Odr/Qty: 2 500

Defects Name	Hour	Total
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Study on Finishing Faults in Garments Industry

	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing				0
Printing spot				0
Label missing	2		1	3
Oil spot				0
Raw edge				0
Improper joining		2		2
Fall of stitch				0
Improper placket			3	3
Broken stitch				0
Hole	1			1
Open seam		2		2
Reject				0
Uncut thread				0
Needle mark	2		1	3
Dirty spot	2			2

Total inspected Qty		185
Total passed Qty		169
Total Defective Qty		16
DHU% [Defect per 100 Unit]		8.4%

Table 3.3.7 finishing report of poem fashion ltd

Study on Finishing Faults in Garments Industry

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Fashion Tex

Day: 8

Style no: WML=0FT

Fabric Description:[men] short sleeve polo-shirt , Lacost fabric

Color: grey

Odr/Qty: 2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing		1		1
Printing spot				0
Label missing	2		1	3
Oil spot			1	1
Raw edge				0
Improper joining		2		2
Fall of stitch			2	2
Improper placket			2	2
Broken stitch				0
Hole				
Open seam		1		1
Reject				0
Uncut thread				0
Needle mark	2			2
Dirty spot				0

Total inspected Qty		208
Total passed Qty		194

Study on Finishing Faults in Garments Industry

Total Defective Qty		14
DHU% [Defect per 100 Unit]		6,7%

Table 3.3.8 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Fashion Tex

Day:9

Style no: WML=LFT

Fabric Description: [Men]long sleeve polo-shirt, Lacost fabric

Color: Grey

Odr/Qty: 2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing			2	2
Printing spot				0
Label missing	2		1	3
Oil spot			1	1
Raw edge				0
Improper joining		2		2
Fall of stitch		2	1	3
Improper placket		1	1	2
Broken stitch				0
Hole				0
Open seam		1		1
Reject				0
Uncut thread				0
Needle mark		1		1
Dirty spot				

Study on Finishing Faults in Garments Industry

Total inspected Qty		213
Total passed Qty		198
Total Defective Qty		15
DHU% [Defect per 100 Unit]		7.57%

Table 3.3.9 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Fashion Tex

Day:10

Style no: WMC=LFT Fabric Description: [Women] long sleeve polo-shirt, Lacost fabric

Color: Grey

Odr/Qty: 2500

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing		1		1
Printing spot				0
Label missing	2		1	3
Oil spot			1	1
Raw edge				0
Improper joining		2		2
Fall of stitch		2		2
Improper placket		1	1	2
Broken stitch				0
Hole				0
Open seam		1		1
Reject				0

Study on Finishing Faults in Garments Industry

Uncut thread				0
Needle mark		1		1
Dirty spot				

Total inspected Qty		223
Total passed Qty		210
Total Defective Qty		13
DHU% [Defect per 100 Unit]		5.57%

Table 3.3.10 finishing report of poem fashion ltd

Poem Fashion Ltd

Daily Quality Check Report for Finishing Unit

Buyer: Aristro life style

Day: 11

Style no: AL001

Fabric Description: long sleeve t-shirt, Lycra fabric,

Color: white

Odr/Qty: 1000

Defects Name	Hour			Total
	09AM-10AM	10AM-11AM	11AM-12PM	
Stitch missing	1		1	2
Printing spot	2	1	1	4
Label missing	2		1	3
Oil spot	1		1	2
Raw edge				0
Improper joining				0
Fall of stitch				0
Improper placket				0
Broken stitch		1	1	2

Study on Finishing Faults in Garments Industry

Hole	1		1	2
Open seam	1	1		2
Reject				0
Uncut thread				0
Needle mark		1	1	2
Dirty spot				0

Total inspected Qty		198
Total passed Qty		179
Total Defective Qty		19
DHU% [Defect per 100 Unit]		9.57%.

Table 3.3.11 finishing report of poem fashion ltd

Indicates the individual faults per hour Finishing faults of day [1-11]. We inspected 3 hour everyday this 11 day.

Faults like Point up down, Measurement faults, Poly attaching faults, Oil spot, Dirty spot, ironing fault, Wrong bar coding etc. are found in finishing section.

3.4 SUMMARY TABLE

I am salehmohammadsanto&my id is 151-23-4103 and my partner name is RaselAhamedtuhin& his id is 151-23-4246. We are doing our internship at **poem fashion ltd**. Here we give a summary table about finishing section

Time / Day	Total Finishing fault name	Total no. of fault

Study on Finishing Faults in Garments Industry

Day 1	Stitch missing, printing spot, label missing, oil spot, improper joining. Hole ,open seam Needle mark dirty spot , reject	21
Day 2	Stitch missing, printing spot, label missing, oil spot improper joining. Hole , Reject ,open seam Needle mark dirty spot	18
Day 3	Stitch missing, printing spot, label missing, improper joining. Hole ,open seam Needle mark, fall of stitch	22
Day 4	Oil spot, printing spot, label missing, oil spot, improper joining. Hole , broken stitch ,Needle mark, dirty spot , fall of stitch	19
Day 5	Label missing, oil spot, improper joining. Improper placket ,Hole , broken stitch ,open seam Needle mark dirty spot	23
Day 6	Stitch missing, label missing, oil spot, improper joining. Hole , broken stitch ,open seam Needle mark dirty spot, improper placket	21
Day 7	Label missing, improper placket, improper joining. Hole ,open seam Needle mark dirty spot	16
Day 8	Stitch missing, labelmissing, oil spot, improper joining. ,open seam ,Needle mark, improper placket	14
Day 9	Stitch missing, label missing, oil spot, improper joining. Hole, broken stitch, open seam Needle mark, improper placket.	15
Day 10	Stitch missing, label missing, oil spot, improper joining. ,open seam ,Needle mark , improper placket	13

Table 3.4.1 Summary table of Finishing section of poem fashion ltd

Study on Finishing Faults in Garments Industry

SL No.	Defects Name	Total number of defects (in 10 Days)
1	Label missing	35
2	Improper joining	26
3	Needle mark	21
4	Improper placket	17
5	Fall of stitch	15
6	Stitch missing	14
7	Printing sport	14
8	Hole	13
9	Broken stitch	12
10	Open seam	12
11	oil spot	10
12	Dirty spot	8
13	Uncut thread	2
14	Reject	1
15	Raw edge	0

Table 3.4.2: Summary table of Total no. of finishing faults [Day 1-11]

Study on Finishing Faults in Garments Industry

Buyer Name	Total cutting	Total sewing	Total finishing	Remarks	Defects that can be solved	Defects that's cannot be solved
FashionTex [women short and long sleeve]	5100	5100	4950	This 125 garments are resend in sewing section for solved the problem	98 pcs garments are solved <ol style="list-style-type: none"> 1. Stitch missing 2. Label missing 3. Improper placket 4. Open seam 	27 products cannot be solved <ol style="list-style-type: none"> 1. Hole [4] 2. Printing spot [9] 3. Dirty spot [4] 4. Oil spot [6] 5. Pin hole [4]
FashionTex [men short and long sleeve]	5100	5100	5031	This 69 garments are resend in sewing section for solved the problem	52 garments are solved <ol style="list-style-type: none"> 1. stitch missing 2. open seam 3. label missing 4. uncut thread 	17 garments cannot be solved <ol style="list-style-type: none"> 1. Hole [3] 2. Printing spot [7] 3. Dirty spot [4] 4. Oil spot [3]
Good man [Men long sleeve]	4090	4090	3962	This 128 garments are resend in sewing section for solved the problem	104 garments are solved <ol style="list-style-type: none"> 1. Broken stitch 2. Label missing 3. Stitch missing 4. Open seam 	24 garments can not be solved due to major faults <ol style="list-style-type: none"> 1. Pin hole [5] 2. Printing spot [11] 3. Needle mark [4] 4. Dirty spot [4]
Aristro life style [HUDI]	1510	1510	1493	This 17 garments are resend in sewing section for solved the problem	9 garments are solved <ol style="list-style-type: none"> 1. Stitch missing 2. Label missing 3. Open seam 	8 garments cannot be solved <ol style="list-style-type: none"> 1. Dirty spot [3] 2. Hole [3] 3. Needle mark [2]
Aristro life style [men long sleeve]	3520	3520	3450	This 70 garments are resend in sewing section for solved the problem	57 garments are solved <ol style="list-style-type: none"> 1. Stitch missing 2. Label missing 3. Broken stitch 4. Open seam 	13 garments cannot be solved <ol style="list-style-type: none"> 1. Hole [4] 2. Printing missing [5] 3. Dirty spot [3] 4. Pin hole [1]

Table 3.4.3: Summary table for production report

CHAPTER-IV
DISCUSSION OF RESULTS

Study on Finishing Faults in Garments Industry

4.1 Graphical analysis of production report for shirt

Here in fashion Tex total order was 5000 pcs men short and long sleeve and they cutting total 5100pcs. From there we got total defected garments is 125 pcs. Then these 125 pcs garments they sent to sewing section to resolve the problem. When we received the garments from sewing section we got 52 pcs solved garments and 17 garments cannot be solved. Here this graph shown the no. of defects pcs which cannot solved

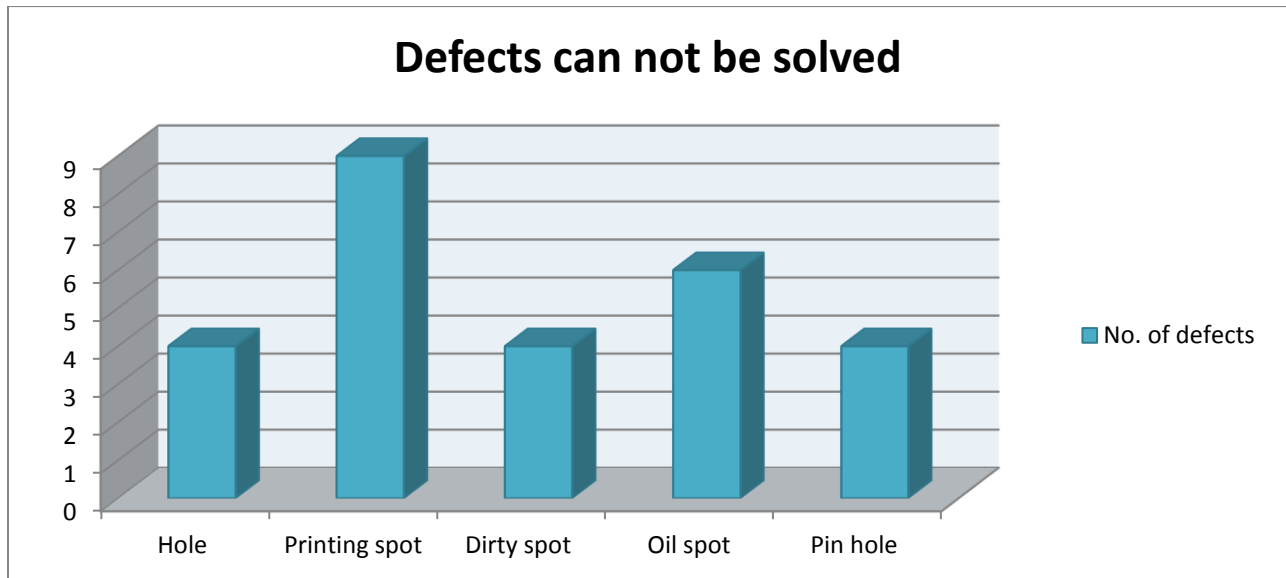


Figure 4.1.1 Graphical analysis of production report

4.2 Graphical analysis of production report for shirt

Here in Good man total order was 4000 pcs men long sleeve and they cutting total 4090pcs. From there we got total defected garments is 128 pcs. Then this 128 pcs garments they sent to sewing section to resolve the problem. When we received the garments from sewing section we got 104 pcs solved garments and 24 garments cannot be solved. Here this graph shown the no. of defects pcs which cannot solved

Study on Finishing Faults in Garments Industry

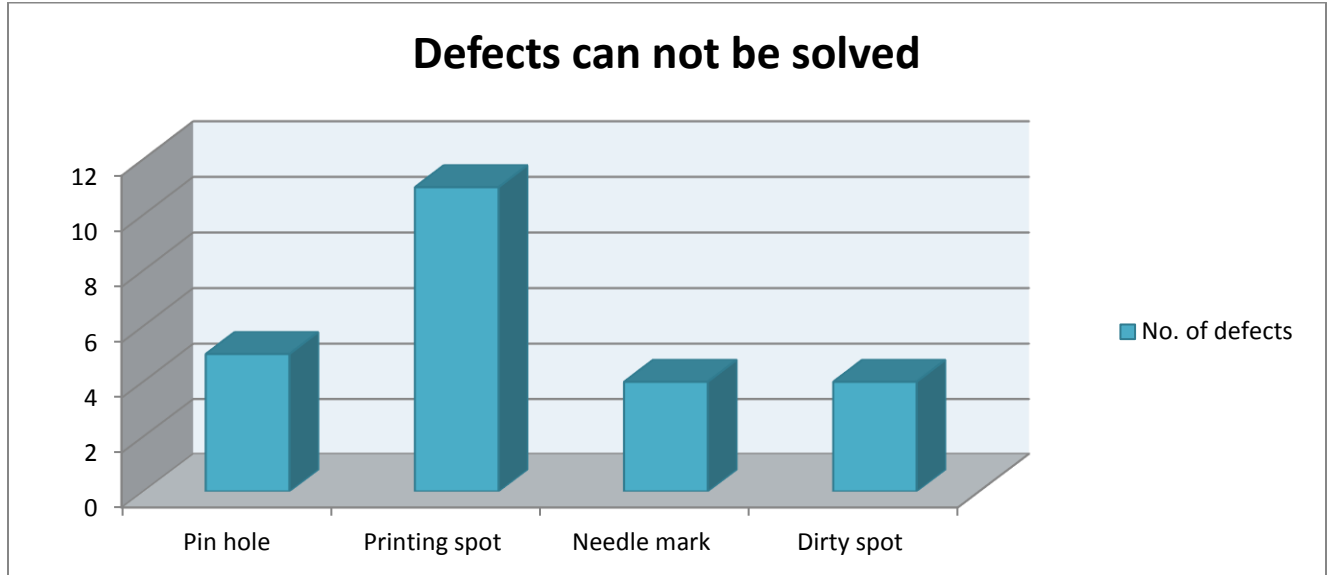


Figure 4.1.2. Graphical analysis of production report

4.3 Graphical analysis of production report for shirt

Here in Aristro life style total order was 1500 pcs hudi and they cutting 1510 pcs. From there we got total defected garments is 128 pcs. Then this 128 pcs garments they sent to sewing section to resolve the problem. When we received the garments from sewing section we got 104 pcs solved garments and 24 garments cannot be solved. Here this graph shown which defect cannot be solved .

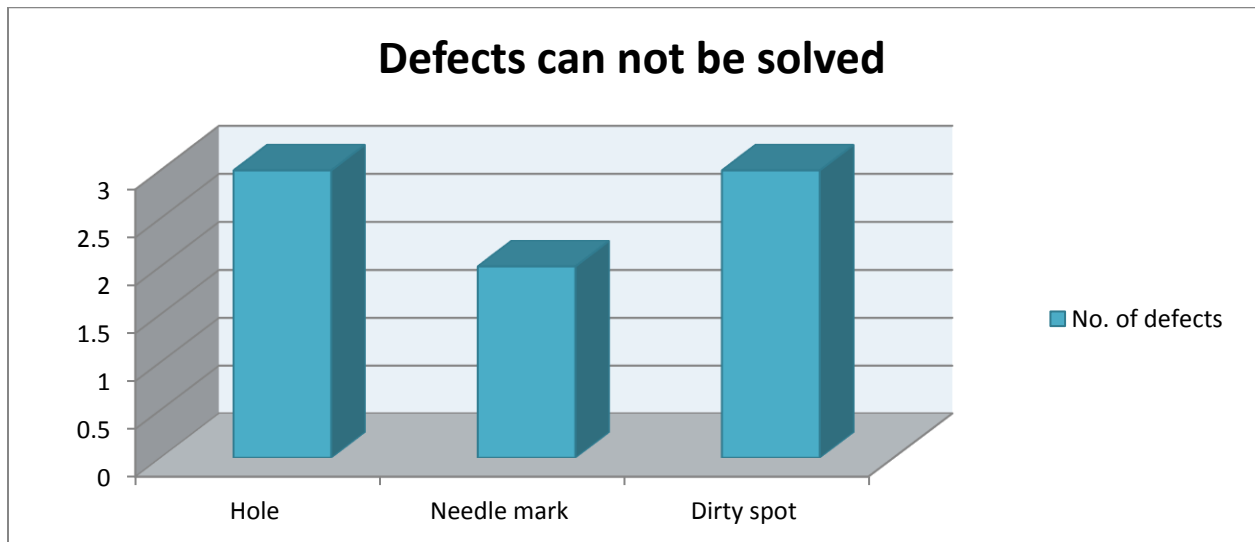


Figure 4.1.3 Graphical analysis of production report

Study on Finishing Faults in Garments Industry

4.4 Graphical analysis of production report for shirt

Here in Aristro life style total order was 3500 pcs men long sleeve and they cutting 3520 pcs .From there we got total defected garments is 70 pcs. Then this 70 pcs garment they sent to sewing section to resolve the problem. When we received the garments from sewing section we got 57 pcs solved garments and 13 garments cannot be solved. Here this graph shown which defect cannot be solved

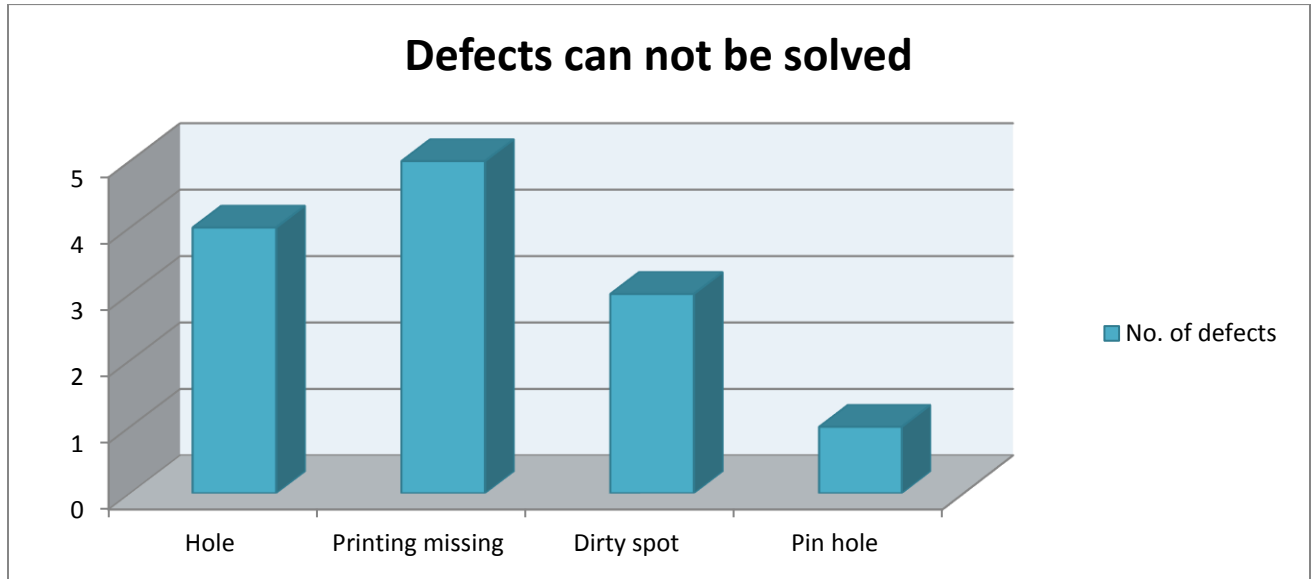
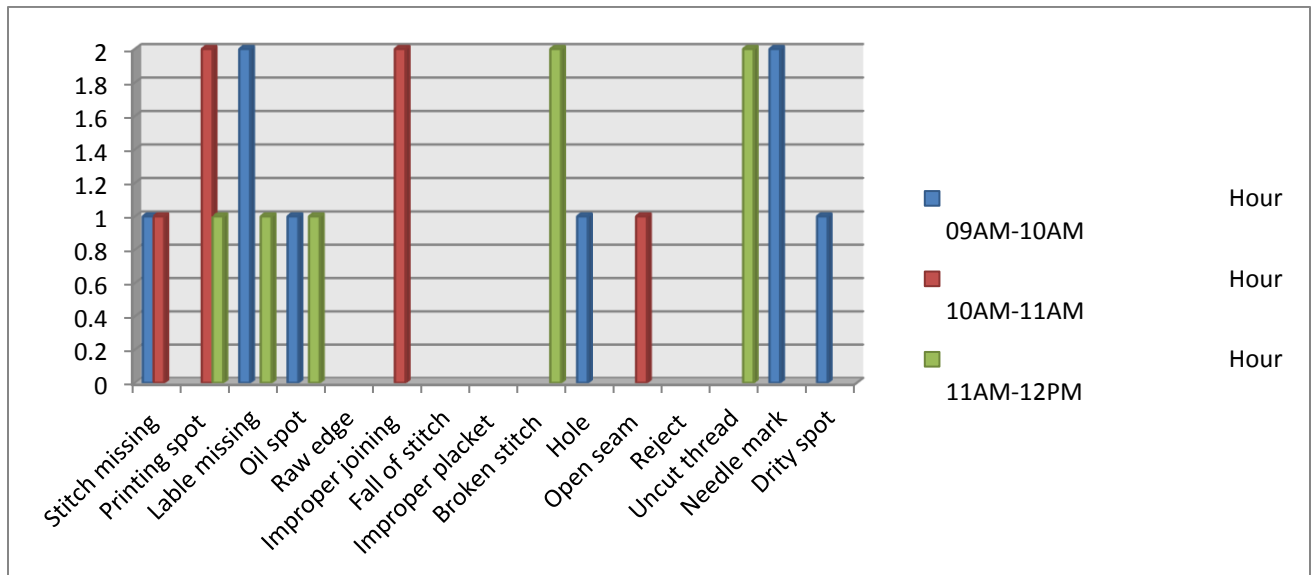


Figure 4.1.4 Graphical analysis of production report

4.5 Graphical analysis of finishing report for shirt

In finishing sector of poem fashion ltd we inspected 11 day every 3 hour and we found some defects. Here we give a graphical report of DAY [1 -10]



Study on Finishing Faults in Garments Industry

Figure 4.5.1 Graphical analysis of finishing report[Day 1]

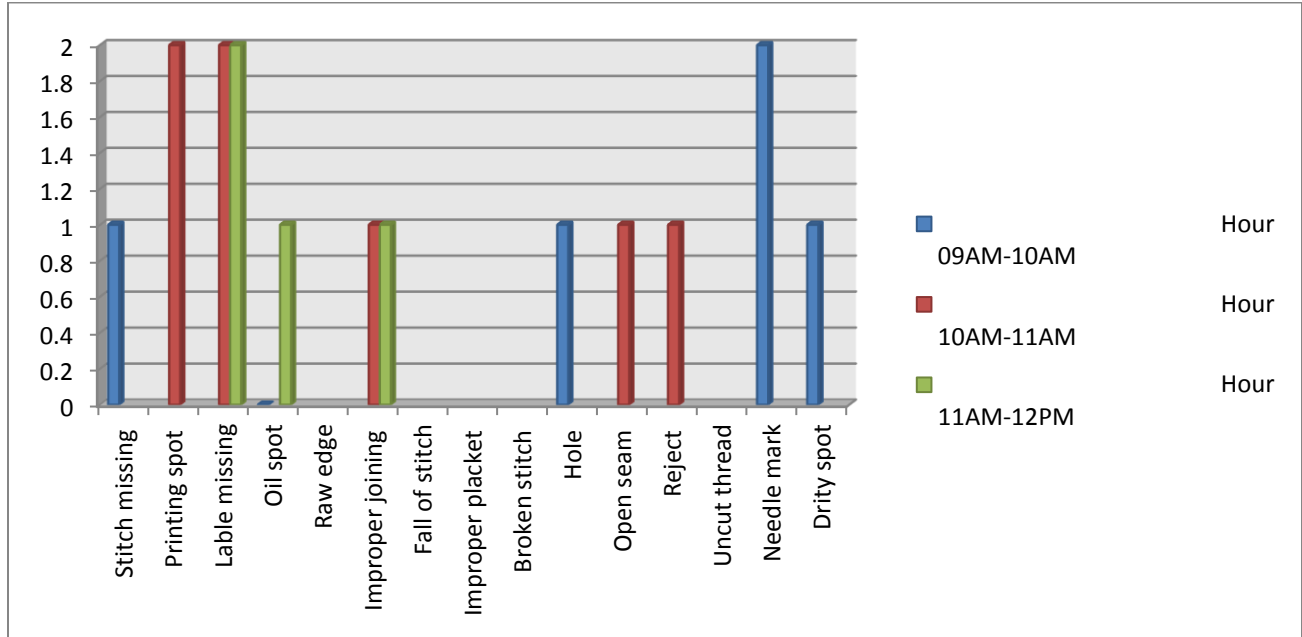


Figure 4.5.2 Graphical analysis of finishing report [Day 2]

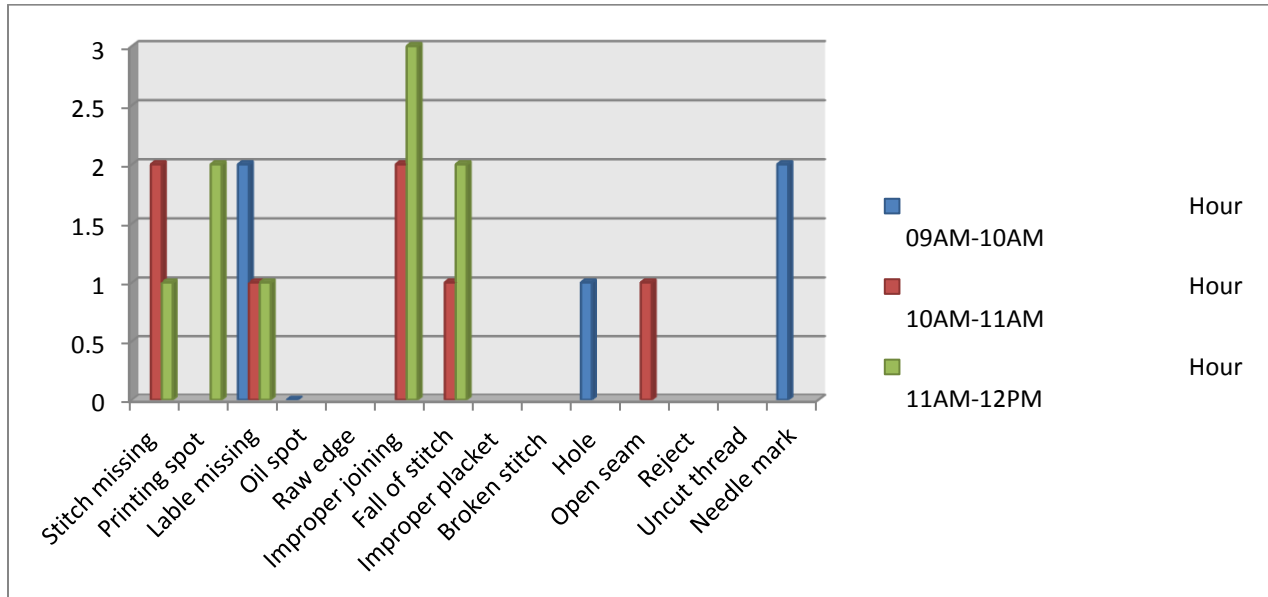


Figure 4.5.3 Graphical analysis of finishing report [Day 3]

Study on Finishing Faults in Garments Industry

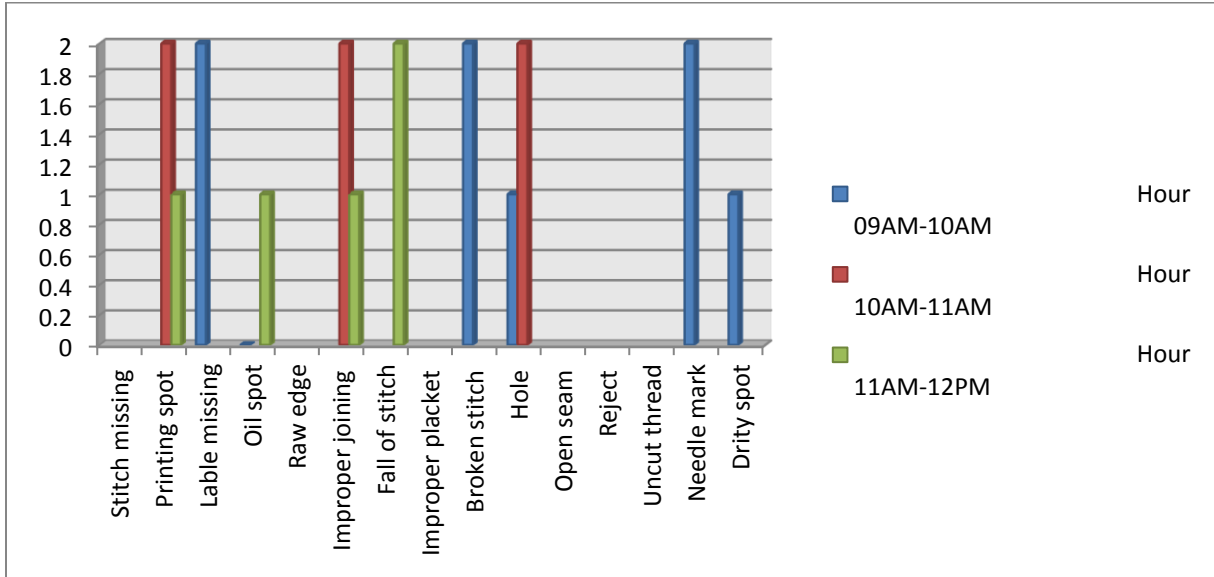


Figure 4.5.4 Graphical analysis of finishing report [Day 4]

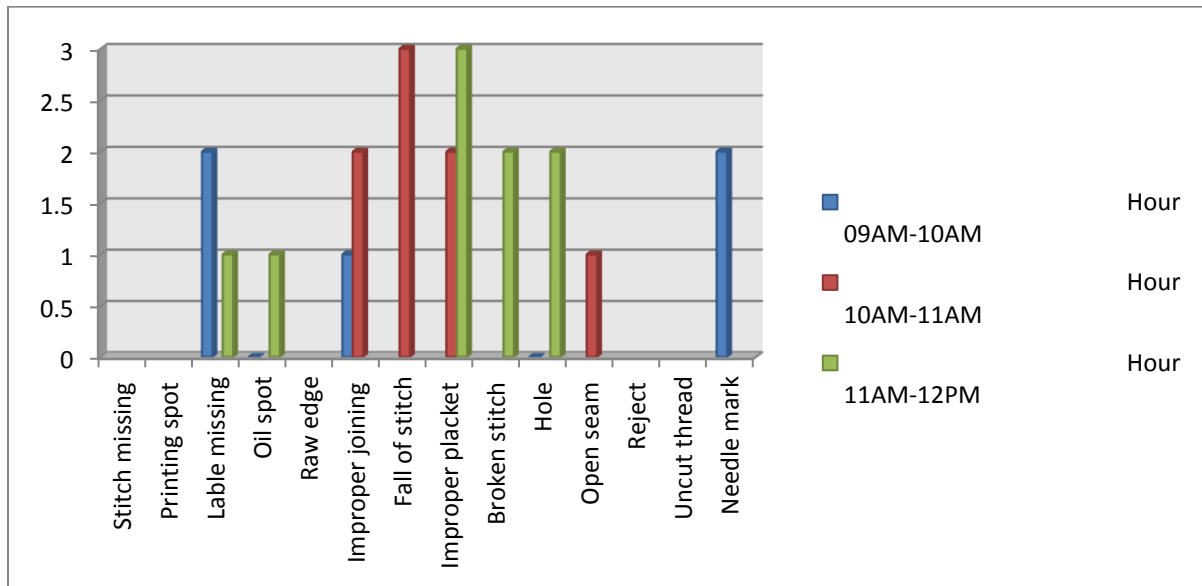


Figure4.5.5 Graphical analysis of finishing report [Day 5]

Study on Finishing Faults in Garments Industry

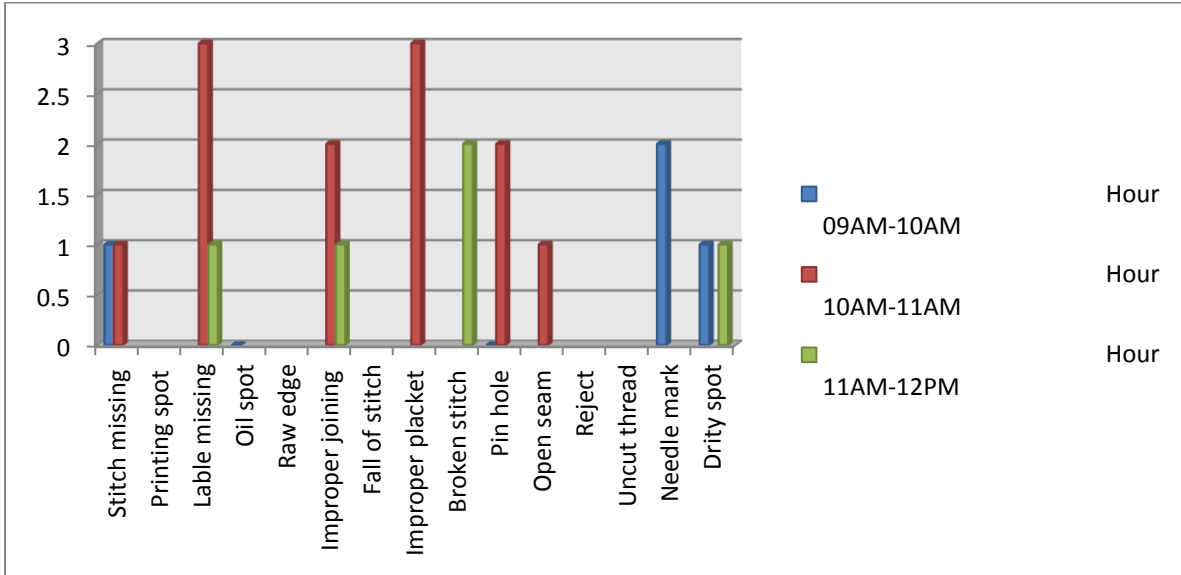


Figure 4.5.6 Graphical analysis of finishing report [Day 6]

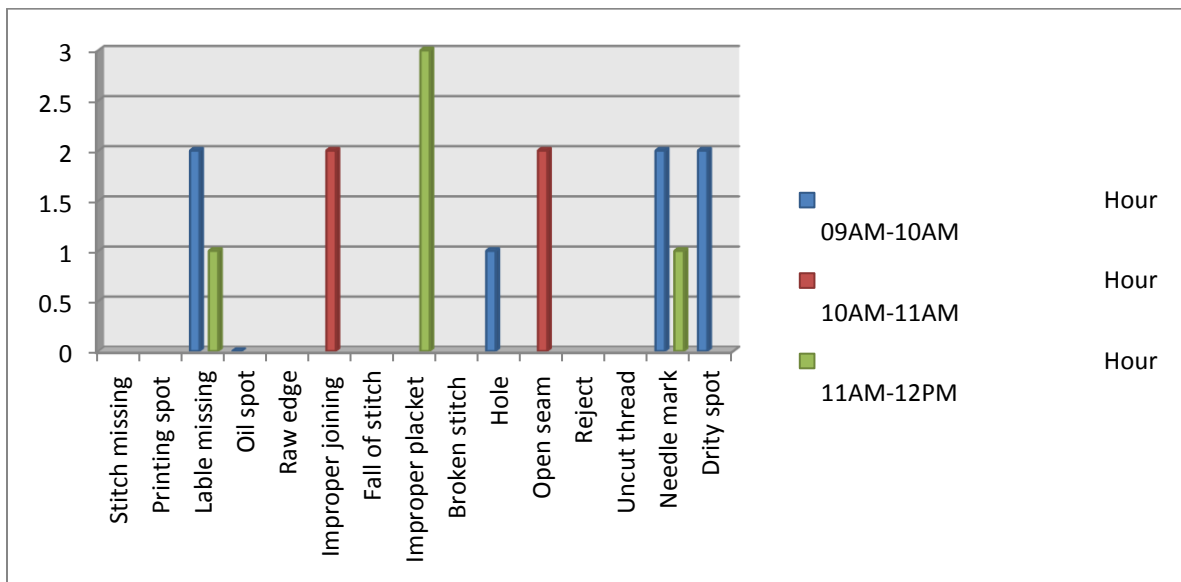


Figure 4.5.7 Graphical analysis of finishing report [Day 7]

Study on Finishing Faults in Garments Industry

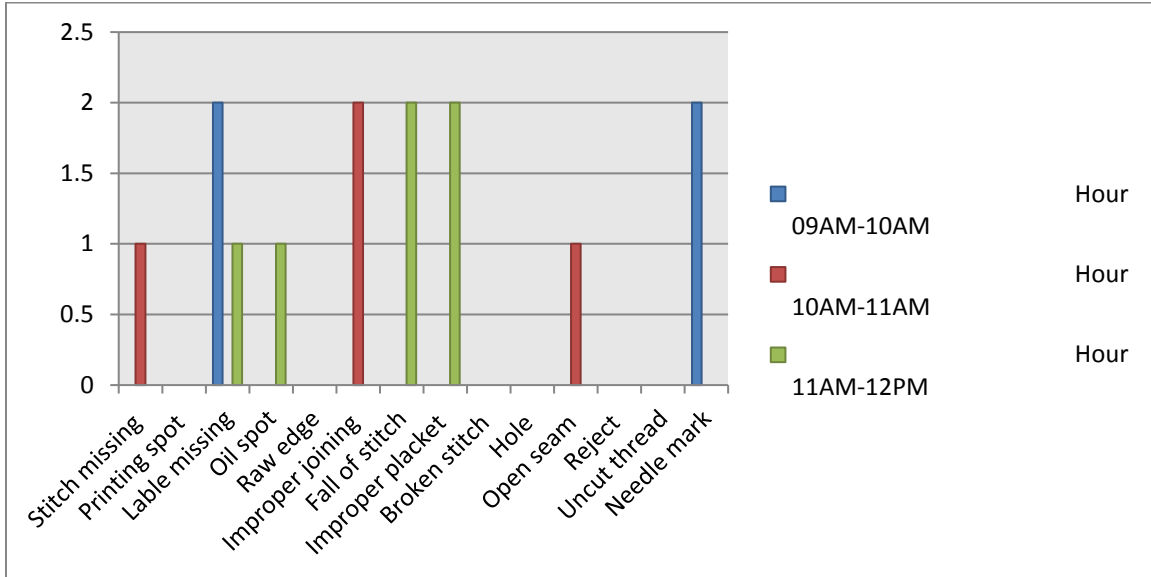


Figure 4.5.8 Graphical analysis of finishing report [Day 8]

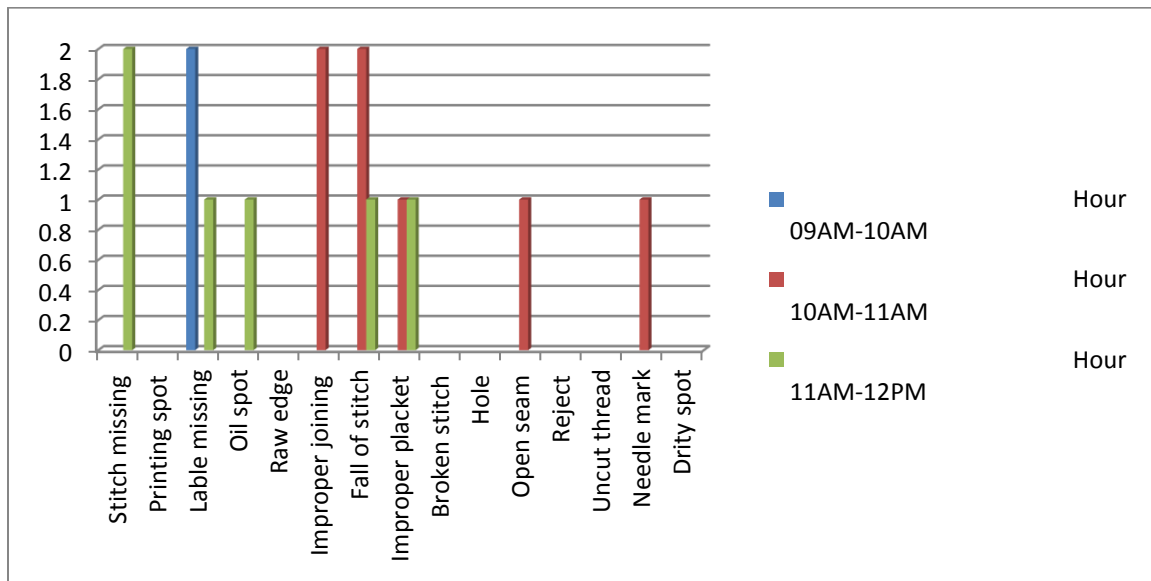


Figure 4.5.9 Graphical analysis of finishing report [Day 9]

Study on Finishing Faults in Garments Industry

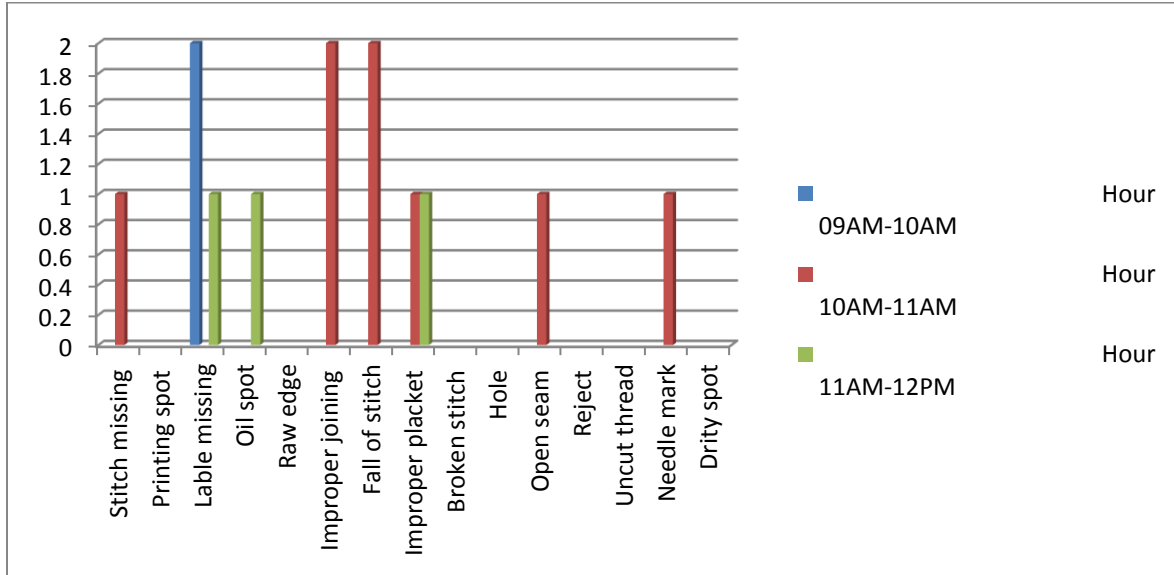


Figure 4.5.10 Graphical analysis of finishing report [Day 10]

Here we totally give 10 day bar chart but we inspected total 11 day. We inspected everyday 3 hour here this bar chart show how many no. of defects we found every 3 hour in 11 day . Day 1 we found totally 21 defects , Day 2 found 18, Day 3 found 22, Day 4 found 19 , Day 5 found 23, Day 6 found 21 , day 7 found 16 , day 8 found 14, Day 9 found 15 , day 10 found 13 and day 11 we found 19 defects .

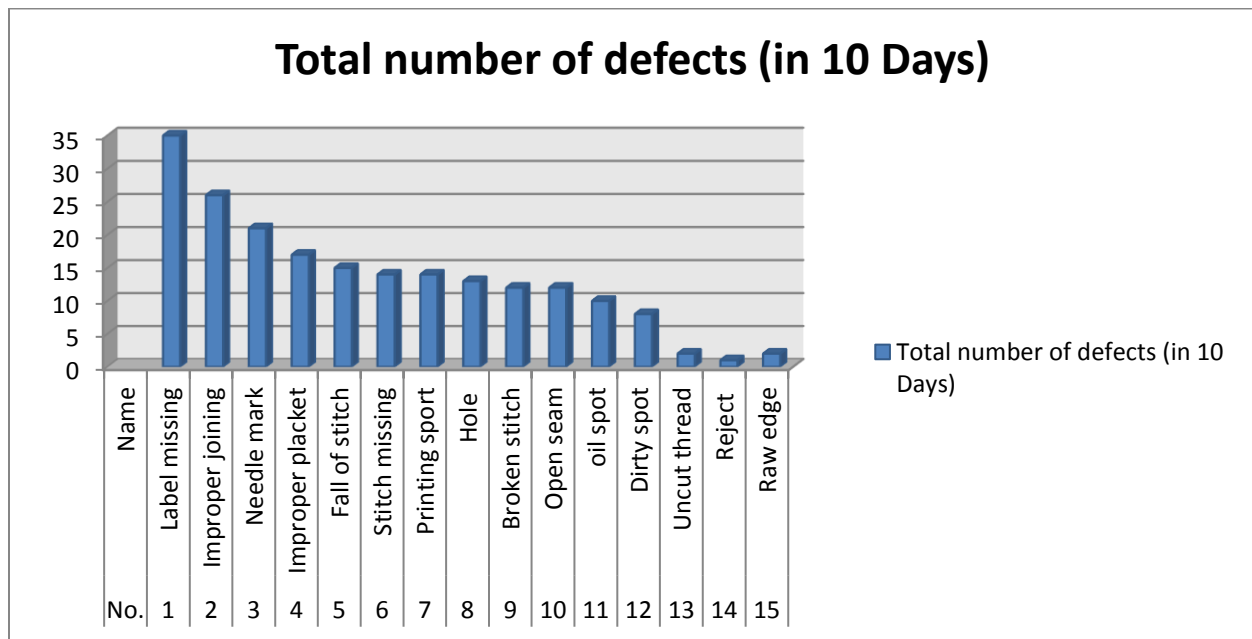


Figure 4.5.11 Graphical analysis of maximum and minimum no. of defects.

Study on Finishing Faults in Garments Industry

In poem fashion ltd we inspected garments and try to find some finishing & sewing faults in 11 day. Every day we inspected three hour. In this 11 day, maximum no. of defects name label missing. Totally 35 garments we found in this 11 day and we also found one totally reject garments.

CHAPTER- V
CONCLUSION

5.1 Conclusion

Finishing section play the vital role of a knit garments industry and the production shipment. Now a day buyer required special requires quality of a products .We are doing our internship at POEM FASHION LTD. By doing this internship we are known /learn about cutting section , sewing section , and finishing section .In Cutting section ,at first we learn about pattern, how to make pattern , how to marker making .According to buyer measurementcutting operator at first make pattern then they spread the fabric and cut the fabric according to pattern . In every order they make new pattern of new design .In sewing section, which is most important process, after cutting section garments send to sewing section. They seam the every part separately. Then they send to finishing section .In finishing section, QC worker inspect every products, worker check their have any defect or fault have in garments. If they find any kind of fault or defect then they divided those garments and again send to sewing section to re solved the problem. In finishing section we inspected every three hour in 10 day.From day one to ten we inspected totally 2196 garments and total passed quantity 2015. From we found total 182 defects garments .Then we send this defects garments to the sewing section to resolved problem.

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