



Faculty of Engineering
Department of Textile Engineering

REPORT ON
Industrial Attachment
At
Daeyu Fashions ltd

Vannara, Konabari, Gazipur, Bangladesh

Course Title: Industrial Attachment
Course Code: TE431

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

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Letter of Approval

December 01, 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” has been prepared by the student bearing ID 143-23-4022 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. Abdullah Al Mamun

Assistant Professor

Department of Textile Engineering

Faculty of Engineering

Daffodil International University

DECLARATION

I am hereby that the work which is being presented in this report entitled, “**Daeyu Fashions Ltd**” is original work of my own under the supervision of **Md. Abdullah Al Mamun**, Assistant Professor, Department of Textile Engineering, Daffodil International University. I also declare that there has not been presented for a degree of any other university and all the resources of collection information for this report have been duly acknowledged.

Submitted By:

.....

Diptaraj Datta

ID: 143-23-4022

Dept. of Textile Engineering

Daffodil International University

Acknowledgement

At first my gratefulness goes almighty to give me strength and ability to complete the industrial and this report.

Now I wish to take this opportunity to thank a lot of people who have assisted and inspired me in completion of my training period.

Md. Abdullah Al Mamun, Assistant Professor of Daffodil International University my supervisor, to whom I am extremely indebted for his tremendous support and guidance throughout my training period. Being working him I have not only earned valuable knowledge but also inspired by his innovativeness which helped enrich my experience to greater extent. His idea and way of working was truly remarkable.

I am also expressing our gratitude to **Prof. Dr. Mahbubul Haque**, Head, Department of Textile Engineering, for his support and continuous guidance throughout my long journey in Daffodil International and industrial training.

I would like to thanks the management of “**Daeyu Fashions Ltd.**” for giving me opportunity to do the industrial training successfully and also their valuable suggestions. It is a great pleasure to express my satisfaction to The Daeyu Fashions Ltd. Authority for their sincere and cordial co-operation and I am very much indebted to **Md. Ruhul Amin, Production Manager**, for his association in completion of our training successfully. My training would never been completed without his convenient helps and supports.

Finally, I must acknowledge our Parents with due respect for their constant support, patients and believe on our ability which drives us in the successful completion of this report.

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Chapter-1

Executive Summary

1.1 Executive Summary:

This report presents a conception of Textile sector especially of Daeyu fashions Ltd and tries to clarify the overall processes required to complete a garment from threads. Two months long training is not enough to capture all the information related to textile but it is possible to overview of all the departments. Union group is a large group in where it is impossible to gather information about all the departments. The factory has a nice system for the internship students that are the training schedule provided by the authority. There are several departments in Daeyu fashions Ltd of them cutting, finishing and merchandising department are the major ones. There are also other departments those act as supporting of them. This report illustrates that how a fabric manufacturing and fabric for garments. It also 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. This report may be a guideline for other small industries to become large in size and for students or other people to learn a little about Daeyu fashions Ltd. without visiting.

Chapter-2

Information about Factory

2.1 Introduction:

By means of the practical knowledge it's possible to apply the theoretical knowledge in the practical field. For any technical education practical experience is almost equally important in association with the theoretical knowledge.

The industrial attachment is the process which builds understanding skills and attitude of the performer, which improves his knowledge in boosting productivity and services. University education provides us vast theoretical knowledge as well as more practical attachment, despite all these industrial attachment help us to be familiar with the technical support of modern machinery, stillness about various operation stages.

It also provides us sufficient practical knowledge about production management, productivity evaluation, work study, efficiency, industrial management, production planning and control, production cost analysis, inventory management, purchasing, utility and maintenance of machinery and their operation techniques etc. the above mentioned cannot be achieved successfully by means of theoretical knowledge only. This is why it should be accomplished with practical knowledge in which it is based on industrial attachment makes us reliable to accustomed with the industrial atmosphere & improve courage & inspiration to take self-responsibility.

I have prepared this report as required in completion of my attachment course in regarding guideline given by the university authority which will lead to a strong guideline and milestone for our future carrier.

2.2 Daeyu Fashions Ltd.

Where we completed our Industrial Attachment, is a sister concern of Union Group. It is one of the leading groups of companies in the field of Textile sector of Bangladesh. It has a bunch of organizations under its ownership.

2.3 Daeyu Fashions Ltd. at a glance:

1. Name of the Factory : Daeyu Fashions Ltd.
2. Factory Proponent : Union Group

3. Type : Garments.
 4. Location : Vannara, Mouchak, Konabari, Gazipur
 5. Corporate Head office :“Union Centre” (6thfloor) 68/1,
Gulshan Avenue, Dhaka-1212
 6. Tel :+88029885771-2,+8802985696
 7. Fax : +880-2-9843454
 8. Factory : Vannara, Mouchak, Konabari, Gazipur
9. Daily Production Capacity: Capable to sewing minimum 15000 pcs garments.

2.4 Mission:

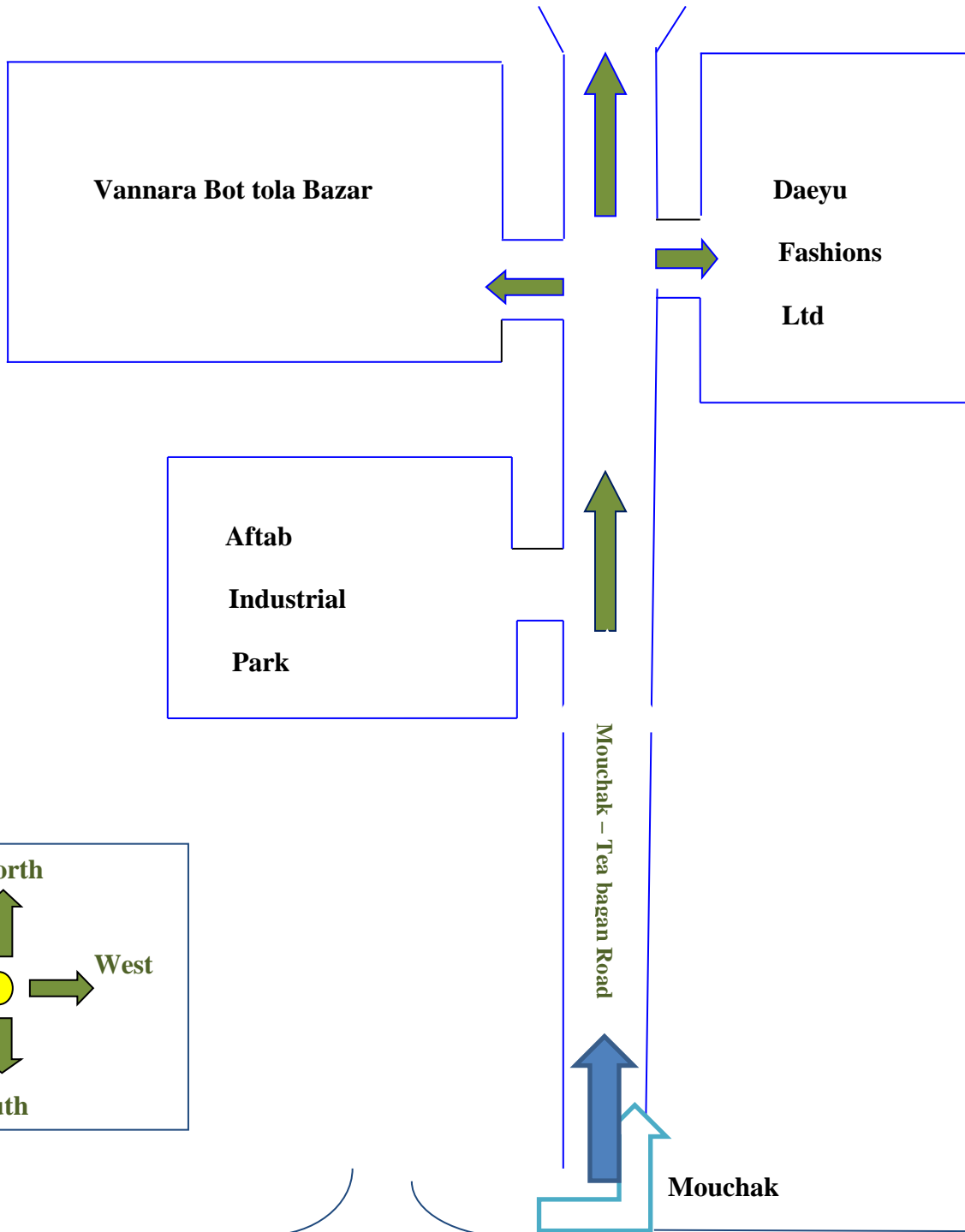
Each of our activities must benefit and add value to the common wealth of our society. We firmly believe that, in the final analysis we are accountable to each of the constituents with whom we interact; namely, our employees, our customers, our business associates, our fellow, citizens.

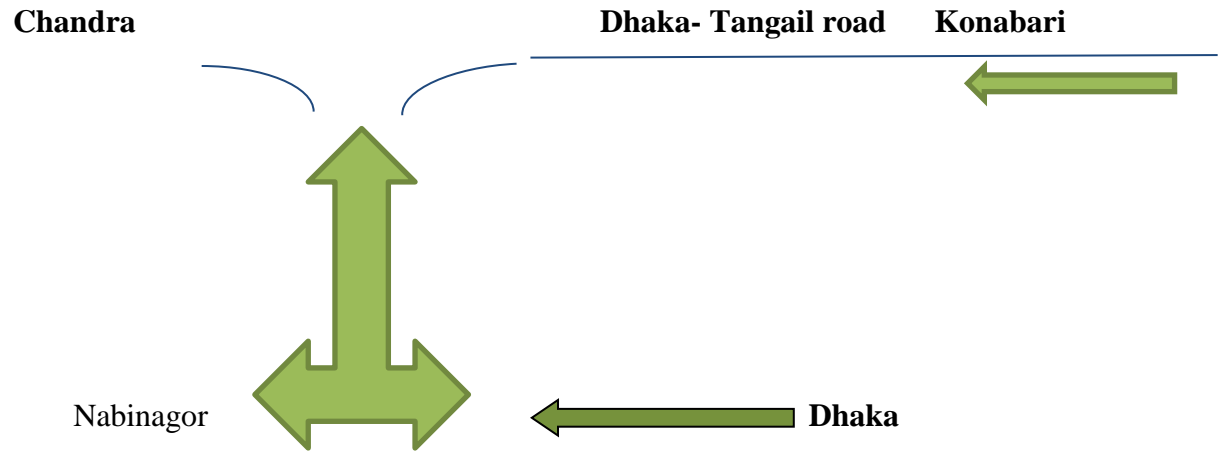
2.5 Vision:

1. To be one of the best leading lingiere garments in Bangladesh
2. To build a true marketing led enterprise with motivated workforce, innovative vision & more value satisfaction & understanding of global market.

2.6 Certification & Award: Certified by BSCI. Application for ACCORD and ALLIANCE certificate, which is on processing.

2.7 Site Location:

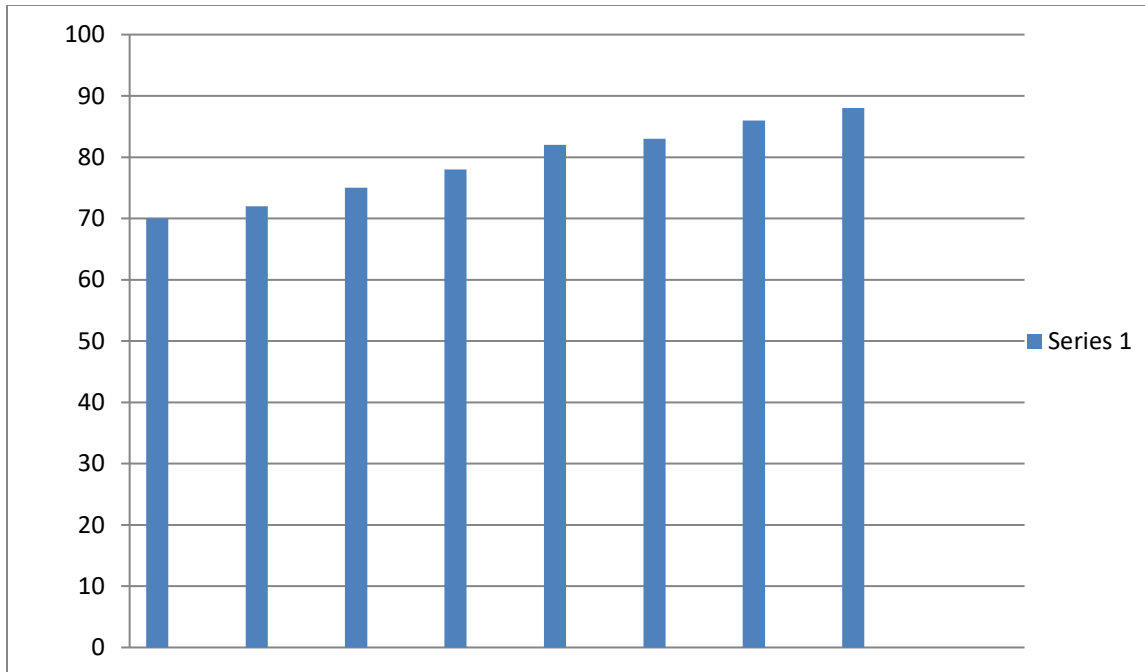




2.8 Sister concern of Union Group:

 <p>DAEYU BANGLADESH LTD</p>	
 <p>Union Properties Ltd.</p>	 <p>SAM REE</p>
 <p>malaysia airlines</p>	 <p>UNION Tours & Travels Limited</p>
 <p>WATCHES WORLD</p>	 <p>UTS union tour services ltd</p>

2.9 Export growth by graph:



2.10 Product mix:

All lingiere items, mans underwear items

2.10.1 Knitted Grey Fabric:

Single Jersey, Double Jersey, S/J Lyc, Rib, 1X1 Rib Cotton Lyc, Interlock, Lacoste, all kinds of Pk, Engineering Stripe, waffle, Jersey twill, Terry, Flicee, Terry Flicee, Net Fabrics and so on.

2.10.2 Knit Garments:

Men's (Boxer,Boxer, Tank top etc)

Landis's, (Bra,Panty,Bikini etc)

Moa Tank Top

Ladies Kart

Ladies Nighty.

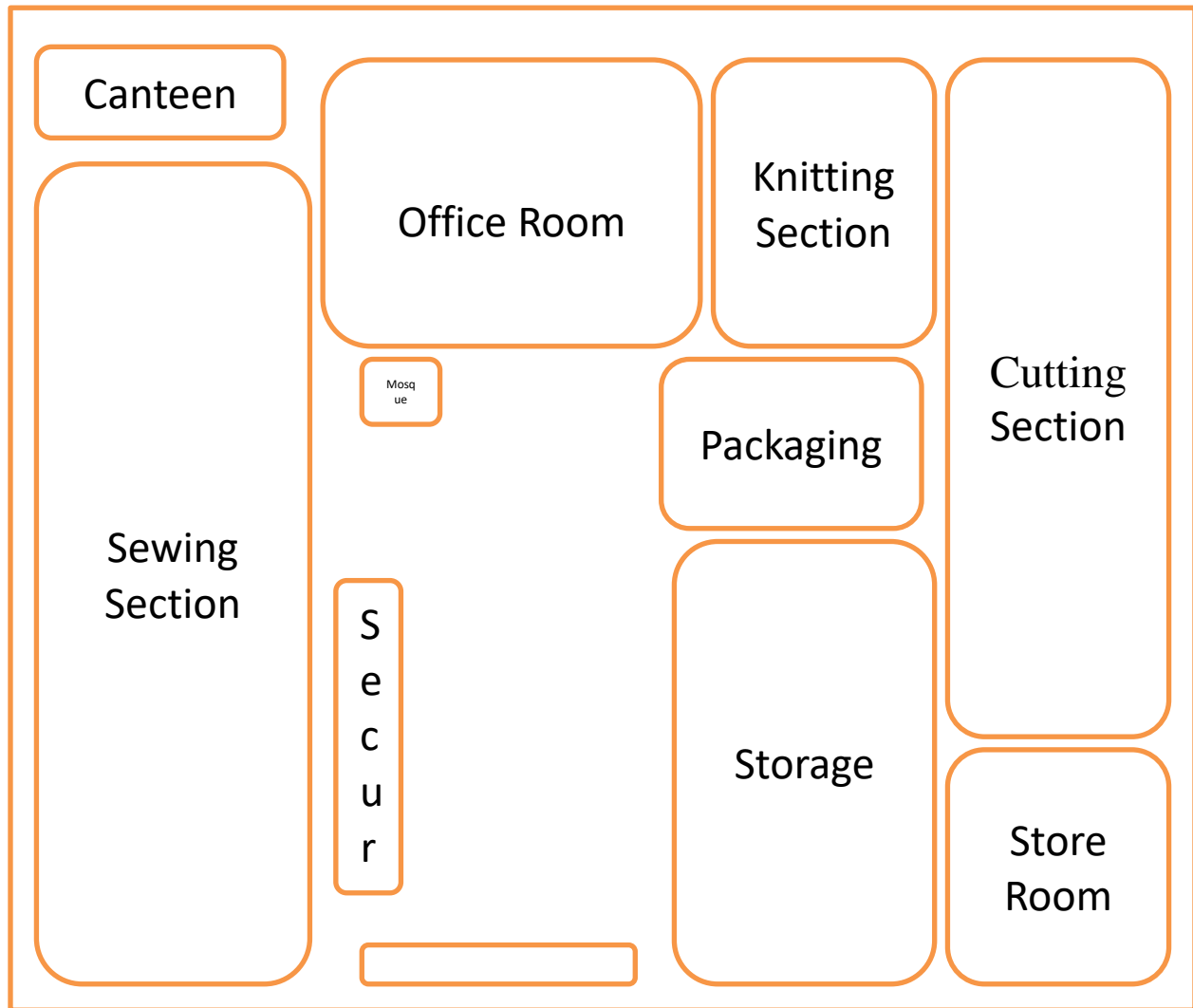
2.11 Major buyer:

1. Nayomi
2. Grafton
3. Bonprix
4. La-halle
5. Europtex

2.11.1 Logo:



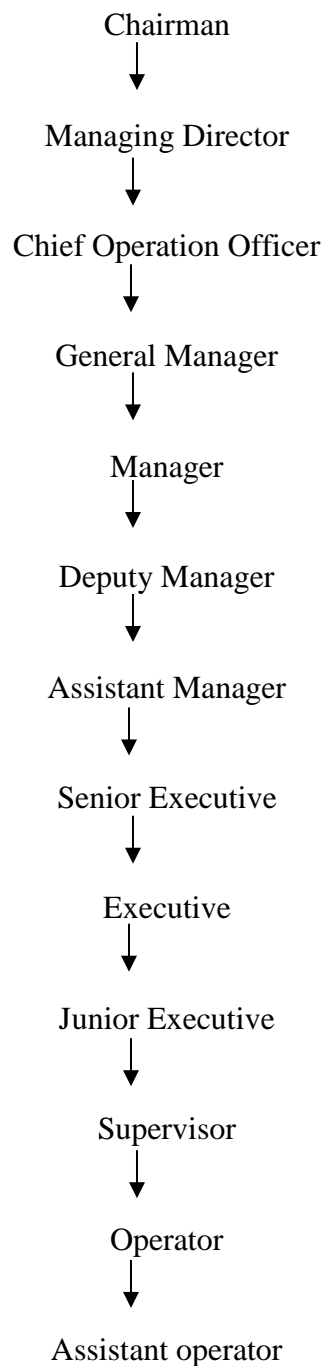
2.12 Layout:



2.13 Organogram:

Organgram of Daeye Fashions Ltd.:

Daeyu Fashions Ltd. is well equipped with highly efficient team of management, which is very essential for smooth running of a factory.



Chapter-3

Description of the Attachment

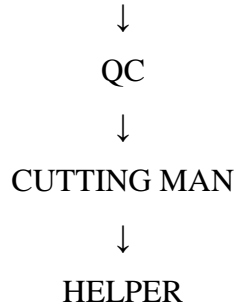
3.1 Sample Section:



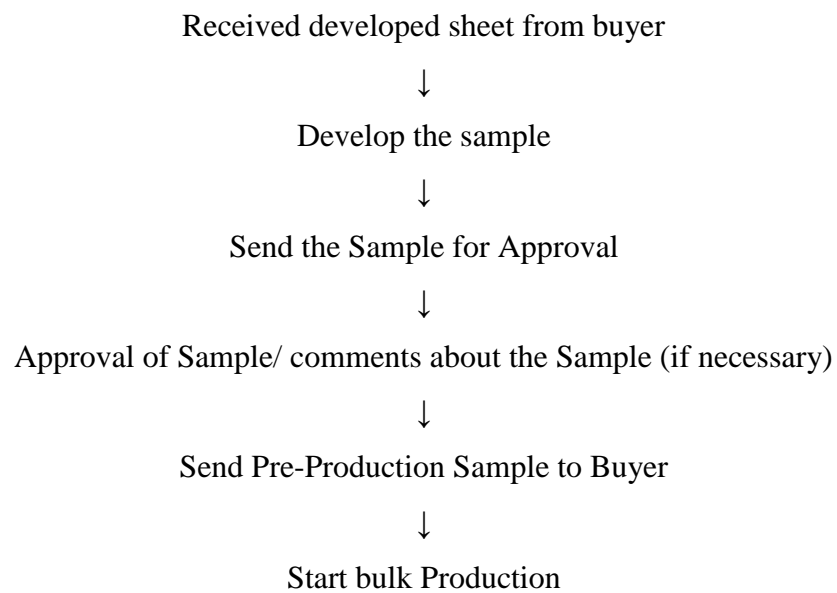
Fig: 3.1 Sewing



Fig: 3.1 Sewing



3.1.3 Process Flow Chart of Sample Section:



3.1.4 Machineries of Sample Section:

Types of Machine	No. Of Machine
Plain M/C	3
Over Lock M/C	4
Flat Lock M/C	3
Button Hole M/C	1
Piping M/C	1
Button Attaching M/C	1

Zigzag Plain M/C	2
Bar Tack M/C	1
Chancha M/C	1
Punch M/C	1
Chain Stitch M/C	1
Total M/C	19

3.1.5 Major Operation carried out by Sample Section:

Garments Design/ Sketch



Basis block



Working Pattern



Fabric cutting



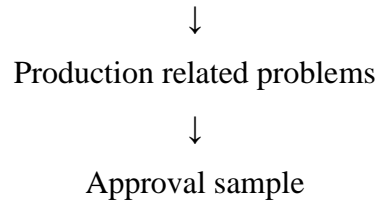
Sewing



Finishing



Sample Garments



3.1.6 Types of Sample Produce:

Serial no.	Sample	Use
01	Development Sample	To convert the pattern into actual garment.
02	Size set / Fitting Sample	To fit the styling of the garment.
03	Counter Sample	Sample against comments on develop sample
04	Pre-Production (PP) Sample	To gain approval before the Bulk Production.
05	Production Sample	To gain approval for shipping the garment
06	Sales Man Sample (SMS)	To gain approval for bulk production
07	Shipment Sample	For shipping by buyer

3.1.7 Pattern Making of Sample Section:

In sample section pattern are made by two pattern master who make pattern by using measurement sheet manually.

Fig: 3.1.7.1 Sample Pattern.

3.1.8 Cutting in Sample Section:

According to pattern marker drawn on fabric then cutting is done manually by scissor.



Fig: 3.1.8.1 cutting in sample.

3.2 Cutting Section:

In garments industries fabric spreading accurately then it cut out the components of a garment as per exact dimension of the patterns/marker from a fabric lay is called fabric cutting. It is totally different from general cutting in which exact dimension is not taken into account. The term fabric cutting is only applicable for Garments Manufacturing Technology.

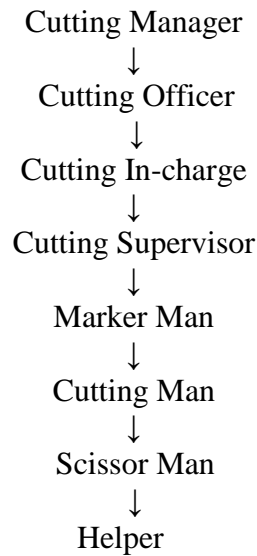


Fig: 3.2 Fabric Cutting

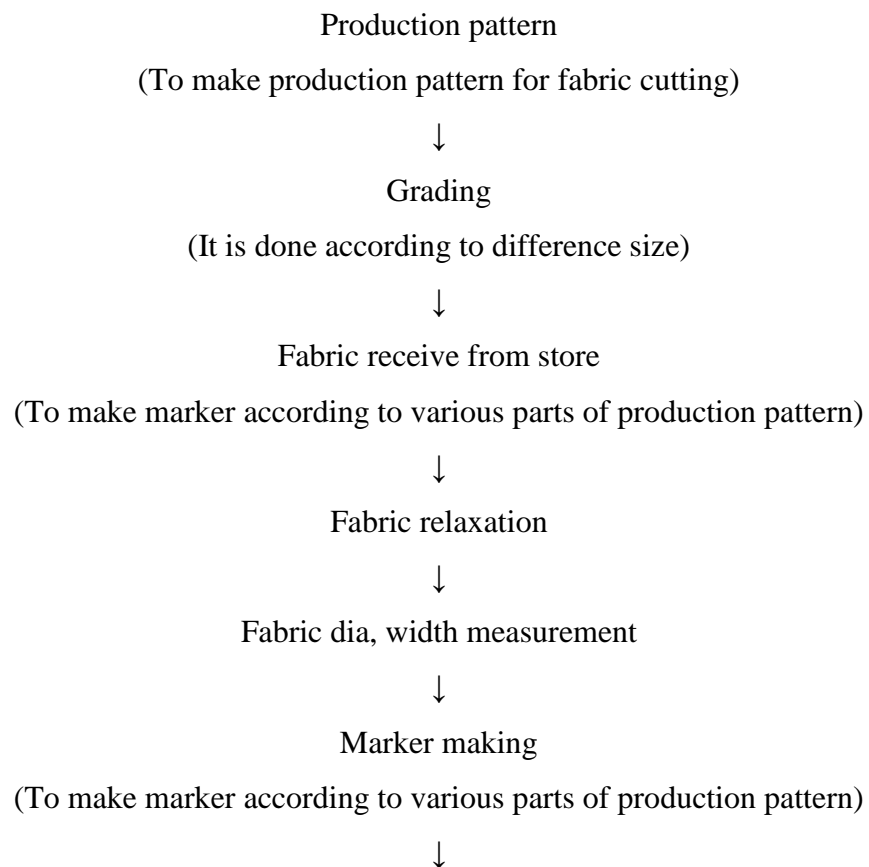
3.2.1. Layout of Cutting Section:

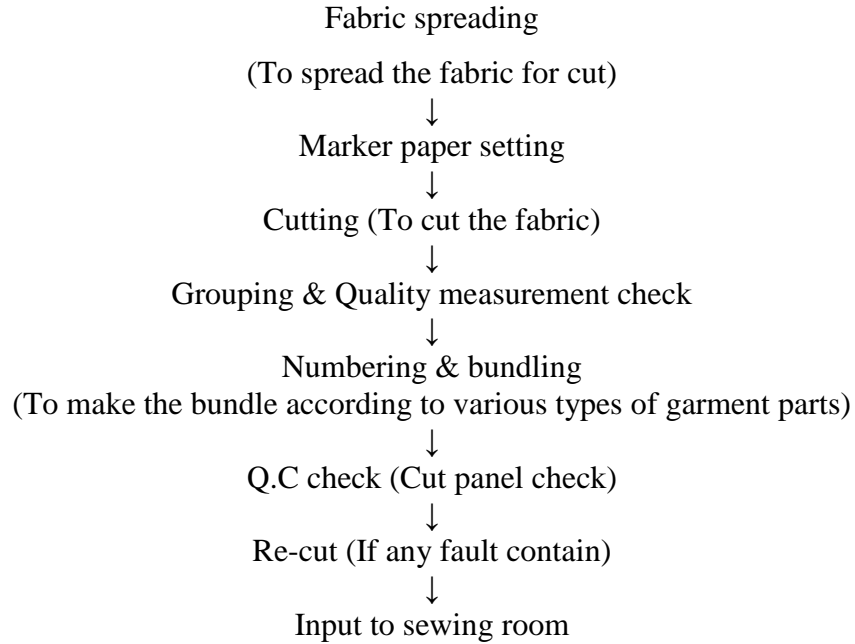


3.2.2. Organogram:



3.2.3. Process Flow Chart of Cutting Section:





3.2.4. Machineries of Cutting Section:

Machine name	Number of Machine
Piping rolling machine	1
Piping cutting machine	1
Straight knife cutting machine	7
Brand knife cutting machine	5
Spreading machine	2

3.2.4.1 Straight Knife Cutting Machine:

Straight knife cutting machine:

- Machine name: STREAK II cloth cutting m/c
- Model: 629X
- Producer: made by EASTMAN Machine co. USA
- Type: Heavy duty industrial cloth cutting m/c self-Sharpener
- Dimension: 8 inch width * 11 inch length * 24 inch height Weight: 33.5 lb.
- Current: A.C 220 V (4.2 AMPS), Speeds: 2850

Machine parts of Straight knife Cutting machine:

- Base plate
- Terminal block
- Plug
- Clamp washer
- Pressure foot
- Blade
- Sharpener pulley
- Pulley spring
- On/off switch



Fig: 3.2.4.1 Straight knife cutting machine

3.2.4.2 Spreading Machine:

Spreading is to place the numbers of places of fabric that the production planning process has dictated to the length of marker plan, color required, correctly aligned to length and width and without tension. Lay height should be 3.5 to 4 inch.



Fig: 3.2.4.2 Spreading m/c.

3.2.4.3 Piping Cutter Machine:

This machine is look like a round shaped with have a roller part which contains fabric. By which the measured pipings are cutdown. A sharp round knife used here to cut the piping cake



3.2.5. Quality Control of Cutting Section:

3.2.5.1 Numbering:

This process is to put a number on the each part of a garment after cutting. So that the same numbers of each part might be combined at the time of sewing .In this stage sticker is attached with all part of cutting part for shade matching. The sticker number maintains cutting number, size number, serial number



Fig: 3.2.5.1 Numbering

3.2.5.2 Prepared the bundle card:

3.2.5.3 Bundling:

In this stage all number parts are bundled according to serial number.

Prepare bundling card according to fabric lay report this card maintain

- Date
- Style number
- Size number
- Card serial
- Quantity
- Color

- Lot size



Fig: 3.2.5.3 Bundling

3.2.5.3 Quality Check (Panel check):

- Oil spot
- Dirty spot
- Crease mark
- Needle mark
- Foreign yarn
- Slub
- Contamination
- Hole
- Then same numbers of sticker are matched fold & bundled.

3.2.5.4 Faulty Fabric Part Re-cut:

During quality check if any garments parts find fault then mark the fabric part in the bundle. Bundle check man check the bundle and send fault bundle in re-cutting section. In re-cutting section the cut the garments parts manually according to pattern and cut manually by scissor.



Fig: 3.2.5.4 Bundle check



Fig: 3.2.5.4.1 Re-cut

3.2.5.5 Relation between Fabric Types & Relaxation Time:

Fabric Type	Relation Time
Single Jersey, Microfleece	12 hrs
Polo PK	24 hrs
Grey Milans	48 hrs
If Spandex fibre contains then relaxation time	48 hrs

Table 3.2.5.5 Relation between Fabric Types & Relaxation Time

3.3 Sewing Section:

The process of joining of fabrics by the use of needle and sewing thread or by other techniques is called sewing.



Fig: 3.3 Sewing floor

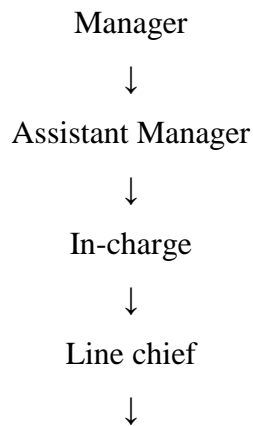
There are five basic components of sewing. They are as follows:

- Needle
- Throat plate
- Pressure foot
- Feed dogs &
- Sewing thread & fabrics.

3.3.1 Layout of Sewing Floor:



3.3.2 Organogram of Sewing Section:



Supervisor



Operator



Helper

3.3.3 Process Flow Chart of Sewing Section:

Product analysis



Set up target for production



Set up machine layout on the basis of target



Set up operator layout on the basis of target



QC check of product



Line balancing



Line setup



Distribution all the processes



Cutting parts received section



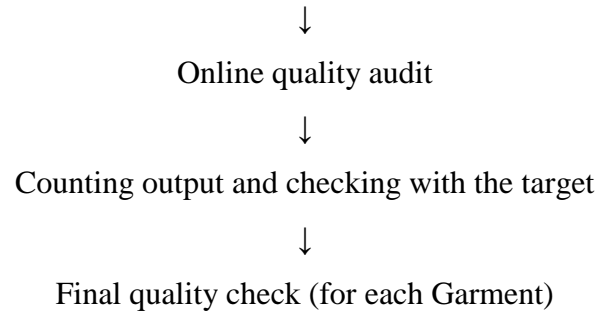
Cutting parts distribution to the operator and helper



Complete parts making individually



Online QC check



3.3.4 Machineries of Sewing Section:

3.3.4.1 Sewing Machines with Specification:

Sewing section is the most important department of a garment manufacturing industry. Because after receive the garments components from cutting section, all the garment's cut parts are assembled here. Sewing machines of different types are arranged as a vertical line to assemble the garments. Sequence of types of sewing machine arrangement depends on sequence of assembling operations.

3.3.4.2 Element of sewing:

- Sewing thread
- Needle
- Sewing machine

Types of sewing machine:

3.3.4.3 PLANE MACHINE:

- It is used to joined two part of fabric
- It used to tuck elastic.
- Neck Tuck

- Label Attach
- Back top stitch



Fig: 3.3.4.3 Plane m/c

3.3.4.4 OVER LOCK MACHINE:

- It is used to front panel joined of fabric
- Shoulder Joining
- Neck Binding
- Neck Servicing
- Sleeve Join
- Side Seam
- Joining rise in lagging

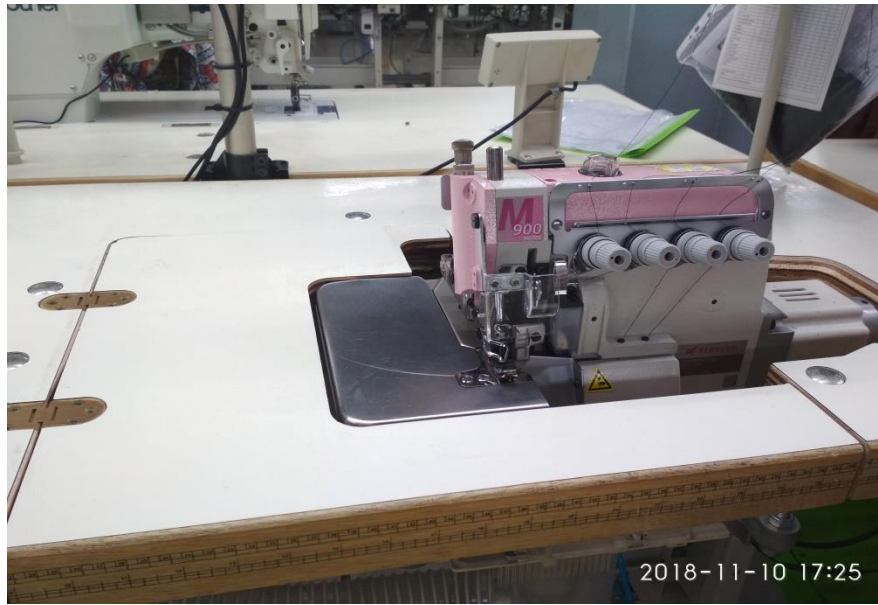


Fig: 3.3.4.4 Over lock m/c.

3.3.4.5 FLAT LOCK MACHINE:

- It is used to top sewing in over lock stitch.
- It is used to hem stitch in garment.



Fig: 3.3.4.5 Flat lock m/c.

3.3.4.6 BUTTON HOLE MACHINE:

- It is used make hole for button.



Fig: 3.3.4.6 Button hole m/c

3.3.4.7 BUTTON ATTACH MACHINE:

- It is used to attach button in the garment.



Fig: 3.3.4.7 Button attach m/c.

3.3.4.8 RIB CUTTER MACHINE:

- It is used to make rib piping for neck and arm hole.



Fig: 3.3.4.7 Fib cutter m/c.

3.3.4.9 BACK LAIS OVERLOCK MACHINE:

- It use to overlock the egde of body, but it have a special process.it turn the looper thread in side the stich when operation is complete.



Fig: 3.3.4.9 Chain stitch m/c.

3.3.4.10 KANSAI MACHINE:

- It is used to elastic joining.
- 4 - 6 needle used.



Fig: 3.3.4.10 Kansai m/c.

3.3.4.11 PUNCHING MACHINE:

- It is used to attach button with garments.



Fig: 3.3.4.11 Punching m/c.

3.3.4.12 ZIGZAG MACHINE:

- It is used for decorative purpose
- Used for lace join in the body



Fig: 3.3.4.12 Zigzag m/c.

3.3.4.13 FLAT SEAMER MACHINE:

- It is used for flat seam purpose
- Used for edge join in the body



Fig: 3.3.4.13 Flat seamer m/c.

3.3.4.14 Bartack MACHINE:

- It is used for bartacking purpose
- Used to small diameter seam in the body for security purpose.



Fig: 3.3.4.14 Bartack m/c.

3.3.5. Sewing Line Quality Check List:

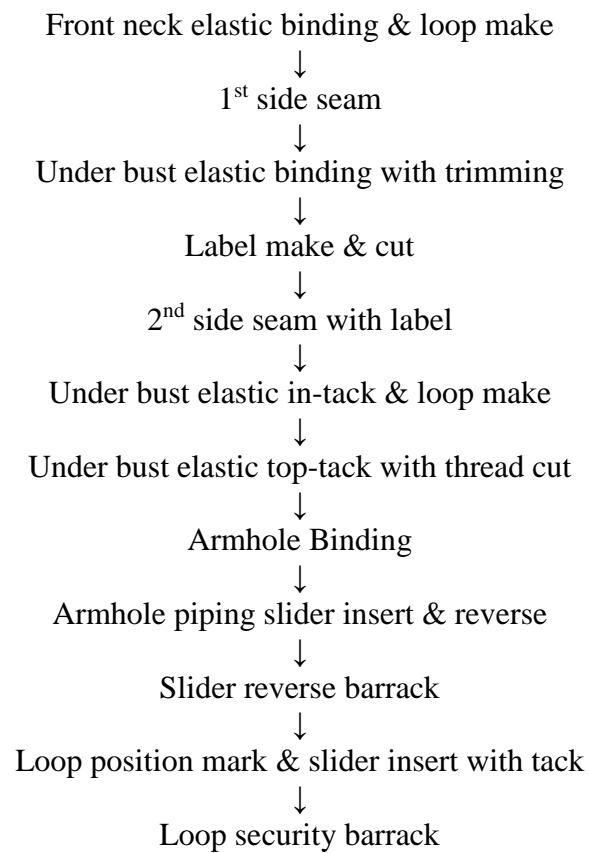
- Buyer approved sample & measurement sheet check.
- Sample wise input check.
- Buyer approved trims card check.
- Buyer approved sample wise style check.
- All machine thread tension check.
- Style wise print & embroidery placement check.
- All process measurement check.
- All machine oil spot check.
- All process S.P.I check as per buyer requirement.
- Input time shading, bundle mistake & size mistake check.
- Buyer approved wise contrast color check.
- As per buyer requirement wise styling check.

- All machine stitch tension balance properly.

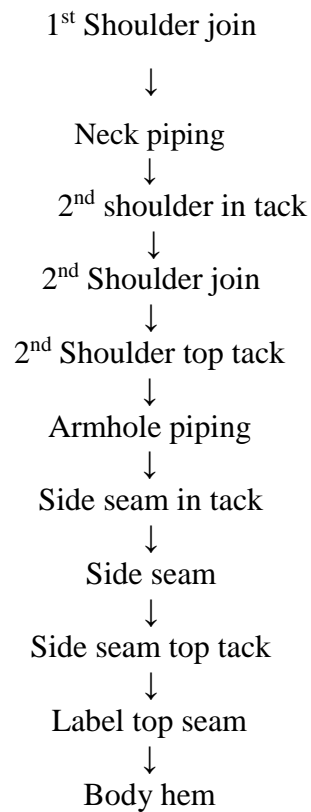


Fig: 3.3.5 sewing line quality check.

3.3.6. Layout of a Kid's Bra:



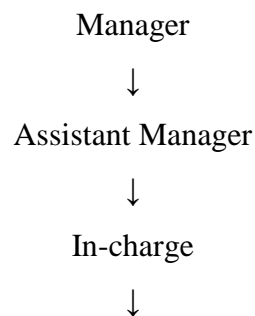
3.3.7 Layout of a Tank top:

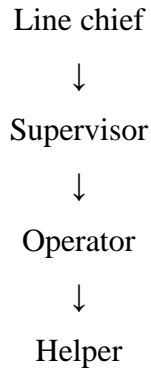


3.4. Finishing:

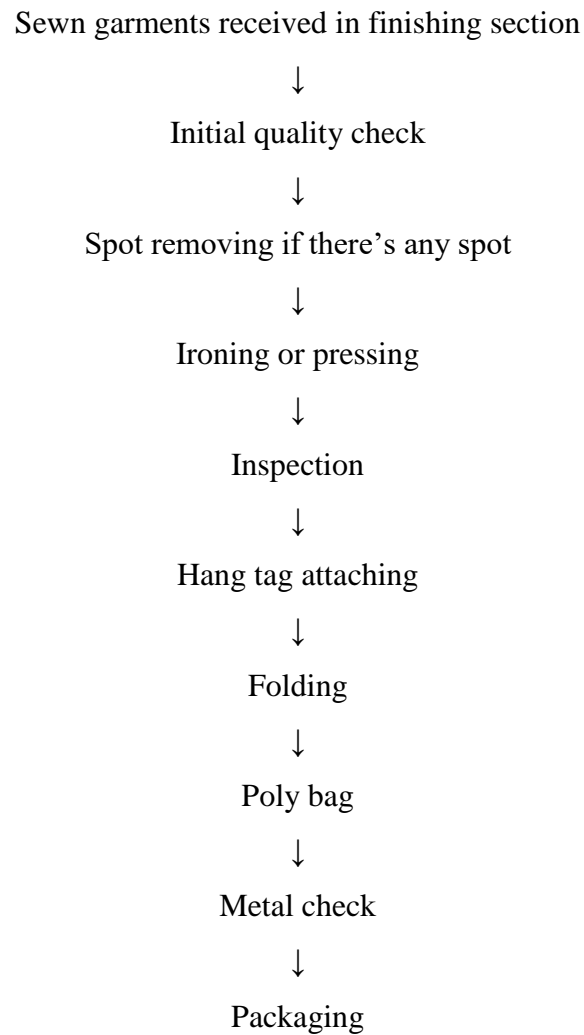
3.4.1. Finishing Lay Out:

3.4.2. Organogram:





3.4.3. Process Sequence of Finishing Section:



3.4.4 Machineries in Finishing Section:

Machine	Number
Heat Iron	15
Stream Iron	8
Metal Detector	1
Neck Press	
Thread Sucker Machine	2

3.4.4.1 Different types of Machine:



Fig: 3.4.4.1 Metal detector m/c



Fig: 3.4.4.2 Steam iron m/c

3.4.5 Quality Check in Finishing Section:

SEWING		FINISHING										
Buyer: HSM	Order No: 292024	Style Name: BASIC TAN TOP MD: ISMAIL										
Color:	Line No:	Table QI Name:										
Defects Name	08-09	09-10	10-11	11-12	12-01	02-03	03-04	04-05	05-06	06-07	Total	
Broken Stc												
Button												
Button Hole												
Fabric Fault												
Skip Stc		I		I								
Needle Hole												
Improper Tack			I									
Joint Stc												
Label Fault												
Measurement												
Needle Mark			II	I	II							
Open Seam												
Print Fault												
Embroidery Fault												
Puckering												
Pleats												
Rawedge												
Slanted												
Reverse												
Shading												
Thread Mistake												
Twisting												
Thread Tension												
Up-Down												
Un-Even												
Un-Cut Thread												
Wavyness												
Wrong SPI												
Yarn Contra												
Collar												
Placket												
Pocket												
Side Band												
Oil Spot	I	II	I	II								
Dirty Spot	III	III	III	III	III							
Rejects												
Size Mistake		II	III	II	I							
Poor Iron												
Others												
Total Check Gmts	20	25	20	20								
Total Pass Gmts	35	22	23	24								
Total Defective Gmts	5	6	8	6								
Total Defects Qty	8	9	10	9								
DHU %	8.88	10.58	11.11	10%								
Defective Rectify Qty	-	11	2	6								
Defective Balance Qty	5	-	-	-								
Rectify Defective Check & pass	-	11	2	6								
Reject Qty												
Supervisor Signature	[Signatures]											

Top 3 Defects Name	Root Cause	CAP	Responsible Person	Implementation Date

INSPECTED BY	Q.C	Q.IN-CHARGE	FL.INCHARGE	AQM	PM	QM
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3.5 Merchandising Section:

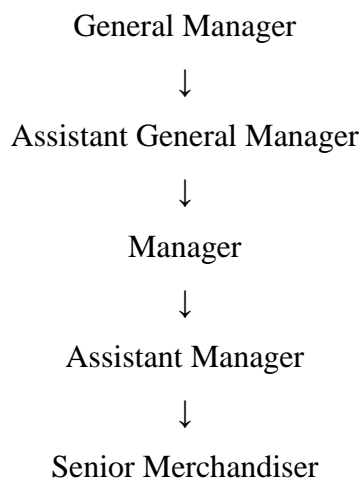
3.5.1 Merchandising:

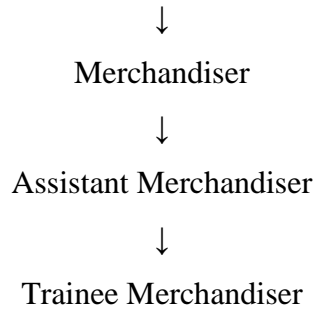


Merchandising department is the star of the department among all the working departments in the Export concern, because Merchandising is the only department having maximum control over the departments and total responsible for Profit and loss of the company.

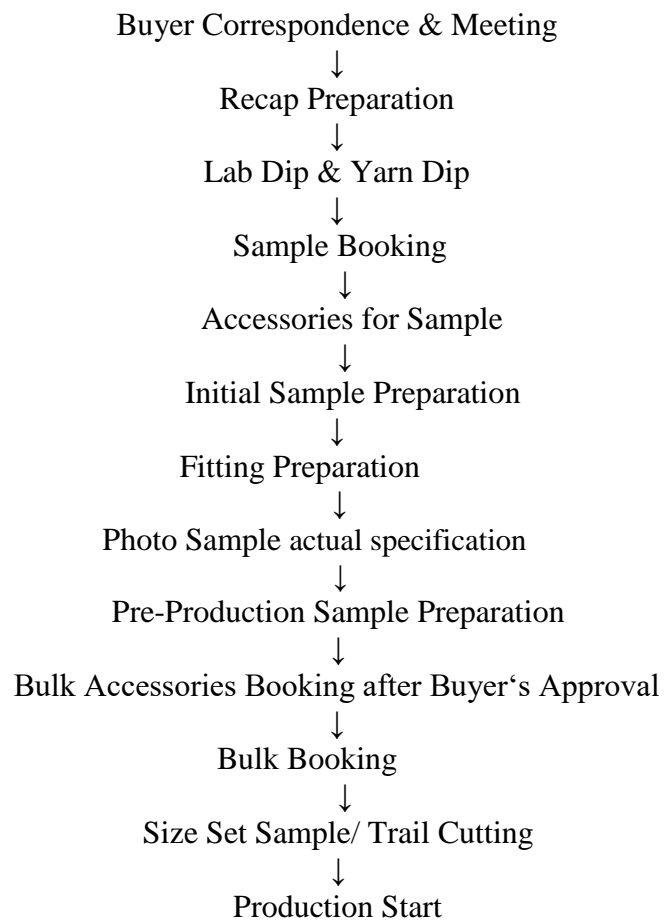
Fig: 3.5.1 merchandising department.

3.5.2 Organogram:





3.5.3 Process Flow Chart:



Chapter-4

Impact of Internship

4.1. Sample development:

- Physically I saw how to make different sample such as PP sample, Counter sample, Shipment sample etc.
- I have Learned about System of sample approval.
- I have learned about different type of machine which is used in making sample .

4.2. Cutting Section:

- I have learned about how to cutting fabric.
- I have learned about method of cutting and flow chart of cutting process.
- Learned different defects which is found in cutting section.
- Learned how to drive different machineries in fabric cutting.

4.3. Sewing Section:

- I have learned about many types of sewing machine.
- I have learned about different parts of sewing machine and their function.
- I have learned about sewing fault and their remedies.
- I have learned about total production of this section and different basic formula for calculate capacity, efficiency and target for a sewing line.

4.4 Finishing Section:

- I have learned about total production of this garments and packaging system.
- Learned about price tag, hang tag and barcode process.
- Learned about quality assurance.

4.5 Merchandising Section:

- I have learned about basic working process of a Merchandising department.
- I have learned basic works a Merchandiser from fabric to shipment.

- I have learned how a Merchandiser deal with buyer.
- I have learned about Trim card, swatch card and different documents

Chapter-5

Conclusion

5. Conclusion:

Industrial training is an important and essential part of education as through this training i have learned all the implementation processes which i have studied theoretically. It gives me an opportunity to compare the theoretical knowledge with practical facts and thus develop my knowledge and skill. This industrial training also gives me an opportunity to enlarge my knowledge of textile administration, production, planning, procurement system, sample section, cutting, sewing, finishing, merchandising, production process and machineries and teach me to adjust with the industrial life. During my two months long industrial training **Daeyu Fashions Ltd.** I got the impression that this factory is a modern export attachment program send me to the expected destiny of practical life. Through the completion of Two Month industrial attachment at **Daeyu fashions Ltd.**I have got the impression that the factory is newborn lingeire project in Bangladesh. Though it was established in 2016, it has earned very good reputation for its best performance among other newborn lingeire projects. During my industrial attachment program I had tried to my best to do my duty. My supervising officer also satisfied to me & offer co-operation in every steps. It is completely a new experience in my life, which will be very effective in my service life. During my training period I realized that practical experience is valuable for service life.