



**Faculty of Engineering
Department of Textile Engineering**

REPORT ON

Study on the Quality Problem in Knit Garments Production with their remedies

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Approval Sheet

The research entitled “Study on the Quality Problem in Knit Garments Production with their remedies’ at Daffodil International University, A. Y. 2019” prepared and submitted by **Sk. Wakil Ahmed, ID: 162-23-4734, Shanawaz Ali, ID: 162-23-4779** in partial fulfillment of the requirement for the degree of BACHELOR OF SCIENCE IN TEXTILE ENGINEERING has been examined and hereby recommended for approval and acceptance

A handwritten signature in black ink, appearing to read 'Abdullah Al Mamun', is written on a light blue background.

Abdullah Al Mamun

Supervisor

DECLARATION

We declare that, this project has been done by me under the supervisor Md. Abdullah Al Mamun, Assistant Professor, Department of Textile 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.

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Finally, we must acknowledge with due respect the constant support and patients of our parents.

DEDICATION

With the deep sense of or honor to our beloved and dearest parents, Teachers and all other those who devoted them yesterday for our successful and bright today.

Abstract

This procedure is a standout amongst the most significant stages in labor serious instant dress ventures. Quality issues happening amid this procedure unfavorably influence the item quality and item productivity, and furthermore increment the creation cost. The point of this examination is to research whether the sew creation process is leveled out in a weave generation endeavor and to recognize the procedures with most noteworthy rates of sewing deficiencies in sewing division lastly to make proposals for improving the quality control. Among the Statistical Process Control techniques; control list, item control graph was utilized in the examination.

Item control outline was utilized to test whether the creation procedure is controlled in the undertaking. Besides, the factual strategies were utilized to decide the issues that should be done in the improvement endeavors and to identify the relations between the procedure bunches as far as anyone knows viable on flaws happening in knitwear creation and the quantity of deficiencies. Al-along these lines, the procedures with most elevated measures of completion texture issue, cutting shortcoming, sewing deficiencies, completed pieces of clothing and the impacts of these procedures on issue rates were examined. Thus, it was inferred that the generation procedure was factually not leveled out in the instant attire endeavor. Moreover, this examination exhibited that the examination of each procedure bunch by illustration their item control graphs would make noteworthy commitments to anticipate the outcomes and get ready progressively viable the improvement plans.

We Collect Quality Control Summery Report in 14 days & we also find out some defects issue. We found Open/ Broken/ Skip Stitch in 22.09%, Shading in 5.82%, Puckening in 4.40%, Neck Shape in 2.31%, Poor Tension in 3.59%, Uneven in 8.29%, Oil Mark in 0.90%, Rewedge in 8.58%, Dirty Mark in 0.60%, Union/ Over Stitch in 7.54%, Label Join in 5.37%, Sleeve Uneven in 0.60%, Size Mistake in 0.77%, Uncut Thread in 23.21%, Others in 13.51%. Every day per hour also find some inspection, good, defects, rejects in products. Total inspection find out in 17932, Good in 16502, Defects in 1510, Rejects in 18

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1. Introduction

1.1 Introduction

Quality is characterized as the dimension of acknowledgment of a merchandise or administration. It is a fundamental necessity for any sort of item. Each item ought to keep up the standard quality dimension and discover the significant shortcoming and Its causes recognize and afterward should expel the flaw.

Mechanical undertaking is the initial step to proficient existence of understudy, particularly of specialized side. It's a key piece of concentrate a for all intents and purposes running handling innovation of a mechanical unit for an understudy. In our college, preparing machines are not in ceaseless running condition, so it would just give showing of mechanical highlights and handling innovation of the material in achievement of the hypothesis there of yet not of the situational factors to accomplish pragmatic learning. Quality has been with us since the beginning of human advancement, in any case, a focused weapon or upper hand. So as to comprehend this we have just to take a gander at Japan which is common example of how a country utilized quality to turn into a world player in exchange the business. A portion of different nations, for example, South Korea, Taiwan, and Singapore in Asia/Pacific pursue this model and turned out to be effective on the planet field. Clients everywhere throughout the world have turned out to be so requesting and expecting great quality that inexorably, quality is never again an upper hand, yet it is turning into a sheer need to make due in the commercial center. Consequently, quality must be planned and incorporated with items and not simply "assessed" into items

The costs spoken to by this exertion can be a noteworthy extent of the items deals esteem (Do you know what the complete is in your Company? In certain occurrences, the expense of scrap, modify and examination costs alone has been observed to be as high as 20% of turnover) and any maker ought to be keen on ensuring that he is getting great incentive for his consumption. He can't feel beyond any doubt except if he has considered what the expenses are, the means by which they are brought about and what they should be. In the event that they are higher than they ought to be, he should consider manners by which they can be diminished. Here we portray the idea of the expenses caused in ring item quality and unwavering quality and shows how expenses can be diminished while quality and dependability are kept up or improved.

1.2 Point of this task

The point of undertaking is expanding the creation by controlling nature of articles of clothing. To blame estimation aloof procedure and rating of shortcoming rate. That is implies which shortcoming the fuller of feeling in this procedure. Also, discover the more successful shortcoming and its causes and cures. With the goal that creation will be high-and brilliant articles of clothing.

1.3 Objective of this undertaking:

- ✚ To build the generation of sew articles of clothing
- ✚ To deliver the high caliber of pieces of clothing
- ✚ To discover the significant flaw
- ✚ To discover the reason the issue which lessens the generation
- ✚ To expel this real issue.
- ✚ To arrangement of this flaw.

2. Literature Review

2.1 Quality

Each and every item includes some uncommon attributes for which it is sought after by buyers. History of value is as old as human progress itself. Aristotle 2500 years prior de-fined quality as following:

1. Quality is the contrast between items.
2. It is the decency or disagreeableness in an item. This definition remains constant till this date. Be that as it may, as a rule terms, quality incorporates significant attributes of an item for which, it is sought after. Quality is additionally alluded to as "conformance of products to purchasers' determinations". ISO 9000: 2000 characterizes quality as "degree to which a lot of innate attributes satisfy prerequisites".

2.2 Quality relies upon

Quality relies upon two things. For example, given underneath:

Structure: It speaks to highlights of an item fit as a fiddle, estimate, style, plan and estimations.

Content: It speaks to highlights communicating inside quality, suggesting nature of crude materials and the esteem augmentations appended to it.

2.3 Significance of quality

Each item should highlight useful qualities just as some different angles identified with its shape, estimate and structure. Customers dependably request following desires for the bought item:

The item should fulfill the shopper as far as magnificence, engaging quality, taste, shape, plan and life span and so forth relying upon the sort of item.

An item without quality has no interest among customers and accordingly, has no attractiveness. Astounding quality attributes upgrades attractiveness of the products and are the keys to productivity for the maker or the vender. In particular, a few criteria of consumer loyalty are debatable however quality is such a factor, that it isn't by any stretch of the imagination

2.4 Sorts of Quality

As per excellence of satisfaction, quality may be grouped into three categories:

1. Quality of general acceptance;
2. Quality of satisfaction;
3. Quality category of higher delight.

A dark and white TV now-a-days acquires just nature of general acknowledgment while a shading TV gives to the purchaser nature of fulfillment. Then again, shading TV with a remote control delivers nature of extraordinary pleasure to purchaser.

2.5 Quality attributes in apparel

In an attire industrial facility, fabricated articles of clothing must have indicated quality attributes. They are supplier underneath:

1. Estimations indicated by the purchasers;
2. Specified sewing and sewing quality
3. Raw materials must have determined quality
4. Garments must have indicated plan qualities.
5. Assortment indicated by the purchaser
6. Finishing, pressing, bundling must be indicated by the clients.

In this way, nature of pieces of clothing suggests whether the predefined article of clothing has been created with determined crude materials, with purchaser indicated sewing and sewing quality, with indicated sizes, shapes, plan and arrangement.

In dress industry, requested quality attributes of the articles of clothing are educated to the producer through work sheet, affirmed test and size spec and so on.

2.6 Quality Control

Quality control is the operational procedures and exercises that are utilized to satisfy prerequisites for quality. On different words, a framework connected to assembling tasks to screen and direct creation process consistently so items meet determination.

To control the nature of pieces of clothing or items two procedures are pursued, for example,

- Testing and
- Inspection

2.6.1 Testing

To those occupied with the generation, conveyance and utilization of materials, testing can be an important guide given tests are made the outcomes must be contemplated cautiously so the correct game-plan might be taken. Testing instruments can't settle on choices and at last some individual needs to translate the information and issue the important directions for future activity.

2.6.2 Inspection

The examinations are done to control the quality is implies by inspecting the items with no instrument. To look at the texture, sewing, catch, string, zipper, articles of clothing estimation, etc as per determination or wanted standard is called investigation. There are such huge numbers of offices for review in each area of articles of clothing industry. The point of reviews is to diminish the time and cost by recognizing the flaws or deformities in each progression of pieces of clothing making.

2.7 Quality Assurance

To complete every one of those arranged and orderly activities important to give satisfactory certainty that an item or administration will fulfill given prerequisites for quality is called Quality affirmation. On the words, this is a framework to guarantee that item and administrations meet client necessities.

2.8 Quality Management System

Quality Management System (QMS) is a lot of interrelated methods, measures and the executives framework intended to keep deserts from happening or on the off chance that they happen by any stretch of the imagination. Counter-measures are received promptly with the goal that they don't repeat. QMS accepts plan of action to preventive just as medicinal measures.

2.9 Quality Management System in the pieces of garments industry

Various frameworks, measures and methods are utilized so just quality merchandise are delivered in any case and imperfections don't begin by any stretch of the imagination. In the event that they happen by any stretch of the imagination, there must be remedial activity with the goal that they are disposed of in the primer stage and would not return. QMS by and large utilizes the accompanying measures, methods the guarantee that just quality great are delivered:

- * Inspect all approaching, in-process and last merchandise to guarantee nature of products.
- * Ensure that all examples and reviewing of examples are alright.
- * Inspect marker and check on the off chance that it is alright and inside utilization.
- * Inspect spreading, cutting and numbering.
- * Ensure if unwinding time was given to weave texture.
- * Install in-line reviewer in the sewing lines.
- * Install Traffic Light Chart framework or other framework to screen quality underway line.
- * Inspect 100% products conveyed from sewing lines.
- * Inspect the table quality passed articles of clothing with Statistical Technique.
- * Control dismiss products so they don't misunderstand with quality passed merchandise.
- * Control repairable merchandise, launder able products with the goal that they can be twofold checked to guarantee quality.
- * Inspect merchandise with right gear's and in right conditions. *Inspect pressing, collapsing.

- * Make rehash examination of pieces of clothing preceding poly-sacking.
- * Inspect poly-stowing and grouping.
- * Final table examination in led preceding shipment of merchandise.
- * Impart preparing QA work force with the goal that they can without much of a stretch recognize absconds and comprehend the reasons for deformities.
- * Impart preparing QA work force on Statistical Methods.
- * Make consistent improvement plans and execute them.

2.10 Total quality management

This is one of the most recent ideas of the executives that can guarantee the most elevated standard of value and efficiency guaranteeing useful for the majority of the laborers, the board and society. In this framework, nature of the executives and activities are guaranteed by guaranteeing quality at all phases from vision, arranging, buy, store, cutting, sewing, examination, pressing, organization, welfare, faculty inspiration and so on. TQM visualizes high work standard, workplace, administrative standard, inspiration and so on. In this way, comes the idea of creation framework with insignificant or "zero de-reality".

2.11 Set of working responsibilities of Quality Manager

The quality director is a significant authority in a piece of clothing production line. Consumer loyalty, notoriety of the organization, to a huge degree, relies on him. His expected set of responsibilities is given beneath:

1. He will introduce or keep up a correct Quality Management System to guarantee nature of item;
2. He will guarantee that the QMS is set up and filling in as imagined;
3. He will guarantee that the current QMS fulfills the purchaser;
4. He will search for methods for improving existing QMS in order to surpass desires for the client;

5. He will guarantee that purchaser's details are legitimately comprehended;
6. If there is any equivocalness/perplexity, he will affirm purchaser's real Specifications;
7. He will guarantee that AQL of the organization is appropriately kept up and surpassed.
8. He will guarantee that all approaching, in-process and last products are appropriately investigated and recorded.
9. He will guarantee that all products coming in the store are thoroughly examined for quality and amount;
10. He will guarantee that Traffic Light Chart arrangement of in-line examination framework is introduced and working;
11. He will introduce both preventive and medicinal measures against event of any deformity;
12. He is in charge of disappointment of value passed article of clothing;
13. He will guarantee that the majority of his faculty are prepared on their themes;
14. He will guarantee nonstop preparing of individual to upgrade their expertise;
15. He will guarantee thorough control of rejects;
16. He will guarantee thorough control of repairable and launder able articles of clothing;
17. He will get ready for year-wise improvement of value;
18. He will set up a quality manual for the organization so organization's quality arrangement and methodology are known to all and actualized at all dimensions;
19. He will guarantee that quality manual incorporates all approach, strategies, techniques and measures in order to bring together activities;
20. He will screen execution of providers of crude materials;
21. He will have his faculty persuaded.
22. He will guarantee that provider client chain is kept up in the creation procedure;

23. He will guarantee that generation starts just when worksheet endorsed test and swatch card are close by.

2.12 Apparel Quality Management

There are various factors on which quality wellness of Apparel industry is based, for example, - execution, unwavering quality, solidness, visual and saw nature of the piece of clothing. Quality should be characterized as far as a specific system of expense. The national administrative quality confirmation and worldwide quality projects like ISO 9000 arrangement set out the wide quality parameters dependent on which organizations keep up the fare quality in the piece of clothing and attire industry. Here some of primary texture properties that are thought about for article of clothing producing for fare premise: Overall look of the garment.

- ✚ Right formation of the garment.
- ✚ Feel and fall of the garment.
- ✚ Physical properties.
- ✚ Color fastness of the garment.
- ✚ Finishing properties of apparels
- ✚ Presentation of the final produced garment.

2.13 Clothing Quality Management for Apparel Exporters

For a piece of clothing exporter or attire exporter there are numerous procedures and standards that are required to be pursued to accomplish great business. The texture quality, item quality, conveyance, value, bundling and introduction are a portion of the numerous viewpoints that should be dealt with in piece of clothing trade business. A few decides that are fitting for article of clothing exporters are recorded underneath:

- ✚ Quality has to be taken care by the exporter, excuses are not entertained in international market for negligence for low quality garments, new or existing exporters for both it is mandatory to use design, technology and quality as major upgradation tools.
- ✚ Apart from superior quality of the garment, its pricing, packaging, delivery, etc. has to be also taken care of.
- ✚ The garment shown in the catalogue should match with the final garment delivered.

- ✦ It is important to perform according to the promises given to the buyer, or else it creates very bad impression and results in loss of business and reputation.
- ✦ In international market, quality reassurance is required at every point.
- ✦ Proper documentation and high standard labels on the garment are also important aspects as these things also create good impression.
- ✦ Timely delivery of garments is as important as its quality.
- ✦ If your competitor has the better quality of garment in same pricing, it is better to also enhance your garment quality.
- ✦ Before entering into international market, garment exporters have to carefully frame out the quality standards, or else if anything goes wrong it could harm the organization. And after that strictly follow it.
- ✦ The garment quality should match the samples shown during taking the orders.
- ✦ The garment exporters should know to negotiate a premium price after quality assurance is done.
- ✦ Quality is a multi-dimensional aspect. There are many aspects of quality based on which the garment exporters are supposed to work.
- ✦ Quality of the production.
- ✦ Quality of the design of the garment.
- ✦ Purchasing functions' quality should also be maintained.
- ✦ Quality of final inspection should be superior.
- ✦ Quality of the sales has to be also maintained.
- ✦ Quality of marketing of the final product is also important as the quality of the garment itself.

2.14 ISO

As indicated by ISO,

Quality is the satisfaction of indicated prerequisites of the item or administration' another meaning of ISO,

The totality of highlights and qualities of item or administration that bear on its capacity to fulfill expressed or inferred needs. The term normally joined with a number or name used to distinguish

material items. A relative term used to demonstrate the apparent benefits of comparative items for same end use. Quality varies from customer to customer. Quality is the reflection of customs.

2.15 Quality Inspection

The reviews are done to control the quality is implies by looking at the items with no instrument. To look at the texture, sewing, catch, string, zipper, articles of clothing estimation, etc as indicated by detail or wanted standard is called examination. There are such a significant number of offices for investigation in each segment of pieces of clothing industry. The point of assessments is to lessen the time and cost by distinguishing the issues or imperfections in each progression of articles of clothing making.

To do accomplishment in review, the procedure can be controlled by looking after "examination circle". Inspection

- ✚ Identify the imperfections or flaws
- ✚ Knock the proper individual
- ✚ Identify the reasons of imperfections or flaws
- ✚ Remove the deformities or shortcomings.

Mainly inspections are done in three steps in garments industries. The steps are:

- Raw material inspection
- In process inspection
- Final inspection.

2.16 Inspection System

There are different texture investigation frameworks as recorded underneath. Be that as it may, we will examine just the 4-point framework since it is utilized generally broadly.

1. 4- Point system
2. 10- Point system
3. Graniteville '78' system

4. Dallas system

5. Textile distributors Institute (National Federation of Textiles-1955) system

6.4- Point system- Revised.

2.17 AQL (Acceptable Quality Level)

The AQL is the most extreme percent damaged that to test review can be viewed as acceptable as a procedure normal. At the point when a client assigns some particular estimation of AQL for a specific deformity or gathering of imperfections he demonstrates to the provider that his (the customer's) acknowledgment inspecting plan will acknowledge the incredible lion's share of the parcels or groups that the provider submits, gave the procedure normal dimension of percent flawed in these parts or clusters is no more prominent than the assigned estimation of AQL. Along these lines, the AQL is an assigned estimation of percent faulty that the client shows will be acknowledged more often than not by the acknowledgment inspecting techniques to be utilized. The AQL is commonly communicated in percent (%). The AQLs most generally utilized in clothing industry are 2.5, 4.0, 6.5, and 10.0 relying upon the cost and thing. For instance, for low value things and youngsters' wear AQLs of 6.5 and 10.0 might be very suitable, be that as it may, for more expensive rate things AQLs of 2.5 and 4.0 might be fitting

2.18 Inspection Zone

Visual deformities are arranged as Major, Minor and Critical imperfections. Sometimes, a noteworthy deformity can be considered as minor dependent on the area of the imperfection in a piece of clothing. This area is called as zone. Zoning is accomplished for reasonable assessment of the piece of clothing amid visual review. A piece of clothing can be isolated up to 3 zones, similar to A, B and C. What number of zones an article of clothing would have are depends on items and end utilization of the piece of clothing. Following zoning and checking abandons appropriately (just major and minor imperfections are considered) auditor gets ready review report. In this way, it is essential to isolate piece of clothing into areas and imprint absconds as needs be. For instance, poor press at focus front (zone - An) of a shirt is considered as significant deformity however in the event that poor press is distinguished in back base (Zone-B) of a similar piece of clothing it is considered as minor imperfection. You ought to know that deserts that falls under B and C zones are not constantly considered as minor deformities.

A large portion of the cases attire purchasers give piece of clothing figures stamping zones in their quality manual. What's more, give a rundown of imperfections that fall under major or

minor classifications. In the accompanying figure (source: Gap Inc.) a sewed top has been appeared with zones An and B. At the front sleeves and upper front is considered as zone 'An' and lower front considered as zone 'B'. On the back of the article of clothing, under arms and back base is considered as zone 'B'

3. Experimental Details

3.1 Inspection Report

We have collected some end table Inspection Report from Magpie Composite Textile Ltd. of different Quality Checking. This report are enlisted below-

Report: 1

Magpie Composite Textile Ltd. 110
LINE LABEL INSPECTION REPORT

Product: Calour- RoyalBlue
 Style: NEW WAVE
 Line: 14
 Mo. No.: OR-442303
 Date: 13-03-19

Inspection	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total
Good	130	125	130	195	192	209	203	207	220	205	1552
Defect	168	163	172	178	192	188	190	187	195	192	1552
Reject	10	22	18	17	15	12	13	15	15	13	150
Defect Rejection Pp		07				01	13	01	15	02	07
Defect Name											
Open Broken/Skip Sis.											
Shading	02	01	01	02	01	02	01	02	01	02	15
Puckering		01									01
Neck Shape	03										03
Poor Tension		02									02
Uneven			03	02	02	01	02	01	02		15
Rawedge	02	02	01						02	02	10
Oil Mark										01	01
Dirty Mark	01	01	01		01	01	02				07
Damage											
Union/Over Sts.											
Wrong Trims											
Label Join		02	02	02		02		01	01	02	12
Stv. Uneven											
Size Mistake											
Bottom/Cup/AH Shape											
Print/Emb/Strip Unven											
Uncut Thread	08	07	07	09	08	06	07	06	07	05	72
Others	04	04	03	02	03						25
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total
Inline Q.C Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	
Pro. Sup. Sign											
Q.C Sup. Sign											
1st		Def. Qty		2nd Highest		Def. Qty		3rd Highest		Def. Qty	

5/12/19
Q.I.

[Signature]
15/3/19
Q.C.

[Signature]
Pro. Sup.

P.M.

[Signature]
Q.M.

Report: 2

Composite Textile Ltd.
Plot - 832/53, Durgam Chaudhry Road, Fateghara, Feroze, Sector, Distt. - Ghazipur, Uttar Pradesh - 224225

END TABLE INSPECTION REPORT

Color - Black Line - 14 Date - 16-03-19

Buyer - NEW WAVE Mo. No. - OK-443343 Item - T-SWIFT

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total
Inspection	120	140	150	150	155	150	150	155			1130
Count	110	127	135	138	145	138	150	142			1075
Defect	20	13	15	12	10	12	10	13			105
Repeat											
Defect Report/Defect Pts											
Defect Name											
Open/Broken/Skip Sts.	03										03
Shading											01
Puckering	01										01
Neck Shape											
Floor Tension											02
Unweave	02			01	02	02	02	03			14
Rawedge	03	01		01	02	02	02	03			01
Oil Mark											02
Dirty Mark	02										02
Damage											12
Unweave/Over Sts.	02										02
Wrong Trims											
Label Join	03	02	01		01	02	02	01			12
Sty. Unweave											
Size Mistake											
Bottom/Cup/AM Shape											32
Print/Emb/Strip Unweave											18
Uncut Thread	05		02	04	05	06	05	05			32
Others / Side Band		10	12	07	02	02	01	04			38
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total
Inline Q.C. Sign.	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	<u>Sumit</u>	
Pro. Sup. Sign.	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	<u>KALIM</u>	
Q.C. Sup. Sign.											
Tst	Def. Qty.		2nd Highest			Def. Qty.		3rd Highest			Def. Qty.

Q.I. Sumit Q.C. KALIM Pro. Sup. KALIM P.M. Q.M. KALIM

Report: 3

magpie composite textile ltd.
Plot - Regional, Durgam Chinn Road, Hyderabad, Andhra Pradesh 775225

END TABLE INSPECTION REPORT

Customer: Celwe - NAVY Line: 14 Date: 17-03-19

Brand: NEW WAVE Mo. No: OR-445320 Item: T-shirt

Defect	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	Total
Distortion	130	140	145	150	155	157	156	153			1192
Good	120	133	135	140	143	150	146	128			1115
Defect	10	07	10	10	12	07	10	03			75
Reject				01		01					
Defect Repair/Repair Pcs											
Defect Name											
Open/Broken/Sup. Srs			01		01	01		01			04
Shading											
Puckering											
Neck Shape											
Poor Tension											07
Uneven		01		02	01	02	01				08
Rawedge	02		02	02	01						
Oil Mark											
Dirty Mark											
Damage											
Uniso/Diver Sta.											09
Wrong Trims											
Label Join											
Slv. Uneven											
Size Mistake											37
Bottom/Cup/AH Shape											16
Print/Embr/Strip Univen											
Uncut Thread	05	03	05	04	05	04	06	05			
Others	02	01	01		03		02	01			
Hours	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	Total
Inline Q.C Sign	<u>Sham</u>	<u>Sham</u>	<u>Sham</u>	<u>Kalim</u>	<u>Kalim</u>	<u>Kalim</u>	<u>Kalim</u>	<u>Kalim</u>			
Pro. Sup. Sign	<u>Kalim</u>	<u>Kalim</u>	<u>Kalim</u>								
Q.C Sup. Sign											
1st											
Def. Qty.											
2nd Highest											
Def. Qty.											
3rd Highest											

Sham Q.I.
Kalim Q.C.
Kalim Pro. Sup.
P.M.
Q.M.

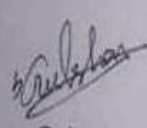
Report: 4


END LABEL INSPECTION REPORT


Line 14 Date 21-03-19

Job No. 124 NEW WAVE


Defect	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	Total	%
Defect	180	187	198	203	206	206	203	205			1889	
Defect	170	174	185	193	193	193	197	191			1805	
Defect	10	13	11	10	12	13	11	14			94	
Defect		01			01		01	01				
Defect												
Defect	01	01	02		02	01	01	02				
Defect												10
Defect	02	01	02	01	01	02	01	01				11
Defect	01	02		01	02	01		02				09
Defect	01				01		01					03
Defect		02	01			02	02	02				09
Defect	01	02	01	02	01							07
Defect												
Defect												
Defect												
Defect	04	03	05	04	05	06	04	05			36	
Defect		02		02			02	02			08	
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Q.C. Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign				
Sup. Sign	Kalim	Kalim	Kalim	Kalim	Kalim	Kalim	Kalim	Kalim				
Sup. Sign												
1st	Def. Qty.	2nd Highest			Def. Qty.			3rd Highest		Def. Qty.		


 Q.I.


 Q.C.


 Pro. Sup.

P.M.


 Q.M.

Report: 5

maxim composite tile ltd.
Unit 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100
END TABLE INSPECTION REPORT

Color - Black / NEW WAVE Unit 14 Date 13-03-13

Mis No. OK-445445 Item T-shirt

Defect	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	Total
Defect	180	200	183	205	206	200	203	206			530
Defect	170	182	191	194	195	198	192	194			
Defect	10	13	12	11	11	10	12	12			
Defect		02		01		01					
Defect Name											
Open/Broken Strip Def.											
Shading	01	02	01	02	01	02	01	02			
Packaging											
Neck Shape											
Flaw/Tarnish	02	02	01	01	02	01	02	01			
Uneven											
Rain-edge											
Oil Mark	01	01		01	01		01	02			
Dirty Mark											
Damage											
Union/Over Sta.		01	02		02	01	02	01			
Wrong Trims											
Label Join	01	01		01							
Bl. Uneven											
Size Mistake											
Bottom/Cup/AM Shape											
Print/Emb/Strip Uneven											
Uncut Thread	05	04	06	05	04	05	04	05			
Others		02	02	01	01	01	02	01			530%
Hours	1st Hr	2nd Hr	3rd Hr	4th Hr	5th Hr	6th Hr	7th Hr	8th Hr	9th Hr	10th Hr	Total
Inline Q.C Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>			
Pro. Sup. Sign	Kalim	Kalim	Kalim	Kalim	Kalim	Kalim	Kalim	Kalim			
Q.C Sup. Sign											
1st	Def. Qty.		2nd Highest			Def. Qty.		3rd Highest		Def. Qty.	

[Signatures]
 Q.I. Q.C. Pro. Sup. P.M. Q.M.

Report: 6

meheri

magpie composite textile ltd.
Plot - 832/833, Dewan Etnis Khat, Kathgora, Antola, Savar, Dhaka, Phone : 7792255

END TABLE INSPECTION REPORT

Color - Black Line: 14 Date: 24-03-19

Buyer: NEW WAVE Mo. No: OK-445445 Item: T-shirt

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Impression	180	200	203	206	204	205	203	204			1605	6.35%
Good	170	187	191	195	191	178	191	188			1503	
Defect	10	13	12	11	13	12	12	16			102	
Defect Name		01			01		01					
Spaw/Seam/Zip St.	01	02	01	02	01	02	01	02			12	
Shading												
Puckering												
Neck Shape												
Poor Tension			02	01		02	01	03			08	
Uneven	02	01	01		01			02			07	
Rawedge		02	01	02	01	02	02	02			12	
Oil Mark												
Dirty Mark												
Damage												
Unico/Over-St.	01	02	01	02	03	01	02	01			13	
Wrong Thrs												
Label/Join												
Sh. Unsew												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Emb/Strip Unsew												
Uncut Thread	04	05	04	04	05	06	05	04			37	6.35%
Others	02	01	02		02	02	01	01				
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Initial Q.C. Sign	Sam	Sam	Sam	Sam	Sam	Sam	Sam	Sam				
Pro. Sup. Sign	Sam	Sam	Sam	Sam	Sam	Sam	Sam	Sam				
Q.C. Sup. Sign												
1st	Def. Qty.		2nd Highest			Def. Qty.		3rd Highest		Def. Qty.		

Q.I. Q.C. Pro. Sup. P.M. Q.M.

Report: 7

magpie composite textile ltd.
Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792255

END TABLE INSPECTION REPORT

Color: Black Line: 14 Date: 25.03.19

Buyer: NEW WAVE Mo. No.: OR-445445 Part: T-shirt

Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	195	203	202	207	205	206	203	203			1614	
Good	165	176	185	193	192	194	190	191			1498	
Defect	15	17	20	14	13	12	13	14			118	7.31%
Reel	01		02			01						
Defect Name												
Open/Broken/Skip Sts	02	01	02	01	02	01	02	01			12	
Shading	05	06	05	03	03	02	01	02			27	
Puckering												
Neck Shape												
Poor Tension	02	02	01	02	01	02	01	02			13	
Unsewn												
Rawedge	01	02	02	01	02	01	01	02			12	
Oil Mark												
Dirty Mark												
Damage												
Union/Over Sts	01	02	01	01	02	01	02	01			11	
Wrog Trim												
Label Join												
Slv. Uneven												
Size Mistake												
Bottom/Cup/SH Shape												
Print/Emb/Strip Union											34	
Uncut Thread	04	03	06	06	03	05	04	03			08	
Others		01	03				01	02				
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign				7.31%
Pro. Sup. Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign				
Q.C Sup. Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign	Sign				
1st	Def. Qty.	2nd Highest				Def. Qty.	3rd Highest					

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Report: 8

Plot - 832/833, Dewani Edris Road, Katigora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date : 03-01-2019

Line : 05

Buyer	Mo. No. : 1358										Total	%
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.		
Inspection	80	95	110	110	150	80	35	50			440	100%
Good	70	80	100	150	93	45	42	47			567	127%
Defect	10	15	10	07	7	5	3	3			60	14%
Reject		02									4	0.9%
Defect Repair/Repair Pas												
Defect Name												
Open/Broken/Skip Sis.	03	03	02	03	04	02	01	02				
Shading												
Puckening												
Neck Shape												
Poor Tention												
Uneven	02	02	01	02	02							
Rawedge	02	01	02	01	02							
Oil Mark												
Dirty Mark												
Damage												
Union/Over Sis.												
Wrong Trms												
Label Join												
Slv. Uneven		01	01	02	01	01						
Size Mistake												
Bottom/Cup/AH Shape												
Print/Emb/Strip Univen		04	03	01								
Uncut Thread												
Others	03	02	01									
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign												
Pro. Sup. Sign												
Q.C Sup. Sign												
1st	Def. Qty.		-2nd Highest									

[Signature]
Q.I.

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Q.C.

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Pro. Sup.

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P.M.

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Q.M.

Report: 9

Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date : 4-4-2019

Line : 05

Item : T. Shirt

Buyer	MISO / Denay		Mo. No. : 1336 / 539							Item : T. Shirt		Total	%
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%	
Inspection	120	125	NIL	NIL	26	50	92	110			531	4.60%	
Good	105	115			3	5	8	10			51		
Defect	15	10	NIL	NIL									
Reject	02												
Defect Repair/Repair Pas													
Defect Name													
Open/Broken/Skip Sis.	4	3	NIL	NIL	01	02	03	5					
Shading													
Puckering													
Neck Shape													
Poor Tention													
Uneven	2	2	NIL										
Rawedge	4	2											
Oil Mark													
Dirty Mark													
Damage													
Union/Over Sts.													
Wrong Trims						01	02	01	01				
Label Join													
Slv. Uneven													
Size Mistake	02	1	NIL										
Bottom/Cup/AH Shape													
Print/Emb/Strip Univen							03	02					
Uncut Thread													
Others	01	02			01	01	02	01					
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%	
Inline Q.C Sign	14	24	24	24	24	24	24	24					
Pro. Sup. Sign													
Q.C Sup. Sign													
1st	Def. Qty.		-2nd Highest			Def. Qty.		3rd Highest		Def. Qty.			

[Signature]
Q.I.

[Signature]
Q.C.

[Signature]
Pro. Sup.

P.M.

[Signature]
Q.M.

Report: 10

Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date : 6-9-2019

Line : 05

Buyer	Mo. No. : 539										Item :	Total	%
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.			
Inspection	120	120	150	135	180	100	110	140				1485	10.46%
Good	150	110	165	160	165	180	185	125				1240	
Defect	20	10	15	25	15	20	25	15				145	
Reject	01	01											
Defect Repair/Repair Pas													
Defect Name				06	05	07	06	04					
Open/Broken/Skip Sis.	05	04	03	04	02	02	02	02					
Shading	03	01	01	02	02	02	02	02					
Puckening													
Neck Shape													
Poor Tentlon				02	02								
Uneven	02		04	03									
Rawedge	4												
Oil Mark													
Dirty Mark				02									
Damage													
Union/Over Sts.													
Wrong Trims		02	02	01									
Label Join													
Slv. Uneven													
Size Mistake													
Bottom/Cup/AH Shape													
Print/Emb/Strip Univen				02	02	04	03	02					
Uncut Thread	02	02	03	02	03	04	03	02					
Others	3	02	03	02	03	04	03	02					
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%	
Inline Q.C Sign	EA	EA	EA	EA	EA	EA	EA	EA					
Pro. Sup. Sign													
Q.C Sup. Sign													
1st		Def. Qty.		.2nd Highest									Def. Qty.

Q.I.

Q.C.

Pro. Sup.

P.M.

Q.M.

Report: 11

Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date : 7.04.2019

Line : 05

Item :

Buyer	Mo. No. : 539										Total	%
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.		
Inspection	220	215	225	220	215	210	200	190			1685	9.23%
Good	200	200	205	204	190	190	180	175			1684	
Defect	20	15	20	16	25	20	20	15			151	
Reject			02	07								
Defect Repair/Repair Pas												
Defect Name												
Open/Broken/Skip Sis	05	02	04	03	05	06	04	03				
Shading	04	02	04	02	02	02	02	02				
Ruckering	02											
Neck Shape												
Poor Tention												
Uneven	02	03	03	07	02	07	02	02				
Rawedge	4											
Oil Mark												
Dirty Mark												
Damage												
Open/Sis	03	02	07	02	07	02	02	01				
					03	07	07	02				
Uncut Thread		04	02		05		04					
Others		02	04	03	04	03	02					
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
Pro. Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
Q.C Sup. Sign	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				
1st	Def. Qty.	2nd Highest		Deft Qty.			3rd Highest		Def. Qty.			

[Signature]
Q.I.

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Q.C.

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Pro. Sup.

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P.M.

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Q.M.

Report: 12

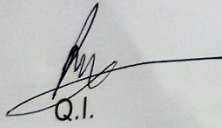
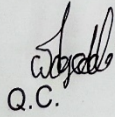
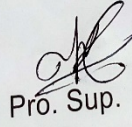
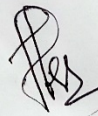
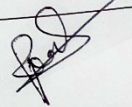
Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date: 08-04-2019

Line: 05 Item: 1. Shirts

Buyer	Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Dona		190	220	200	180	200	210	200	215			1615	8.66%
Inspection		170	205	180	165	180	195	180	200			1575	
Good		20	15	20	15	20	15	20	15			140	
Defect		01		01		01		01					
Reject													
Defect Repair/Repair Pas													
Defect Name													
Open/Broken/Skip Sis.		4	5	5	4	5	4	3	3				
Shading		02	01	02	02	01	01	02	02				
Puckering		02	02	01									
Neck Shape													
Poor Tention													
Uneven		02	02	02	02	03	02	02	02				
awedge		03	02	02	03	02	02	01					
Mark													
Dirty Mark													
Damage		02	01	02	02	02	02	02	01				
Union/Over Sis.													
Wrong Trims													
Wrinkle/Down													
Stk. Uneven													
Size Mistake													
Bottom/Cup/AH Shape						4		3	3				
Print/Emb/Strip Univen													
Uncut Thread		5	5	4			02	3	3				
Others													
Hours		1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign													
Pro. Sup. Sign													
Q.C Sup. Sign													
1st		Def. Qty.		2nd Highest				Deft Qty.		3rd Highest			Def. Qty.

 Q.I.
  Q.C.
  Pro. Sup.
  P.M.
  Q.M.

Report: 13

Majma Composite Textile Ltd.
 Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date: 09.04.2019

Line: 05

Item: V.T. Skirt - R.T. Skirt

Buyer	Mo. No. : 539-105										Item : V.T. Skirt - R.T. Skirt	
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inspection	200	205	190	180	150	125		120			1150	13.7
Good	180	190	170	160	120	100		20			1000	
Defect	20	15	20	20	30	25		32			150	
Reject			01		01	01						
Defect Repair/Repair Pass												
Defect Name												
Open/Broken/Skip Sts.	4	3	3	4	5	15		10				
Shading	02	01	02	02	02							
Puckering	02	02	02	02	02							
Neck Shape	WIPING	02	02	02	04							
Poor Tention												
Uneven	01	02	03	02	3							
Rawedge	02		02									
Oil Mark	01			01								
Dirty Mark												
Damage												
Union/Over Sts.	02	02	01	02	3	02		02				
Wrong Trims												
Label Join												
Slv. Uneven												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Emb/Strip Univen												
Uncut Thread	4	02	02	4	7	07		03				
Others	Under style	Mistake	02	3	4	5						
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline Q.C Sign	A	A	A	A	A	A		A				
Pro. Sup. Sign												
Q.C Sup. Sign												
1st	Def. Qty.		2nd Highest		Def. Qty.		3rd Highest		Def. Qty.			

Lima
Q.I.

[Signature]
Q.C.

[Signature]
Pro. Sup.

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Report: 14



maggie composite textile ltd.
 Plot - 832/833, Dewan Edris Road, Kathgora, Amtola, Savar, Dhaka, Phone : 7792265

END TABLE INSPECTION REPORT

Date : 16.04.2019

Buyer	Mo. No. :	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%		
Donat	105											
Hours												
Inspection	150	180	200									
Good	120	155	180									
Defect	30	25	20									
Reject	01		01									
Defect Repair/Repair Pas												
Defect Name	7	10	6									
Open/Broken/Skip Sts.												
Shading												
Puckening	02	01	2									
Neck Shape	02	02										
Poor Tention												
Uneven	03	06	9									
Rawedge												
Oil Mark												
Dirty Mark												
Damage	5	4	3									
Union/Over Sts.												
Wrong Trims												
Label Join												
Slv. Uneven												
Size Mistake												
Bottom/Cup/AH Shape												
Print/Embi/Strip Univen												
Uncut Thread	8	02										
Other Defect												
Hours	1st Hr.	2nd Hr.	3rd Hr.	4th Hr.	5th Hr.	6th Hr.	7th Hr.	8th Hr.	9th Hr.	10th Hr.	Total	%
Inline O.C Sign												
Pro. Sup. Sign												
O.C Sup. Sign												
1st	Def. Qty.		2nd Highest								Def. Qty.	

Q.I.

Q.C.

Pro. Sup.

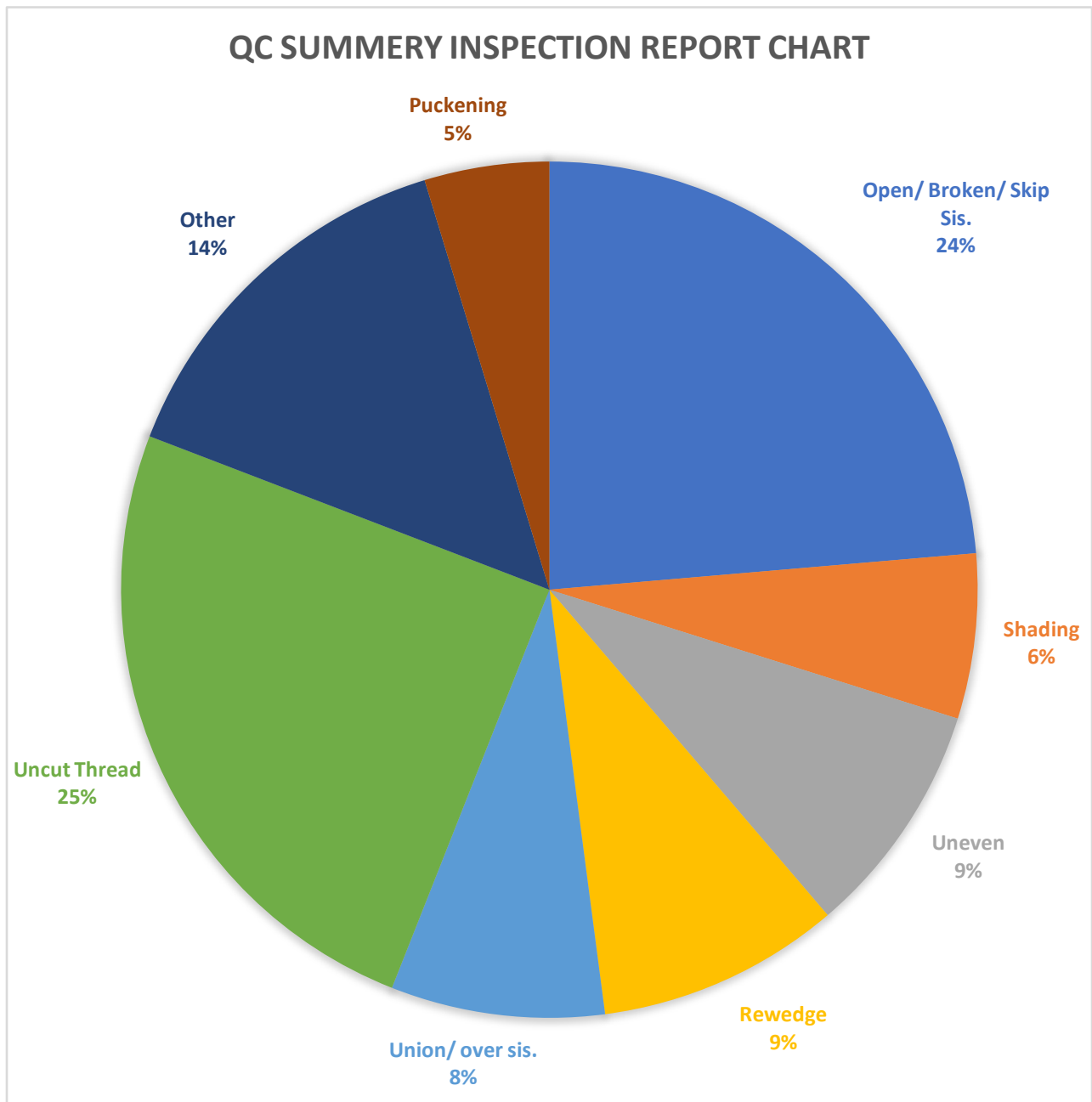
P.M.

Q.M.

3.2 Summary of the reports (14 days)

Date	Open/ Broken/ Skip Stitch	Shading	Puckening	Neck Shape	Poor Tension	Uneven	Oil Mark	Rewedge	Dirty Mark	Union/ over stitch	Wrong Trims	Label Join	Sleeve Uneven	Size mistake	Uncut Thread	Other	Total
13.3.19	15	1	✓	3	15		✓	10	7	✓	✓	12	✓	✓	72	55	75
16.3.19	3	✓	1	✓	✓	2	✓	14	1	2	✓	12	✓	✓	32	18	85
17.3.19	4	✓	✓	✓	✓	7	✓	8	✓	✓	✓	9	8	✓	✓	10	46
21.3.19	10	✓	✓	11	✓	9	3	✓	✓	9	✓	7	✓	✓	37	11	97
23.3.19	12	✓	✓	✓	12	✓	7	✓	✓	9	✓	3	✓	✓	38	10	91
24.3.19	12	✓	✓	✓	8	7	✓	12	✓	13	✓	✓	✓	✓	1	✓	53
25.3.19	42	27	✓	✓	13	✓	✓	12	✓	11	✓	✓	✓	✓	34	8	147
3.4.19	20	✓	✓	✓	✓	9	✓	8	✓	✓	✓	✓	✓	7	8	6	58
4.4.19	18	✓	✓	✓	✓	4	✓	6	✓	✓	✓	5	✓	3	3	8	47
6.4.19	40	17	14	✓	✓	11	✓	17	✓	4	✓	10	✓	✓	11	17	141
7.4.19	32	19	16	✓	✓	16	✓	9	✓	14	✓	7	✓	✓	15	18	146
8.4.19	33	9	13	✓	✓	17	✓	15	✓	14	✓	7	✓	✓	21	7	138
9.4.19	44	5	10	13	✓	11	2	4	✓	13	✓	✓	✓	✓	29	10	141
10.4.19	23	✓	5	4	✓	18	✓	✓	✓	12	✓	✓	✓	✓	10	3	75

total	296 (22.09%)	78(5.82%)	59 (4.40%)	31 (2.31%)	48 (3.59%)	111 (8.29%)	12 (0.90%)	115 (8.58%)	8 (0.60%)	101 (7.54%)	✓	72 (5.37%)	8 (0.60%)	10 (0.77%)	311 (23.21%)	181 (13.51%)	1340
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Date	Inspection	Good	Defect	Reject
13.3.19	1663	1615	150	08
16.3.19	1190	1085	105	
17.3.19	1192	1117	75	
21.3.19	1589	1495	94	
23.3.19	1603	1512	91	4
24.3.19	1605	1503	102	
25.3.19	1614	1496	118	
3.4.19	630	567	63	4
4.4.19	531	480	51	
6.4.19	1385	1240	145	
7.4.19	1635	1484	151	
8.4.19	1615	1453	140	
9.4.19	1150	1000	150	

10.4.19	530	455	75	2
total	17932	16502	1510	18

4. Result & Discussion

We collect 14 days Quality Control Inspection Report from Magpie Composite Textile Ltd. Then we analyze it and find out many faults from quality control section. We found 24% fault in Open/ Broken/ Skip sis., 6% in Shading, 5% in Puckering, 9% in Uneven, 9% in Rewedge, 8% in Union/ Over sis., 25% in Uncut, 14% in Others. So we observe that the percentage of quality control inspection report defects. QC defects is occurring for machine problems and worker faults or unskilled operator etc.

Along these lines, we can say that greatest shortcoming which found in assessment, happen for laborer unreliability and machine issue too.

In Bangladesh pieces of clothing industry, the male or female who join as a specialist, their activity is qc area under. Articles of clothing ventures organization don't give any preparation to the specialist. Therefore, they don't have the foggiest idea why quality control area shortcoming happens.

In the event that we orchestrate least 1-month preparing period for new laborer and administrator then they will comprehend that what they will do.

4.1 Causes & Remedies of defects:

4.2 Broken Stitch

Non-continuous sewing thread.

Causes:

- ✚ It appears due to improper trimming or machine usage.

Remedies:

- ✚ Needle plate, presser foot and feed dog should be checked periodically for damages
- ✚ Proper machine usage
- ✚ Tension and threading should not be fiddled with much
- ✚ Washing parameters should be strictly followed
- ✚ Proper trimming
- ✚ Good quality or D-core thread should be used
- ✚ Needle thread fabric combination should be well judged
- ✚ Needle alignment should be right

4.3 Drop stitch/Skipped stitch

Irregular stitching along the seam.

Causes:

- ✚ It appears due to improper handling of cut pieces or machine usage.

Remedies:

- ✚ Examine the setting and timing between needle and hook or looped.
- ✚ Placing of needle properly.
- ✚ The tension of thread should be adjusted.
- ✚ Needle size & thread size must be adjusted.
- ✚ The pressure of pressure foot must be adjusted accurately.

4.4 Shading

Causes:

- ✦ It arises due to improper cutting, bundling and numbering.
- ✦ Uneven to batch missing shade.
- ✦ Different Batch mixing for same garment.

Remedies:

- ✦ After cutting the garment parts must be kept in proper bundle with number.
- ✦ One batch fabric shade is used for same garment in every part.
- ✦ Shade is marking each part due to fabric cutting.

4.5 Puckering

4.5.1 Seam Puckering

Seam puckering refers to the gathering of a seam either just after sewing or after laundering causing an unacceptable seam appearance.

Causes:

This problem arises due to uneven stretching on to plies of fabric during sewing , improper thread tension , wrong sewing thread selection , dimensional instability of the plies of fabric etc.

Remedies:

- ✦ Feed dog, eyelets and thread guides should be checked periodically for damages
- ✦ Machine feed mechanism must be better quality
- ✦ Operator training
- ✦ Tension, SPI and presser foot pressure should not be fiddled with much
- ✦ UBT/trimmer should be used instead of pulling and breaking thread
- ✦ Needle-thread-fabric combination should be well judged
- ✦ Sewing thread must be selected properly

4.5.2 Tension Puckering

If a sewing thread tension is higher in the seam, it will be in stretched condition during the stitching process and it will try to relax after sewing. This leads to seam puckering instantly as the seam is coming out from beneath the presser foot. This incident also happens after the garment is laundered causing the seam to pucker. Excessive sewing thread tension will not only lead to seam puckering but also cause other problems such as skipped stitches and sewing thread breakage.

Causes:

To check whether the puckering is due to structural jamming or thread tension, the top and bottom threads of all stitches along a seam have to be cut for a few centimeter's, without displacement of yarns in the fabric. If the seam pucker is disappeared over this length, then it was caused by sewing thread tension and subsequent recovery as shown in Figure

Remedies:

- ✚ Optimize needle thread and bobbin thread tensions.
- ✚ Synchronization of timing of feeding has to be set correctly as incorrect feed timing can lead to the need to apply excessive tension to the needle thread, in order to create a properly balanced stitch.
- ✚ Positioning finger should be set correctly to permit the sewing thread to go through the bobbin hook easily in case of lock stitch machines.
- ✚ Stitch balance should be adjusted on chain stitch machines in a manner that the needle loops on the bottom side of the seam lay over at least halfway to the next needle penetration when the looper thread is unraveled out of the seam.

4.5.3 Feed Puckering

It occurs when different fabric plies are fed at variable rates than one another. This leads to a gathering effect in the over-fed ply.

Causes:

- ✚ When the presser foot holds back on the upper fabric ply as the bottom fabric ply is being fed at a greater rate by the feed dog

- ✚ When the operator grips the bottom fabric ply but shoves the top fabric ply to the seam line hence the fabric edges will come out evenly

To identify the feed puckering, two perpendicular cuts across a sewn seam have to be done where the puckered condition is the maximum. Then, the sewing thread has to be removed from the seam and ensure whether two fabric plies are of equal length. If one fabric is longer than the other, then the puckering is being caused by the uneven feeding of fabric.

Remedies:

- ✚ The presser foot pressure exerted on the fabric should be less to keep up uniform feeding. The clamping of fabric by the presser foot should be ensured at the front as well as the back of the needle.
- ✚ Setting of feed dogs with respect to their height as well as back feeding should be ensured. The selection of feed dog with reference to the number of teeth per inch and number of rows of teeth should be done. The feed dog with 20–24 TPI (teeth per inch) for lightweight fabrics, 14–18 TPI for medium weight and 8–12 TPI for heavy weight fabrics are normally preferred.
- ✚ The presser foot and needle plate should have comparatively small needle holes with respect to the needle size being used.
- ✚ Sewing machines equipped with more positive feeding mechanisms are advisable.

4.5.4 Shrinkage Puckering

Shrinkage puckering could happen when one fabric panel in the seam shrinks differently compared to the other fabric panel as shown in Figure-5. Typical components include the base fabric, interlining, zipper tapes, stay tapes and the thread. All these components should have minimum shrinkage to produce a pucker-free seam.

- ✚ Wash pucker: If the sewing thread shrinks during the washing process, it pulls the fabric with it causing puckering and is more prominent with the use of cotton sewing threads.
- ✚ Ironing pucker: It occurs while using synthetic sewing threads in the garment. The application of heat changes the molecular structure of the fibers in the thread, which results in shrinkage leading to puckering.

To identify the shrinkage puckering, two perpendicular lines at a distance of 10" across a seam should be marked using an indelible ink pen that normally shows extreme seam puckering after laundering. Two perpendicular lines against the seam line which has been marked before should be connected with a line running parallel to the seam. The length of the seam should be verified after the garment is subjected to finishing and pressing cycles. The gap between the two marked lines will be less than 10" if there is seam shrinkage. To minimize this puckering, the sewing thread having low shrinkage characteristics has to be selected.

4.6 Neck Shape

The neckline is the top edge of a garment that surrounds the neck, especially from the front view. Neckline also refers to the overall line between all the layers of clothing and the neck and shoulders of a person, ignoring the unseen undergarments.

For each garment worn above the waist, the neckline is primarily a style line and may be a boundary for further shaping of the upper edge of a garment with, for example, a collar, cowl, darts, or pleats. In that respect it is similar to the waistline and hemline.

Causes:

- ✚ Neck width plus & minus from cutting department
- ✚ Negligence & misshading of press man while pressing the garments
- ✚ Neck shape out or uneven neck cutting from cutting department
- ✚ Improper machine cutting by machine operator

Remedies:

- ✚ Take in at the shoulder seam
- ✚ Make the neckline smaller with gathering
- ✚ Stitch a stay tape for the neckline
- ✚ Add a fabric piece
- ✚ Sew in Darts / pleats / tucks
- ✚ Try to shrink neckline
- ✚ Alter it into an off-shoulder style

4.7 Uneven Stitch

The uneven basting stitch is made the same as the even basting stitch except that the stitch on the upper side of the cloth is made about two or three times as long as the stitch on the underside of the cloth.

Uneven basting is used in fastening together two or more pieces of cloth where there is to be no strain on them before the permanent basting is done. For instance, in holding together the lower part of a full skirt, basting the seams for cuffs or holders and things of that sort.

Causes:

- ✚ Incorrect tension of sewing thread.
- ✚ Used incorrect thread path.
- ✚ Incorrect adjustment of needle thread path.
- ✚ Snagging of needle with bobbin case and positioning finger.
- ✚ If sewing threads are not lubricated.

Remedies:

- ✚ Setting of accurate tension to the threads
- ✚ Using of accurate thread path.
- ✚ Using of right thread path.
- ✚ Bobbin case to be smooth and finger positioning to be set again.

4.8 Oil Mark

In garment manufacturing where garments are stitched oil stains may be often found in garments. Stains are considered one kind of defects in garments, which leaves an unpleasant mark on clothes. In case such stains found on garments, factories remove stain by spotting or washing prior to packing garments. There is a cost involved in removing the oil stain. It is better to take precaution in material handling throughout the manufacturing process - from fabric receiving to shipping the packed garments to avoid oil staining.

Causes:

- ✚ Poor garments handling at Cutting and sewing
- ✚ Poor machine maintenance as a result of oil leakage
- ✚ A spot in washing
- ✚ Dirty workplace
- ✚ Improper lubrication
- ✚ Lick age of lubricant pipe

Remedies:

- ✚ Blot away any excess grease or oil with a paper towel.
- ✚ Cover grease or oil stain generously with baby powder.
- ✚ Remove the baby powder from the clothing with a paper towel or spoon.
- ✚ Work a small amount of hand dishwashing detergent and water into stain with your thumb.
- ✚ Wash the clothing, alone, with laundry detergent.

4.9 Dirty Mark

Causes:

- ✚ Fabric is placed in dirty place
- ✚ Contamination of dust

Remedies:

- ✚ Production body keep in safe place
- ✚ Keep Production body in to the poly

4.10 Damage

Causes:

- ✚ Mechanical damage.
- ✚ Needle heating damage.

Remedies:

- ✚ By using perfect size and shape of needle and needle point.
- ✚ By testing sew ability before sewing fabrics.
- ✚ By flowing cool air on the needle during sewing.
- ✚ By using lubricant to the needle and fabrics to the sewing line.

4.11 Uncut/ loose thread

Extra thread or loose thread on seam line.

Causes:

- ✚ It appears due to improper trimming or finishing.

Remedies:

- ✚ UBT/thread trimmer should be used
- ✚ Operator training
- ✚ Garments finishing should be checked properly.

4.12 Skipped Stitches

Skipped stitch means that one stitch will be missed by tension or faulty needle it's called Skipped Stitches

Causes

- ✚ Hook, looped or needle failing to enter thread loops at the correct time.
- ✚ Needle deflections or bent needle.
- ✚ Incorrect sewing tension in the needle or under threads.

Remedies

- ✚ Check machine clearances and timings. Check if the needle is inserted and aligned correctly. Use a needle with a deeper scarf.
- ✚ Use a reinforced needle, reset the needle guard and replace the needle.
- ✚ Re-adjust the tensions.

5. Conclusion

The undertaking has gone to an end at long last after loads of reasoning, talk and our consistent attempting. We truly have endeavored to finish this task well ahead. We wished to make it as an imitation of changes on sew articles of clothing quality by evacuating issue. At the point when the advancement of the nation was at a stop position because of the inheritance of broke economy and industrialization was stale, the fare situated material and RMG part had demonstrated the beam of expectation by its everything inescapable position sway on the national economy. At the most distant end of the eighty, this area began extending and inside a brief time of its reality, this early industry turned into the biggest outside trade worker.

Remaining at the skirt of another thousand years, Textile and RMG division is presently the core of the national economy. Indeed, even after this accomplishment, this industry faces the real test of worldwide alteration in the coming years when it needs to react the new exchanging course of action after 2000.

Presently a days Textile field become aggressive and the purchaser needs 100 % trade quality item. Consequently, it is critical to think about the most recent advancements in material part. To create a quality Product, as a Textile designer I should have a huge learning about the generation Parameters and how to deliver amazing item and Techniques of preparations and the administration framework. With the goal that it gives a total learning about examination on changes on sew pieces of clothing quality issue for the creation Though there were a few impediments like lack of time that constrained us to finish the proposal as quickly as time permits, and, after its all said and done we have attempted to put forth a strong effort. . In this paper, we can see that greatest no. of deficiency is gap, skip line. soil spot .oil spot and so on are for the most part impact on quality on the pieces of clothing generation.

Along these lines, we figure this undertaking will help us in future.

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