Faculty of Engineering

Department of Textile Engineering

REPORT ON

"Study on the quality reports of cutting & sewing section of a knit composite factory"

Course Title: Project (Thesis)
Course Code: TE 4214

Submitted By

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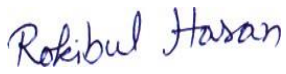
This Report Presented in Partial Fulfillment of the Requirements for the Degree of Bachelor of Science in Textile Engineering.

Advance in Apparel Manufacturing Technology

Fall, 2019

Declaration

We attest that this report is totally our own work, except where we have given fully documented references to the work of others and that the materials contained in this report have not previously been submitted for assessment in any formal course of study. If we do anything, which is going to breach the first declaration, the examiner/supervisor has the right to cancel ourreport at any point of time.



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Approval Sheet

This is to certify that the thesis entitled **"**Study on quality reports of cutting & sewing section of a knit composite factory**"** submitted by Md. Rokibul Hasan (Student ID: 161-23-4556) & Mohammad IftekharulAlam (Student ID: 161-23-4551) to the Department of Textile Engineering under the Faculty of Engineering of Daffodil International University towards partial fulfillment of the requirements for the award of the degree of B.Sc. in Textile Engineering (Apparel Manufacturing) is a genuine record of the work carried out by him under my supervision and guidance.

Md. Abdullah AL Mamun
Assistant Professor
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Acknowledgement

At first we would like to express our deep appreciation to Allah for providing the opportunity to complete our Thesis on depth study of quality reports of cutting & sewing section of a knit composite factory.

Firstly, our special thanks go to Abdullah Al Mamun, Assistant Professor, and Department of textile Engineering, Daffodil Intentional University for his encouragement and valuable suggestions.

We would like to thank the management of the GMS Composite Knitting Industry Ltd. for giving us the opportunity to perform the Thesis successfully.

We are indebted to Umme Flora, AGM (Compliance), Rahazul Amin Rafiz(Asst. Merchandiser) for their valuable teaching, advising, supervising and training during our industrial attachment. We hope their valuable information regarding to production process will help us a lot for our future carrier.

Dedication

We dedicate this report to our **Parents** who give us chance to study in Textile Engineering and support us all time.

Specially dedicate this report **Rahazul Amin Rafiz, (**Asst. Merchandiser)Of GMS Composite Knitting Industry Ltd and all the people who have helped us in the GMS Composite Knitting Industry Ltdto complete this report.

Abstract

We have successfully done our report on **"**Study on quality reports of cutting & sewing section of a knit composite factory" We have visited all the sections (Knitting, dyeing, dye finishing, cutting, printing, sewing, washing, dyeing lab, yarn dyeing lab, R&D, IE planning, ETP, HR& Admin) in GMS Composite Knitting Industry Ltd and Identify that cutting and sewing is very important section for garments making.

We selected our thesis topic on cutting and sewing department because most of the fault is occurred in these two sections and affect on garments quality. We also tried to identify different types of defects, their causes and remedies.

We have mainly collected in cutting section their daily and weekly cutting quality reports and some fault show Major defect and some fault show minor defect and also identified which types of defects mainly occurred and calculate their (%). Some major faults are (Crease mark, oil sport, missing yarn,hole, thick yarn, uneven dyeing, running shade).Final cutting result is:

Neps (8.38%),Knitting Hole (7.38%), Dyeing Spot (7.35%),Needle Mark (7.01%), Thick/thin yarn (7.0%), Yarn Contamination (6.70%),Lycra (6.59%),Crease Mark (6.22%),Drop Needle (6.18%),Oil spot (6.15%), Knot (6.11%),Uneven dyeing (5.55%),Off Grain (5.26%), Tron (4.72%), Dirty Spot (4.12%),Selvedge Uneven (2.66%), Miss Print (2.57%).

We have also collected daily/ weekly sewing end line quality reports for different style and identified which types of defects mainly occurred and some fault show major defect and some fault show minor defect and also calculate their(%). Some major fault are: (thick thin stitch, open seam, size mistake, down stitch, without bartack). Final sewing result is:Uncut Thread(42.27%),Oil Mark (12.29%),Dirty Mark (9,84%),Wrong Label (6.62%),Uneven Seam (5,90%),Broken Stitch (5.78%),Open Seam (5.23%), Skipped Stitch (4.67%), Hole (3.73%), Up down point (2.34%), Puckering (2.34%), Pleated (2.00%), Raw
edge (1.95%)

Minor faults can be eliminated by different process after sewing or cutting.

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Chapter 1: INTRODUCTION

1.1 Background of the study:

The RMG is totally incomplete without cutting & sewing process. But sometimes there are different difficulties and the result is cutting & sewing defects. It is because of lack of proper skill, machine disturbance and improper machine adjustment. Due to these obscurities fault occurred and effects quality, productivity, expense and also efficiency. So Quality standard are part of a firm standard operating procedure, product development and production planning. Standards reflect the overall intrinsic quality level the firm seeks to achieve. The fundamental purpose of using quality standard is to provide consistency between products and products line. Because of maintaining standard or quality of product it is mandatory to detect the fault and find out the best solution to reduce the error. Among the process control list, product control chart were used in the study. Rapid detection of a cutting &sewing defect is significant to optimization of the relationship between quality and productivity. Defects found after cutting &sewing negatively affect costs of the product. There is different plus to identifying an imperfection before other operations hinder replacement of cutting and seam removal and re sewing. This observation is based upon the current system in which the operator serves as the first line of quality control implementation. And other cutting and sewing stations have no operator to serve in the first line quality control position. Then finally assessment procedure of defect was done and find out the best suggestion.

1.2 Objectives of the Sewing Study:

- ❖ To know about cutting and sewing.
- ❖ To know about cutting and sewing faults and their remedies.
- ❖ To identify the cutting and sewing faults and solve.
- ❖ To solve the cutting and sewing faults.
- ❖ To improve the cutting and sewing fault
- ❖ To reduce the cutting and sewing faults.

❖ To know about technical solution of the cutting and sewing faults.

1.3 Important and Scope of the study:

To analyze the types of faults in sewing section.

❖ To play an important role in increase or decrease production.

❖ To easily calculate daily, weekly and monthly faults in a line.

❖ To reduce cutting and sewing fault during production.

❖ It gives knowledge why sewing fault increase or decrease.

❖ Avoid defects on garments and save time.

1.4 Limitations of the study:

❖ Limitation of time to research this topic.

❖ Limitation of primary data sources.

❖ Limitation of accurate data.

❖ Input and output problem.

❖ Changing the style and arrangement.

Chapter 2: LITERATURE REVIEW

2.1 Previous Study:

Most of the time previous studies means exactly that, studies published were disseminated in the past that report result of research findings.

Some previous studies are:

- Study on Quality Problem in Knit Garments Production with their remedies done byMd. Rokibul Hasan (Student ID: 161-23-4556) & Mohammad IftekharulAlam (Student ID: 161-23-4551) on Fall 2019.

That project was mainly on the basis of cutting, sewing and finishing and their final quality report to maintain for the business employed in export business has to sustain a high level of quality to ensure better business globally.

- Study on Different Types of Sewing Faults and Their Remedies in Knit Garment Production done by Md. Rokibul Hasan (Student ID: 161-23-4556) & Mohammad IftekharulAlam (Student ID: 161-23-4551) on Fall 2019.

That project was mainly on the basis of sewing fault like(skipped stitch, puckering, broken stitch, thick and thin Stitch, without bar tack, raw edge, uncut thread, down stitch, open seam, etc) and how this types of fault was often occurred and how to reduce this types of fault.

Table No: 2.1

Faults	**Fault%**
Uncut thread	38.22%
Oil Mark	15.34%
Dirty Mark	11.26%
Uneven Seam	6.43%
Broken Stitch	5.14%
Open Seam	5.00%
Puckering	4.60%
Thick and Thin Stitch	3.20%
Raw Edge	2.56%
Total	91.75%

Now our report is, study on the quality reports of cutting and sewing section of a knit composite factory. Here we will make a project on cutting and sewing quality report and which types of fault mainly occurred and how to control this types fault.

2.2 Quality

Quality is defined as the level of admission of a good or service. It is a very necessary need for any kind of product. All product should sustain the value quality level. In this 21st century of globalization plaza are proper one after another complicated that‟s why each industry are frontal a high level of emulation for their business. So the product must make the buyer necessity. For this reason every product should sustain the quality level. For the textile industry and apparel manufacturing industry, product quality is calculated in word of quality norm of fiber, yarn, fabric construction, color fastness, design and the ultimate finished garment. Nowadays customer are very much quality aware. If it is probable to keep up a high Quality system of inspection policy, the buyers shall be motivated and more quality products can be made. All appreciated the term "Quality" but it is hard to define. Quality note the full form and feature of a product trust on customers‟ prospect of performance and permanence of that product. Quality alter from people to people as their preferences. Quality is the unanimous label of acceptance of any product between the two parties. User‟s satisfaction is the ultimate object of the garments quality. According to the International Organization for Standardization (ISO) –

"Quality is the fulfillment of the specified requirements for a product or service".

2.2.1 Importance of Quality:

Quality is critical to satisfying your customers and retaining their loyalty so they continue to buy from you in the future. Quality products make an important contribution to long-term revenue and profitability. They also enable you to charge and maintain higher prices.

There are several stages to control quality in garment manufacturing.
They are given below:

1. Pre-production quality control
2. Quality control during production
3. Final inspection
4. Quality control to developing a sampling plan
5. Post-production quality evaluation

2.2.2 Objective of Quality Control

- To reduce per unit cost of a product
- To utilize the raw materials, men, machines

- To gain customer satisfaction by reducing faults.

2.3 Quality Inspection

The inspections are done to control the quality is means by examining the products without any instrument. To examine the fabric, sewing, button, thread, zipper, garments measurement and so on according to specification or desired standard is called inspection. There are so many facilities for inspection in every section of garments industries. The aim of inspections is to reduce the time and cost by identifying the faults or defects in every step of garments making.

To do success in inspection, the process can be run by maintaining following “inspection loop”.

a. Inspection

b. Identify the defects or faults

c. Knock the appropriate person

d. Identify the reasons of defects or faults

e. Remove the defects or faults.

Mainly inspections are done in three steps in garments industries.

The steps are:

1. Raw material inspection
2. In process inspection
3. Final inspection.

2.3.1 Inspection System:

There are various fabric inspection systems as listed below. However we will discuss only the 4point system because it is used most widely.

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

2.3.2 4-Point System

The 4- Point system also called the American Apparel Manufacturers Association (AAMA). In this method, defected points are found out in 100 square. Yds. Of fabric must be rejected if the defected points are greater than 40.

Table No: 2.2

Defects length for warp way and weft way	Points
Up to 3”	1
3” ~ 6”	2
6” ~ 9”	3
Above 9”	4

Defects area for holes and openings	Points
1” or less that 1”	2
Above 1”	4

2.3.3 Acceptable Quality Level (AQL):

AQL is one of the most repeatedly used terms when it comes to quality in the garments export industry. As most of the acknowledgment decisions of the apparel shipments for the export market are made on the basis of AQL. AQL means admissible Quality Level. In any business process, before accepting the finished goods from the manufacturer buyer do inspection of goods. It is so much important in export garment sector. Foreign buyers are so much concerned about product quality. They give AQL on the product to the manufacturer. Buyers do inspection of goods as randomly process. If AQL pass that means goods are in

acceptable quality level he gives certificate to ship the goods. The AQL level varies process to process, product to product and even buyer to buyer. In the following table a sampling plan is given for final shipment inspection. Acceptance Quality Level (AQL) refers to the maximum number of defective items that could be considered accepted during the random sampling of and inspection. The defects that are found during inspection are classified into 3 categories:

1. Critical: Must be 100% accurate. There is no range.
2. Major: Normally 2.5
3. Minor: Normally 4

Table No: 2.3

Footwear Industry standard final inspection level sampling plan (Normal)								
Lot size or quantity Audited								
	1.5		2.5		4		6.5	
	Inspect	Accept	Inspect	Accept	Inspect	Accept	Inspect	Accept
Less than 150	20	1	20	1	20	2	20	3
151-280	32	1	32	2	32	3	32	5
281-500	50	2	50	3	50	5	50	7
501-1200	80	3	80	5	80	7	80	10
1201-3200	125	5	125	7	125	10	125	14
3201-10000	200	7	200	10	200	14	200	21
10001-35000	315	10	315	14	315	21	315	21
35001-150000	500	14	500	21	500	21	500	21
150001-500000	800	21	800	21	800	21	800	21
500001& Over	1250	21	1250	21	1250	21	1250	21

2.4 Cutting:

Cutting is the preproduction process of separating a spread into garments parts that are of precise size and shape od pattern piece on a marker.

2.4.1 Flow chart of Cutting section:

FLOW SEQUESNCE OF CUTTING

2.4.2 Types of Cutting knife:

- Die cutter
- Drill cutter
- Straight knife cutter
- Round knife

2.4.3 Marker Making:

During garments manufacturing process, marker making is the most useful process to draw the pattern pieces over a thin marker paper and this marker paper is placed on the fabric lay for minimizing the fabric wastage.

2.4.4 Fabric cutting:

Fabric lay is cutting by straight knife cutting machine then separated cutting part.

2.4.5 Numbering:

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.

2.4.6 100% checking and replacing if needed

After cutting the lay of the fabric inspection are done. If any part of the cutting fabric get defect or need replacement then replacing is done.

2.4.7 Different types of Cutting faults:

- Miss cut
- Running shade
- Matching plies
- Number and Bundling
- Notch mark
- Oil spot
- Tension loose
- Bias
- Skew

Mainly there have a cut panel checking room there also check mainly all types of fabric faults.

Some pictures are given below:

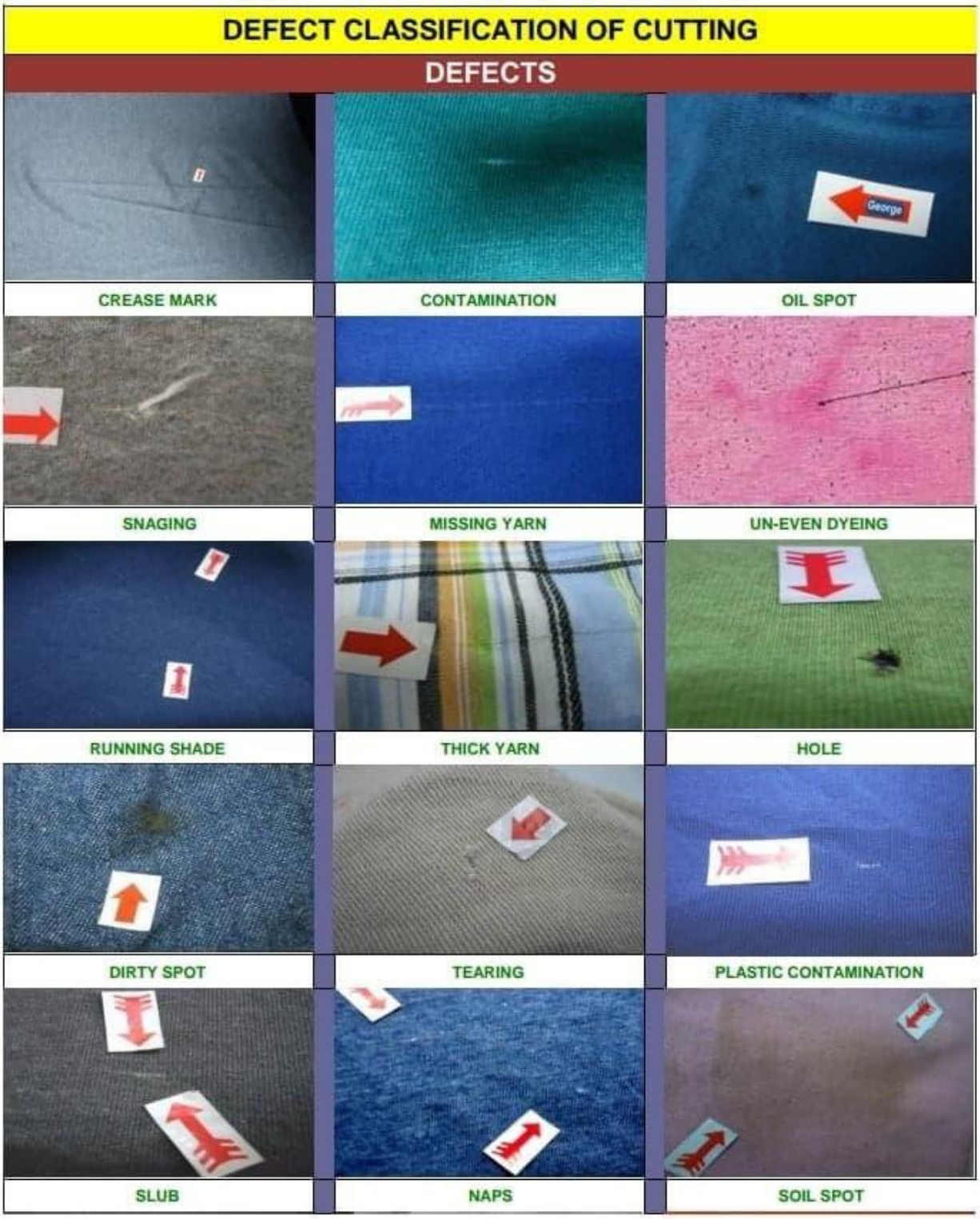
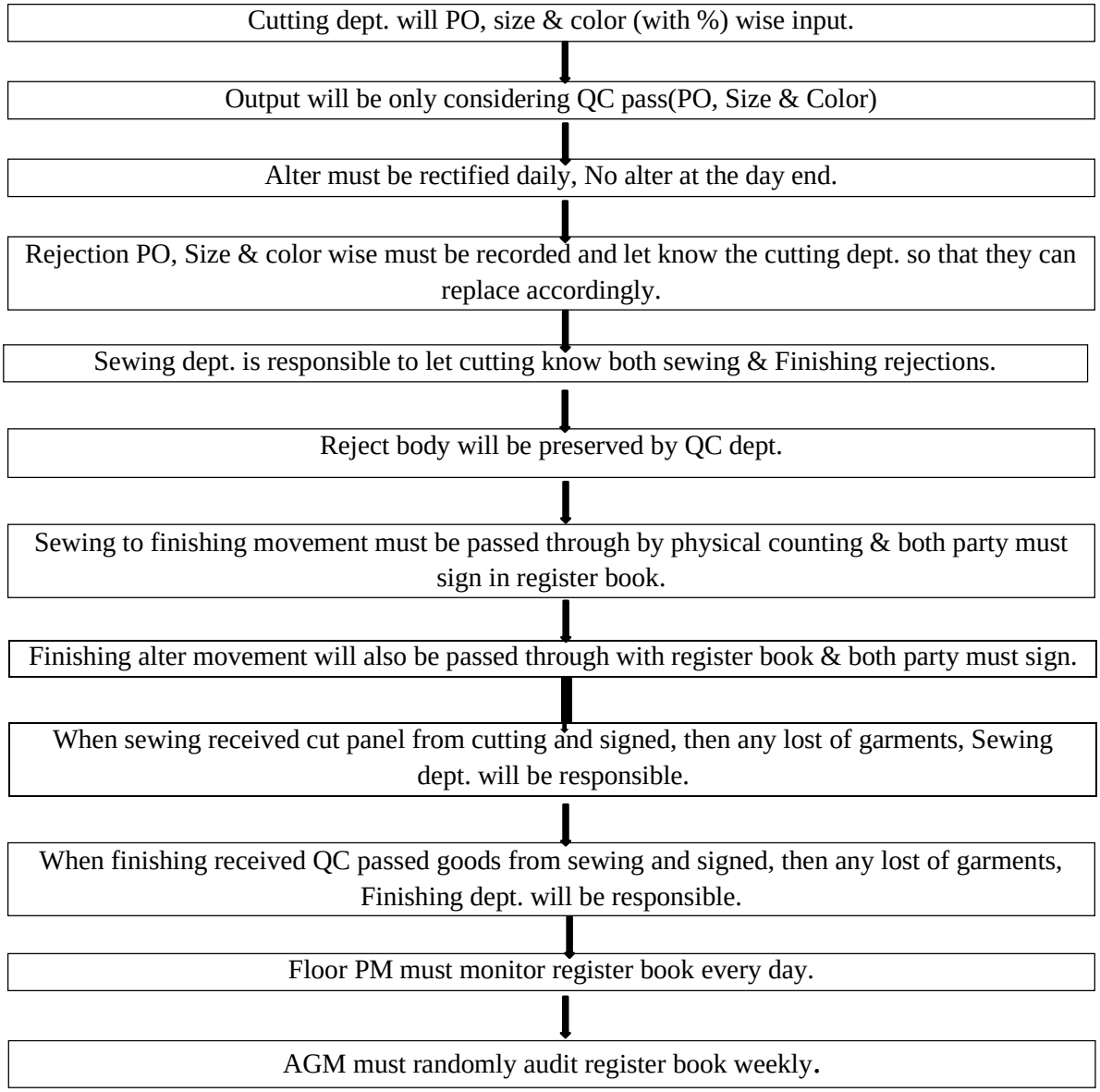


Figure 2.1: Defect of cutting

2.5 What is sewing?

Sewing is the craft of fastening or attaching objects using stitches made with a needle and thread.

2.5.1 Flow Chart of Sewing Section:



2.5.2 Generally Using Sewing Machine:

- Over lock
- Flat Lock
- Plain M/C
- Bartack M/C
- Button Hole M/C
- Punch M/C
- Eyelet M/C
- Feed of the arm
- Button attach M/C
- Fusing M/C
- Piping M/C
- Iron M/C
- Logo attach M/C

2.5.3 Machine Brand:

- Pegasus
- Juki
- Brothers
- Kansai

2.5.4 Types of sewing needle:

- Sharps
- Short darners
- Long darners
- Yarn darners
- Curved repair
- Leather needle
- Cross stitch

2.5.5 Types of sewing defects:

There are two main types of defects:

1. Non-Sewing defects.
2. Sewing defects.

Non-sewing defects:

- ❖ Wrong pattern.
- ❖ Wrong cutting.
- ❖ Poor handling of goods.
- ❖ Oil marks.
- ❖ Defects to wrong ironing, folding, and packing.

Sewing defects:

Sewing defect can be classified as three groups:

1. Problem of stitch formation.
2. Seam pucker.
3. Fabric damage along the seam line or stitch.

2.5.6 Problems of stitch formation:

- ❖ Broken stitches.
- ❖ Skip Stitch.
- ❖ Slipped Stitch.
- ❖ Staggered Stitch.
- ❖ Unbalanced Stitch.
- ❖ Variable Stitch Density.
- ❖ Puckering.
- ❖ Uneven.
- ❖ Slanted.
- ❖ Uncut thread.
- ❖ Dirt marks.
- ❖ Open seam

2.5.7 Different Types of Sewing Faults Picture:

Dirty Mark

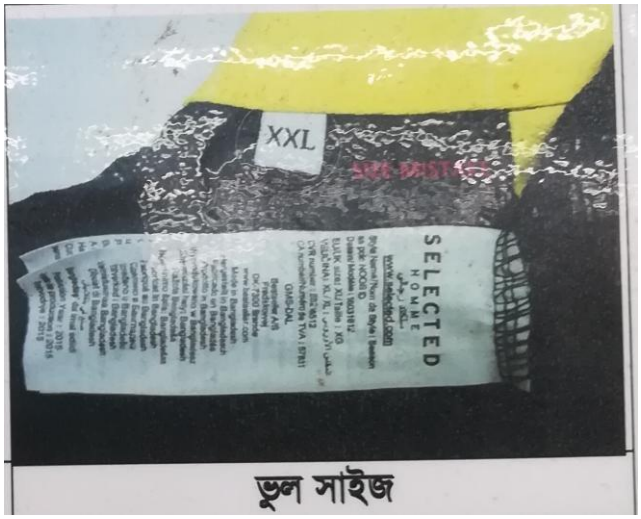
Skipped Stitch

Armhole Point Up down

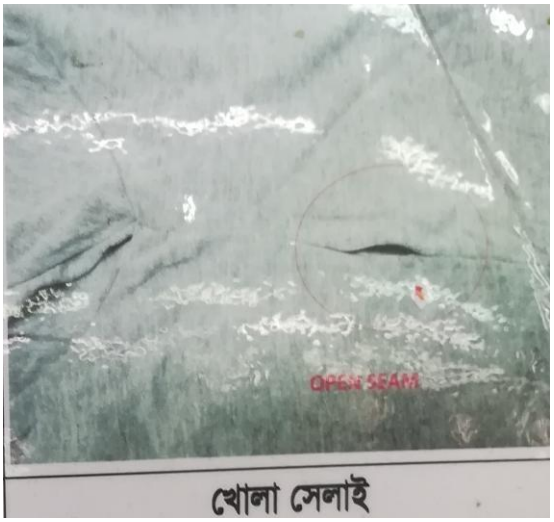
Raw Edge

Without Bartack

Uneven Stitch

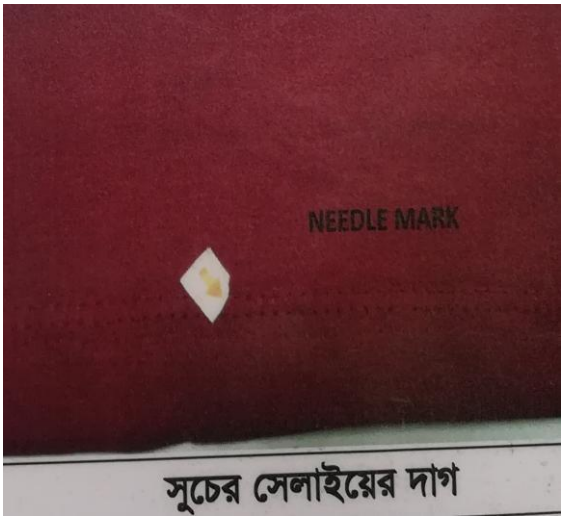


Wrong Size



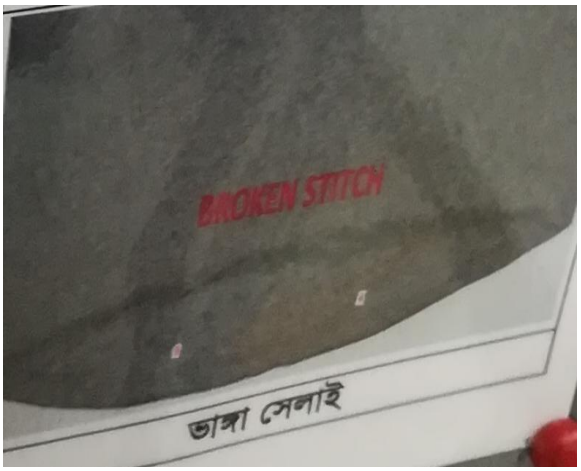
Open Seam

Down Side Seam



Needle Mark

Puckering



Broken Stitch

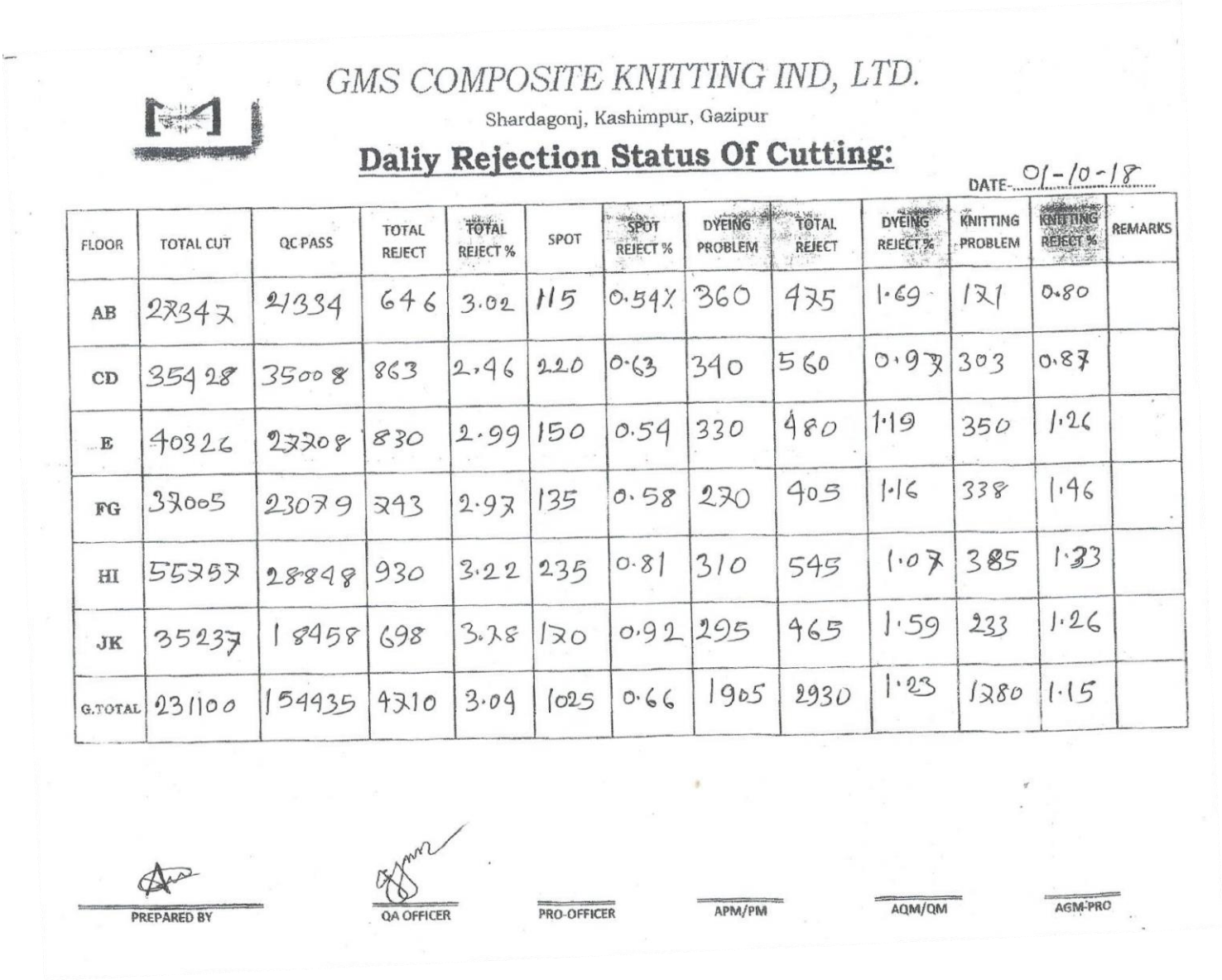
Figure 2.2: Sewing Fault

Chapter 3: METHODOLOGY

3.1 Data Collection

We have collected some data for cutting and sewing section. For cutting we are collected (daily, weekly and monthly) cutting quality report, and for sewing (different style end line) quality report.

3.2 Cutting Quality Report



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Shardagonj, Kashimpur, Gazipur

Daliy Rejection Status Of Cutting:

DATE- 01-10-18

FLOOR	TOTAL CUT	QC PASS	TOTAL REJECT	TOTAL REJECT %	SPOT	SPOT REJECT %	DYEING PROBLEM	TOTAL REJECT	DYEING REJECT %	KNITTING PROBLEM	KNITTING REJECT %	REMARKS
AB	27347	21334	646	3.02	115	0.54%	360	475	1.69	171	0.80	
CD	35428	35008	863	2.46	220	0.63	340	560	0.97	303	0.87	
E	40326	27208	830	2.99	150	0.54	330	480	1.19	350	1.26	
FG	37005	23079	743	2.97	135	0.58	270	405	1.16	338	1.46	
HI	55757	28848	930	3.22	235	0.81	310	545	1.07	385	1.33	
JK	35237	18458	698	3.78	170	0.92	295	465	1.59	233	1.26	
G.TOTAL	231100	154435	4210	3.04	1025	0.66	1905	2930	1.23	1280	1.15	

PREPARED BY | QA OFFICER | PRO-OFFICER | APM/PM | AQM/QM | AGM-PRO

3.2.1 Daily Rejection Status of Cutting:

Figure 3.1: Daily Rejection Status of Cutting

In that Daily Rejection Status of Cutting, there has 7 floors (AB, CD, E, FG, HI, JK). But we will describe only AB floor and also identify which types of faults mainly effect on quality.

3.2.2 Weekly Rejection Status of Cutting for (AB Floor, 1st week):

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Weekly Rejection Status of Cam:-01+02 Cutting:

FLOOR:- AB CUTTING

DAY	Total Prod.	Q.C Check	Alter	Spot	Reject
SAT	27347	21334	431	176	646
SUN	30142	21544	666	100	760
MON	29311	21285	486	66	552
TUES	28215	20245	572	112	689
WEB	34236	25903	628	225	903
THURS	35023	20933	490	34	525
G.TOTAL	184329	152523	3352	718	4035

FLOOR Date: 01-10-18 TO 07-10-18

DAY	Yarn Fault			Knitting Fault					Dyeing Fault							Aop					Cutting Defect					Total
	Slub/Neps	Stripe/Thick/Thin	Yarn Contamination	Line Star/Knot	Sinker/Dia/Needle Mark	Knitting Hole/Drop	Lycra/Yarn Missing	Drop Needle/Patta	Dyeing Hole Tron	Dyeing Spot/Sopner Spot	Crease Mark/Abdasion	Bias/Off Grain	Un-Even Dyeing/Running Shade	Oil/Greese Spot	Dirty/Soil Spot	Miss Print/Dot Print	Print Shade Chapge	Salvage Side Not Cut	Aop Inside Color Pass	Un-Even Aop	Un-Even Shape	Measurement Less/Plus	Bothside Not Even	Un-Even Parts	Any Mistake	
SAT	40	35	55	15	32	60	31	38	65	20	38		10	50	55	27		25								696
SUN	20	25	45	13	28	22	68	48	29	62	65		35	28	10	7		5								760
MON	62	65	35	45	38	55	65	45	38	32	25		10	14	20	3										552
TUES	35	29	26	60	46	38	48	9	56	66	35	5	93	25	26	35		7								689
WEB	85	46	55	24	48	45	41	36	60	85	39	12	45	65	25	50		2								903
THURS	21	55	56	31	48	55	56	65	15	16	19	5	15	10	8											525
G.TOTAL	363	305	322	238	290	330	309	281	308	331	221	22	208	192	199	122		39								4075

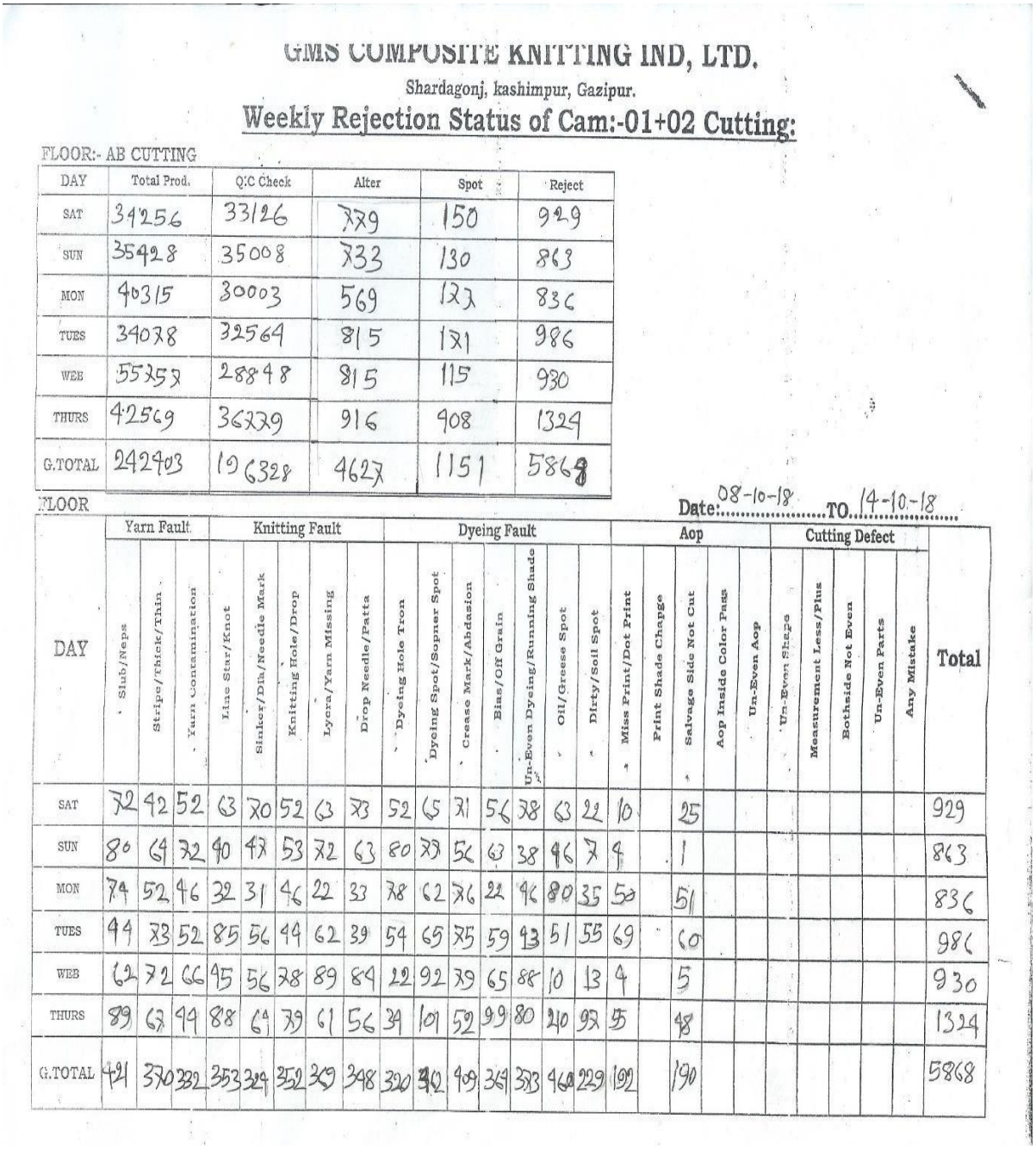
Figure 3.2: Weekly Rejection Status of Cutting (01/10/18-07/10/18)

Table: 3.1 **Weekly Rejection status of cutting**

Floor: AB		**Date: 01/10/18-07/10/18**
Total Cut: 184774	**Total Q.C check: 152573**	**Total Reject: 4075**

Faults	**Date**					
	01-10-18	**02-10-18**	**03-10-18**	**04-10-18**	**06-10-18**	**07-10-18**
Neps	40	70	62	35	85	71
Thick/thin	35	75	65	29	46	55
Yarn contamination	55	45	35	76	55	56
knot	15	13	45	60	74	31
Needle Mark	32	78	38	46	48	48
Knitting hole	60	77	55	38	45	55
Lycra	31	68	65	48	41	56
Drop Needle	38	48	45	9	76	65
Tron	65	74	38	56	60	15
Dyeing Spot	70	62	32	66	85	16
Crease Mark	38	65	25	35	39	19
Off Grain				5	12	5
Un even Dyeing	10	35	10	93	45	15
Oil spot	50	28	14	25	65	10
Dirty Spot	55	10	20	26	75	8
Miss Print	27	7	3	35	50	-
Selvedge uneven	25	5	-	7	2	-
Total	**646**	**760**	**552**	**689**	**903**	**525**

3.2.3 Weekly Rejection Status of Cutting for (AB Floor, 2nd week):



GMS COMPOSITE KNITTING IND, LTD.

Shardagonj, kashimpur, Gazipur.

Weekly Rejection Status of Cam:-01+02 Cutting:

FLOOR:- AB CUTTING

DAY	Total Prod.	Q:C Check	Alter	Spot	Reject
SAT	34256	33126	779	150	929
SUN	35428	35008	733	130	863
MON	40315	30003	569	127	836
TUES	34078	32564	815	121	986
WEB	55253	28848	815	115	930
THURS	42569	36279	916	908	1324
G.TOTAL	242403	196328	4627	1151	5868

FLOOR Date: 08-10-18 TO 14-10-18

DAY	Yarn Fault			Knitting Fault					Dyeing Fault							Aop				Cutting Defect					Total
	Slub/Neps	Stripe/thick/Thin	Yarn Contamination	Line Star/Knot	Sinker/Dia/Needle Mark	Knitting Hole/Drop	Lycra/Yarn Missing	Drop Needle/Patta	Dyeing Hole Tron	Dyeing Spot/Sopner Spot	Crease Mark/Abdasion	Bias/Off Grain	Un-Even Dyeing/Running Shade	Oil/Grease Spot	Dirty/Soil Spot	Miss Print/Dot Print	Print Shade Chapge	Salvage Side Not Cut	Aop Inside Color Pass	Un-Even Aop	Un-Even Shape	Measurement Less/Plus	Bothside Not Even	Un-Even Parts	Any Mistake	
SAT	72	42	52	63	70	52	63	73	52	65	71	56	38	63	22	10		25								929
SUN	80	64	72	40	47	53	72	63	80	79	56	63	38	96	7	9		1								863
MON	74	52	46	32	31	46	22	33	78	62	76	22	96	80	35	50		51								836
TUES	44	73	52	85	56	44	62	39	54	65	75	59	93	51	55	69		60								986
WEB	62	72	66	95	56	78	89	84	22	92	79	65	88	10	13	4		5								930
THURS	89	63	44	88	64	79	61	56	34	101	52	99	80	240	92	15		48								1324
G.TOTAL	421	370	332	353	324	352	349	348	320	340	409	364	383	460	229	192		190								5868

Figure 3.3: Weekly Rejection Status of Cutting (08/10/18-14/10/18)

Table: 3.2 **Weekly Rejection status of cutting**

Floor: AB	**Date: 08/10/18-14/10/18**	
Total Cut: 242403	**Total Q.C check: 196328**	**Total Reject: 5868**

Faults	**Date**					
	08-10-18	**09-10-18**	**10-10-18**	**11-10-18**	**13-10-18**	**14-10-18**
Neps	72	80	74	44	62	89
Thick/thin	42	64	52	73	72	67
Yarn contamination	52	72	46	52	66	44
knot	63	40	32	85	45	88
Needle Mark	70	47	31	56	56	64
Knitting hole	52	53	46	44	78	79
Lycra	63	72	22	62	89	61
Drop Needle	73	63	33	39	84	56
Tron	52	80	78	54	22	34
Dyeing Spot	65	77	62	65	92	101
Crease Mark	71	56	76	75	79	52
Off Grain	56	63	22	59	65	99
Un even Dyeing	78	38	46	43	88	80
Oil spot	63	46	80	51	10	210
Dirty Spot	22	7	35	55	13	97
Miss Print	10	4	50	69	4	55
Selvedge uneven	25	1	51	60	5	48
Total	**929**	**863**	**836**	**986**	**930**	**1324**

3.2.4 Weekly Rejection Status of Cutting for (AB Floor, 3rd week):

GMS COMPOSITE KNITTING IND, LTD.

Shardagonj, kashimpur, Gazipur.

Weekly Rejection Status of Cam:-01+02 Cutting:

FLOOR:- AB CUTTING

DAY	Total Prod.	Q.C Check	Alter	Spot	Reject
SAT	40236	41325	968	200	1168
SUN	41026	34311	794	120	964
MON	40326	22208	258	32	830
TUES	41967	25289	692	83	329
WEB	40127	25230	290	236	1026
THURS	35006	30967	698	127	825
G.TOTAL	238688	185330	4700	892	5592

FLOOR Date:15-10-18 TO.21-10-18

DAY	Yarn Fault			Knitting Fault					Dyeing Fault							Aop					Cutting Defect					Total
	Slub/Neps	Stripe/Thick/Thin	Yarn Contamination	Line Star/Knot	Sinker/Dik/Needle Mark	Knitting Hole/Drop	Lycra/Yarn Missing	Drop Needle/Patta	Dyeing Hole Tron	Dyeing Spot/Sopner Spot	Crease Mark/Abdasion	Bias/Off Grain	Un-Even Dyeing/Running Shade	Oil/Grease Spot	Dirty/Soil Spot	Miss Print/Dot Print	Print Shade Chapge	Salvage Side Not Cut	Aop Inside Color Pass	Un-Even Aop	Un-Even Shape	Measurement Less/Plus	Bothside Not Even	Un-Even Parts	Any Mistake	
SAT	89	54	66	98	84	120	90	88	48	96	52	66	44	69	35			22	23							1168
SUN	27	36	45	45	110	92	39	48	20	88	23	63	81	43	39			32	29							964
MON	69	35	61	38	99	89	46	32	42	30	54	81	37	12	26			19	11							830
TUES	88	32	46	56	89	91	55	33	41	39	52	53	38	29	19	9			9							329
WEB	99	46	62	35	53	48	39	69	19	130	88	39	59	60	46			25	29							1026
THURS	63	65	35	49	89	65	35	43	53	84	59	62	28	32	10			10								825
G.TOTAL	485	328	355	361	524	505	304	315	228	462	382	404	287	250	185	9		108	105							5592

Figure 3.4: Weekly Rejection Status of Cutting (15/10/18-21/10/18)

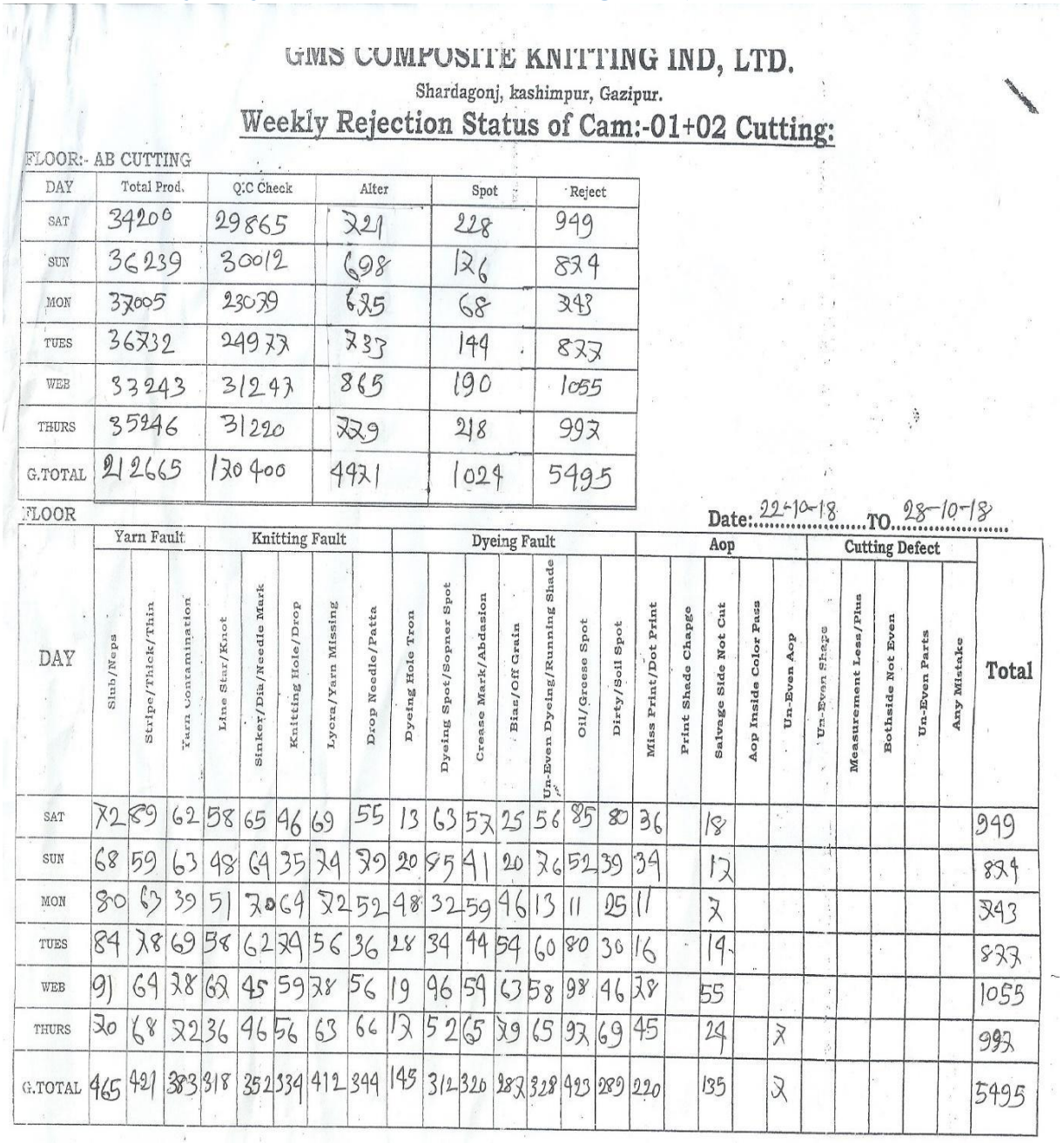
GMS Composite Knitting Industry Ltd

Table: 3.3 **Weekly Rejection status of cutting**

Floor: AB	**Date: 15/10/18-21/10/18**	
Total Cut: 238688	**Total Q.C check: 18330**	**Total Reject: 4700**

Faults	**Date**					
	15-10-18	**16-10-18**	**17-10-18**	**18-10-18**	**20-10-18**	**21-10-18**
Neps	89	77	69	88	99	63
Thick/thin	74	36	75	32	46	65
Yarn contamination	66	45	61	46	62	75
knot	98	45	38	56	75	49
Needle Mark	84	110	99	89	53	89
Knitting hole	120	92	89	91	48	65
Lycra	90	39	46	55	39	35
Drop Needle	88	48	32	33	69	43
Tron	48	20	47	41	19	53
Dyeing Spot	96	88	30	39	130	84
Crease Mark	52	77	54	52	88	59
Off Grain	66	63	81	53	79	62
Un even Dyeing	44	81	37	38	59	28
Oil spot	69	43	16	29	60	33
Dirty Spot	35	39	26	19	46	10
Selvedge uneven	22	32	19	9	25	10
Aop inside color pass	27	29	11	9	29	-
Total	**1168**	**964**	**830**	**779**	**1026**	**825**

3.2.5 Weekly Rejection Status of Cutting for (AB Floor, 4th week):



GMS COMPOSITE KNITTING IND, LTD.

Shardagonj, kashimpur, Gazipur.

Weekly Rejection Status of Cam:-01+02 Cutting:

FLOOR:- AB CUTTING

DAY	Total Prod.	Q.C Check	Alter	Spot	Reject
SAT	34200	29865	321	228	949
SUN	36239	30012	698	126	824
MON	37005	23039	625	68	343
TUES	36732	24977	733	149	827
WEB	33243	31247	865	190	1055
THURS	35246	31220	729	218	997
G.TOTAL	212665	170400	4471	1024	5495

FLOOR Date:22-10-18 TO.28-10-18

DAY	Yarn Fault			Knitting Fault					Dyeing Fault							Aop					Cutting Defect					Total
	Slub/Neps	Stripe/Thick/Thin	Yarn Contamination	Line Star/Knot	Sinker/Dia/Needle Mark	Knitting Hole/Drop	Lycra/Yarn Missing	Drop Needle/Patta	Dyeing Hole Tron	Dyeing Spot/Sopner Spot	Crease Mark/Abdasion	Bias/Off Grain	Un-Even Dyeing/Running Shade	Oil/Grease Spot	Dirty/Soil Spot	Miss Print/Dot Print	Print Shade Chapge	Salvage Side Not Cut	Aop Inside Color Pass	Un-Even Aop	Un-Even Shape	Measurement Less/Plus	Bothside Not Even	Un-Even Parts	Any Mistake	
SAT	72	89	62	58	65	46	69	55	13	63	57	25	56	85	80	36		18								949
SUN	68	59	63	48	64	35	74	79	20	85	41	20	76	52	39	34		12								824
MON	80	63	39	51	70	64	72	52	48	32	59	46	13	11	25	11		7								343
TUES	84	78	69	58	62	79	56	36	28	34	44	54	60	80	30	16		14								827
WEB	91	64	38	62	45	59	78	56	19	96	59	63	58	98	46	38		55								1055
THURS	70	68	72	36	46	56	63	66	12	52	65	29	65	93	69	45		24		7						997
G.TOTAL	465	421	383	318	352	334	412	344	145	312	320	287	328	493	289	220		135		12						5495

Figure 3.5: Weekly Rejection Status of Cutting (22/10/18-28/10/18)

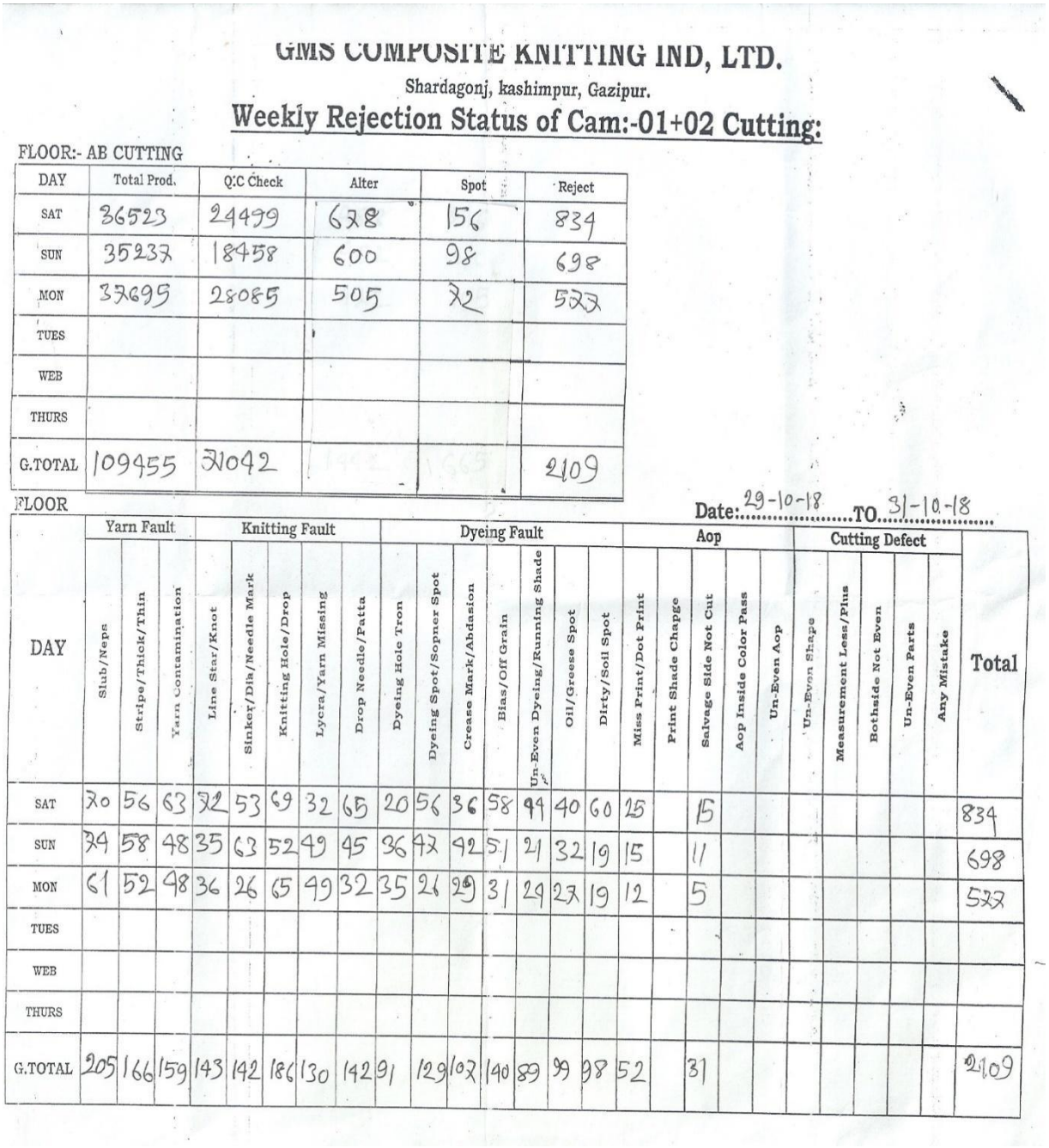
GMS Composite Knitting Industry Ltd

Table: 3.4 **Weekly Rejection status of cutting**

Floor: AB	**Date: 22/10/18-28/10/18**	
Total Cut: 212665	**Total Q.C check: 170400**	**Total Reject: 4700**

Faults	**Date**					
	22-10-18	**23-10-18**	**24-10-18**	**25-10-18**	**27-10-18**	**28-10-18**
Neps	72	68	80	84	91	70
Thick/thin	79	59	63	78	64	68
Yarn contamination	62	63	39	69	78	72
knot	58	48	51	58	67	36
Needle Mark	65	64	70	62	45	46
Knitting hole	46	35	64	74	59	56
Lycra	69	74	72	56	78	63
Drop Needle	55	79	52	36	56	66
Tron	13	20	48	28	19	17
Dyeing Spot	63	85	32	34	46	52
Crease Mark	57	41	59	44	54	65
Off Grain	25	20	46	54	63	79
Un even Dyeing	56	76	13	60	78	65
Oil spot	85	52	11	80	98	97
Dirty Spot	80	39	25	30	46	69
Miss Print	36	34	11	16	78	45
Selvedge uneven	18	17	7	14	55	31
Total	**949**	**874**	**743**	**877**	**1053**	**997**

3.2.6 Weekly Rejection Status of Cutting for (AB Floor, 5th week):



GMS COMPOSITE KNITTING IND, LTD.

Shardagonj, kashimpur, Gazipur.

Weekly Rejection Status of Cam:-01+02 Cutting:

FLOOR:- AB CUTTING

DAY	Total Prod.	Q:C Check	Alter	Spot	Reject
SAT	36523	24499	628	156	834
SUN	35237	18458	600	98	698
MON	37695	28085	505	72	523
TUES					
WEB					
THURS					
G.TOTAL	109455	71042			2109

FLOOR Date: 29-10-18 TO 31-10-18

DAY	Yarn Fault			Knitting Fault					Dyeing Fault							Aop					Cutting Defect					Total
	Slub/Neps	Stripe/Thick/Thin	Yarn Contamination	Line Star/Knot	Sinker/Dia/Needle Mark	Knitting Hole/Drop	Lycra/Yarn Missing	Drop Needle/Patta	Dyeing Hole Tron	Dyeing Spot/Sopner Spot	Crease Mark/Abdasion	Bias/Off Grain	Un-Even Dyeing/Running Shade	Oil/Greese Spot	Dirty/Soil Spot	Miss Print/Dot Print	Print Shade Chapge	Salvage Side Not Cut	Aop Inside Color Pass	Un-Even Aop	Un-Even Shape	Measurement Less/Plus	Bothside Not Even	Un-Even Parts	Any Mistake	
SAT	70	56	63	72	53	69	32	65	20	56	36	58	99	40	60	25		15								834
SUN	74	58	48	35	63	52	49	45	36	42	42	51	21	32	19	15		11								698
MON	61	52	48	36	26	65	49	32	35	26	29	31	29	27	19	12		5								523
TUES																										
WEB																										
THURS																										
G.TOTAL	205	166	159	143	142	186	130	142	91	129	107	140	89	99	98	52		31								2109

Figure 3.6: Weekly Rejection Status of Cutting (29/10/18-31/10/18)

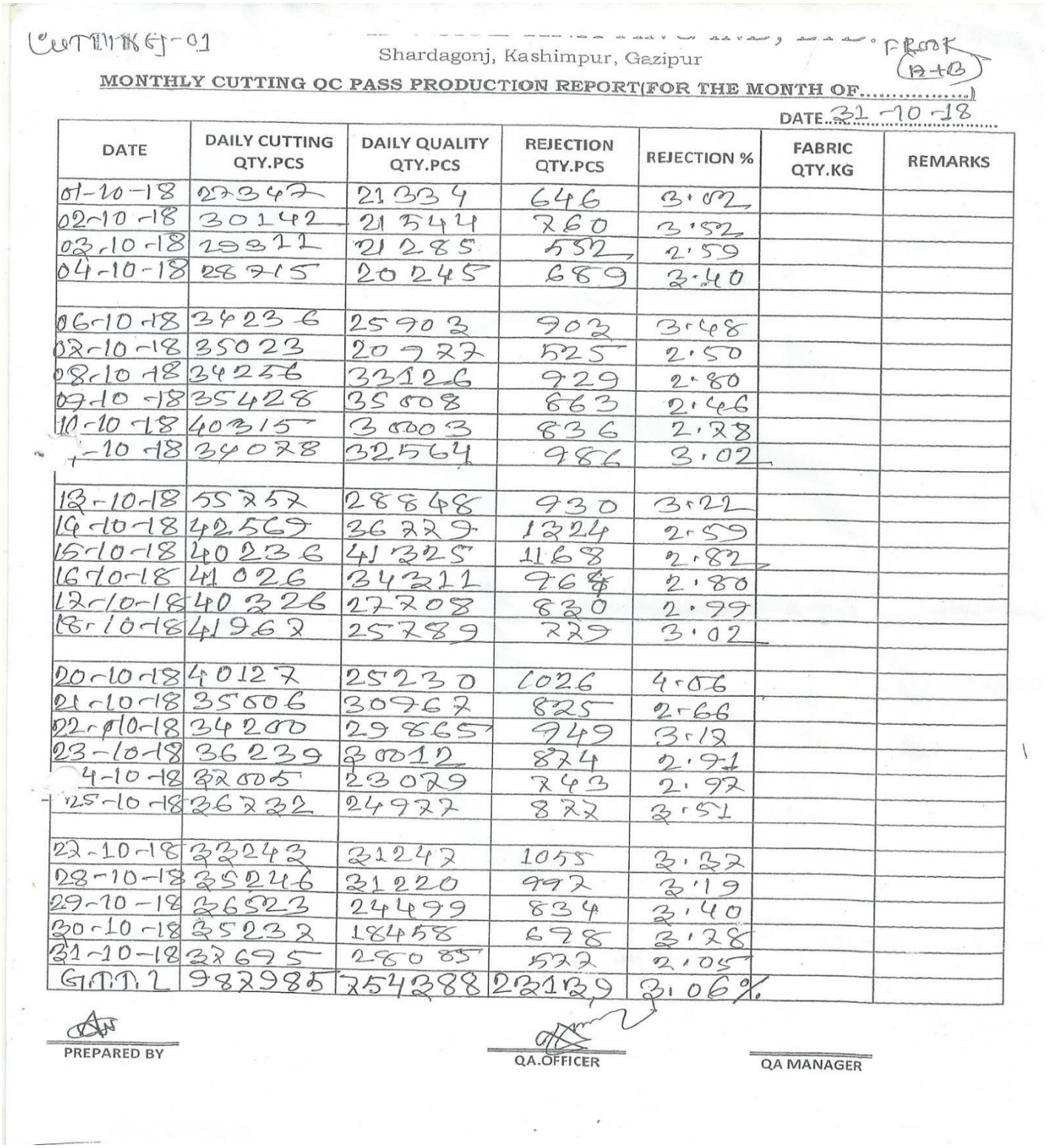
GMS Composite Knitting Industry Ltd

Table: 3.5 **Weekly Rejection status of cutting**

Floor: AB		**Date: 29/10/18-31/10/18**
Total Cut: 109455	**Total Q.C check: 71042**	**Total Reject: 2109**

Faults	**Date**		
	29-10-18	**30-10-18**	**31-10-18**
Neps	70	74	61
Thick/thin	56	58	52
Yarn contamination	63	48	48
knot	72	35	36
Needle Mark	53	63	26
Knitting hole	69	52	65
Lycra	32	49	49
Drop Needle	65	45	32
Tron	20	36	35
Dyeing Spot	56	47	26
Crease Mark	36	42	29
Off Grain	58	51	31
Un even Dyeing	44	21	24
Oil spot	40	32	27
Dirty Spot	60	19	19
Miss Print	25	15	12
Selvedge uneven	15	11	5
Total	**834**	**698**	**577**

3.2.7 Monthly Cutting QC Pass Production Report for (AB Floor):



CUTTING-01

Shardagonj, Kashimpur, Gazipur

FLOOR (A+B)

MONTHLY CUTTING QC PASS PRODUCTION REPORT(FOR THE MONTH OF.....)

DATE..31-10-18

DATE	DAILY CUTTING QTY.PCS	DAILY QUALITY QTY.PCS	REJECTION QTY.PCS	REJECTION %	FABRIC QTY.KG	REMARKS
01-10-18	27347	21334	646	3.02		
02-10-18	30142	21544	760	3.52		
03-10-18	29311	21285	552	2.59		
04-10-18	28715	20245	689	3.40		
06-10-18	34236	25903	903	3.48		
02-10-18	35023	20727	525	2.50		
08-10-18	34256	33126	929	2.80		
09-10-18	35428	35808	663	2.46		
10-10-18	40315	38003	836	2.28		
-10-18	34028	32564	986	3.02		
13-10-18	55257	28848	930	3.22		
14-10-18	42569	36229	1324	2.59		
15-10-18	40236	41325	1168	2.82		
16-10-18	41026	34311	968	2.80		
12-10-18	40326	27208	820	2.99		
18-10-18	41962	25789	229	3.02		
20-10-18	40127	25230	1026	4.06		
21-10-18	35606	30767	825	2.66		
22-10-18	34200	29865	949	3.12		
23-10-18	36239	30012	874	2.91		
4-10-18	32805	23029	743	2.92		
25-10-18	26232	24927	872	3.51		
27-10-18	33243	31247	1055	3.37		
28-10-18	35246	31220	997	3.19		
29-10-18	26523	24499	834	3.40		
30-10-18	25232	18458	678	3.28		
31-10-18	27695	26085	572	2.05		
GRAND	982985	754388	23139	3.06%		

PREPARED BY

QA.OFFICER

QA MANAGER

Figure 3.7: Monthly Cutting QC Pass Production Report

3.2.8 Summary of Reports 27 Day (GMS Composite Knitting Industry Ltd):

Table: 3.6

Faults		Neps	Thick/thin	Yarn contaminatio	knot	Needle Mark	Knitting Hole	Lycra	Drop Needle	Tron	Dyeing Spot	Crease Mark	Off Grain	Un even Dyeing	Oil Spot	Dirty Spot	Miss Print	Selvedge Uneven	**Total**
Date	**01-10-18**	**Total Qc Check: 21334** **Total Rejection %: 3.02%**																	
		40	35	55	15	32	60	31	38	65	70	38	-	10	50	55	27	25	646
	02-10-18	**Total Qc Check: 21544** **Total Rejection %: 3.52%**																	
		70	75	45	13	78	77	68	48	74	62	65	-	35	28	10	7	5	760
	03-10-18	**Total Qc Check: 21285** **Total Rejection %: 2.59%**																	
		62	65	35	45	38	55	65	45	38	32	25	-	10	14	20	3	-	552
	04-10-18	**Total Qc Check: 20245** **Total Rejection %: 3.40%**																	

	35	29	76	60	46	38	48	9	56	66	35	5	93	25	26	35	7	689
06-10-18	**Total Qc Check: 25903** **Total Rejection %: 3.48%**																	
	85	46	55	74	48	45	41	76	60	85	39	12	45	65	75	50	2	903
07-10-18	**Total Qc Check: 20977** **Total Rejection %: 2.50%**																	
	71	55	56	31	48	55	56	65	15	16	19	5	15	10	8	-	-	525
08-10-18	**Total Qc Check: 33126** **Total Rejection %: 2.80%**																	
	72	42	52	63	70	52	63	73	52	65	71	56	78	63	22	10	25	929
09-10-18	**Total Qc Check: 35008** **Total Rejection %: 2.46%**																	
	80	64	72	40	47	53	72	63	80	77	56	63	38	46	7	4	1	836
10-10-18	**Total Qc Check: 30003** **Total Rejection %: 2.78%**																	

	74	52	46	32	31	46	22	23	78	62	76	22	46	80	35	50	51	836
11-10-18	**Total Qc Check: 32564** **Total Rejection %: 3.02%**																	
	44	73	52	85	56	44	62	39	54	65	75	59	43	51	55	69	60	986
13-10-18	**Total Qc Check: 28848** **Total Rejection %: 3.22%**																	
	62	72	66	45	56	78	89	84	22	92	79	65	88	10	13	4	5	930
14-10-18	**Total Qc Check: 36779** **Total Rejection %: 2.59%**																	
	89	67	44	88	64	79	61	56	34	101	52	99	80	210	97	55	48	1324
15-10-18	**Total Qc Check: 41325** **Total Rejection %: 2.82%**																	
	89	74	66	98	84	120	90	88	48	36	52	66	44	69	35	22	27	1168
16-10-18	**Total Qc Check: 34311** **Total Rejection %: 2.80%**																	

	77	36	45	45	110	92	39	48	20	88	77	63	81	43	39	32	29	964
17-10-18	**Total Qc Check: 27708** **Total Rejection %: 2.99%**																	
	88	32	46	56	89	91	55	33	41	39	52	53	38	29	19	9	9	779
18-10-18	**Total Qc Check: 25789** **Total Rejection %: 3.02%**																	
	99	46	62	75	53	48	39	69	19	130	88	79	59	60	46	25	29	1026
20-10-18	**Total Qc Check: 25230** **Total Rejection %: 4.06%**																	
	63	65	75	49	89	65	35	43	53	84	59	62	28	33	10	10	-	825
21-10-18	**Total Qc Check: 30967** **Total Rejection %: 2.66%**																	
	69	75	61	38	99	89	46	32	47	30	54	8	37	16	26	19	11	830
22-10-18	**Total Qc Check: 29865** **Total Rejection %: 3.17%**																	

	72	89	62	58	65	46	69	55	13	63	57	25	56	85	80	36	18	949
23-10-18	**Total Qc Check: 30012** **Total Rejection %: 2.91%**																	
	68	69	63	48	64	35	74	89	20	85	41	20	76	52	39	34	17	874
24-10-18	**Total Qc Check: 23079** **Total Rejection %: 2.97%**																	
	80	63	39	51	70	64	72	52	48	32	59	46	13	11	25	11	7	743
25-10-18	**Total Qc Check: 24977** **Total Rejection %: 3.51%**																	
	84	78	69	58	62	74	56	36	28	34	44	54	60	80	30	16	14	877
27-10-18	**Total Qc Check: 31247** **Total Rejection %: 3.37%**																	

	31-10-18		**30-10-18**		**29-10-18**		**28-10-18**	
61	**Total Qc Check: 28085**	74	**Total Qc Check: 18458**	70	**Total Qc Check: 24499**	70	**Total Qc Check: 31220**	91
2		58		56		68		64
48		48		63		72		78
36		35		72		36		67
26		63		53		46		45
65		52		69		56		69
49		49		32		63		78
32		45		65		66		56
35		36		20		17		19
26		47		56		52		46
29		42		36		65		54
31		51		58		79		63
24		21		44		65		58
27		32		40		97		98
19		19		60		69		46
12		15		25		45		78
5		11		15		31		55
577	**Total Rejection %: 2.05%**	698	**Total Rejection %: 3.78%**	834	**Total Rejection %: 3.40%**	997	**Total Rejection %: 3.19%**	1055

	Total	1939	1629	1551	1413	1623	1707	1524	1430	1092	1701	1439	1217	1285	1424	955	595	615	23139
		Total QC Check: 754388 **Total Reject: 23139**																	
	Fault (%)	8.38%	7.04%	6.70%	6.11%	7.01%	7.38%	6.59%	6.18%	4.72%	7.35%	6.22%	5.26%	5.55%	6.15%	4.12%	2.57%	2.66%	3.06%

											Total
Lycra	Drop Needle	Tron	Dyeing Spot	Crease Mark	Off grain	Un even dyeing	Oil spot	Dirty Spot	Miss Print	Selvedge Uneven	
309	281	308	331	221	22	208	192	194	122	39	4075
369	348	320	462	409	364	373	460	229	192	190	5868
304	313	228	467	382	404	287	250	175	117	105	4700
412	344	145	312	320	287	348	423	289	220	142	4700
130	142	91	129	107	140	89	99	98	52	31	2109
1524(6.59 %)	1430(6.18 %)	1092(4.72%)	1701(7.35 %)	1439(6.22 %)	1217(5.26%)	1285(5.55%)	1424(6.15%)	955(4.12 %)	595(2.57 %)	615(2.66 %)	23139

Date	QC Checked						
		Neps	Thick/Thin	Yarn Contamination	Knot	Needle Mark	Knitting Hole
01-10-18 to 07-10-18	131288	363	305	322	238	290	330
08-10-18 to 14-10-18	196328	421	370	322	353	324	352
15-10-18 to 21-10-18	185330	485	328	355	361	524	505
22-10-18 to 28-10-18	170400	465	411	383	318	352	334
29-10-18 to 31-10-18	71042	205	166	159	143	142	186
Grand Total	754388	1939(8.38%)	1629(7.04%)	1551(6.70%)	1413(6.11%)	1623(7.01%)	1707(7.38%)

3.3 Sewing Quality Report

3.3.1 Daily/Weekly Sewing End Line Quality Report

Item: Hoody

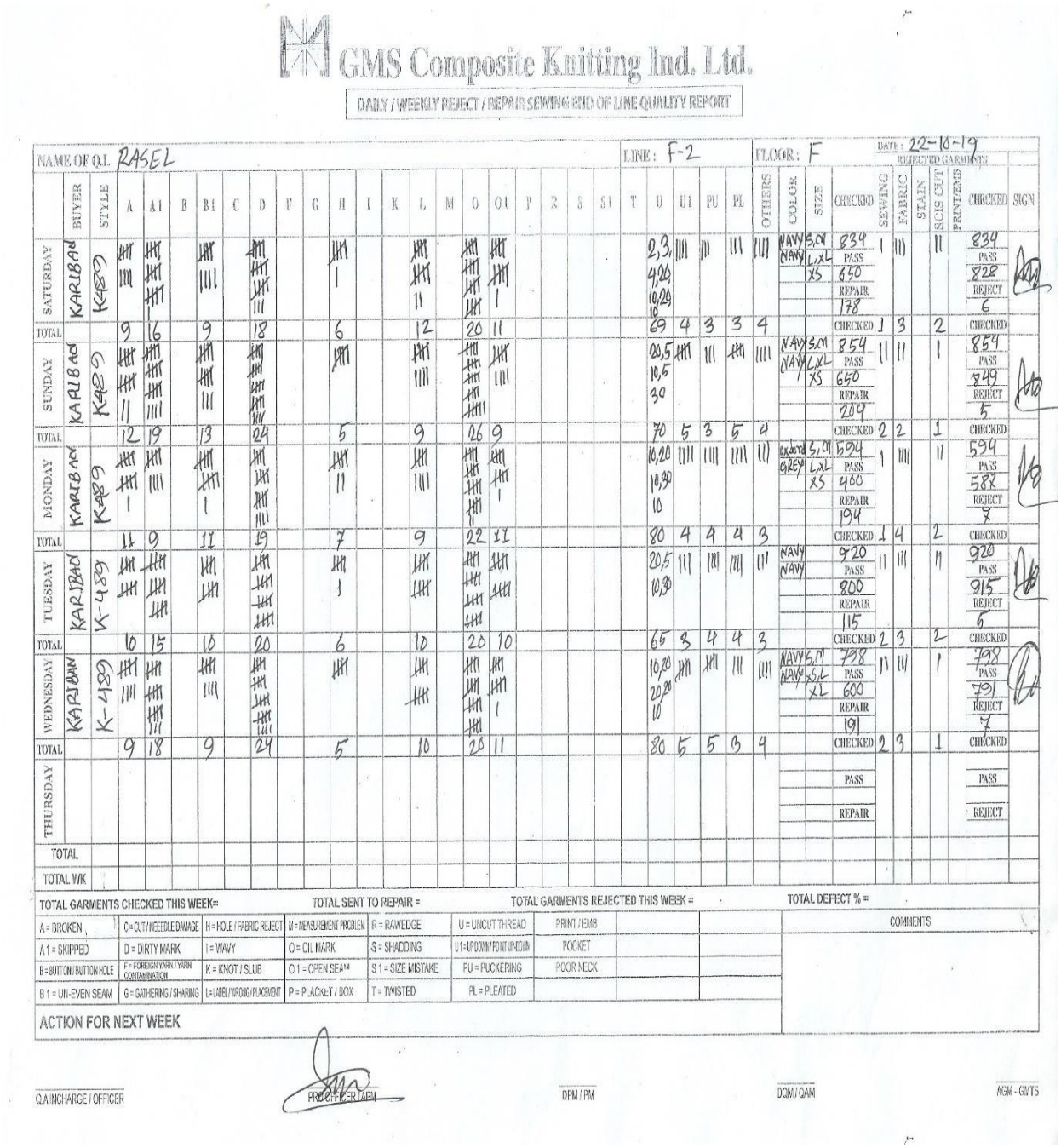
Buyer: KARIBAN

Style No: K489

Color: Navy Blue

Size: S, M, L, XL, XS

Figure 3.8: Hoody


GMS Composite Knitting Ind. Ltd.

DAILY / WEEKLY REJECT / REPAIR SEWING END OF LINE QUALITY REPORT

NAME OF Q.I. RASEL | LINE: F-2 | FLOOR: F | DATE: 22-10-19

	BUYER	STYLE	A	A1	B	B1	C	D	F	G	H	I	K	L	M	O	O1	P	R	S	S1	T	U	U1	PU	PL	OTHERS	COLOR	SIZE	CHECKED	REJECTED GARMENTS: SEWING	FABRIC	STAIN	SCIS CUT	PRINTEMB	CHECKED	SIGN
SATURDAY	KARIBAN	K489	111	1111 1111 1		1111		1111 1111 111			1			1111 1111 11		1111 1111	1111 1					2,3, 4,20, 10,20 10	1111	111	111	1111		NAVY NAVY	S,M L,XL XS	834 PASS 650 REPAIR 178	1	111		11		834 PASS 828 REJECT 6	
TOTAL			9	16		9		18			6			12		20	11					69	4	3	3	4				CHECKED	1	3		2		CHECKED	
SUNDAY	KARIBAN	K489	1111 1111 11	1111 1111 1111		1111 1111 111		1111 1111 1111			1111			1111 1111		1111 1111 1111	1111					20,5 10,5 30	1111	111	111	1111		NAVY NAVY	S,M L,XL XS	854 PASS 650 REPAIR 204	11	11		1		854 PASS 849 REJECT 5	
TOTAL			12	19		13		24			5			9		26	9					70	5	3	5	4				CHECKED	2	2		1		CHECKED	
MONDAY	KARIBAN	K489	1111 1111 1	1111 1111		1111 1111 1		1111 1111 1111			1111 11			1111 1111		1111 1111 1111	1111 1					10,20 10,30 10	1111	1111	1111	111		oxford GREY	S,M L,XL XS	594 PASS 480 REPAIR 194	1	1111		11		594 PASS 588 REJECT 7	
TOTAL			11	9		11		19			7			9		22	11					80	4	4	4	3				CHECKED	1	4		2		CHECKED	
TUESDAY	KARIBAN	K-489	1111 1111	1111 1111 111		1111 1111		1111 1111 1111			1111 1			1111 1111		1111 1111 1111	1111					20,5 10,30	111	1111	1111	111		NAVY NAVY		920 PASS 800 REPAIR 115	11	111		11		920 PASS 915 REJECT 6	
TOTAL			10	15		10		20			6			10		20	10					65	3	4	4	3				CHECKED	2	3		2		CHECKED	
WEDNESDAY	KARIBAN	K-489	1111	1111 1111 111		1111 1111		1111 1111 1111 1			1111			1111 1111		1111 1111 1111	1111 1					10,20 20,20 10	1111	1111	111	1111		NAVY NAVY	S,M L,XL XL	738 PASS 600 REPAIR 191	11	111		1		738 PASS 731 REJECT 7	
TOTAL			9	18		9		24			5			10		20	11					80	5	5	3	4				CHECKED	2	3		1		CHECKED	
THURSDAY																														PASS REPAIR						PASS REJECT	
TOTAL																																					
TOTAL WK																																					

TOTAL GARMENTS CHECKED THIS WEEK= | TOTAL SENT TO REPAIR = | TOTAL GARMENTS REJECTED THIS WEEK = | TOTAL DEFECT % =

A = BROKEN	C = CUT / NEEDLE DAMAGE	H = HOLE / FABRIC REJECT	M = MEASUREMENT PROBLEM	R = RAWEDGE	U = UNCUT THREAD	PRINT / EMB		COMMENTS
A1 = SKIPPED	D = DIRTY MARK	I = WAVY	O = OIL MARK	S = SHADDING	U1 = UPDOWN / FONT UPSIDE	POCKET		
B = BUTTON / BUTTON HOLE	F = FOREIGN YARN / YARN CONTAMINATION	K = KNOT / SLUB	O1 = OPEN SEAM	S1 = SIZE MISTAKE	PU = PUCKERING	POOR NECK		
B1 = UN-EVEN SEAM	G = GATHERING / SHARING	L = LABEL WRONG / PLACEMENT	P = PLACKET / BOX	T = TWISTED	PL = PLEATED			

ACTION FOR NEXT WEEK

Q.A INCHARGE / OFFICER | PRODUCTION OFFICER / APM | DPM / PM | DQM / QAM | AGM - GMTS

Figure 3.9: Daily/Weekly Sewing End Line Quality Report

GMS Composite Knitting Industry Ltd

Table: 3.7 **Daily/Weekly Rejection status of sewing**

Floor: F	**Name of Q.I: Rasel**	**Buyer: KARIBAN**	**Style No: K489**
Total Q.C check:4000	**Total Q.C Pass: 3100** **Total Reject: 900**	**Total Repair: 882**	

Faults	**Date**					
	Saturday	**Sunday**	**Monday**	**Tuesday**	**Wednesday**	**Thursday**
Broken Stitch	9	12	11	10	9	-
Skipped Stitch	16	19	9	15	18	-
Button Hole	-	-	-	-	-	-
Un even Seam	9	13	11	10	9	-
Needle Damage	-	-	-	-	-	-
Dirty Mark	6	5	7	6	5	-
Yarn Contamination	-	-	-	-	-	-
Gathering/ Sharing	-	-	-	-	-	-
Hole	6	5	7	6	5	-
Wavy	-	-	-	-	-	-
Knot/ Slub	-	-	-	-	-	-
Wrong label	12	9	9	10	10	-
Measurement Problem	-	-	-	-	-	-
Oil Mark	20	26	22	20	20	-
Open seam	11	9	11	10	11	-
Placket/ Box	-	-	-	-	-	-
Raw edge	-	-	-	-	-	-

Shadding	-	-	-	-	-	-
Size Mistake	-	-	-	-	-	-
Twisted	-	-	-	-	-	-
Uncut Thread	69	70	80	65	80	-
Up Down	4	5	4	3	5	-
Puckering	3	3	4	4	5	-
Pleated	3	5	4	4	3	-
Raw edge	4	4	3	3	4	-
Total	**172**	**185**	**182**	**166**	**184**	**-**

3.3.2 Daily/Weekly Sewing End Line Quality Report

Item: Hoody

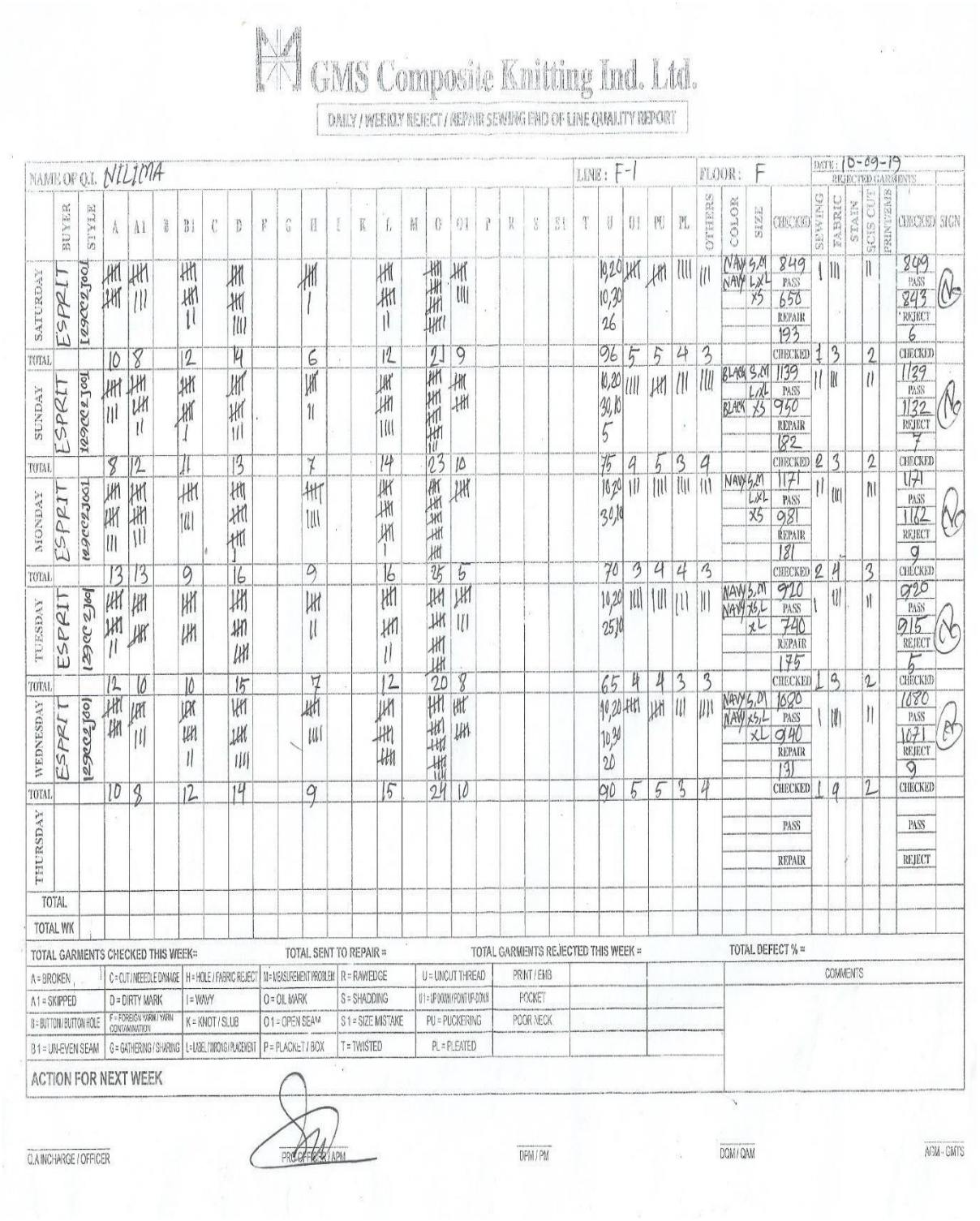
Buyer: ESPRIT

Style No: 129CC2J001

Color: Navy Blue

Size: S, M, L, XL, XS

Figure 3.10: Hoody


GMS Composite Knitting Ind. Ltd.

DAILY / WEEKLY REJECT / REPAIR SEWING END OF LINE QUALITY REPORT

NAME OF Q.I. NILIMA — LINE : F-1 — FLOOR : F — DATE : 10-09-19

	BUYER	STYLE	A	A1	B	B1	C	D	F	G	H	I	K	L	M	O	O1	P	R	S	S1	T	U	U1	PU	PL	OTHERS	COLOR	SIZE	CHECKED	REJECTED GARMENTS: SEWING	FABRIC	STAIN	SCIS CUT	PRINT/EMB	CHECKED	SIGN
SATURDAY	ESPRIT	[illegible]																					10,20 10,30 26					NAVY NAVY	S,M L,XL XS	849 PASS 650 REPAIR 193	1				849 PASS 843 REJECT 6	
TOTAL			10	8		12		14			6			12		21	9						96	5	5	4	3				CHECKED	1	3		2	CHECKED	
SUNDAY	ESPRIT	[illegible]																					10,20 30,10 5					BLACK BLACK	S,M L,XL XS	1139 PASS 950 REPAIR 182	11				1139 PASS 1132 REJECT 7	
TOTAL			8	12		11		13			7			14		23	10						75	9	5	3	9				CHECKED	2	3		2	CHECKED	
MONDAY	ESPRIT	[illegible]																					10,20 30,10					NAVY	S,M L,XL XS	1171 PASS 981 REPAIR 181	11				1171 PASS 1162 REJECT 9	
TOTAL			13	13		9		16			9			16		25	5						70	3	4	4	3				CHECKED	2	4		3	CHECKED	
TUESDAY	ESPRIT	[illegible]																					10,20 25,30					NAVY NAVY	S,M XS,L XL	920 PASS 740 REPAIR 175	1				920 PASS 915 REJECT 5	
TOTAL			12	10		10		15			7			12		20	8						65	4	4	3	3				CHECKED	1	3		2	CHECKED	
WEDNESDAY	ESPRIT	[illegible]																					10,20 10,30 20					NAVY NAVY	S,M XS,L XL	1080 PASS 940 REPAIR 131	1				1080 PASS 1071 REJECT 9	
TOTAL			10	8		12		14			9			15		24	10						90	5	5	3	4				CHECKED	1	9		2	CHECKED	
THURSDAY																														PASS REPAIR					PASS REJECT	
TOTAL																																				
TOTAL WK																																				

TOTAL GARMENTS CHECKED THIS WEEK= TOTAL SENT TO REPAIR = TOTAL GARMENTS REJECTED THIS WEEK = TOTAL DEFECT % =

A = BROKEN	C = CUT / NEEDLE DAMAGE	H = HOLE / FABRIC REJECT	M = MEASUREMENT PROBLEM	R = RAWEDGE	U = UNCUT THREAD	PRINT / EMB	COMMENTS
A1 = SKIPPED	D = DIRTY MARK	I = WAVY	O = OIL MARK	S = SHADDING	U1 = UP DOWN / POINT UP DOWN	POCKET	
B = BUTTON / BUTTON HOLE	F = FOREIGN YARN / YARN CONTAMINATION	K = KNOT / SLUB	O1 = OPEN SEAM	S1 = SIZE MISTAKE	PU = PUCKERING	POOR NECK	
B1 = UN-EVEN SEAM	G = GATHERING / SHARING	L = LOSE / WRONG PLACEMENT	P = PLACKET / BOX	T = TWISTED	PL = PLEATED		

ACTION FOR NEXT WEEK

Q.A INCHARGE / OFFICER — PRODUCTION / APM — DPM / PM — DQM / QAM — AGM - CMTS

Figure 3.11: Daily/Weekly Sewing End Line Quality Report

GMS Composite Knitting Industry Ltd

Table: 3.8 **Daily/Weekly Rejection status of sewing**

Floor: F	**Name of Q.I: Nilima**	**Buyer: ESPRIT**	**Style No:128CC2J001**
Total Q.C check: 5159	**Total Q.C Pass: 4261** **Total Reject: 898**		**Total Repair: 862**

Faults	**Date**					
	Saturday	**Sunday**	**Monday**	**Tuesday**	**Wednesday**	**Thursday**
Broken Stitch	10	8	13	12	10	-
Skipped Stitch	8	12	13	10	8	-
Button Hole	-	-	-	-	-	-
Un even Seam	12	11	9	10	12	-
Needle Damage	-	-	-	-	-	-
Dirty Mark	14	13	16	15	14	-
Yarn Contamination	-	-	-	-	-	-
Gathering/ Sharing	-	-	-	-	-	-
Hole	6	7	9	7	41	-
Wavy	-	-	-	-	-	-
Knot/ Slub	-	-	-	-	-	-
Wrong label	12	14	16	12	15	-
Measurement Problem	-	-	-	-	-	-
Oil Mark	21	23	25	20	24	-
Open seam	9	10	5	8	10	-
Placket/ Box	-	-	-	-	-	-
Raw edge	-	-	-	-	-	-
Shadding	-	-	-	-	-	-

Size Mistake	-	-	-	-	-	-
Twisted	-	-	-	-	-	-
Uncut Thread	96	75	70	65	90	-
Up Down	5	4	3	4	5	-
Puckering	5	5	4	4	5	-
Pleated	4	3	4	3	3	-
Raw edge	3	4	3	3	4	-
Total	**205**	**189**	**190**	**173**	**241**	**-**

3.3.3 Summary of Reports 12 Day (GMS Composite Knitting Industry Ltd.):

Table: 3.9

Faults	Broken Stitch	Skipped Stitch	Un Even Seam	Dirty Mark	Hole	Wrong Label	Oil Mark	Open Seam	Uncut Thread	Up Down Point	Puckering	Pleated	Raw edge	**Total**
1st Week **Style No: K-489** **Total QC Check: 4000** **Total Reject:900**														
Saturday	9	16	9	18	6	12	20	11	69	4	3	3	4	172
Sunday	12	19	13	24	5	9	26	9	70	5	3	5	4	185

Monday	Sunday	Saturday	2nd Week Style No: 129CCj001 Total QC Check: 5159 Total Reject: 898	Thursd	Wednesda	Tuesday	Monda
13	8	10		-	9	10	11
13	12	8		-	18	15	9
9	11	12			9	10	11
16	13	14		-	24	20	19
9	7	6		-	5	6	7
16	14	12		-	10	10	9
25	23	21		-	20	20	22
5	10	9		-	11	10	11
70	75	96		-	80	65	80
3	4	5		-	5	3	4
4	5	5		-	5	4	4
4	3	4		-	3	4	4
3	4	3		-	4	3	3
190	189	205		-	184	166	182

Tuesday	12	10	10	15	7	12	20	8	65	4	4	3	3	173
Wednesday	10	8	12	14	9	15	24	10	90	5	5	3	4	241
Thursday	-	-		-	-	-	-	-	-	-	-	-	-	-
Total	104	84	106	177	67	119	221	94	760	42	42	36	35	1887
	Total Qc Check: 9159 **Total Reject:1887**													
Fault %	5.51%	6.78%	5.61%	5.35%	5.24%	6.30%	11.71%	4.98%	40.27%	2.22%	2.22%	1.90%	1.85%	20.60%

defects	1st week	2nd week	total	percentage
Broken Stitch	51	53	104	5.51%
Skipped Stitch	77	51	128	6.78%
Uneven Seam	52	54	106	5.61%
Dirty Mark	29	72	101	5.35%
Hole	29	70	99	5.24%
Wrong Label	50	69	119	6.30%
Oil Mark	108	113	221	11.71%
Open Seam	52	42	94	4.98%
Uncut Thread	364	396	760	40.27%
Up down	21	21	42	2.22%
Puckering	19	23	42	2.22%
Pleated	19	17	36	1.90%
Raw Edge	18	17	35	1.85%
Grand Total			1887	

Chapter 4: RESULTS AND DISCUSSION

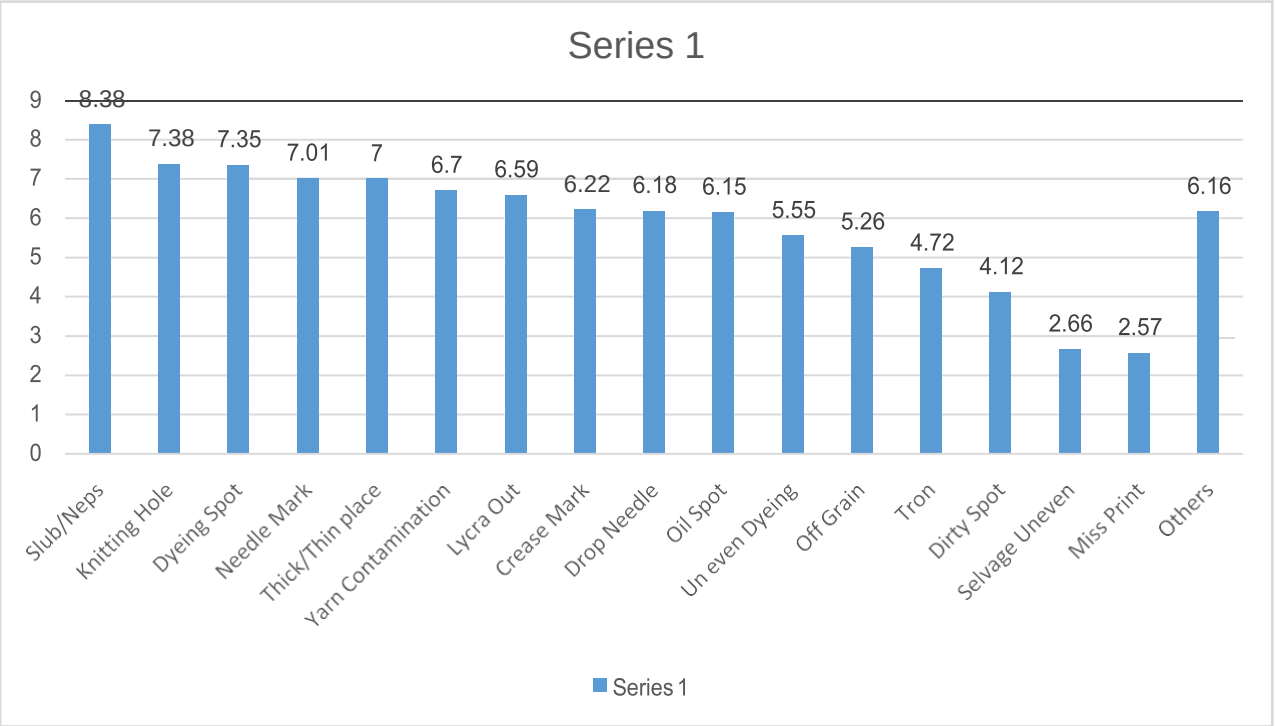
4.1 Cutting Section Result:

In cutting section different types of defect is occur for different types of reason. So we analyzed the result, tried to make a solution for how to reduce this types of defects.

The calculated result is:

Table: 4.1

Fault Name	**Fault %**
Slub/Neps	8.38%
Knitting Hole	7.38%
Dyeing Spot	7.35%
Needle Mark	7.01%
Thick/Thin place	7.00%
Yarn Contamination	6.70%
Lycra Out	6.59%
Crease Mark	6.22%
Drop Needle	6.18%
Oil Spot	6.15%
Un even Dyeing	5.55%
Off Grain	5.26%
Tron	4.72%
Dirty Spot	4.12%
Selvage Uneven	2.66%
Miss Print	2.57%
Others	6.16%
Total	100%



4.2 Definition, Photo, Causes and remedies of Cutting Defects:

4.2.1 Slub/ Neps= 8.38%:

Slub and neps is a yarn fault. An abnormally thick place or lump in yarn showing less twist at that place.

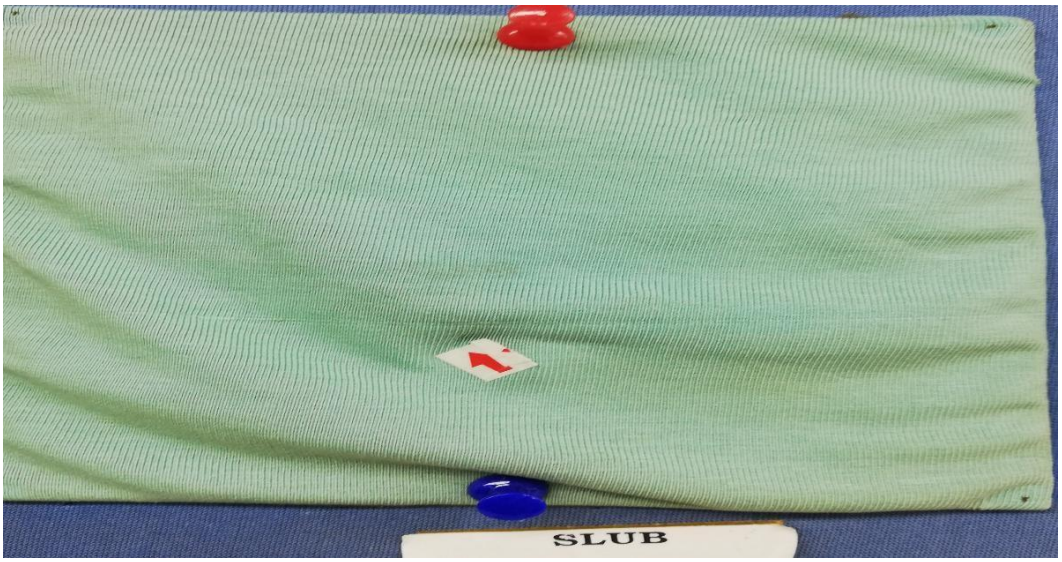


Figure 4.1: Slub/Neps

Causes:

1. Accumulation of fly and machine parts
2. Poor Carding
3. Defective ring frame and bad piecing
4. Improper clothed top roller cleaner

Remedies:

1. Machine surface to be maintained clean
2. Avoid all types of faulty teeth of machine
3. Setting at ring frame to be maintained

4.2.2 Thick and Thin Place=7.04%:

Measurable by Uster imperfection indicator and observable on appearance.

Figure 4.2: Thick/ Thin place

Causes:

1. Eccentric top and bottom roller
2. Insufficient pressure on bottom roller
3. Improper meshing of gear wheels

Remedies:

1. Eccentric top and bottom roller to be avoided
2. Better fiber individualization at card to be achieved
3. Correct space to be utilized

4.2.3 Needle Mark=7.01%:

Figure 4.2: Needle Mark

Causes:

1. When a needle breaks down then needle mark comes along the fabrics.
2. If a needle or needle hook is slightly bends then needle mark comes on the fabrics.

Remedies:

1. Needle should be straight as well as from broken latch.
2. Bent needle should be changed

4.2.4 Knitting Hole=7.34%:

Figure 4.3: Knitting hole

Causes:

1. Due to break down or bend of the latch, pin hole may come in the fabric.
2. Rough mechanical parts are common culprits for fabric tearing during manufacturing.
3. Very stiff & dry yarn

Remedies:

1. Prevent future holes by ensuring your supplier has procedures in place to regularly check needles and machinery prior to production.
2. Better inspection of fabric and cut piece.
3. Use a fabric fault detector
4. Use of yarn having lower hairiness

4.2.5 Lycra Out=6.59%:

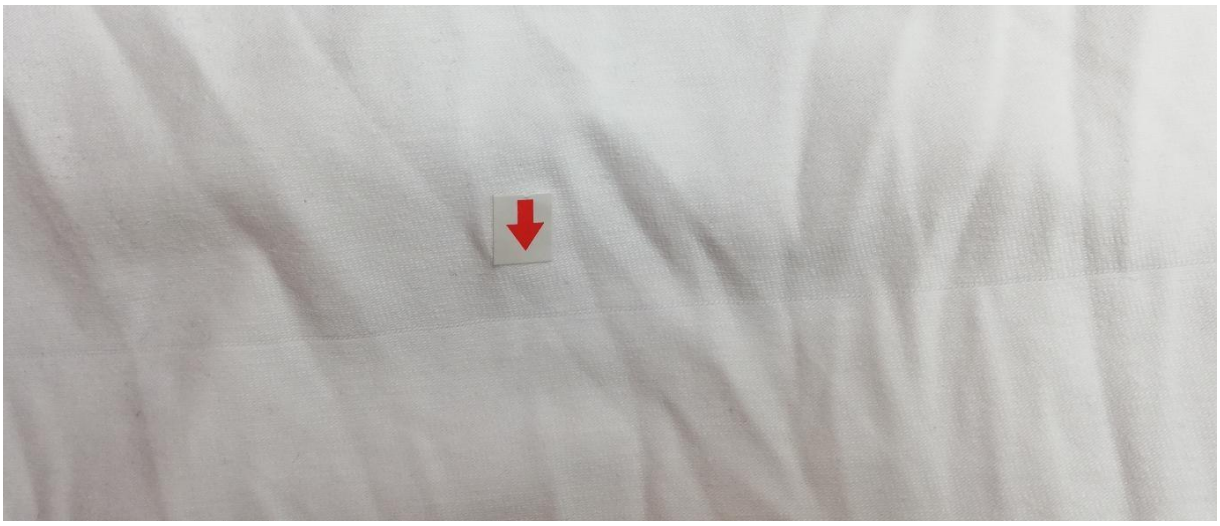


Figure 4.1: Lycra Out

Causes:

1. Breakage of Lycra yarn
2. uneven tension of Lycra

Remedies:

1. To maintain uniform tension
2. Proper checking the knitting machine

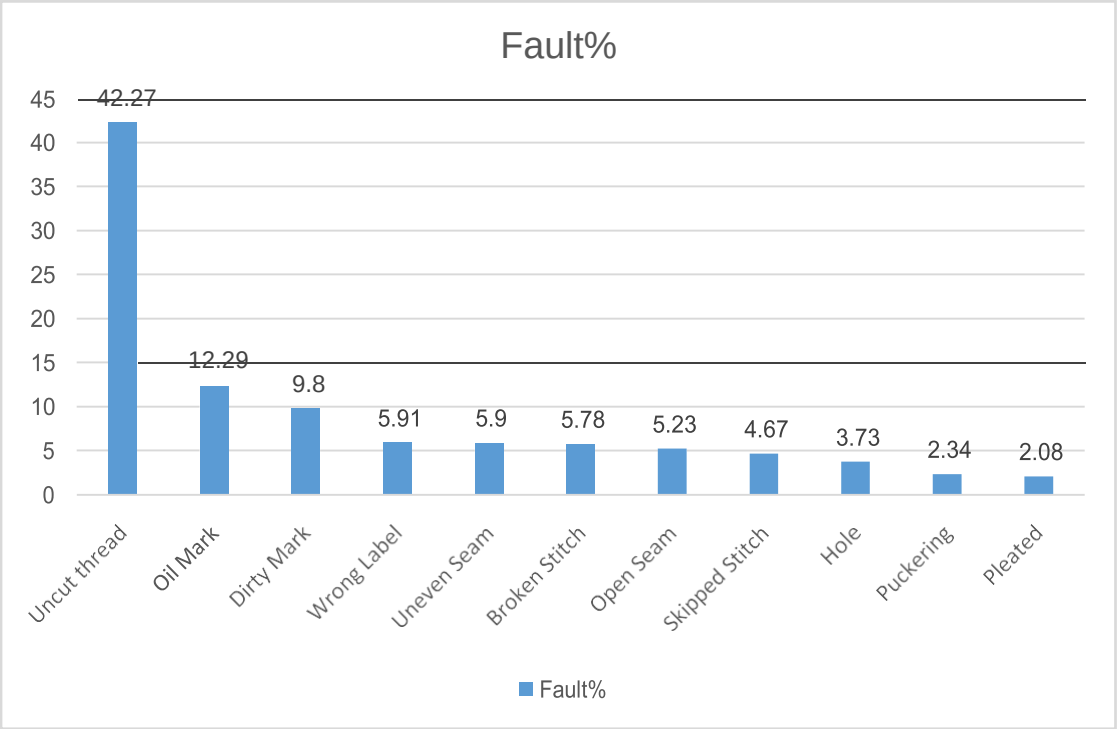
4.3 Sewing Section Result:

In sewing section different types of defect is occur for different types of reason. So we analysed the result, tried to make a solution for how to reduce this types of defects.

The calculated result is:

Table: 4.2

Faults	**Faults%**
Uncut thread	40.27%
Oil Mark	11.71%
Dirty Mark	9.80%
Wrong Label	5.91%
Uneven Seam	5.90%
Broken Stitch	5.78%
Open Seam	5.23%
Skipped Stitch	4.67%
Hole	3.73%
Puckering	2.22%
Pleated	1.90%
Total	100%



4.4 Definition, Photo, Causes and remedies of Sewing Defects:

4.4.1 Uncut Thread=42.27%:

Extra thread or loose thread on seam line.

Figure 4.5: Uncut Thread

Causes:

1. It appears due to improper trimming or finishing.

2. Improper training of worker
3. Garments would not check properly

Remedies:

1. thread trimmer should be used
2. Operator training
3. Garments finishing should be checked properly

4.4.2 Oil Mark=12.29%:

Oil recolor with residue clung to surface which makes the stains increasingly conspicuous. Can result in the product‟s failure, reducing marketability, usability

Figure 4.6: OilMark

Causes:

1. If proper lubricant is not use
2. If machine parts are not clean
3. For operator it can be done.
4. Natural dust.

Remedies:

1. Proper use of lubricant oil.
2. Working flooring all instances easy up
3. Proper support of machine.

4. Proper cleaning of machine.

4.4.3 Broken Stitch=5.78%

One or more stitches (stitching thread) are broken in the stitch line.

Figure 4.7: Broken Stitch

Causes:

1. It appears due to improper trimming or machine usage
2. Due to high stress

Remedies:

1. Needle plate, presser foot and feed dog should be checked properly
2. Proper trimming
3. Needle thread fabric combination should be well judged
4. Needle alignment should be right

4.4.4 Skipped Stitch=4.67%:

Irregular stitching along the seam

Figure 4.8: Skipped Stitch

Causes:

1. It appears due to improper handling of cut pieces or machine usage
2. Incorrect set-up of thread in sewing machine
3. Thread overfeeding or underfeeding

Remedies:

1. Checking the setting and timing between needle and hook or looped
2. Placing of needle properly
3. Needle size & thread size must be adjusted
4. The pressure of pressure foot must be adjusted accurately

4.4.5 Puckering=2.34%:

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

Figure 4.9: Puckering

Causes:

1. uneven stretching on to plies of fabric during sewing
2. improper thread tension
3. wrong sewing thread selection

Remedies:

1. Machine feed mechanism must be better quality
2. Needle-thread-fabric combination should be well judged
3. Sewing thread must be selected properly.

Chapter 5: CONCLUSION

5.1 Conclusion:

After analyzed cutting and sewing section from GMS Composite Knitting Industry Ltd we have completed our thesis with different types of inspection, experiment and discussion. We have gathered lot of knowledge from this experiment. It also help us to know the inspection procedure and we also know the sewing & cutting faults. At first cutting where different types of faults mainly occurs for faulty handling, use of faulty machine, improper supervision, and non-trained worker. If they use more experienced worker then they will increase productivity with less defect. Secondly, in our sewing floor mainly three things are responsible for defects. Such as different type and new product, sewing machine problem, and improper supervision. They have IE department but the management should try to make a potential IE department by which increase their productivity with less defect.