



Faculty of Engineering
Department of Textile Engineering

REPORT ON
Study on Different Types of Sewing Faults and Their Remedies

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DEDICATION

Dedicated to our beloved and dearest parents, teachers and all other those who devoted them
for our bright future.

DECLARATION

We hereby declare that, under the guidance of Sharmin Akter, Lecturer, Faculty of Engineering, Department of Textile Engineering, Daffodil International University, this proposal document has been completed by us. Furthermore, we claim that neither this theory paper nor any part of this postulation paper was submitted for the honor of any degree or recognition anywhere else.

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ABSTRACT

This project is ‘**Study on Different Types of Sewing Faults and Their Remedies**’ of **Crystal Composite Knit Ltd**” The production of garments is very distinct from any other traditional production. It is not a method of massive supply. Each style is a particular item that needs a different fabric form, paint, buttons, thread, etc. One of the most valuable stages in labor-intensified instant clothing manufacturers is the sewing measure. Quality problems that arise during this cycle have oppositional effects on the quality of the item and the efficacy of the item, and also increase the cost of production.

The aim of this analysis is to investigate whether the woven development measure is leveled out in a woven development enterprise and finally to identify the cycles with the most prominent sewing vulnerabilities in the sewing division to make recommendations for enhancing quality control. In addition, the cycles with the most noticeable sewing defect measurements and the effects of these cycles on fault rates were studied. On the 05 days we recognize 366 pieces garments bar tack missing on the end of the line audit report. In the sewing area, Irregular stitching, Broken Stitching, Puckering, Point Up-Down, Irregular Stich, Down Stich, Button Stich etc. faults are found by examining fabric. The big issue in the sewing section is the missing bar tack. The missing bar tack average is 16 percent. Finally, through the sewing machine and operator, we have found different kinds of sewing faults . We are also mentioning remedies for specific reasons that are included in this project report. In addition, for different purpose that are included in this project study, we refer to solutions for problems. Furthermore, we add a final summary of the test from “**Crystal Composite Knit Ltd**”.

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Chapter-1 Introduction

1.1 Background of the Study

The sewing section is the largest and most important section of an item in the clothing industry. In this section, every last sewing machine and machine administrator occupation should be studied for a standard purpose to identify, revise and monitor flaws and preserve the design of products. Quality control personnel need to control quality in an alternative field in the clothing industry, which is directly or in a roundabout way necessary, to guarantee the nature of the good via formation. The difference between products is consistency. It is the dignity or unpleasantness of an object. Till this day, this description remains unchanged. In addition, The Fabric plays an important role in the general public. We have to ensure quality and quality depends on the sewing course of action of the piece of clothing to make great clothing pieces.

1.2 Objectives of the Study

- > To learn how to reliably and productively evaluate clothes.
- > Discern and address the causes for sewing faults.
- > To upgrade advanced thread defect arrangements.
- > To illustrate how advanced skills can improve productivity in production.
- > To restrict textile sewing faults .
- > To improve the quality of the garments.

1.3 Importance of the Study

A A cost cutting method at the manufacturing unit for clothes. The reasons for sewing deficiencies in instant clothing pieces are explained in this article. Sewing deficiencies are a concern commonly looked at by manufacturers of apparel. Regardless of it being an incredibly simple issue, it is exceedingly difficult to fully dispose of it. This article describes a few components of the sewing fault arrangement, its causes, and assurance and cures. The developer found that it is incredibly difficult to completely dispense with flaws. The inquiries as to whether or not the rate of a fault is adequate depend to a great extent on the type of clothing item, the region of the crease, the appearance. Quality faults arising in the middle of this process unfavorably impact the quality of the item and the competence of the item, and further increase the cost of generation. The aim of the review is to examine how to monitor quality in the production of pieces of clothing and make suggestions for improving quality control. Through this analysis, we showed that the analysis of could quality control process will allow a notable commitment to produce a better piece of clothing and get ready more persuasive in the designs of progress. Even so, the reduction in sewing deficiencies would be reliably promoted and will be a critical angle in the universal advertisement of instant fashion items.

1.4 Limitations of our Study

We had faced the following restriction during the research :

- **Shortage of time:** It took at least three months for the final report to be finished, but we didn't have enough time for the Corona pandemic. The most important limitation for us is, therefore, to gain vast information.

Chapter- 2 Literature Review

2.1 faults in Apparel:

The manufacturing of apparel is the last step of assembly before promotion. The whole consumer wants to get an object that is free from some kind of deformity. Therefore, the creator should know about the object's deformity. Various types of mix-ups may occur in each stage of assembly [1]. Clothing faults can be defined as the absence of desired highlights in the item or undesirable elements in goods. No man wants an imperfect object. In the market, faulty goods lose their motivation. An object can contain different imperfections. Another word similar to abandon is referred to as reject. When it loses its solidity in the market, an object becomes an oddball. Clothing rejection is costly to manufacturers [1].

2.2 Types of faults:

There Two major forms of faults exist:

(a) Sewing faults

(b) Non-sewing faults

faults can occur in the mass-scale delivered garment industry. The sources for the faults are given here:

2.3 Non-sewing faults :

- ❖ faults because of wrong pattern.
- ❖ faults because of wrong cutting.
- ❖ faults because of poor handling of goods.
- ❖ faults because of oil marks.
- ❖ faults because of wrong pressing/collapsing/pressing.

2.4 Sewing faults

Sewing defect can be classified by the following three groups:

- a. Issue of stitch formation.
- b. Seam pucker.
- c. Fabric damage along the line/fasten

2.4.1 Problems of stitch formation [2] [3]:

- 1) Skip Stitch
- 2) Slipped Stitch
- 3) Staggered Stitch
- 4) Unbalanced Stitch
- 5) Density of Variable Stitch
- 6) Breakage of Frequent Thread
- 7) Frequent Thread Breakage
- 8) Slanted
- 9) Broken Stitch
- 10) Raw Edge
- 11) Damage to Needle Heating
- 12) Needle Heating Damage
- 13) Oil Spot
- 14) Open Seam

1. Skip stitch:

Stitching stitches are frequently present. If interlacing or interlacing between the top and bottom line of the point does not occur or does not occur, it is known as skip stitch.



Figure 2.1 Skip Stitch

Causes-

- ❖ Failure of the hook and needle at the right time to reach the circle. In the upper or lower loop, irregular thread tension.
- ❖ Due to the needle displacement.
- ❖ If the yarn loop size of the needle is very small.
- ❖ If fabric wear happens during stitching.
- ❖ If the sewing thread can not form a loop.

Remedies-

- ❖ Examine the setup and time between the hook or scissors as well as the needle.
- ❖ It is important to change the thread tension.
- ❖ The needle must be replaced.
- ❖ You must change the needle size and thread.
- ❖ The pressure of the pressure foot must be accurately balanced. It is important to change the subject or a lopper.
- ❖ The scale of the needle thread loop is very small here.

Slipped stitch: No or upper and lower interlacing. The hook or needle failed to enter the thread loops at the correct time.

Causes:

- ❖ At the correct time, the hook or needle failed to reach the thread loops.
- ❖ Thread loop failure due to incorrect needle size.
- ❖ Yarn deformation due to the wide hole in the plate of the throat.
- ❖ On the needle time, incorrect sewing stress.

Remedies:

- ❖ It is important to verify the clearance and time of the system.
- ❖ Check that the needle is correctly inserted and positioned.
- ❖ There must be an adjustment in the needle size.
- ❖ The throat plate hole and the needle 's size must be changed. Tensions Readjust..

2. Staggered stitch:

It is known as a step stitch if the stitches formed by the needles are not parallel or curved to the sewing thread.

Causes-

- ❖ Point of the wrong or blunt needle.
- ❖ Vibration or deflection of the Needle.
- ❖ Incorrect or blunt tip for needles.
- ❖ The feeding dog oscillation.
- ❖ Weak fabric regulation, foot heel presser.
- ❖ Improper needle and thread size change

Remedies-

- ❖ Increase the size of the needle or move to a reinforced or tightened needle. Modify the needle.
- ❖ Resetting the foot of the presser. Modify the feeding instrument.
- ❖ Needle size and string size are to be changed.
- ❖ Tightening up the canine meal.

3. Unbalance Stitch:

Wrong interlacing of the line , particularly on the fixed point machine.

Causes-

- ❖ Wrong thread tension for sewing.
- ❖ Used incorrect line direction.
- ❖ An incorrect change of the direction of the needle thread.
- ❖ Unless the thread is lubricated.
- ❖ Thread the needle and put the finger with the bobbin case

Remedies-

- Using the correct thread path to set the proper tension for sewing threads
- Better quality threads should be used for smoothness in the bobbin situation.

4. Variable stitch density: It is called variable stitch density if the number of stitches per unit length is not equal and the number of stitches per unit length is not equal.

Causes-

- Improper unwinding during stitching of the packaging thread
- Twisting the needle thread in the lower part of the thread pack
- Thread twist on the guide for threads
- Line of line until disk stress
- More Wire Voltage for the Wire
- Fraying of thread on the needle
- Getting from the line hotter

Remedies-

- The location of the guide for the thread must be 2.5
- times greater than the location of the bundle of threads
- At the bottom of the line bag, the foam pad must be used
- During sewing, thread the sewing thread correctly
- The edges should be smooth and the needle should be adjusted as appropriate.
- Thinner thread or a thick needle should be used,
- A needle of high quality should be used.

5. Frequent thread breakage:

This is the frequent breaking of the thread during sewing. And more time and what is detrimental to output is also required. Particularly when a seam opening is required in order to solve the case..

Causes-

- Wrong winding of the threads on the bobbin, more tension on the threads of the bobbin.
- If the bobbin case corners, cutter eye and so on are finer, the wrong bobbin case suits finer.

Remedies-

- The tension must be balanced for the bobbin threads to correctly wind the threads on the bobbin. The size and form of the coil should be tested smoothly by Edges.

6. Broken Stitch:

A part of the fabric that has not been hidden by a split sewing thread or an open seam.



Fig 2.2: Broken Stitch

Causes:

This issue is due to clothing parts being treated improperly, improper configuration and alignment between the needle and the scissors or pin, etc.

Remedies:

- Markings with simple point line
- Thread or D core of fine quality should be used
- The pattern must be correct,
- Excellent fit and timing between the needle and the hook or lopper. Workers' preparation.
- Proper treatment of pieces of clothing Proper stress must be quantifiable.

8. Oil spot-**Causes:**

- The sewing machine parts can be stuck or in need of cleaning or repair for different purposes. It must be oiled or lubricated by the computer. To minimize friction, the sewing machine needle may also be lubricated with oil.
- There might be an oil mark if the computer is at that stage.
- For this, a test thread and fabric must be passed through the machine to extract excess oil.



Figure 2.3 Oil Spot

Remedies:

- At the beginning, liquid washing detergent is pre-treated with the pre-wash stain remover. Then wash your clothes with the fabric with warmer water. [4].



Figure 2.4 Puckering

2.4.2 Seam Puckering:

With knitted fabrics, seam wrinkling is a common issue. During or after washing, seam wrinkling refers to the wrinkling of a seam, creating an unsatisfactory seam appearance.

Causes:

- ❖ Thread extension sewing.
- ❖ Construction of cloth.
- ❖ Incompatible norms.
- ❖ Shrinking of threads for sewing.
- ❖ The fabric 's dimensional volatility.
- ❖ Variable and inconsistent elongation in the fabric

Remedies:

- For an equal elongation of the layer, the proper feeding mechanism must be used. The fabric's shrinkage property should be approximately the same.
- The fabric and sewing thread retraction percentage must be the same.

2.4.3 Damage of fabric on seam line:

It occurred because the needle selection was wrong or the needle was damaged. But this can happen with needles that are fresh or small. There are 2 types of fabric that may be harmful, as shown below [5]:

1. Mechanical damage:

The measures to be taken to keep the fabrics free from this form of fault are as follows:

- Without any defects, the ideal needle size and shape and needle tip.
- Reducing the sewing machine's rpm.
- Utilizing lubricant.
- Checking sewing skills until fabrics are sewed.

2. Needle heating damage:

There was fabric damage between the needle and the fabric due to friction. At this temperature, the fabric can be affected. In the case of natural fiber materials, the risk of damage is smaller.

To keep the fabric free from this form of defect, the following are the steps to be taken:

- ❖ Changing the needle size and shape so that there is less heat generation for the needle
- ❖ Needle sewing at high speed for shorter distances.
- ❖ · Use the needle lubricant.
- ❖ Use a needle filled with Teflon.

Chapter-3 DATA ANALYSIS AND PRESENTATION

3.1 Data Collection [6] [7]

We visited two processing plants and gathered data about the problems with sewing. Crystal Composite Ltd has 16 more sewing threads. We took a picture with 8 sewing threads from these 16 threads and gathered some details about the order value of clothing pieces, name of the buyer, style number. Clothing, no. Administrator, no companion, excluding sewing problems. The data checked is given below on the sewing floor of **Crystal Composite Ltd.**

Data Analysis

Here we examine information obtained from sewing line 8 of Crystal Composite Ltd. on the subject of sewing and other details. We present some clothing details here, such as order value, purchaser name, style number. In the knowledge table, change and discard garments and so on, excluding the no. imperfection.

[Attachment of sewing report \[8\] \[9\]:](#)

Line inspection report 1

LINE (I) in Crystal Composite Ltd.

A copy of the End of Line Inspection report that we received from the factory is attached.

Report:1

Crystal Composite Ltd. Ashulia, Savar, Dhaka

Date: 17-03-2020
 Buyer: KIABI
 Style No: JBMS18MCRAAG

Hours	Total Price Check	No. of Price Pass	Defective Pc/Rectified Pc	Total Pc Rejector	Section	Broken Stitch	Raw Edge	Packring	Up & Down Part	Uneven Stitch	Shape Out	Wrong Size	Shading	Damage	Stain/Oil	Bartack	Hook & Bar/ Button	Iron Mark	Defects Total
1	134	120	14/13		Front Back														14
2	146	130	16/17		Front Back														16
3	145	135	10/10		Front Back														10
4	145	132	13/12	03	Front Back														13
5	136	125	11/10	03	Front Back														11
6	142	135	07/07		Front Back														07
7	148	142	06/05	03	Front Back														06
8	156	150	06/06		Front Back														06
9	152	150	05/05		Front Back														05
10	142	136	07/07		Front Back														07
	1449	1354	95/92	05		18	23	06	08	10			18			13			10

(Total No of Defects) = 99

Figure 3.1 Report on sewing section

100% End of Line Inspection Report in Sewing Section 10/03/2020

CRYSTAL GROUP

Crystal Composite Ltd.

Date: 17-03-2020

DAILY END-LINE INSPECTION REPORT

Buyer: KIABI

Sewing Line: I

Style No: JBMS18MCRAAG

Po No:

Inspector:.....

Hours	1 st	2 nd	3 rd	4 th	5 th	6 th	7 th	8 th	9 th	10 th	Total
Total Pieces check	134	146	145	145	136	142	148	156	155	142	1449
No. Of. Pcs Passed	120	130	135	132	125	135	142	150	150	135	1354
Defective Pc/ Rectified Pc	14/ 13	16/ 16	10/ 10	13/1 2	11/1 0	07/0 7	06/0 5	06/0 6	05/0 5	07/0 7	95/92

Total Pc Rejected	0	0	0	1	1	0	1	0	0	0	3
Section	Front/ back	Front/ back	Front/ back	Front/ back	Front/ back	Front/ back	Front/ back	Front/ back	Front/ back	Front/ back	
The Damaged Stich		2		2	1	1	1		2	1	10
Skip Stich	6	4	3	3		2				3	21
Raw-Edge				2			2	1			5
Join Stich		2		1	2	1	1		1		8
The Puckering											
Up & Down Parts											
Uneven Stich	1	2	1		2	1		2	1		10
Shape Out											
Wornng Size											
Twisting	5	4	3	2	2					2	18
Shading											
Fabric Fault											
Hole Damage											
Stain Oil	3	2	2		3	2		1			13
Bar tack											
Hook & Bar/Button											
A Mark of Iron											
Pleat		1	1	2	1		1	2	1	1	10
Opening the Seam			1	2	1		1		1		6
faults Total	15	15	11	14	12	7	6	6	6	7	101

DHU= (total number of faulty parts / total number of tested pieces) * 100= 6.97%

1st Highest Defect = 21pcs Disregard Point 2nd Highest Defect = 18pcs Twist 3rd Highest Defect = Oil Stain 13pcs Total Parts Review = 1449 Total defects = 101 Total defects = 101 Total defects = 101 Total defects

We can see from the table that our observation date was 17/03/18, in line (I). KIABI was the purchaser. S / S T SHIRT (Basic T-Shirt) was the product made. With 12 assistants and 2 QC operators, the total number of staff or operators working on line (I) was 16.

DHU= (total number of faulty parts / total number of tested pieces) * 100= 6.97%

We noticed from our observation that 135 garments are tested from 8 am to 9 am but there are a total of 15 faults. Thus, our 10-hour observation confirmed a total of 1449 units of clothing. I find 101 pieces of faulty clothing here, where 98 pieces have been modified and 3 pieces have been discarded. The list of faults below that we find in line (I) is shown here:

The Broken Stitch=10

The Skip Stitch=217

The Raw-Edge=5

The Join Stitch=8

The Uneven Stitch=10

The Twisting=18

The Stain Oil=13

The Pleat=10

The Open Seam=6

3.4 Attachment of sewing report

A Line inspection report 2
LINE (B) in Crystal Composite Ltd.

A copy of End of Line Inspection report is attached that we have collected from the factory.

FINISHING QC INSPECTION REPORT

Sewing Line: B
 Inspector: M. O. BUIP/Tolmor

Hours	Total Price Check	No. of Price Pass	Defective Price/Rectified Price	Total Price Rejected	Section	Broken Stitch	Skip Stitch	Raw Edge	Join Stitch	Rolling	Irregular Pile	Uneven Stitch	Shape Out	Wring Size	Twisting	Shading	Fabric Fault	Notch/Damage	Skirt/Cut	Barback	Hook & Bar/Buttons	Iron Mark	Print	Defects Total
1	143	123	20	19	Front Back																			20
2	124	119	9	9	Front Back																			9
3	146	140	6	6	Front Back																			6
4	137	127	8	7	Front Back																			8
5	148	135	13	12	Front Back																			13
6	156	147	7	7	Front Back																			7
7	138	130	8	7	Front Back																			8
8	142	135	5	5	Front Back																			5
9	142	131	11	11	Front Back																			11
10	144	130	14	12	Front Back																			14
	149	136	13	12																				13
						16	24	12	10			9			9									47

Defective = (Total No of Defective Pieces / Total No of Pieces Inspected) * 100 =

DHU = (Total No of Defective Pieces / Total No of Pieces Checked) * 100 =

Sign of Checker: Sing Compliance Unit
 10/10, Block-K, Rupnagar VA, Mirpur, Dhaka-1216

Sign of QC: _____

Sign of Supervisor: _____

Sign of In-Charge: _____

Sign of QAM: _____

Figure 3.2 Report on sewing section

100% End of the report for line inspection in Sewing Section 10/03/2020

CRYSTAL GROUP
Crystal Composite Ltd.
DAILY END-LINE INSPECTION REPORT

Po No:

Date: 10-03-2018

Buyer: K-MART

Sewing Line: B

Style No: KP195

Inspector:

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Total Pieces check	143	124	146	137	148	156	138	140	142	144	1418
Total Passed Pieces	123	115	140	129	135	149	130	135	130	130	1316
Defective Pc/Rectified Pc	20/19	9/9	6/6	8/7	13/12	7/7	8/7	5/5	12/11	14/12	102/95
Total Pc Rejected	1			1	1		1		1	2	7
Section											
Broken Stich	2	2	1	1	3	1		2	3	1	16
Skip Stich	5	3	2	3	2	2	2	1	2	2	24
Raw-Edge	2	1			2				4	3	12
Join Stich	2	1			1	2	1		3		10
Puckering											
Up & Down Parts											
Uneven Stich	2		2	1	1					3	9
Shape Out											
Wrong Size											
Twisting	3	2		1	2	1					9
Shading											
Fabric Fault											

Hole Damage											
Stain Oil	4		1		2		2			2	11
Bar tack											
Hook & Bar/Button											
Iron Mark											
Pleat				1		1	1			1	4
Open Seam				4			2	2		2	7
faults Total	20	9	6	8	13	7	8	5	12	14	102

$$\text{DHU} = (\text{Total number of defective parts} / \text{Total number of verified parts}) * 100 = 7.07\%$$

1st Highest Defect = Ignore 24pcs Point

2nd Highest Defect = Broken Point = 16

3rd Highest Defect = Gross Edge = 12

Total Parts Check = 1418

Total Defect = 102

We can see from the table that, in line no. (B) Our date of observation was 11/2/18. The total quantity of the order was 17,000 units and K-MART was the buyer. A polo shirt was the item made. With 32 helpers and 2 QC operators, the total number of staff or operators operating on line (B) was 44. We discovered from our observation that 143 pieces of clothing were tested from 8 am to 9 am and there were a total of 20 flaws. They can change 19 of those 20 defects and discard 1 piece of clothing.

Thus, in our 10-hour observation, we totaled 1418 units of clothing made. We found 102 pieces of faulty clothing here, where 95 pieces had been modified and 7 pieces had been rejected.

The list of faults we find in line (B) below is shown here:

The Broken Stitch=16

The Skip Stitch=24

The Raw-Edge=12

The Join Stitch=10

The Uneven Stitch=9

The Twisting=9

The Stain Oil=11

The Pleat=4

The Open Seam=7

3.5 Attachment of sewing report

Line inspection report 3

Style: 100217-153

FINISHING QC INSPECTION REPORT

Inspector: _____

Hour	Total Pieces Check	No. of Pieces Pass	Defective Puff/Total Puff	Total Inspected	Seam Defect	Broken Stitch	Skp Stitch	Raw Edge	Join Stitch	Feblity	Stk Line Fes	Unsew Stitch	Shape Out	Wring Site	Welding Drooping	Fabric Fault	Iron Damage	Stitch Off	Back Stitch	Mark & Bar Stitch	Non Mark	Other	Appec Total	Defect Total	
1	157	147	8	8		11		11															1	8	
2	149	148	9	2																			1	9	
3	140	138	3	2																			1	7	
4	147	136	11	10				11															1	11	
5	148	149	9	8																				1	9
6	135	129	8	8																				1	8
7	142	135	9	8																			1	11	
8	147	145	12	12																			1	12	
9	144	140	9	8																			1	9	
10	135	131	8	8																			1	8	
	1405	1341	93	90	5	16	14	15		5	8	4										12	5	11	90

% Defective = (Total No of Defective Pieces / Total No of Pieces Inspected) * 100
 DHI = (Total No of Defective Pieces / Total No of Pieces Checked) * 100

Sign of Checker: _____ Sign of QC: _____ Sign of Supervisor: _____ Sign of In-Charge: _____ Sign of G.M: _____

RSIG Compliance Unit
 Plot/10, Block-K, Rupnagar (A), Mizpur, Dhaka-1216

Figure 3.3 Report on sewing section 10/03/2020

LINE (F) in Crystal Composite Ltd.

A copy of the End of Line Inspection report that we received from the factory is attached.

Crystal Composite Ltd.

DAILY END-LINE INSPECTION REPORT

Date: 15-02-2020

Po No:

Buyer: K-MART

Sewing Line

Style No: 10NSTP-455

Inspector:

Hours	1st	2nd	3rd	4th	5th	6th	7th	8th	9th	10th	Total
Total Pieces check	155	149	145	147	138	135	142	147	142	135	1435
Total Passed Pieces	147	140	138	136	129	127	133	135	133	127	1345
Defective Pc/Rectified Pc	8/8	9/7	7/7	11/10	9/8	8/8	9/8	12/12	9/8	8/8	90/84
Total Pc Rejected		2		1	1		1		1		6
Section											
Broken Stich	2	1	2	3	1	2			3	2	16
Skip Stich	1	3		2	3		1	1	2	1	14
Raw-Edge	3		2	4	1	2			2	1	15
Join Stich											
Puckering		1		1	2				1		5
Up & Down Parts											
Uneven Stich		2	1		1	2		2			8
Shape Out		1		1			1	1			4
Wrong Size											

Twisting											
Shading											
Fabric Fault											
Hole Damage											
Stain Oil	1		1		1	2	2	3		2	12
Bar tack											
Hook & Bar/Button											
Iron Mark											
Pleat		1					2	2			5
Open Seam	1		1				3	3	1	2	11
faults Total	8	9	7	11	9	8	9	12	9	8	90

DHU = (Total number of faulty parts / Total number of checked parts) * 100 = 5.77%

1st highest defect= broken point= 16pcs 2nd highest defect= rough edge= 15pcs 3rd highest defect= ignoring point= 14pcs total parts check= 1435pcs total defects= 90pcs total defects= 90pcs

We can see from the table that my observation date for line (F) was 02/15/18. The total order number was 10,000 units and K-MART was the buyer. LONG PANT (All Over Print) was the item made. The total number of staff or operators

Thus, in our 10-hour observation by operator 2QC, we totaled 1435 units of clothing made. We found 90 pieces of faulty clothing here, where 84 pieces had been modified and 6 pieces had been rejected.

The list of faults below we find in line (I) is shown here:

The Broken Stitch=16

The Skip Stitch=14

The Raw-Edge=15

The Puckering=5

The Uneven Stitch=8, The Shape Out=4

The Stain Oil=12 Pleat=5

The Open Seam=11

3.6 Attachment of sewing report

Thus, we totaled 1435 units of clothing created in our 10-hour observation by operator 2QC. Here we find 90 pieces of defective clothing, where 84 pieces were changed and 6 pieces were rejected.

The following list of faults we find in line (I) is shown here:

Line inspection report 4

Buyer : ONEEDGE
 Style : SUN-94
 PO/Art : OULT-PULT
 Item : LADIES LONG PANT

TABLE INSPECTION REPORT
Section : Sewing

Line No. : D
 Inspector : TONIA
 N.B. $\frac{\text{Alter Pcs} \times 100}{\text{Total Pcs}} = \%$

Broken Stitch	Embroidery	Incomplete Stitch	Needle Mark	Puckering	Skip Stitch	Thread Mistake	Visible Edge
✓	✓	✓	✓	✓	✓	✓	✓

Description	1	2	3	4	5	6	7	8	9	10	Total	Remarks													
Total Received	130	130	300	210	510	240	250	1000	190	1100	210	1400	300	1700	250	1050	250	2200							
OK	122	122	160	282	195	478	222	200	235	183	118	200	1318	283	1605	238	1841	242	2085	208 3					
Alter	08	08	10	8	14	32	18	50	15	65	02	72	10	82	12	02	12	100	08	112	112				
Alter Rectified	08	08	10	8	14	32	18	50	15	65	02	72	10	82	12	02	12	100	08	112	112				
Total OK	130	130	300	210	510	240	250	1000	190	1100	210	1400	300	1700	250	1050	250	2200	2200						
INSEAM	UP-11				P-111					UP-11											09				
INSEAM				P-111	P-111																	12			
BELT T/S	M-11			U-111						D-1111	U-1											16			
BELT BACK				M-111			P-111				UP-11 U-1											13			
BDR BACK	BR-111	BR-11			BR-111	BR-111																	18		
HEM O/L		B-11								UP-1111													12		
HEM B/S		SK-111			UP-111	UP-11																	15		
HEM B/S		UP-11			SK-1111	D-11																	15		
L/B BEL					P-11																		10		
L/Chief Sign	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ	Ⓟ			
Line Controller	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]	[Signature]		

D.H.U. → 5.311

Line Chief Production Manager Q. Manager/Incharge Head of Quality

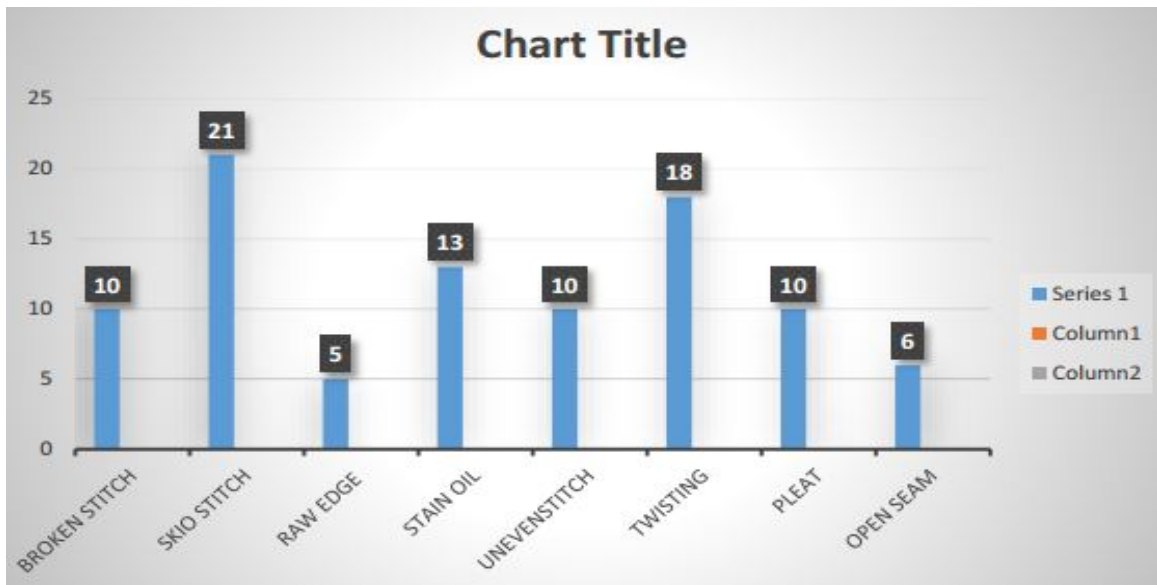
Figure 3.4 Report on sewing section

Chapter-4 RESULT AND DISCUSSION

4.1.1 Analysis Data Collection

We divided the floor of the sewing area into "Crystal Composite Ltd." Furthermore, we discovered various forms of poor cut, downline, oil search, raw-edge, clean seal, bad iron, irregular spot, and so on as often as possible, we found the bad cut, which is almost greater than various deformities.

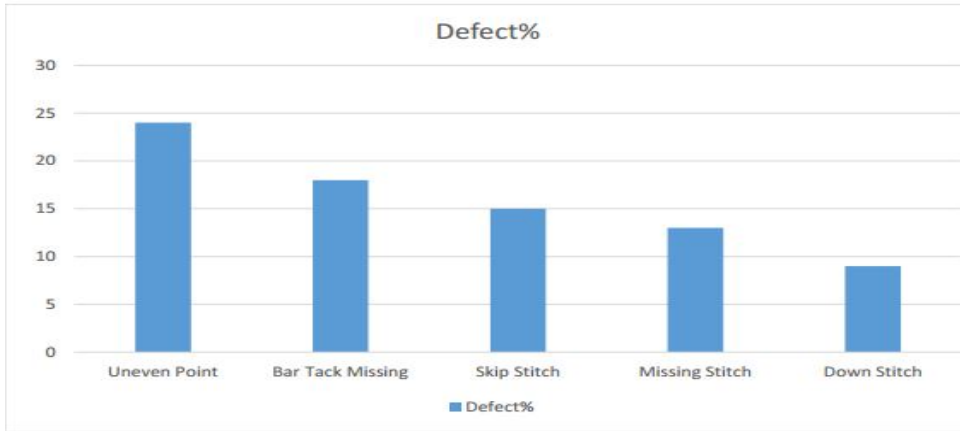
Graph 4.1.1 Table 3.3 End of the report for line inspection I (17/03/2020)



We find abnormal Stich defects after perception 3.1 rather than numerous flaws. We watched the 10th hour of formation and found 16 pieces in inconsistent stitching with deficiencies, but all pieces are improving and no discarded pieces have been found. In 4 hours of development time, the most serious irregular stitching issue emerges. In the most intense hours, the standard fault occurs at 1.6 bits.

We took a lot of data from the Q.A.D for actual causes and remedies for this form of guilt for this edition of Shirt sewing. This fault really occurred during sewing with the texture that is being pulled. The more developed or mediocre rope is another excuse for uneven lines. It is important to ensure that you never pull on the texture while sewing-let the texture be absorbed by the sewing machine.

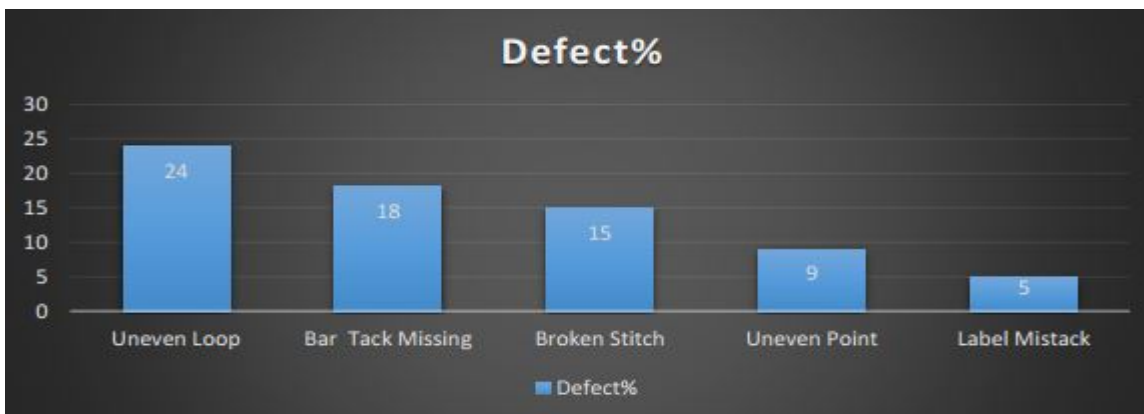
Graph 4.1.2 Table 3.6 The End Line Inspection report 4 (15/02/2020).



As compared to other faults, we find unequal point faults after Observation 3.1. The production of the 10th hour was observed and 24 odd stitch sewing failures were found, but all the parts were modified and no parts were found that were rejected. The maximal loss of irregular stitching takes place during a cycle period of 5 to 8 hours. D.H.U Total = 5.3%. In fact, this failure occurred because the fabric was pulled during stitching.

In fact, this failure occurred because the fabric was pulled during stitching. Another explanation for the unusual condition is not using the proper handling. We get a lot of data from the Q.A.D for the exact causes and solutions of this type of failure for this seam failure of the trousers. In fact, this failure occurred because the fabric was pulled during stitching. A further source of irregular dots is the older or lower line. It is important to remember never to pull the fabric when sewing, allowing the sewing machine to push the fabric.

Graph 4.1.3 Table 3.7 End of the report for line inspection 5 (16/02/2020)



We find abnormal mesh faults after Observation 3.1 relative to other faults. The 10th hour production was observed and 24 abnormal loop seam failures were found, but all parts were modified and no rejected parts were found. The maximum failure of the abnormal loop seam occurs within 7 to 10 hours of production time. D.H.U Total = 6.07 percent. This failure actually occurred because, during stitching, the fabric is pulled. Another explanation for the abnormal loop is that correct handling is not used. For this MANS TR sewing process.

For the real reasons and solutions for this type of failure, we gather a lot of knowledge from the Q.A.D. This failure actually occurred because, during stitching, the fabric is pulled. The older or lower line is another source of irregular dots. It is important to remember never to pull the fabric while sewing-let the fabric be pulled by the sewing machine.

Graph 4.1.4 Table 3.7 End of the report for line inspection 6 (18/02/2020)



We observed broken point failures after observation 3.3, rather than other failures. In the 10th hour, we observed the development and noticed 23 broken stitch stitching errors, but all the pieces were changing and no pieces were noticed that were refused. 1-4 hours of development time is the maximum broken stitch sewing failure. D.H.U Total = 5.38 percent. This failure actually occurred because, during stitching, the fabric is pulled. We obtain a lot of data from the Q.A.D for the exact causes and remedies for this form of failure for this MANS TR sewing failure. This failure actually occurred because, during stitching, the fabric is pulled. The older or lower line is another source of irregular dots. It is important to remember never to pull the fabric while sewing-let the fabric be pulled by the sewing machine.

4.1 Comment

We did 03 Days Study for 6575 Pieces of Sewing Pant & MANS TR and inspected the end of the line and finally we got the following faults that occur more than other faults,

The Uneven Point: 43

The Bar Tack Missing : 53

The Skip Stitch: 25

The Missing Stitch: 28

The Down Stitch: 19

The Uneven Loop: 46

The Broken Stitch: 42

The Label Missing: 9

The Run OF Stitch: 16

Uneven Stitch : 30

The Loop Slanted: 4

The Puckering :22

The Incomplete Stitch : 9

The Open Stitch: 20

End of line 03 Days Report inspected 366 faults.

Bar Tack Displace, which inspected the 03 Days Report at the end of the line, received 366 faults out of 6575 pieces of clothing.

4.2.1 Sewing Defects Percentage Measurement

Defect name	Defect Number	Defect %
Uneven Point	43	11.7
Bar Tack Missing	53	14.48
Skip Stitch	25	6.83
Missing Stitch	28	7.65
Down Stitch	19	5.19
Uneven Loop	46	12.56
Broken Stitch	42	11.47
Label Missing	9	2.45
Run OF Stitch	16	4.37
Uneven Stitch	30	8.19
Puckering	22	6.01
Incomplete Stitch	9	2.45
Open Stitch	20	5.46
Loop Slanted	4	1.09
Total	366	100%

4.2.2 Different Sewing faults are shown in the pie chart:

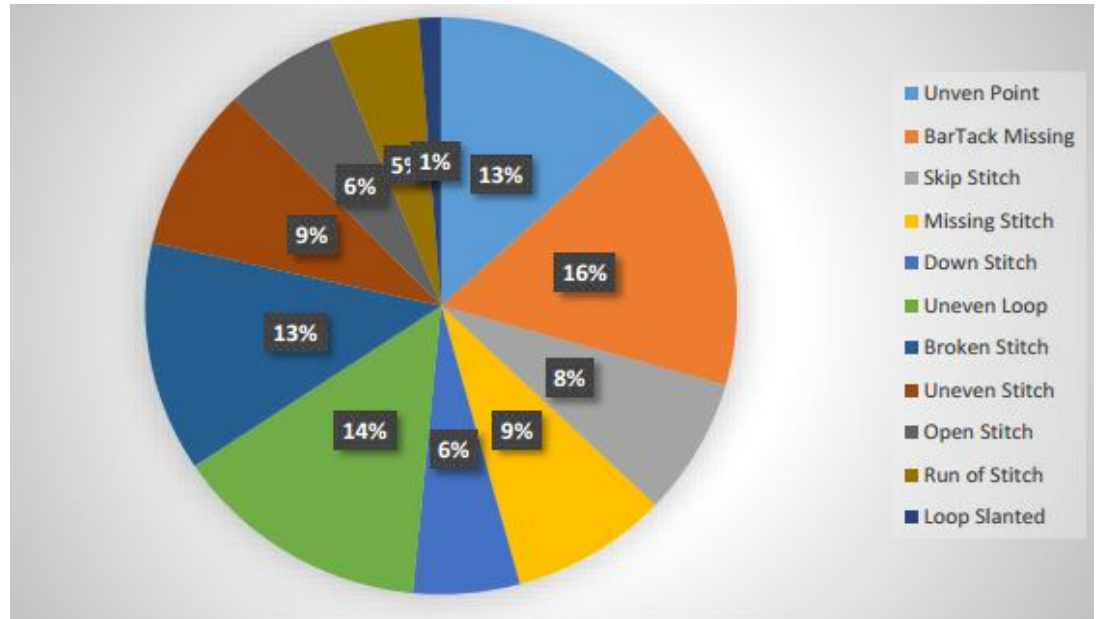


Figure 4.2 pie chart of graphical view

Graph 4.3 Major problems occur in the sewing section:



Chapter-5 Conclusion

5.1 Conclusion

We did 03 Days Study for 6575 Pieces of Sewing Pant & MANS TR and inspected the end of the line and finally we got the following faults that occur more than other faults,

Finally, after much examination, calculation, experiment and debate, we conclude our study. With this project, we have gained great experience. We increase our knowledge of how to finish sewing to make clothing, problems with sewing and how to mitigate these problems. A selection of clothing samples that were classified according to the final product categories were used in this thesis. In this research into the sewing process in a ready-made organization.

There must be a sufficient number of quality employees in order to facilitate a good quality system in businesses, and knowledge of the quality of staff must be increased. The quality of the material must be regulated by means of input checks, while the quality of the output must be regulated by means of intermediate checks during processing. The standard of quality must be continually increased and frequent training in the business must be prepared for that.

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