An Analysis of the Quality Control Operations of Maksons Spinning Mills Limited

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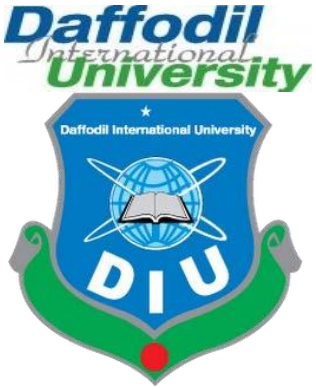

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Letter of Transmittal

14 October 2020

Professor Mohammad Masum Iqbal, PhD

Faculty of Business and Entrepreneurship

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Subject: Internship report on An Analysis of the Quality Control Operations of Maksons Spinning Mills Limited.

Dear Sir,

With profound respect and honor I would like to inform that; I have completed my internship report titled "An Analysis of the Quality Control Operations of Maksons Spinning Mills Limited''. This is a partial requirement to fulfill my Master of Business Administration degree.

My paper covers the methods of collecting information to prepare this paper, objectives and scope of the paper, the limitations that I had in my preparations and I have attempted with whatever expertise I have, to analyze activity and prepare possible recommendations and suggestions as to how it could have been improved perhaps. Under this paper i hope that you will find all the necessary information of our procedures into our findings and analyses.

I express my sincere gratitude for your guidance and suggestions in preparing the report. I would be glad to answer any inquiries and offer clarifications if required.

Sincerely yours,

B.M. Asaf Ud Daula
ID: No 191-14-100
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Certificate of Approval

This is certified that Mr. B.M. Asaf Ud Daula, Masters of Business Administration, ID No: 191-14-100, Daffodil International University has successfully completed his dissertation report entitled "An Analysis of the Quality Control Operations of Maksons Spinning Mills Limited .''

This report is recommended for submission.

……

Professor Mohammed Masum Iqbal, PhD

Dean

Faculty of Business and Entrepreneurship

Acknowledgement

Foremost I would like to express my gratitude to my almighty Allah for keeping all circumstance in favour and let me complete my internship successfully.

Then I would like to take the opportunity to thank Professor Mohammed Masum Iqbal, PhD, Daffodil International University & my internship supervisor for providing me guidelines helps in assisting my reports he was constantly supporting me with his inspiring personality. I will be always thankful for his extraordinary reinforcement.

Then my special thanks go to honourable managing director of Maksons Spinning Mills Limited Mohammad Ali Kokhon.

Then I would special thanks to Mostafizur Rahman, Sr. AGM quality control department and those who helped me during intern period.

And finally, I would like to thank Maksons Spinning Mills Limited for providing me with the opportunity to do my internship in the reputed organization.

Executive Summary

The spinning sector of Bangladesh covers the 95% demand of knit yarn. It gives a better opportunity to lead the market shear so that quality of yarn is produce very important. In the whole process of exporting and communicating with in the knitting factory, the quality department has a great influence and responsibility. Moreover, the quality department is an important part of the export oriented spinning mills. It increases the development opportunity in spinning sector in one hand. On the other hand, it helps the unemployed people as well as the government to remove unemployment problem and plays an important role in the economic development of the country. So, analysis of the quality control process is demand academic research. The study has been carried out on Maksons Spinning Mills which is a reputed contributor in the spinning of the country. Overall findings show that despite having large number of employees Maksons Spinning Mills Limited productivity is getting lower day by day. This is ultimately resulting in low profit.

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Part -1

Introduction

Introduction

Maksons Spinning Mills is one of the largest spinning mills in our country. It is stand B-Bangla, Ashulia, Saver, Dhaka. Which is established in 25th September 2003.It has ruining with 39960 spindles. After 2016 it has established 2nd unit running with 52800 spindles. Now it has total 97900 spindles making it one of the highest production of yarn ,with a production capacity of 20.65 million kg annually .Maksons Spinning Mills produce different type of yarn to better serve its customer .The different type of yarn produce in Maksons are cotton card, combed , slub , organic ,BCI, compact yarn. It focus in more than just producing different types of yarn it also focuses on providing its customer with its customer with the best quality product at a reasonable price .Maksons is certified and purchase its cotton from internationally well reputed cotton producers Such as us cotton , BCI cotton and organic Cotton.

The quality department is the most important department in spinning sector. Now a day's quality is very important in the world. Peoples are now like to prefer quality. In spinning sector quality & production department is most important.

Spinning sub –sector crucial to RMG value chain helping to stabilize supply chain ,while controlling costs .The production of the spinning sub sector are cotton yarn ,polyester, synthetic yarn ,woollen yarn and blended yarn mixed of cotton and polyester of different count There is 350 spinning mills in Bangladesh and there has been a boost in investment since 2001.The privet sector spinning mills can now meet 100 % demand of yarn at the domestic level as well as 95 % of the demand for yarn export oriented knit fabrics mills .In addition almost 85% of the cotton yarn & 50 % demand for synthetic and blended yarn of export oriented fabric producing mills are being met by the privet sector spinning mills .in Maksons Spinning Mills Limited Produce 100% knit yarn .Our daily production 52 ton per day.

Statement of the problems

The study will deal with the quality control operation of spinning mills. Which element are affected the quality to make the quality process? How they are ordering raw material. How they get raw materials and how they supply the product. How they motivated buyers to buy knitting factories. These are the things that we want to find from the study.

Background of the study

Bangladesh is the second largest readymade garment (RMG) exporter country in the world. The primary textile sectors are producing yarn and fabric needed for readymade garments sector. Primary textile sectors are the backbone of clothing industries because it provides the backward linkage for the both the woven and knit sector. The sector provides the yarn towards the clothing industries where yarn is the primary raw material of these industries where yarn is the primary raw material of these industries to produce fabric. Primary textile sectors are usually the factories under the leadership of Bangladesh textile mills association (BTMA) comprises of spinning sector and weaving and woven processing sector of Bangladesh.

RMG sector in Bangladesh started its modest journey as a small non-traditional sector of export in late 1970s and transformed itself as the country's highest revenue generating sector within three decades, contributing 81% (USD24.49 billion FY 13-14) of the country total export July 14-feb 15 period.

The growth in the export of clothing with the phasing out of MFA in 2005 has led to the setting up of 350 spinning mills and there has been a boost in investment since 2001.The private sector spinning mills can now meet around 100% demand of yarn at the domestic level as well as 95 % of the demand for yarn for export oriented knit fabric mills . In addition ,almost 85 % of cotton yarns and 50m% demand for synthetic and blended yarn of export –oriented fabric producing mills are being met by the privet sector spinning Mills .(source :Bangladesh Textile Mills Association).the rest of the import is being from china and India.

Although Bangladesh has production capabilities in manufacture of thread and fabric, the country has to import almost all raw materials, primarily cotton and other man-made fibre like as polyester, viscose and staple fibre. The country spends substantial foreign exchange every year to import raw materials and accessories to feed the RMG sector. In 2014-2015, Bangladesh is projected to increase raw cotton import by 7.6 % to 4.2 million bales on sustained export demand for value –added products, particularly in RMG sector. The main raw cotton exporters include India (35% market share) and Uzbekistan (25% market share).

Scope of the study

A master of business administration (MBA) is a graduate degree that provides theoretical and practical training for business or investment management. An MBA is designed to help graduates gain a better understanding of general business management functions. Internship is a part of business administration degree, which provides a practical experience of a student.

I tried to collect more information about the importance of production, quality and marketing section for the 100 % export oriented spinning mills. The current strategy of Maksons Spinning Mills Limited is to emphasize specially in production and quality. There is a motto "Production Fast, Quality must"

- The study will also help me to understand the quality activity in spinning sector
- The Study will give a clear idea about the quality activities of Maksons Spinning Mills Limited.
- The guiding principle of the company is to develop and maintain strong secure relation with buyers and to support the customers.

Objective of the study

The study has been carried out with the following objectives.

- To explain the quality control procedure of Maksons Spinning Mills Limited ;
- To analyze how quality control improves the productivity of the company of Maksons Spinning Mills Limited ;
- To identify the problems related to the quality control operation of Maksons Spinning Mills Limited ;
- To make the recommendations to solve the problems;

Methodology

The report is based on both primary and secondary data. But maximum data used in this report are collected from secondary sources. Exact sources of the secondary sources will be mentioned. Thus, the report is basically qualitative in nature. However, primary data is also used depending on the requirement.

Sources of data collection

Primary data

The primary data were collected on the basis of:

- Observation method was followed, as I have to study the entire quality process in depth.
- Interview with quality officers
- Group discussion with the company personnel and the clients.

Secondary Data

The secondary data were collected on the basis of:

- Organizational profile
- Internet
- Newspaper

Time Period

Time period of the study was 2nd may 2020 to 31st August 2020

Limitation of the study

- It is hard to find necessary information because there is no fixed place such as library
- In spinning factory most of the employee does not have any education background they do their job only with experience.
- They know machine parts their own world which is not exist in book
- Time was one off the major limitation as our internship program is only three-month long.it was difficult to cover and collect all the necessary materials for completion of such a larger report within this time boundary.
- The people of quality are under tremendous workload. Although they wanted to cooperate with me in writing my report, their busy schedules something did not allow them to do so. On the other hand, due to secrecy of official information, sometimes they showed unwillingness to provide me information.

  Political unrest of our country such as strike or hartal was major problem in this regard as it difficult to go out and work during that time and to maintain the work schedule.

Part 2

Organization Overview

Profile of the organization

Maksons Spinning Mills Limited is one of the largest spinning mills in our country. It is stand B-Bangla, Ashulia, Saver, Dhaka, which is established in 25th September 2003.It has ruining with 39960 spindles. After 2016 it has established 2nd unit running with 52800 spindles. Now it has total 97900 spindles making it one of the highest productions of yarn, with a production capacity of 20.65 million kg annually. Maksons Spinning Mills produce different type of yarn to better serve its customer .The different type of yarn produce in Maksons is cotton card, combed, slub, organic, BCI, compact yarn.it focus in more than just producing different types of yarn it also focuses on providing its customer with the best quality product at a reasonable price .Maksons is certified and purchase its cotton from internationally well reputed cotton producers such as us cotton, BCI cotton and organic cotton.

Vision of the organization

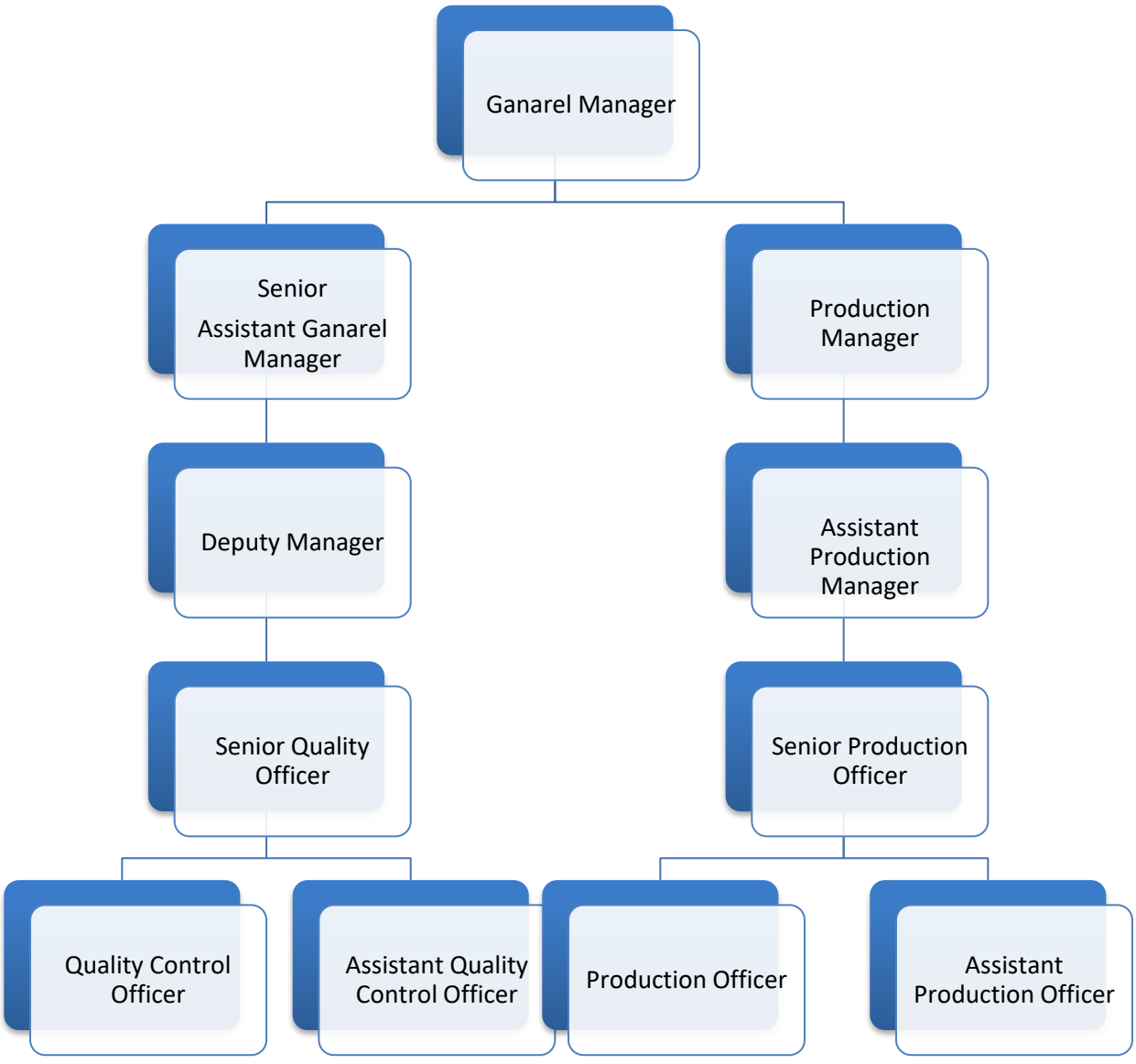
To obtain a leading position in the spinning sectors of Bangladesh as well as international through maintaining standard quality.

- In time action.
- Clear understanding of customer's instruction.
- Clear instruction for production.
- Strict compliance with quality control system.
- Total devotion maintains first class quality standard.
- To maintain international standard like as organic, BCI standard.
- Absolute efforts for delivery to knitting factory.

Mission of the organization

Maksons Spinning Mills Limited is to committed to maintain discipline, punctuality and quality product a reasonable price and quality Service. Their focus is on the customer needs and satisfaction.

Organogram



Product of Maksons Spinning Mills Limited

Maksons Spinning Mills Limited produces of this type of yarn such as

- Card yarn
- Comb yarn
- Compact card yarn
- Compact comb yarn
- Compact card slub yarn
- Compact comb slub yarn
- Lycra yarn
- Card Woven yarn

Maksons Spinning Mills has factories with the latest machinery manpower with delivery and quality standards. These factories can produce any quality and any quantity under our guidance and control. Some buyers our yarn approve our yarn as they are ready to produce their fabric like as Gap, Wal-Mart, Target, Jc Penney etc.

PART -03

DUTIES, POSITIONS & LEARNING POINTS

The internship program

I did my internship at Maksons Spinning Mills Limited. I got the opportunity to work as an internee in the quality assurance department of Maksons Spinning Mills Limited.

The job Description

It is clearly mentioned in my joining letter that I was supposed to give regular attendance at the place where I would be depended to work on my project. As an internee.

I was supposed to perform the following works.

- Follow up the process.
- Follow up the daily process.
- Changing count if required.
- Cooperate with produce high production.

The daily routine

I worked in the quality department of Maksons Spinning Mills Limited. I worked there 6 days in a week. My office hour was 9 am to 5 pm. But sometimes I had to stay more than 8 hours for wok. At the beginning of my internship of my internship they tell me about my duties and then introduce me about the whole system of quality department of Maksons Spinning Mills Limited. They give me primary data about the function of the function of different section of the spinning sector. My job was to communicate with the production department and follow the process. To help the production to achieved target production.

Use of office machinery

In Maksons Spinning Mills Limited as an intern I was authorized to use all the machineries of the office. I used the following machinery-

- Computer for preparing different document
- Uster machine to check the sliver and yarn report
- Use uster auto sorter to checking count.
- Use moisture meter

Essential knowledge

As a quality officer must have some essential knowledge and skill about spinning process. How spinning process running. very good known about fiber, bale management, blow room action and quality parameter. Other machine name function and quality parameter. How they run, how they operate. There is a flow chart to clear understanding spinning process.

Learning

Quality department is a very important department to taking the leading position to other company. The sales rate will be high if the quality of yarn is good.it will making more demand in the market.

- The study will also help me to understand the quality activity in spinning sector
- The study will give a clear idea about the quality activities of spinning sectors.
- The study will give to mechanical activities of spinning sectors

Part 4

Analysis and Interpretation of Data

Analysis and interpretation of data

Process flow chart of spinning mills limited-

Process flow chart

Input	**Machine name**	**Output**
	Bale Management	
Bale	**Blow Room**	Lap
Lap	**Carding Machine**	carded sliver
Sliver	**Breaker Draw Frame**	Drawn Sliver
Sliver	**finisher Draw frame**	Drawn sliver
Sliver	**Simplex Machine**	Roving
Roving	**Ring Machine**	Yarn
Yarn	**Auto cone Machine**	Package

Fibre

Textile fibre can be spun into a yarn or made into a fabric by various method including weaving, knitting, cohesiveness and sufficient strength. It also has elasticity, finesse uniformity, durability and lustre. Textile fibre is two kind.

1. Natural fiber
2. Manmade fiber

Natural fibre

Natural fibres are those are producing by plants animals and geological process. They are bio degradable over time.

They can be classified according to their origin.

1. Animal fibre example silk fibre, wool fibre etc.
2. Mineral fibre example asbestos fibre
3. Vegetable fibre example cotton fibre flax fibre jute fibre.

Figure 1 Natural fibre

Manmade fibre

Manmade fibres are produced from synthetic materials such as petrochemicals. For example: nylon fibre, polyester fibre, acrylic fibre.

Figure 2 Manmade fibre

Sampling

Fibres are coming to the factory. Then samples are collected by giving a sample identification number taking 200-300-gram fibre as a sample. Store the storehouse. After taking, samples are tested HVI (high volume instrument). Then we got some quality factor which are

- Staple length
- Length uniformity index
- Micronaire
- Color
- Color Grade
- Trash

Staple length

Staple length is reported as the length of the longer half of the fibres measured by clamping a fibre sample then combing and brushing to make the fibres straight and parallel.

Length uniformity index

Staple length, length uniformity affects yarn strength and evenness. It also affects the efficiency of the spinning process. Cotton with a low length uniformity index has a high variance in fibre length which can make processing difficulties and ultimately result in lower quality yarn.

Strength

Fibre strength is large determined by genetics .So cotton variety plays an important role in fibre quality. It is shown by gram per tex.

Micronaire

The micronaire is a measurement of fibre finesse and maturity .It is determined the air permeability of a constant mass of cotton fibres compressed to a fixed volume. Fine or immature fibres are that easily compressed have a lower air permeability and therefore low micronaire ,course or mature fibre that resist compression have high micronaire measurement.

Colour and colour grade

The colour of cotton is measured using a cotton colorimeter and is expressed by the degree of reflectance (Rd).

It typically ranges between 50-85 units and indicates how White or grey a sample is as well as yellowness(+b) values indicates intensity of yellow shades .so cotton with higher +b measurement is more yellowness.

Trash

Trash is a measure of the amount of non-lint materials in cotton ,such as leaf and bark from the cotton plant .The ratio between percentage area of trash and trash particle count is a good indicator of the average particle size in a cotton sample.

Blow room

Blow room is the most important part of textile of spinning sector.It consists of a number of machine where the supplied compressed are opened, cleaned, and mixing or blending for making uniform lap of definite length. The range of blow room cleaning efficiency is 60-65%.In blow room section normally 40-70 % trash is removed. Blow room is the first section of spinning line for producing cotton yarn.

Basic operation in blow room

The below operation has done blow room section in spinning line

- Opening
- Cleaning
- Mixing or Blending
- Lap forming.

All the above operation has explained in the following.

Opening

Here the compressed bales of fibres are opened for making the cotton tuft in a small size

Cleaning

This operation is used to remove dust, dirt, broken leaf's, broken seeds, stalks and other foreign materials from the fibre.

Mixing or Blending

Mixing or Blending process has performed for producing higher quality yarn by reducing production costing which is only possible by mixing different grade of fibres.

Lap forming

This operation has due to the below reason

1. It is done transfer the opened and cleaning fibers into a sheet of specific width and uniform unit length which is termed as lap.
2. It is also used to roll the lap of predetermined length into a cylinder shape around a lap pin.
3. It is also used to transfer the lap from the lap pin into a rode to suitable handle and feed it to subsequent processing.

Carding machine

A process in the manufacture of spun yarns whereby the staple is opened cleaned aligned and formed into a continuous, untwisted strand called carding process. Carding machine is called heart of spinning.

Function of carding machine

- Opening to individual fiber
- Elimination of impurities
- Elimination of dust
- Disentangling of neps
- Elimination of short fibers
- Fiber blending
- Fiber orientation
- Sliver formation

Figure 3 Carding machine

Draw frame

Draw frame is a machine for combing and drawing slivers of textile fibre. Drawing is the operation by which sliver are blended doubled and levelled

Action Involved in draw frame

Drafting

It is the process of increasing length per unit weight of sliver. It mainly due to Peripheral speed of the rollers.

Doubling

The process of combing two or more card sliver into a single from is called doubling. In draw frame machine six slivers are fed to convert into one. i.e. six doubling.

Drawing in the cotton industry the term is applied exclusively to processing on the draw frame, where the operation is one of doubling & drafting.

Figure 4 Breaker draw frame

Comber

Comber is a machine by which fibre are combed and the action is called combing .The straightening and parallelization of fibre and the removal of short fibres and impurities by using combs knives, brushes and rollers. One combed sliver is product from eight lap .Combed yarns are superior in quality when compared to carded yarn as they generally finer, stronger smoother and more uniform due to the removal of short fibres and the alignment of fibres.

Function of comber machine

- To remove predetermine length of short fiber (noil %)
- To remove nep's
- To remove remaining impurities
- To straightening hook fiber

Figure 5 Comber machine

Lap former

Lap former forms the lap by doubling a limited number of slivers (16 to 32 slivers) previously subjected to a drawing passage. The slivers are normally fed to the machine in side by side passing through the roller and stop motion.to produce a compact lap slivers enter the drafting section and then calendared it. Finally, lap is wound on the bobbin.

Necessity of lap former

- To reduce the strains to delicate comber.
- To reduce short fiber.
- To control wastage.
- To parallel and straight of fiber in carded sliver by changing pushing of fibers.
- To reduce chance of good fibers waste.
- To reduce thick thin place in the sliver.
- Not freely opening of fiber from the sliver.

Figure 6 Lap former machine

Ring frame

Ring spinning is a method of spinning such as cotton. Spinning process done by ring frame machine. Ring machine converted the roving bobbin into the yarn. The roving bobbin taken from roving process is mounted on the ring frame either automatically or manually. The ring frame stretches and drafts the material.

Function of ring frame:

- To reduce the mass of the material by drafting until the required finesse is obtained.
- To twist the drafted yarn by twisting to obtain maximum strength
- To wind the twisted yarn onto the bobbin by winding process for suitable storage transportation and further processing.

Figure 7 Ring machine

Auto cone

The factors such as conversation of the specific quality of the yarn , further optimization of the structure and build of the yarn packages and the production of yarn like spliced joints for gentle handing and undistributed processing of yarn and package in the production process downstream of winding are still considered vital in the yarn winding process .In addition to these ,advance monitoring and operating system, proven automation solution ,energy and raw material saving technologies constitute the other performance feature of the modern Winding Machines.

Function of the auto cone winding machine

Auto cone is a modern yarn winding machine. It is used to prepare bigger package from ring bobbin .it is just not only having a winding machined, there also some extra specification of this machine. There are

- Automated spinning bobbin feed
- Linkage with the ring spinning machine
- Manual filling of the feed bobbins into the feed magazines
- Rewinding of manually creel yarn packages
- Rewinding of residual yarn package
- Predefined package density
- Continuous online measuring of the yarn tension
- Easy operation and maintenance
- Highest accuracy and reproducibility of the yarn tension
- Increase in productivity
- Compensation of yarn tension variation
- Flexible splicing principle
- Systematic data analysis and targeted process control

Figure 8 Auto cone machine

Quality objective of Maksons Spinning Mills Limited

Machine name: Carding
Quality Object:

- To remove neps.
- Fiber parallelization
- To produce sliver form
- Element all impurities

Machine Name: Breaker Draw Frame
Quality Object:

- To parallelization fiber
- To mixing sliver
- To produce draft
- To remove sliver hook
- To produce draft

Machine Name: Lap Former
Quality Object:

- To maintain proper mixing
- To parallelize fiber
- Lap tension
- Lap uniformity
- To reduce thick thin place on sliver
- To reduce short fiber
- To decrease fiber damage

Machine Name: Comber
Quality Object:

- To remove short fiber
- Increase sliver quality
- Improve uniformity
- Improve strength of fiber
- Evenness

Machine Name: Simplex
Quality Object:

- To produce standard roving
- To maintain proper tension
- To produce draft
- To produce twist

Machine Name: Ring Frame Machine
Quality Object:

- To produce yarn
- To minimize hairiness
- To produce draft
- To produce twist
- Winding, building

Machine Name: Auto Cone Machine
Quality Object:

- To remove yarn fault
- To maintain proper package tension
- To maintain proper package size
- To adding proper Waxing
- To make suitable Package

Machine Name: Heat setting
Quality Object:

- To gain moisture
- To increase strength
- To strong twist

Part 5

Problems and Recommendations

Identifying problems of Maksons Spinning Mils Limited

Based on the analysis and practical experience of the internship period, the following problems are identified

1. Procurement department is not very strong in this company which causes delayed delivery of the raw material to the factory management which results in low production.
2. Lot change rate is very high which affects the production. It directly leaves a negative effect on higher production.
3. Manpower turnover rate is very high because the job environment and other facilities like salary, increment, provident fund is poor. Manpower is highly related to higher production.
4. The mechanical department is not strong and time management is very poor. The productivity is getting lower due to poor command of mechanical department.
5. The electrical department is not strong enough and not well trained. The productivity is greatly hampered by their low-level work
6. Production performance is getting lower due to quality defects like nep's problem, gauge out, cot roller damage.
7. The HRM department is almost unprofessional and performs only on disbursing salaries and overseeing the attendance of the worker. They do not bother to train employees and make appraisals to evaluate them.

Recommendation

Maksons Spinning Mills Limited is a primary textile industry in Bangladesh. It has an outstanding reputation in the market. However, this organization is not facing profit due to many of reason what I have observed from the internship period. Based on my observation I my recommendations are as follows-

1. Procurement department should be strong for higher productivity.
2. Lot change should be reduced 3 to 4 times in a year for higher productivity.
3. Providing standard salary and other benefits to reduce frequent job turnover of the workers.
4. Maintenance department should be stronger and better trained for Higher Production.
5. Electric department should be trained for higher production.
6. Different type's defects should be removed, and extra attention should be given on maintenance.
7. The Human Resource Management department must have to be more active. They have to train up workers, employees and make appraisals to evaluate them.

Conclusion

Bangladesh is the third largest readymade garment exporter country in the world. The primary textile sector is producing yarn and fabric needed for readymade garment sector. The sector provides the yarn toward the clothing industry where yarn is the primary raw material of this industry to produce fabric. Spinning mills are trying to find out the demand and supply gap of its output yarn. Overall, my internship journey inferred Maksons Spinning Mills Limited have some issues in the quality control operations which are responsible for low productivity and the low profit. Those problems can be easily solved with proper management and efficiency which, eventually can increase the productivity as well as the profit.

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