



Daffodil
International
University

Faculty of Engineering
Department of Textile Engineering

Study on Finished Fabric & Knit Garments Inspection Report

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

Presented By:

Akash Chandra Das	152-23-4316
Zahidul Islam	151-23-4277
Mohammad Rayhan Hosen	151-23-4205

Supervised By:

Mst. Murshida Khatun
Assistant Professor
Department of Textile Engineering
Daffodil International University

A thesis submitted in partial fulfillment of the requirements for the degree of Bachelor of
Science in Textile Engineering

Advance in Apparel Manufacturing Technology

April: 2019

Acknowledgement

First of all we are grateful to Allah who gives us sound mind & sound health to accomplish this project successfully.

We are also grateful to our supervisor **Mst. Murshida Khatun**, Assistant Professor, Department of Textile Engineering, Faculty of Engineering in Daffodil international University. Her endless patience, scholarly guidance, continual encouragement, energetic supervision, constructive criticism, valuable advice, reading many inferior draft and correcting these at all stages have made it possible to complete this project.

We are also thankful to our all teachers, lab assistant, register sir, coordinators and all the employees of Daffodil International University. We are highly delighted to express our regards & gratitude to honorable Head **Prof. Dr. Md. Mahbubul Haque** for providing his best support to us.

Finally, we would like to express a sense of gratitude to our beloved parents and friends for their mental support, strength and assistance throughout writing the project report.

Declaration

We hereby declare that, this project has been done by us under the supervision of **Mst. Murshida Khatun**, Assistant Professor, Department of Textile Engineering, and Faculty of Engineering in Daffodil International University. We also declare that, neither this project nor any part of this project has been submitted elsewhere for award of any degree or diploma.

.....

Akash Chandra Das

ID: 152-23-4316

.....

Zahidul Islam

ID: 151-23-4277

.....

Mohammad Rayhan Hosen

ID: 151-23-4205

Letter of Approval

May 09, 2019

To

The Head

Department of Textile Engineering

102, Shukrabad, Mirpur Road, Dhaka 1207

Subject: Approval of Project Report of B.Sc. in TE Program.

Dear Sir,

I am just writing to let you know that this project report titled as “**Study on Finished Fabric & Knit Garments Inspection Report**” has been prepared by the student bearing ID’s 152-23-4316, 151-23-4277 and 151-23-4205 are completed for final evaluation. The whole report is prepared based on the proper investigation and interruption through critical analysis of empirical data with required belongings. The student were directly involved in their project activities and the report become vital to spark of many valuable information for the readers.

Therefore it will highly be appreciated if you kindly accept this project report and consider it for final evaluation.

Yours Sincerely



.....
Mst. Murshida Khatun

Assistant Professor

Department of Textile Engineering

Daffodil International University

Abstract

This report presents the finishing process report in different types of knit garments. During manufacturing various defects are occurring in different types of knit fabric & garments. Finishing process is depending on buyer's requirement. Quality represents company reputation and buyer satisfaction. So every industry tries to produce good quality of product. This report giving idea about spinning fault, knitting fault, dyeing fault, finishing fault, sewing fault and how to minimize or solution garments defect. It also helped to know how to find out defects and how to rectify this in efficient way. Overall this report will be helped for producing good quality knit garments.

Table of content

Acknowledgement	I
Declaration	II
Letter of approval	III
Abstract	IV
Table of content	V
Chapter-I.....	01
Introduction	01
1.1 Objective	02
1.2 Outcomes	02
1.3 Limitations	02
Chapter-II.....	03
Literature review	03
2.1 Garments Finishing Process	04
2.2 Finished Fabric Inspection System.....	04
2.3 Four point Fabric Inspection System	04
2.3.1 The main considerations in a four point Inspection System	04
2.4 Penalty points in Four point system	05
2.4.1 The formula to determine the penalty points per 100 square yds.	05
2.5 Different types of Fabric fault	05
2.6 Sewing Faults	06
2.7 Finishing process for T-shirt	06
2.8 Mashing Layout for T-shirt	07
2.8.1 Sewing sequence of T-shirt	07
Chapter-III.....	08
Experimental Details	08
3.1 Picture of T-shirt of H&M Buyer	09
3.2 Fabric inspection report	10
3.2-1 Table of Fabric Inspection report	11
3.2-2 Figure of Fabric inspection report	12
3.2-2 Table of Fabric Inspection report	13
3.2-3 Figure of Fabric inspection report	14
3.2-3 Table of Fabric Inspection report	15
3.2-4 Figure of Fabric inspection report	16
3.2-4 Table of Fabric Inspection report.....	17
3.2-5 Summary Table	18

3.2.1 Graphical Analysis.....	20
3.3 Inspection Report	21
3.3-1 Table of Fabric Inspection report	22
3.3-2 Figure of Fabric inspection report	24
3.3-2 Table of Fabric Inspection report	25
3.3-3 Figure of Fabric inspection report	26
3.3-3 Table of Fabric Inspection report	27
3.3.1 Sample of Bizzbee Buyer	28
3.3-4 Figure of Fabric inspection report	29
3.3-4 Table of Fabric Inspection report	30
3.3.2 Sample of Bizzbee Buyer	31
3.3-5 Figure of Fabric inspection report	32
3.3-5 Table of Fabric Inspection report	33
3.3.3 Summary Table	34
3.3.3-1 Graphical Analysis	36
3.4-1 Figure of Q.C inspection report	37
3.4-1 Table of Q.C inspection report	38
3.4-2 Figure of Q.C inspection report	40
3.4-2 Table of Q.C inspection report	41
3.4-3 Figure of Q.C inspection report	43
3.4-3 Table of Q.C inspection report	44
3.4-4 3 Figure of Q.C inspection report	46
3.4-4 Table of Q.C inspection report	47
3.4-5 Figure of Q.C inspection report	49
3.4-5 Table of Q.C inspection report	50
3.4.1 Summary Table of Finishing Garments Inspection Report.....	52
3.4.2 1 Graphical Analysis of Sewing fault	53
3.5-1 Q.C Inspection Report of Finishing Section	54
3.5-1 Table of Q.C inspection report	55
3.5-2 Q.C Inspection Report of Finishing Section	56
3.5-2 Table of Q.C inspection report	57
3.5.1 Summary Table of Finishing Garments Inspection Report.....	58
 Chapter-IV.....	 59
Discussion of Result	59
4.1 Fabric Inspection Report Analysis for Chaity Composite Ltd	60
4.2 Garments Finishing Report Analysis for Chaity Composite Ltd	60
4.3 Fabric Inspection Report Analysis for Fatullah Apparels	60
4.5 Compare between the spinning faults in Chaity groups & Fatullah Apparels	60
4.6 Compare between the knitting faults in Chaity groups & Fatullah Apparels	61
4.7 Compare between the Dyeing faults in Chaity groups & Fatullah Apparels	61

Chapter -V	62
Conclusion	62
5.1 Conclusion.....	63
Reference.....	64

Chapter- I

Introduction

1.1 Objective

- To know about garments finishing.
- To know about sewing faults.
- To know about different types of faults.
- To know about garments finishing process.

1.2 Outcomes

- We have learnt about fabric inspection (4 point system).
- We have learnt fabric relaxation before cutting.
- We have learnt about fabric spreading, cutting, and sewing.
- We have learnt about fabric faults and sewing faults.

1.3 Limitations

- Two months is not enough time to complete thesis. If we get more time we will know lot and complete more effectively.
- Industry did not agree to provide their latest or running order data.
- It was not possible to collect all data in specific order.
- It has taken so much time to collect any data or list from employees because they were so much busy.
- Internet had not enough information regarding some topic.

Chapter II

Literature Review

2.1 Garments Finishing Process

In the garments industry, finishing section is the last steps of garment manufacturing or assembling the operation are performed. After making complete stitched garments by sewing section, these are passed in finishing department for ironing, folding, poly packing, cartooning to get attractive appearance. All types of garments finishing activities are done here.

2.2 Fabric Inspection System

After the receipt of a fabric roll to the garment industry, it must be inspected to evaluate its tolerability from quality point of view or else additional cost in garment manufacturing may be incurred. It is normally carried out on fabric inspection machines, which are designed such that fabric rolls are mounted at the back side of the inspection table. As the fabric is moving at a slow speed and at an angle, the fabric inspector has a better view of the fabric and could identify faults easily. These machines are normally power driven or the operator has to pull the fabric over the inspection table. The fabric faults are identified, labelled and recorded in a fabric inspection form.

2.3 Four Point Fabric Inspection System

The four-point assessment method is a commonly established method of fabric inspection globally. Fabric inspection is done as per ASTM D 5430–04 standard and this system is agreed by The American Society for Quality Control, Textile and Needle Trades Division, The American Apparel Manufacturers Association and is used by the United States Government for all of their piece goods purchased.

2.4 The main considerations in a four-point inspection system are given here

- ❖ The fabric has to be passed longitudinally through the inspection area at a speed approved by the customer.
- ❖ The light source should be perpendicular to the fabric surface and the fabric should run at an angle of 45° to the vertical for better vision for the operator.
- ❖ The illumination intensity in the inspection room should have a minimum of 1075 lux and the light source used should be white fluorescent lamps.
- ❖ The fabric should be checked at a distance of 1 m from the fabric inspector when it is in motion.
- ❖ Defect points should be assigned based on the length of the defect as mentioned in Table -1.
- ❖ Four points should be assigned to each meter of fabric where usable width is lower than the minimum specified.
- ❖ The fabric should not be penalized more than four points.
- ❖ Defects not obvious on the face side of the fabric should not be registered unless agreed between supplier and customer.

2.5 Penalty Points in Four Point System

Size of the defect	Point
Defects up to 3"	1
Defects 3" to 6"	2
Defects 6" to 9"	3
Defect over 9"	4
Holes up to 1"	2
Holes over 1"	4

Total defect points per 100 square yards of fabric should be determined and the criterion for the acceptance of a fabric roll is generally not more than 40 penalty points. If it is more than 40 points, it will be considered 'seconds'.

2.5.1 The formula to determine the penalty points per 100 square yards is given by-

$$= \frac{\text{Total points scored in the roll} \times 36 \text{ inch}}{\text{Fabric width in inches} \times \text{Total yards inspected}} \times 100$$

2.6 Different Types of Fabric Faults

There are various types of defects occur in the knitted fabrics. This are given below:

- Barrie
- Fly Contra
- Neaps
- Hole
- Needle Mark
- Miss Yarn
- Oil Stain
- Lycra Missing
- Crease Mark
- Softener Stain
- Color Spot
- Enzyme Spot
- Dirty Spot
- Pin Hole
- Compaction Mark

2.7 Sewing Faults

There are many sewing faults. These are given below:

- Skip Stitch
- Broken Stitch
- Down Stitch
- Open Seam
- Tension Problem
- Joint Un matching
- Uneven Stitching
- Pleat
- Gathering Neck Area
- Part Mistake
- Part Shading
- Pocket Shading
- Label Missing
- Label Mistake
- Size Mistake
- Both Sleeve Up Down
- Both Shoulder Up Down
- Armhole Point Up Down
- Uneven Hem

2.8 Finishing Process for T-Shirt

After stitching the T-shirt have to finish it and pack (if apply) it prior to sending the t-shirts to retail store. Quality of packing and presentation is as important as the product quality.

Following are process need to do in finishing process.

- Thread trimming: Trim all thread tails and remove loose threads.
- Quality checking: Check stitching quality. Follow the quality document for checking quality. In the finished garment fabric defects and stitching defects should not be allowed.
- Pressing / Ironing: Press all garments using a steam press. By pressing creases on the t-shirt is removed.
- Folding: Fold the t-shirt according to folding dimension.
- Tagging: Attach hang tags, price tags using tag-gun.
- Packing: Pack individual t-shirts into poly bags. Or follow packing instruction from buyer.

2.9 Machine Layout for T-Shirt

To achieve required amount of garment production, perfect machine layout of any styles plays an important role in readymade garments sector. There are three types of machines needed in T-shirt manufacturing such as over lock machine, plain machine and flat lock machine. Number of machines with operator and helper should be increased according to the production target. In the below table, all the processes of T-Shirt manufacturing has shown with used machine name and quantity.

2.9.1 Sewing Sequences of T-Shirt Applied in Garments Industry:

SL No.	Operation	Machine	Machine Quantity
01	Shoulder join	Over lock	2
02	Neck join	Over lock	2
03	Rib tack	Plain machine	1
04	Main label join	Plain machine	1
05	Neck tape join	Plain machine	3
06	Neck top sin	Plain machine	3
07	Sleeve hem	Flat lock	2
08	Sleeve join	Over lock	2
09	Care label join	Plain machine	1
10	Side seam	Over lock	3
11	Sleeve tack	Plain machine	2
12	Sleeve soap tack	Plain machine	2
13	Body hem	Flat lock	2
Total Machine			26

Chapter III

Experimental Details


3.1 Picture of T-Shirt of H&M



Figure 3.1-1 Picture of T-Shirt (Chaity Composite Ltd.)

3.2 Finished Fabric Inspection Report (4 point system)

M/C SP: 35
SK SP: 30



Chaity Composite Ltd.

Fabric Department

HC P-1

Fabric Inspection Report (4 Point System)

CCL-241/19

Buyer : <u>HBM</u>	Order No. : <u>226737-1670</u>	Composition :	Required Width : <u>65 cuttable</u>
Batch No. :	Colour : <u>Grey Dusty Light</u>	Required GSM : <u>140</u>	Inspected Roll :
Fabrication: <u>317</u>		Fabric Weight : <u>585.24</u>	Accepted Roll :
		Total Roll :	Rejected Roll :

Date: 18.3.19

Roll No.	Roll Weight (kg)	Roll Length (Mtr.)	Width Inch.	GSM	Spinning Fault					Knitting Fault					Processing Fault					Others Fault	PTS	PTS/100 Sq.MTR	Class A/B/C						
					Barrie	Yarn Conta	SLUS	NEPS	Hole	Needle Mark	Miss Yarn	Oil Stain	Lycra Missing	Crease Mark	Softener Stain	Color Spot	Joint-4	Bowing	Pin Holl Others Fault										
1			69							11								115	DIS										
2			11							11								11											14
3			70							11								11											12
4			11							11																			16
5			11							11																			12
6			70							11																			17
7			69							11								1											10
8			11							11																			18
9			11							11								1											16
10			69							11																			12
11			11							11																			19
12			69							11																			13
13			70							11																			21
14			11							11																			22
15			11							11																			17
16			70							11																			11

4-Point System	Acceptance Calculation	
0-3"	1 Up to 20	A = Acceptable
>3"-6"	2 21 to 28	B = Acceptable
>6"-9"	3 Above 28	= Rejected
>9"	4	
Hole < 1"	2	
Hole > 1"	4	

02. $\frac{R.Dia \times R.GSM \times 39.37}{1550 \times 1000} = \text{Constant.}$

03. $\frac{\text{Roll Weight}}{\text{Constant}} = \text{Roll Length (In mtr)}$

04. $\frac{\text{Point/100 mtr}}{\text{Roll Length (Mtr)} \times \text{Cutable Width (Inch)}} = \frac{TTL PTS \times 100 \times 39.37}{\text{Roll Length (Mtr)} \times \text{Cutable Width (Inch)}}$

Shrinkage	
Length	
Width	
Spirality	
Shade	

Monir
Inspector

Incharge

Manager

Figure: 3.2-1 Finished Fabric Inspection Report.

Table 3.2-1 Finished Fabric Inspection Report (4 point system)

Chaity Composite Ltd
 Fabric Department
 Fabric Inspection Report (4 point system)


Buyer Name: H&M
 Order number: 220737-1670
 Batch Number: 2778/19
 Color: Grey Dusty Light
 Fabrication: S/J

Fabric GSM: 140
 Required Width: 65 cut able
 Fabric Weight: 585.24

Date: 18. 03. 19

Roll No.	Width (Inch)	GSM	Spinning Fault	Knitting Fault					Processing Fault			Points	Class A/B/C	
			Slub	Hole	Needle Mark	Mis Yarn	Oil Stain	Color Spot	Enzyme Dust	Dusty Spot	Pin Hole			
1	69	140		2						2		2	14	A
2	69			2						2		1	12	A
3	70			3	1-m							2	16	A
4	70			2								2	12	A
5	70			2							1	4	17	A
6	70			2						1	1	2	10	A
7	69			3							2	2	18	A
8	69			2						1	1	3	16	A
9	69			2								2	12	A
10	69			3						2	1	2	19	A
11	69			2						1		2	13	A
12	69			3						5		2	21	B
13	70			2	1-m					2		6	22	B
14	70			2						1		4	17	A
15	70			1						1		3	11	A
16	70			2						2		3	16	A

Finished Fabric Inspection Report (4 point system)



Chaity Composite Ltd.

Fabric Department

AIC P-2

ecl-241/19 **Fabric Inspection Report (4 Point System)**

Buyer : <u>HBM</u>	Order No. : <u>220797-1670</u>	Composition :	Required Width : <u>65 cuttable</u>
Batch No. : <u>2778/19</u>	Required GSM : <u>140</u>	Inspected Roll :	
Colour : <u>Grey Dusty Light</u>	Fabric Weight : <u>585.24</u>	Accepted Roll :	
Fabrication: <u>51</u>	Total Roll :	Rejected Roll :	

Date: 18.3.19

Roll No.	Roll Weight (kg)	Roll Length (Mtr.)	Width Inch.	GSM	Spinning Fault				Knitting Fault				Processing Fault				Others Fault	PTS	PTS/100 Sq.MTR	C	A
					Barrie	Yarn Conta	SLUS	NEPS	Hole	Needle Mark	Miss Yarn	Oil Stain	Lycra Missing	Crease Mark	Softener Stain	Color Spot					
17			70															18			
18			11															12			
19			70							1-m					1			19			
20			11							2-m						✓		19			
21			11															21			
22			70															20			
23			11												1-m	✓		20			
24			70															12			
25			11												2-m			14			
26			11															20			
27																					
28																					
29																					
30																					
31																					
32																					

01.

4-Point System	Acceptance Calculation
0-3"	1 Up to 20 A = Acceptable
>3"-6"	2 21 to 28 B = Acceptable
>6"-9"	3 Above 28 = Rejected
>9"	4
Holes<1"	2
Holes>1"	4

02. $\frac{R. Dia \times RGSM \times 39.37}{1550 \times 1000} = \text{Constant.}$

03. $\frac{\text{Roll Weight}}{\text{Constant}} = \text{Roll Length (In mtr)}$

04. $\frac{\text{Point/100 mtr}}{=} = \frac{\text{TTL PTS} \times 100 \times 39.37}{\text{Roll Length (Mtr)} \times \text{Cuttable Width (Inch)}}$

monia
Inspector

Incharge

Manager

Figure: 3.2-2 Finished Fabric Inspection Report.

Table 3.2-2 Finished Fabric Inspection Report (4 point system)

Chaity Composite Ltd
 Fabric Department
 Fabric Inspection Report (4 point system)

Buyer Name: H&M

Date: 18.03.19

Order number: 220737-1670

Required Width: 65 cut able

Batch Number: 2778/19

Fabric GSM: 140

Color: Grey Dusty Light

Fabric Weight: 585.24


Fabrication: S/J

Rol l No.	Widt h (Inch)	GS M	Spinnin g Fault Yarn contra	Knitting Fault				Processing Fault			Point s	Class A/B/ C
				Hol e	Needl e Mark	Mis s Yar n	Colo r Spot	Enzym e Dust	Dust y Spot	Pin Hol e		
17	70			3				1-m		3	18	A
28	70			2						2	12	A
39	70			3	1-m			1		3	19	A
20	70			2	2-m			3		4	19	A
21	70			3				3		3	21	B
22	70			3				2		3	20	A
23	70			2				1-m		6	20	A
24	70			2						2	12	A
25	70			2				2-m		3	14	A
26	70			3				2		3	20	A
27	70											
28												

Finished Fabric Inspection Report (4 point system)

M/c SP: 35
SK SP: 30

A/C P-1



Chaity Composite Ltd.

Fabric Department

Fabric Inspection Report (4 Point System)

Buyer : HBM Date: 18.3.19
 Order No : 220737-1670 Composition :
 Batch No. : 2813/19 Required GSM : 140 Required Width : 57 CUTTABLE
 Colour : Gray DUSTY LIGHT Fabric Weight : 608 Inspected Roll :
 Fabrication: 517 Total Roll : Accepted Roll :
 Rejected Roll :

Roll No.	Roll Weight (kg)	Roll Length (Mtr.)	Width Inch.	GSM	Spinning Fault					Knitting Fault					Processing Fault					Others Fault	PTS	PTS/100 Sq.MT		
					Barrie	Yarn Conta	SLUS	NEPS	Hole	Needle Mark	Miss Yarn	Oil Stain	Lycra Missing	Crease Mark	Softener Stain	Color Spot	Joint-4	Bowing	Pin Holl Others Fault					
1			60							11							1/5	1/5	1/1			13		
2			11							11									1			10		
3			11							1												9		
4			60.5							11									1		1/1	12		
5			4							4											1/1	12		
6			4							1/1									4		1/1	18		
7			4							1											1/1	10		
8			60.5							1											1/1	10		
9			61							11											1/1	14		
10			60							11											1	1/1	13	
11			11							11											1/1	1/1	16	
12			11							1												1/1	8	
13			60							11											1	1/1	13	
14			60							11												1/1	12	
15			60.5							1/1												1/1	18	
16			11							1/1												1/1	21	

01. 4-Point System Acceptance Calculation

0-3"	1	Up to 20	A = Acceptable
>3"-6"	2	21 to 28	B = Acceptable
>6"-9"	3	Above 28	= Rejected
>9"	4		
Hole < 1"	2		
Hole > 1"	4		

02. $\frac{R.Dia \times R.GSM \times 39.37}{1550 \times 1000} = \text{Constant.}$

03. $\frac{\text{Roll Weight}}{\text{Constant}} = \text{Roll Length (In mtr)}$

04. $\frac{\text{Point/100 mtr}}{\text{Roll Length (Mtr)} \times \text{Cuttable Width (Inch)}} = \frac{\text{TTL PTS} \times 100 \times 39.37}{\text{Roll Length (Mtr)} \times \text{Cuttable Width (Inch)}}$

Shrinkage	
Length	
Width	
Spirality	
Shade	

Inspector: monir Incharge: _____

Figure: 3.2-3 Finished Fabric Inspection Report

Table 3.2-3 Finished Fabric Inspection Report (4 point system)

Chaity Composite Ltd
 Fabric Department
 Fabric Inspection Report (4 point system)

Buyer Name: H&M

Date: 18.03.19

Order number: 220737-1670

Required Width: 57 cut able

Batch Number: 2813/19


Fabric GSM: 140

Color: Grey Dusty Light

Fabric Weight: 608

Roll No.	Width (Inch)	GSM	Spinning Fault		Knitting Fault			Processing Fault			Points	Class A/B/C
			Yarn Contra	naps	Hole	Needle Mark	Miss Yarn	Color Spot	Dusty Spot	Pin Hole		
1	60				2				1	2	13	A
2	60				2					1	9	A
3	60				1				1	2	10	A
4	60.5				2					2	12	A
5	60.5				2					2	12	A
6	60.5				3				2	2	18	A
7	60.5				1					3	10	A
8	60.5				1				2	2	10	A
9	61				2				2	2	14	A
10	60				2				1	2	13	A
11	60				2				2	3	16	A
12	60				1					2	8	A
13	60				2				1	2	13	A
14	60				2					2	12	A
15	60.5				3				2	2	18	A
16	60.5				3				2	3	21	B

Finished Fabric Inspection Report (4 point system)



Chaity Composite Ltd.
Fabric Department
Fabric Inspection Report (4 Point System)

Date: 18.3.19
HCP-2

Order No: 220737-1670
Batch No: 28/3/19
Colour: Grey Dusty Light
Fabrication: 51

Composition: _____
Required GSM: 140
Fabric Weight: 608
Required Width: 57 Cuttable
Inspected Roll: _____
Accepted Roll: _____
Rejected Roll: _____

Roll No.	Roll Weight (kg)	Roll Length (Mtr.)	Width Inch.	GSM	Spinning Fault				Knitting Fault				Processing Fault				Others Fault	PTS	PTS/100 Sq.MTR	Class A/B/C	
					Barrie	Yarn Conta	SLUS	NEPS	Hole	Needle Mark	Miss Yarn	Oil Stain	Lycra Missing	Crease Mark	Softener Stain	Color Spot					Joint-4
17			60.5																14		
18			11																8		
19			60																12		
20			11																22		
21			60.5																16		
22			60																19		
23			11																14		
24			11																15		
25			60																20		
26			4																14		
27			11																20		
28			60																18		
29																					
30																					
31																					
32																					

01.

4-Point System	Acceptance Calculation
0-3"	1 Up to 20 A = Acceptable
>3"-6"	2 21 to 28 B = Acceptable
>6".9"	3 Above 28 = Rejected
>9"	4
Hole<1"	2
Hole>1"	4

02. $\frac{R.Dia \times RGSM \times 39.37}{1550 \times 1000} = \text{Constant.}$

03. $\frac{\text{Roll Weight}}{\text{Constant}} = \text{Roll Length (In mtr)}$

04. $\frac{\text{Point/100 mtr}}{\frac{TTL PTS \times 100 \times 39.37}{\text{Roll Length (Mtr)} \times \text{Cuttable Width (Inch)}} = \text{Constant.}$

Shrinkage	
Length	
Width	
Spirality	
Shade	

Inspector: Monir Incharge: _____

Figure: 3.2-4 Finished Fabric Inspection Report

Table 3.2-4 Finished Fabric Inspection Report (4 point system)

Chaity Composite Ltd
Fabric Department
Fabric Inspection Report (4 point system)

Buyer Name: H&M

Date: 18.03.19

Order number: 220737-1670

Required Width: 57 cut able

Batch Number: 2813/19

Fabric GSM: 140

Color: Grey Dusty Light

Fabric Weight: 608

Roll No.	Width (Inch)	GSM	Spinning Fault	Knitting Fault			Processing Fault				Points	Class A/B/C
			Yarn Contra	Hole	Needle Mark	Oil Stain	Color Spot	Enzyme Dust	Dusty Spot	Pin Hole		
17	60.5			2					2	2	14	A
18	60.5			1					2	1	8	A
19	60			2						2	12	A
20	60			3					2	4	22	A
21	60.5			2				1	1	3	16	A
22	60			3				2	1	2	19	A
23	60			2						3	14	A
24	60			2				1	2	2	15	A
25	60			3					2	3	20	A
26	60			2					2	2	24	B
27	60			3					2	3	20	
28	60			3					2	2	18	

Table 3.2-5 Finished Fabric inspection Report

**Summery Table for
Chaity Composite Ltd:**

Date: 18. 03. 19

Roll No.	Knitting Faults		Processing Faults		
	Hole	Needle Mark	Enzyme Dust	Dirty Spot	Pin Hole
1	2		2		2
2	2		2		1
3	3	1-m			2
4	2				2
5	2			1	4
6	2		1	1	2
7	3			2	2
8	2		1	1	3
9	2				2
10	3		2	1	2
11	2		1		2
12	3		5		2
13	2	1-m	2		6
14	2		1		4
15	1		1		3
16	2		2		3
17	3		1-m		3
18					
19					
20	2	2-m	3		4

21	3		3		3
22	3		2		3
23	2		1-m		6
24	2				2
25	2		2-m		3
26	3		2		3
28	2				2
39	3	1-m	1		3
Total Defect:	60	5-m	4-m, 31	6	74

3.2.1 Graphical Analysis

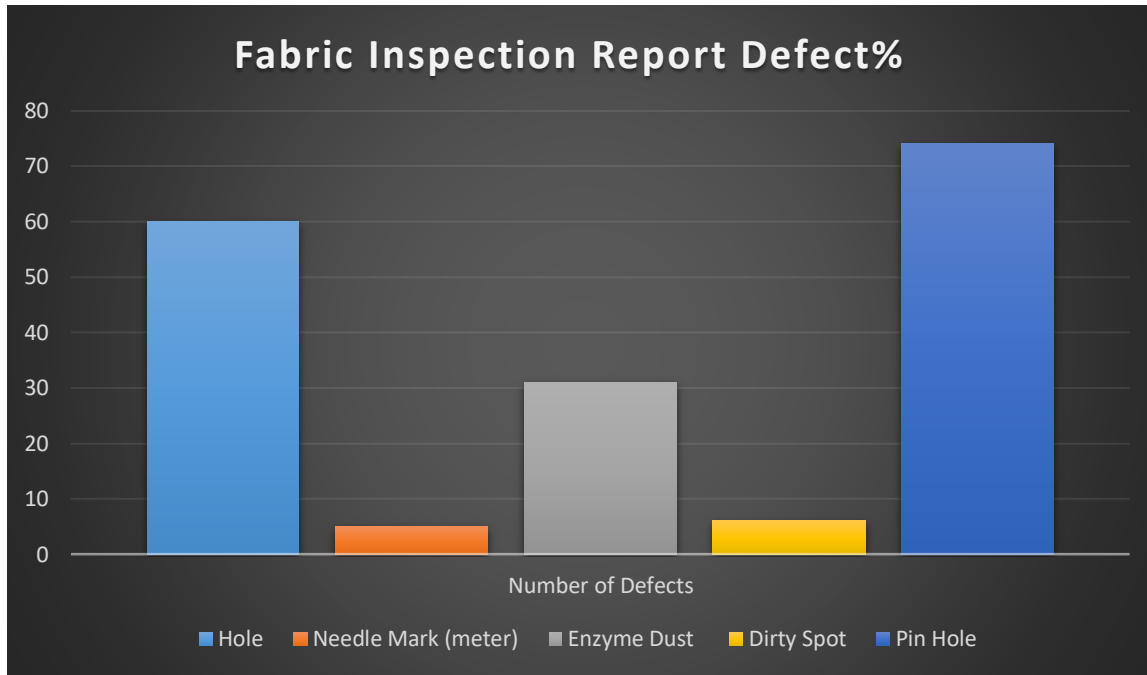


Figure: 3.2-5, Buyer: H&M, Style: SS T-shirt (Table: 3.2-5)

3.3 Inspection Report

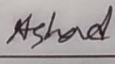
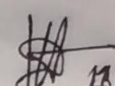
DAZ INTERNATIONAL		INSPECTION REPORT		IN-PROCESS / FINAL				
				1	2	3	4	5
DATE: 13.03.19	INSPECTOR: Donald	SEASON: 19	BUYER Bizzbee					
ORDER NO. 367743-1	STYLE NO. 718836	QTY. 1000 Ship (1010 Pcs)	DESCRIPTION B20-TEE-shirts B1					
VENDOR'S NAME: DAZ Int		SUB-CONTRACTOR'S NAME Fatullah Apparels						
PERSON CONTACT Md. Shohel 01834161655		PERSON CONTACT MD. Ashad 01711786801						
MATERIAL/PRODUCTION STATUS		FABRICS/ YARNS		ACCEPT	REJECT			
MAIN LABEL / HANGTAG / PXS- TAG	OK / NOT OK	COLOUR	OK / NOT OK	2.5	-			
SIZE/ CONTENTS	OK / NOT OK	PRINT	OK / NOT OK	05	06			
COLOUR / SIZES ASSORTMENT	OK / NOT OK	HANDFEELS	OK / NOT OK	4.0	-			
POLYBAG/ INNER BOX/ MASTER POLY	OK / NOT OK	WASHING	OK / NOT OK	07	08			
WORKMANSHIP DESCRIPANCES:				MAJOR	MINOR			
Old spot (S), (M, L)				1	2			
Fabrics hole (M, XL)				2	-			
poor neck shape (M, L, XL)				1	2			
Dirty stain (S, M, L)				1	2			
MEASUREMENT / COMPONENT & TRIM								
Fabrics shade does not match with the Lab slip								
ORD. WT. 160 GMS/LBS/DZ								
PRD. WT. 155 GMS/LBS/DZ								
+1.5 GMS/LBS/DZ				4	6			
PCS INSPECTED	% TO SHIPMENT	CARTONS INSP TD (GIVE CTN NOS)	TTL GMTS WITH MAJOR DEFECTS (% TO PCS INSP)	TTL GMTS WITH MINOR DEFECTS (% TO PCS INSP)				
80 pcs	extra 10 pcs	1, 6, 11, 16, 20						
RELEASE <input checked="" type="checkbox"/>	HOLD <input type="checkbox"/> FOR BUYER APPROVAL	RE-INSPTN <input type="checkbox"/>	REJECT <input type="checkbox"/>	OTHERS <input type="checkbox"/>				
Q. C. COMMENTS / ACTION TAKEN If buyer will give any claim or discount for fabrics shade issue It's all responsibility of fatullah Apparels.								
REMARKS: VENDOR MUST TAKE FULL RESPONSIBILITY IF SHIPMENT SHIPPED WITH RE-INSPECTION.				NEXT INSPECTION DATE:				
CARTON MEASUREMENT 60 X 40 X 20 CMS				NT. WT.: 120 KGS. GR. WT.: 140 KGS.				
SHIPPING MARK: Ok				 VENDOR / FTY. REPRESENTATIVE DATE: 13.03.2019				
 13-3-19 INSPECTED BY:								

Figure: 3.3-1 Inspection Report

Table 3.3-1 Inspection Report

DAZ INTERNATIONAL

INSPECTION REPORT

IN- PROCESS/FINAL

1	2	3	4	5
---	---	---	---	---

DATE: 13.04.19	INSPECTOR: Donald	SEASON: 19	BUYER: BIZZBEE	
ORDER NO: 367743-1	STYLE NO: 718836	QTY: 1000, ship(1010 piece)	DESCRIPTION: B20-TEE Shirts Boy	
VENDORS NAME: Daz International		SUB-Contractors Name: FATULLAH APPARELS		
Person Contact: Md, Shohel 01837161655		PERSON CONTACT: Md Asad, 01711786801		
MATERIALS/PRODUCTION STATUS:		FABRICS/YARN:	ACCEPT	REJECT
MAIN LABEL/HANGTAG/PXS-TAG: OK/NOT OK		COLOUR: OK/NOT OK	2.5	-----
SIZE/CONTENTS: OK/NOT OK		PRINT: OK/NOT OK	05	06
COLOUR/SIZE ASSORTMENT: OK/NOT OK		HANDFEELS: OK/NOT OK	4.0	-----
POLYBAG/INNER BOX/MASTER POLY: OK/NOT OK		WASHING: OK/NOT OK	07	08
WORKMANSHIP DESCRIPANCES:			MAJOR	MINOR
OIL SPOT-(S, M, L)			1	2
FABRIC HOLE: (M, XL)			2	----
POOR NECK SHAPE: (M, L, XL)			1	2
DIRTY STAIN: (S, M, L)			---	2
MEASUREMENT/COMPONENT & TRIM:				
FABRICS SHADE DOES NOT MATCH WITH THE LAB DIP				
ORD. WT. 160 GMS/LBS/DZ				
PRD. WT. 155 GMS/LBS/DZ				
+ / - : 5 GMS/LBS/DZ			4	6


PCS INSPECTED 80 piece	% TO SHIPMENT 10 piece	CARTONS INSPDT (GIVE CTN NOS) 1,6,11,16,20	TTL GMTS WITH MAJOR DEFECTS (% TO PCS INSP)	TTL GMTS WITH MINOR DEFECTS (% TO PCS INSP)
--------------------------------------	--------------------------------------	--	--	--

Q.C. COMMENTS / ACTION TAKEN: If Buyer will give any claim or discount for fabrics shade issue his all responsibility of fatullah apparels.

REMARKS: VENDOR MUST TAKE FULL RESPONSIBILITY IF SHIPMENT SHIPPED WITH RE-INSPECTION.	NEXT INSPECTION DATE:
CARTON MEASUREMENT: 60 × 40 × 20 CMS NT. WT: 120 KGS. GR. WT: 140 KGS.	

SHIPPING MARK	ASHAD
OK	VENDOR/FTY. REPRESENTATIVE
INSPECTED BY: Donald	DATE: 13.03.2019

Finished Fabric Inspection Report



Fatullah Apparels

Finish Fabric Inspection Reports

544

Buyer: DAZ	Batch No: 57188	Req. Dia: 185	Date: 23-02-19
Order: 716240	Finish Wt:	Req. GSM: 320	Process Loss:
Color: orange		Fabric Type: piece	

Roll No	A/gsm	A/Dia	Roll Wt.	Yarn Faults				Knitting/Construction Faults						Dyeing Faults				Finishing				Total Point	Total Length	Point/100sq yds	Grade	Remarks				
				Slub	Thick & Thin	Edg Yarn Com-Mantion	De ad Cotton	Loop	Star Mark/Patta	Oil Spot/Stain	Lycr a Out	Sinker Mark	Hole	Knot s	Needl e Mark	Stripe/ Cut	Set off	Miss Yarn	Dyein g Spot	Creas e Mark	Softn er Spot						Hole	Rub Mark	Comp action Mark	Shani ng Mark
10	338	180	31.5								2																246	56	225	reject
24		181	18.3																								58	34	86	reject
2		185	29.9																								195	55	174	reject
30		181	31.9			3																					78	55	72	reject

Size of defect	Penalty
3 inches or less	1 points
Over 3 but not over 6	2 points
Over 6 but not over 9	3 points
Over 9 inches	4 points

Comments

DIA to dia uneven all roll rejection.

[Signature]
23.02.19

Shrinkage Report	
Length %	
Width %	
Spirality %	

Accepted Points	
Up To 20 Points	A
21 to 29 Points	B
30 to 39	C
40 to Above	Reject

Points per 100 yard Square =

Total points Scored in Roll X 36 inch

..... X100

Fabric width/inches X Total length yard inspected

[Signature]
Inspection By

[Signature]
Quality Supervisor

Quality Manager

[Signature]
G.M.

Developed by PACE Professional Services

Figure: 3.3-2 Finished Fabric Inspection Report.

Table 3.3-2 Finishd Fabric Inspection Report

Fatullah Apparels
Finished Fabric Inspection Report

BUYER NAME: DAZ Order No: 716240 Color: Orange

Batch No: 57188

Req. Dia	185
Req. GSM	320
Fabric Type	Fleece

Date: 25. 02. 19

Roll No:	Gs m	A/ Dia	Roll Wt.	Yarn Fault	Knitting Faults				Dyeing Fault	Finishing Fault	Total point	Total Length	Point /100s q yds.	Gr ade
					Fly yarn	Oil spot	Sinker mark	Hole						
10	338	180	31.5		2	56	3	2			246	56	223	rej ect
24		181	18.3			34	2	2	2		58	34	86	rej ect
2		185	29.9			55	2	3		304	195	55	174	rej ect
30		181	31.9	3		55	3	2			78	55	72	rej ect

Finished Fabric Inspection Report

Fatullah Apparels
Finish Fabric Inspection Reports

542

Buyer DAZ	Batch No: 57188	Req. Dia 185	Date 24-02-192
Order FIG 240	Finish Wt	Req. GSM 320	Process Loss
Color orange		Fabric Type fleece	

Roll No	A/gsm	A/Dia	Roll Wt.	Yarn Faults																Knitting/Construction Faults						Dyeing Faults						Finishing					Total Points	Total Length	Point/100sq yds	Grade	Remarks
				Slub	Thick & Thin	ELY Yarn Com-Mantion	Dead Cotton	Loop	Star Mark/Patta	Oil Spot/Stain	Lycra Out	Sinker Mark	Hole	Knots	Needle Mark	Stripe/Cut	Set off	Miss Yarn	Dyeing Spot	Creease Mark	Softener Spot	Hole	Rub Mark	Compaction Mark	Shaning Mark	Scum Abration Mark	Dirty Spot	Hole / setup													
23	182	339																												89	6371		reject								
3	185	313																												83	5565		reject								
16	180	323		2																										77	6264		reject								
5	182	318																												93	5781		reject								
4	182	321																												76	5767		reject								

Size of defect	Penalty
3 inches or less	1 points
Over 3 but not over 6	2 points
Over 6 but not over 9	3 points
Over 9 inches	4 points

Comments

Dia to dia uneven
all roll rejection.

Shrinkage Report	
Length %	
Width %	
Spirality %	

Accepted Points	
Up To 20 Points	A
21 to 29 Points	B
30 to 39	C
40 to Above	Reject

Points per 100 yard Square =

Total points Scored In Roll X 36 inch

..... X100

Fabric width/inches X Total length yard inspected

Inspection By: Pined Quality Supervisor: 24/02/19 Quality Manager: _____ G.M.: _____

Developed by PACE Professional Services

Figure: 3.3-3 Finished Fabric Inspection Report

Table 3.3-3 Finished Fabric Inspection Report

Fatullah Apparels

Finished Fabric Inspection Report

BUYER NAME: DAZ
Order No: 716240
Color: Orange

Batch No: 57188

Req. Dia	185
Req. GSM	320
Fabric Type	Fleece

Date: 24. 02. 19

Roll No:	A/ Dia	Roll Wt.	Yarn Fault	Knitting Faults				Dyeing Fault	Finishing	Total point	Total Length	Point/ 100sq yds.	Grade
				Fly yarn	Oil spot	Sinker mark	Hole						
23	182	33.7		2	63	3	2		1	89	63	71	reje ct
3	185	31.3			55	3	2		1	83	55	65	reje ct
16	180	32.3	2		62	2	1		1	77	62	64	reje ct
5	182	31.8		20	57	2	2			93	57	81	reje ct
4	182	32.1		3	57	3	1			76	57	67	reje ct

3.3.1 Pre-Production Sample of Bizzbee Buyer

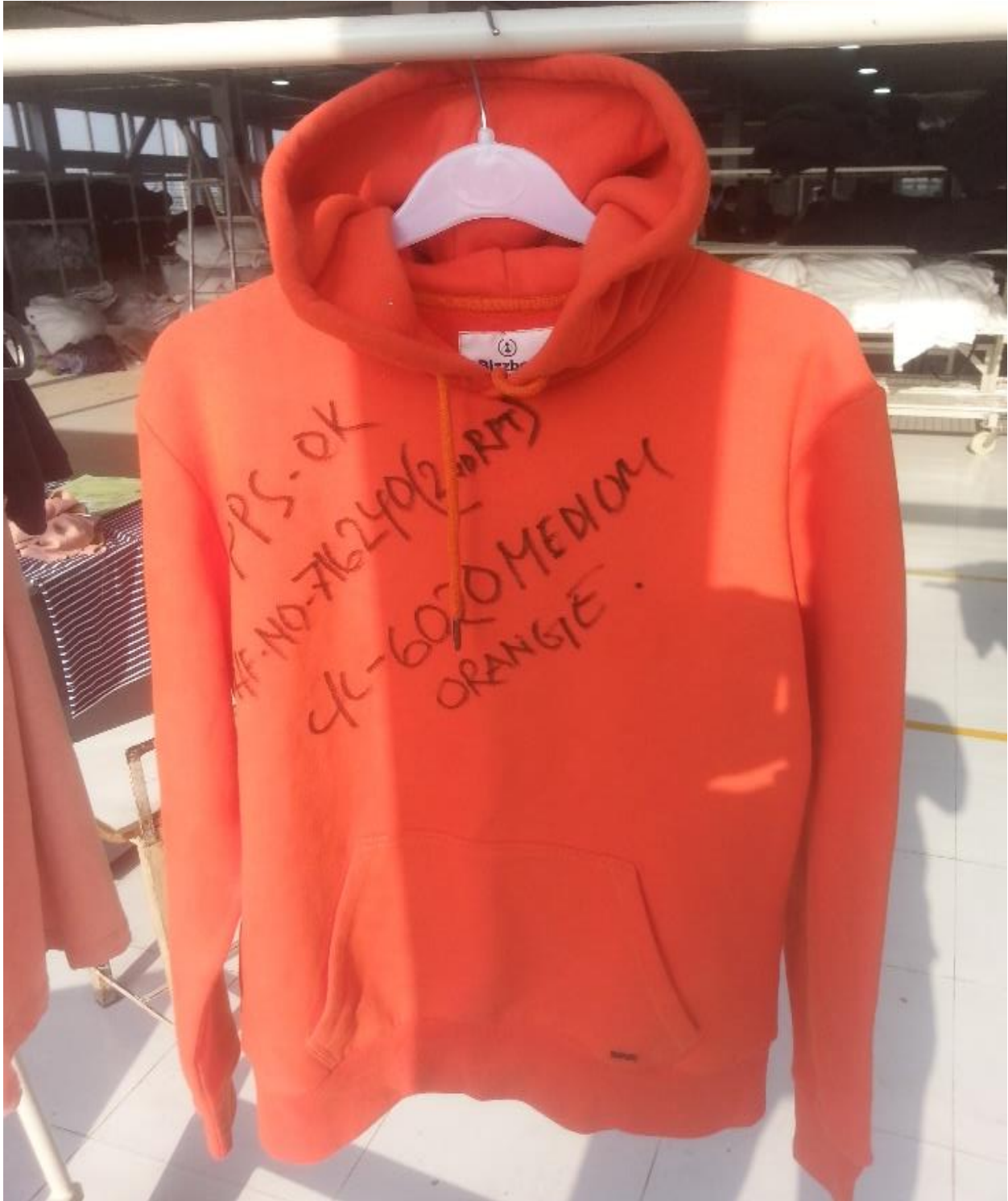


Figure: 3.3.1-1 Picture of hoody jacket

Finished Fabric Inspection Report

481			Finish Fabric Inspection Reports				
Buyer	DAZ	Batch No:	56682			Req. Dia	165
Order	#13495	Finish Wt				Req. GSM	350
Color	honey				Fabric Type	Fleece	
		Date	31-01-1985			Process Loss	

Roll No	A/gsm	A/Dia	Roll Wt.	Yarn Faults						Knitting/Construction Faults						Dyeing Faults						Finishing			Total Point	Total Length	Point/100sq yds	Grade	Remarks						
				Slub	Thick & Thin	Yarn Com-Mantion	De ad Cot-ton	Loop	Star Mark/Patta	Oil Spot/Stain	Lycr a Out	Sinker Mark	Hole	Knot s	Needle Mark	Stripe/ Cut	Set off	Miss Yarn	Dyein g Spot	Creas e Mark	Softn er Spot	Hole	Rub Mark	Comp action Mark						Shani ng Mark	ShiN Abfatio n Mark	Dirty Spot	Hole / setu p		
25		164	23.6																																
32		161	17.5																																
27		162	11.6																					3											
17		163	11.0																																
4		165	15.0																							3									
3		163	14.4																							1	3								
4		163	21.4																							3									
8		162	22.9																																
2		168	16.9																																
13		163	20.2																																
5		168	19.2																																

Size of defect	Penalty
3 inches or less	1 points
Over 3 but not over 6	2 points
Over 6 but not over 9	3 points
Over 9 inches	4 points

Comments	

Shrinkage Report	
Length %	
Width %	
Spirality %	

Accepted Points	
Up To 20 Points	A
21 to 29 Points	B
30 to 39	C
40 to Above	Reject

Points per 100 yard Square =	
Total points Scored in Roll X 36 inch	
.....X100	
Fabric width/inches X Total length yard inspected	

Inspection By	Quality Supervisor	Quality Manager	G.M.
---------------	--------------------	-----------------	------

Developed by PACE Professional Services

Figure: 3.3-4 Finished Fabric Inspection Report

Table 3.3-4 Finished Fabric Inspection Report

Fatullah Apparels

Finished Fabric Inspection Report

BUYER NAME: DAZ
Order No: 713495
Color: honey

Batch No: 56682

Req. Dia	165
Req. GSM	350
Fabric Type	Fleece

Date: 31. 01. 19

Roll No:	A/ Dia	Roll Wt.	Yarn Fault	Knitting Faults			Dyeing Fault	Finishing		Total Length	Total Point	Grade
				Oil spot	Star mark	Hole		Set off	Abra sion mark			
25	164	23.6			3	2		3		46	32	C
32	161	17.5			2	2				35	16	A
27	162	11.6			2	2			3	21	19	A
17	163	11.0	2		3	2		1	3	22	29	B
3	163	14.4			1	2		3		31	24	B
4	165	21.4			3	2		1		42	20	A
8	162	22.9			3	2		1		44	36	C
2	168	16.9			2	2		1		34	20	A
13	163	20.2			3	2				42	20	A
5	168	19.2		2m				1		37	40	D

3.3.2 Pre-Production Sample of Bizzbee Buyer

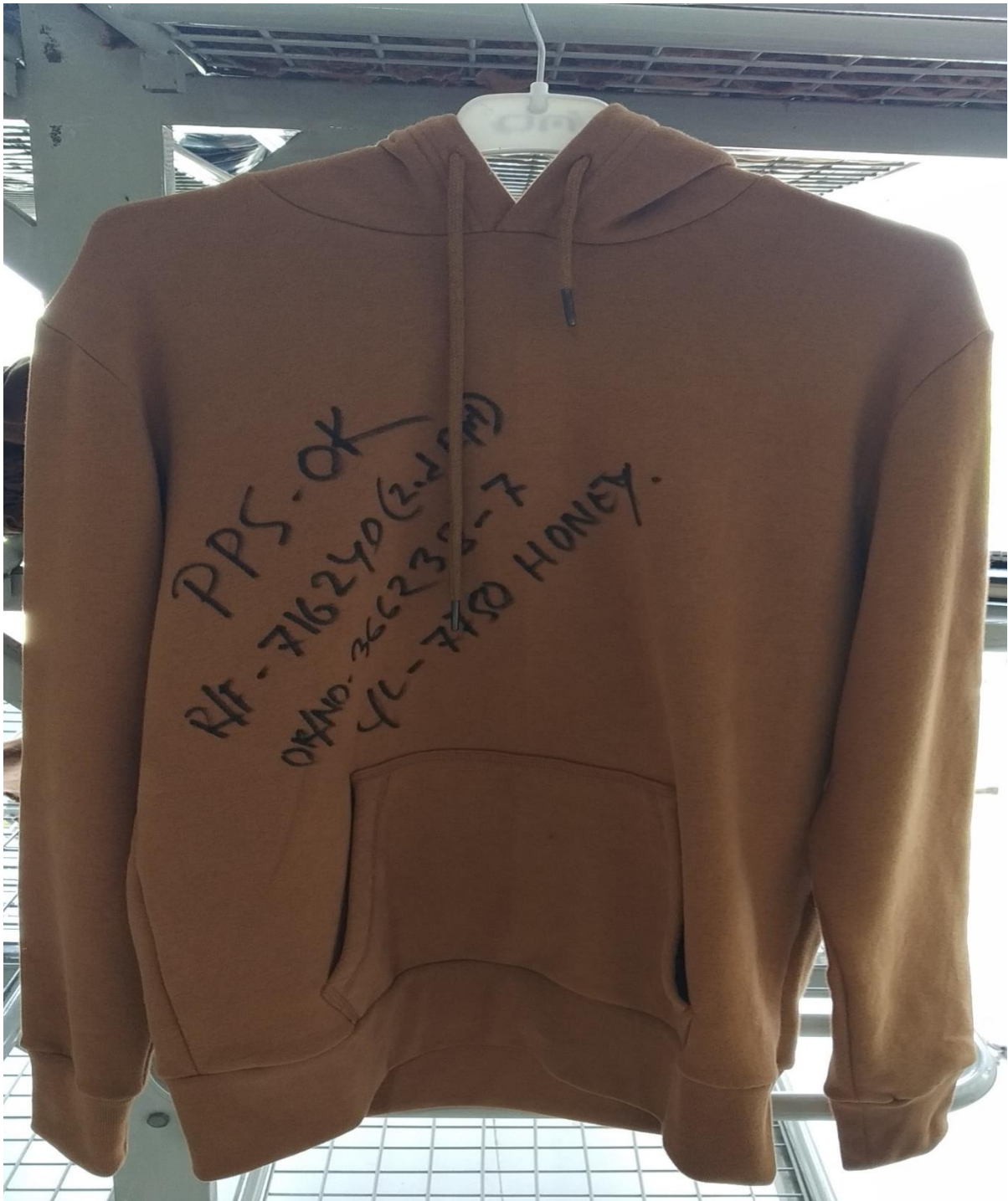


Figure: 3.3.2-1 Picture of Hoody Jacket

Finished Fabric Inspection Report

F. APP. 104



Fatullah Apparels

Finish Fabric Inspection Reports

Buyer: <u>DAZ</u>	Batch No: <u>57437</u>	Req. Dia: <u>155</u>	Date: <u>19-03-2019</u>
Order: <u>708585</u>	Finish Wt: <u>25.65</u>	Req. GSM: <u>350</u>	Process Loss: _____
Color: <u>Anthra</u>		Fabric Type: <u>FIRCC</u>	

Roll No	A/gem	A/Dia	Roll Wt.	Yarn Faults			Knitting/Construction Faults							Dyeing Faults					Finishing				Total Points	Total Length	Point/60m yds	Grade	Remarks		
				Slub	Thick & Thin	EN Yarn Com-Mention	Dead Cotton	Loop	Star Mark/Patta	Oil Spot/Stain	Lyer A Out	Slaker Mark	Hole	Knot x	Needle Mark	Stripes/Cut	Set off	Mix Yarn	Dyein g Spot	Crease Mark	Softn er Spot	Hole						Rub Mark	Comp action Mark
07	152	280				3																			15	53	7	A	
12	153	170																							2	36	13	A	
6	153	215				2																			14	56	15	A	
20	153	228																							12	60	12	A	
19	153	218																							8	44	11	A	
L	153	265								1															16	54	17	A	
22	153	174																							12	37	10	A	
B	151	155																							2	33	14	A	
F	153	150																							2	31	15	A	
BB	152	280								1															16	60	16	A	
11A	152	236																							8	40	10	A	

Size of defect	Penalty
3 inches or less	1 points
Over 3 but not over 6	2 points
Over 6 but not over 9	3 points
Over 9 inches	4 points

Shrinkage Report	
Length %	
Width %	
Spirality %	

Accepted Points	
Up To 20 Points	A
21 to 29 Points	B
30 to 39	C
40 to Above	Reject

Points per 100 yard Square =
Total points Scored in Roll X 36 inch
Fabric width/inches X Total length yard inspected

Figure: 3.3-5 Finished Fabric Inspection Report

Table 3.3-5 Finished Fabric Inspection Report

Fatullah Apparels

Finished Fabric Inspection Report

BUYER NAME: DAZ
Order No: 708585
Color: Anthra

Batch No: 57437

Req. Dia	155
Req. GSM	350
Fabric Type	Fleece

Date: 19. 03. 19

Roll No:	A/ Dia	Roll Wt.	Yarn Fault	Knitting Faults		Dyeing Faults		Finish ing	Total point	Total Length	Point/ 100sq yds.	Grade
				Fly yarn	Hole	Set off	Dyein g spot					
7	152	26.9	3		3				15	53	17	A
12	153	17.9			2				8	36	13	A
6	153	27.5	2		3				14	56	15	A
20	153	28.8			3				12	60	12	A
19	153	21.8			2				8	44	11	A
L	153	26.5		1	3				16	56	17	A
22	153	17.4			3				12	37	19	A
B	151	15.5			2				8	33	14	A
F	153	15.0			2				8	31	15	A
BB	152	28.9		1	3				16	60	14	A
11A	152	23.6			2				8	49	9	A

Table 3.3.3 Finished Fabric Inspection Report

Summery Table for Fatullah Apparels

Date: 19. 03. 19

Roll No:	Yarn Fault		Knitting Faults			Dyeing Fault	Finishing	
	Oil spot	Fly yarn	Sinker mark	Hole	Set off	Hole	Abrasion mark	Dirty Spot
1		3		3	2		3	
2			63	3	2		1	
3	2		62	2	1		1	
4	20		57	2	2			
5	2		56	3	2			
6			34	2	2	2		
7		2						
8		3			3			
9					2			
10		2			3			
11					3			
12					2			
13				1	3			
14					3			
15					2			
16					2			

17				1	3			
18				2	2			
19				2	2			3
20	2			3	2		1	3
21				3	2		3	
22				1	2		3	
23				3	2		1	
24				2	2		1	
25				3	2			
26			2m				1	
Total								
Defect:	26	10	2m, 272	36	53	2	15	6

3.3.3-1 Graphical Analysis

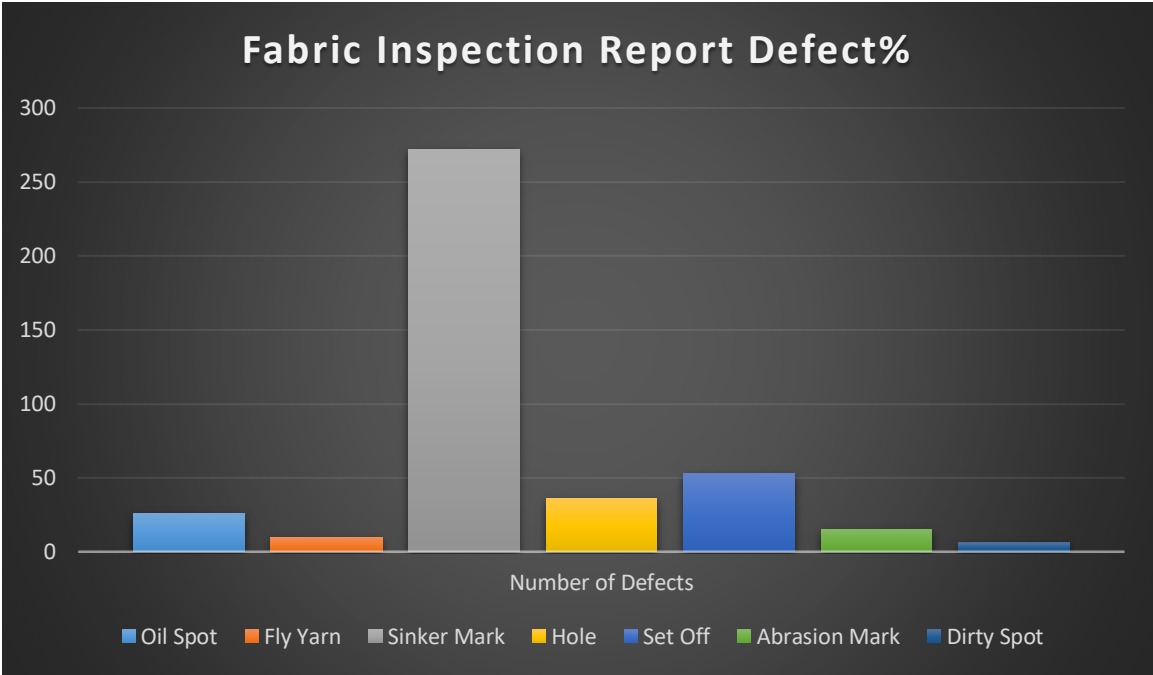


Figure: 3.3.3-1, Buyer: Bizzbee, Style: Hoody Jacket

Q.C Garments Inspection Report in Sewing Section

Style No. : 307863		Quality Control Department										Date : 12/12/19
Po No. : T-SHIRTS		100% End Line/Finishing Inspection Report										Color : GREY
Item :		Line : 10										
	DESCRIPTION	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	TOTAL
1	SKIP STITCH ✓		1						1	1		5
2	BROKN STITCH ✓											
3	DOWN STITCH ✓											
4	OPEN SEAM ✓	11	11	11	11	1	1	111	111	11	11	20
5	TENSION PROBLEM ✓											
6	JOINT UNMATCHING ✓										111	3
7	UNEVEN STITCHING ✓											
8	PLEAT E ✓	111	1111	11	1111	111	1111	111	1111	111		30
9	GATERING AT NECK AREA ✓		1	1			11	1				5
10	GATHERING AT ARMHOLE ✓											
11	GATHERING AT SIDE SEAM ✓											
12	GATHERING/IMPROPER ZIPPER JOINT ✓											
13	GATHERING AT WAIST ✓											
14	BAR TACK MISSING ✓											
15	TUCK/PRESS TUCK MISSING ✓										1	1
16	IMPROPER TUCK/PRESS TUCK ✓											
17	PART MISTAKE ✓											
18	PART SHADING ✓											
19	POCKET SHADING ✓											
20	NECK RIB/PIPING SHADING ✓											
21	DRAW CORD SHADING ✓											
22	SLEEVE SHADING ✓											
23	PLACKET SHADING ✓											
24	IMPROPER/SLANTED POCKET JOINT ✓											
25	POCKET UP DOWN ✓											
26	PLACKET/PLACKET BOX UN-EVEN ✓											
27	UP DOWN PLACKET ✓											
28	U NEVEN/SLANTED PLACKET ✓											
29	HOLE DISPLACE ✓											
30	BUTTON HALF STITCH ✓											
31	MAIN/CARE LABEL REVERSE ✓											
32	CENTER OUT/SLANTED LABEL ✓											
33	LABEL ATTACH AT WRONG SIDE ✓											
34	LABEL MISSING ✓		11	1		111	11	1		11	11	13
35	OPEN SEAM AT LABEL ✓											
36	LABEL MISTAKE ✓											
37	SIZE MISTAKE ✓											
38	WAIST BAND MISTAKE ✓											
39	PRINT PROBLEM ✓											
40	EMBROIDERY PROBLEM ✓											
41	SHOULDER POINT UP DOWN ✓											
42	SHOULDER/HALA POINT UP ✓											
43	BOTH SHOULDER UP DOWN ✓											
44	BOTH SLEEVE UP DOWN ✓											
45	ARMHOLE POINT UP DOWN ✓	11	1	11	11	111		11		111	11	18
46	SIDE SLIT UNEVEN/UP DOWN ✓											
47	CROSS POINT UP DOWN ✓											
48	RAWCORD UP DOWN ✓											
49	BOTH SIDE LEG UP DOWN ✓											
50	OFF SHAPE AT ARMHOLE ✓											
51	POOR NECK SHAPE ✓											
52	NECK RIB WIDTH UN - EVEN ✓											
53	IMPROPER SLEEVE JOINT ✓											
54	OFF SHAPE AT SIDE SEAM ✓											
55	UNEVEN HEM ✓											
56	BOTTOM HIGH LOW ✓											
57	PUCKERING AT HEM ✓											
58	CHELLY REVERSE ✓											
59	TWISTING ✓											
60	UNCUT THREAD ✓											
61	RAWEDGE ✓											
62	UNMATCHING STRIPE ✓											
63	SNAP BUTTON IMPROPER ATTACHING ✓											
64	UNEVEN FLY SHAPE ✓											
65	OIL STAIN ✓											
66	DIRTY MARK ✓											
67	NEEDLE CUT/ HOLE ✓											
68	NEEDLE MARK ✓											
69	FABRIC FAULT ✓											
70	SEWING REJECT ✓											
71	FABRIC REJECT ✓											
	TOTAL DEFECT	17	11	8	11	1	10	0	11	12	10	6

Figure: 3.4-1 Q.C Garments Inspection Report

Table 3.4-1 Q.C Garments Inspection Report in Sewing Section

Chaity Composite Ltd.
 Quality Control Department
 100% End Line/Finishing Inspection Report

Buyer: Red Label
 Item: T-Shirt
 Color: Grey

Style No: 307069
 Date: 04. 03. 19

SL NO	Description	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	Total
1	Skip Stitch		1			1	1		1	1		5
2	Broken Stitch											
3	Down Stitch											
4	Open Seam	2	2	2	2	1	1	3	3	2	2	20
5	Tension Problem											
6	Joint Un-matching										3	3
7	Uneven Stitching											
8	Pleat	3	4	2	4	3	4	3	4	3		30
9	Gathering at Neck Area	1		1			2	1				5
10	Gathering at Armhole											
11	Gathering at Side Seam											
12	Improper Zipper Joint											
13	Gathering at Waist											
14	Bar tack missing											
15	Press Tuck Missing										1	1
16	Improper Tuck											
17	Part Mistake											
18	Part Shading											
19	Pocket Shading											
20	Neck Rib											
21	Draw Cord Shading											
22	Sleeve Shading											
23	Placket Shading											
24	Improper Pocket Joint											
25	Pocket Up-Down											
26	Placket Box Uneven											
27	Up-Down Placket											
28	Uneven Placket											
29	Hole Displace											
30	Button Half Stitch											
31	Main/Care Label Reverse											

32	Center Out Label											
33	Label Attach at Wrong Side											
34	Label Missing		2	1		3	2	1		2	2	13
35	Open Seam at Label											
36	Label Mistake											
37	Size Mistake											
38	Waist Band Mistake											
39	Print Problem											
40	Embroidery Problem											
41	Collar Point Up-Down											
42	Shoulder Point Up											
43	Both Shoulder Up-Down											
44	Both Sleeve Up-Down											
45	Armhole Point Up-Down	2	1	2	2	3		2		4	2	18
46	Side Slid Uneven											
47	Cross Point Up-Down											
48	Draw Cord Up-Down											
49	Off Shape at Armhole											
50	Poor Neck Shape											
51	Neck Rib Width Uneven											
52	Improper Sleeve Joint											
53	Off Shade at Side Seam											
54	Uneven Hem											
55	Bottom High/Low											
56	Puckering at Hem											
57	Chelly Reverse											
58	Twisting											
59	Uncut Thread											
60	Raw edge Un-matching Strip											
61	Snap Button Improper Attaching											
62	Uneven Fly Shape											
63	Oil Stain											
64	Dirty Mark											
65	Needle Hole											
66	Needle Mark											
67	Fabric Fault											
68	Sewing Reject											
69	Fabric Reject	1			2	1		1	2			6
	Total Defect	7	11	8	8	11	10	9	8	17	10	101


Q.C Garments Inspection Report in Sewing Section

Buyer: Red Label

Style No.: 307063

Po No.: T-SHIRT

Item: T-SHIRT



Chaity Composite Ltd.

Quality Control Department

100% End Line/Finishing Inspection Report

QC/SE-CCL-22
Version-2

Date: 05-02-19

Color: GREEN

Line: 12

DESCRIPTION	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	TOTAL
1 SKIP STITCH											6
2 BROKN STITCH											4
3 DOWN STITCH											8
4 OPEN SEAM											15
5 TENSION PROBLEM											10
6 JOINT UNMATCHING											10
7 UNEVEN STITCHING											24
8 PLEAT E											3
9 GATERING AT NECK AREA											
10 GATHERING AT ARMHOLE											
11 GATHERING AT SIDE SEAM											
12 GATHERING/IMPROPER ZIPPER JOINT											
13 GATHERING AT WAIST											
14 BAR TACK MISSING											
15 TUCK/PRESS TUCK MISSING											
16 IMPROPER TUCK/PRESS TUCK											
17 PART MISTAKE											
18 PART SHADING											
19 POCKET SHADING											
20 NECK RIB/PIPING SHADING											
21 DRAW CORD SHADING											
22 SLEEVE SHADING											
23 PLACKET SHADING											
24 IMPROPER/SLANTED POCKET JOINT											
25 POCKET UP DOWN											
26 PLACKET/PLACKET BOX UN-EVEN											
27 UP DOWN PLACKET											
28 UNEVEN/SLANTED PLACKET											
29 HOLE DISPLACE											
30 BUTTON HALF STITCH											
31 MAIN/CARE LABEL REVERSE											
32 CENTER OUT/SLANTED LABEL											
33 LABEL ATTACH AT WRONG SIDE											
34 LABEL MISSING											12
35 OPEN SEAM AT LABEL											
36 LABEL MISTAKE											
37 SIZE MISTAKE											
38 WAIST BAND MISTAKE											
39 PRINT PROBLEM											
40 EMBROIDERY PROBLEM											
41 COLLAR POINT UP DOWN											
42 SHOULDER/HALA POINT UP											
43 BOTH SHOULDER UP DOWN											
44 BOTH SLEEVE UP DOWN											
45 ARMHOLE POINT UP DOWN											
46 SIDE SLIT UNEVEN/UP DOWN											10
47 CROSS POINT UP DOWN											
48 DRAWCORD UP DOWN											
49 BOTH SIDE LEG UP DOWN											
50 OFF SHAPE AT ARMHOLE											
51 POOR NECK SHAPE											
52 NECK RIB WIDTH UN - EVEN											
53 IMPROPER SLEEVE JOINT											
54 OFF SHAPE AT SIDE SEAM											
55 UNEVEN HEM											
56 BOTTOM HIGH LOW											
57 PUCKERING AT HEM											
58 CHELLY REVERSE											
59 TWISTING											
60 UNCUT THREAD											
61 RAWEDGE											
62 UNMATCHING STRIPE											
63 SNAP BUTTON IMPROPER ATTACH ING											
64 UNEVEN FLY SHAPE											
65 OIL STAIN											
66 DIRTY MARK											
67 NEEDLE CUT/ HOLE											
68 NEEDLE MARK											
69 FABRIC FAULT											
70 SEWING REJECT											
71 FABRIC REJECT											
TOTAL DEFECT	12	14	12	8	9	10	11	10	12	15	114

Figure: 3.4-2 Q.C Garments Inspection Report

Table 3.4-2 Q.C Garments Inspection Report in Sewing Section

Chaity Composite Ltd.
 Quality Control Department
 100% End Line/Finishing Inspection Report


Buyer: Red Label
 Item: T-Shirt
 Color: Grey

Style No: 307069
 Date: 05. 03. 19

SL NO	Description	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	Total
1	Skip Stitch		1		1		1	1	1	1		6
2	Broken Stitch	1		1		1	1					4
3	Down Stitch	2							2	2	2	8
4	Open Seam	2	2	1				4	2	1	3	15
5	Tension Problem											
6	Joint Un-matching	1	2	1	1	1	1				3	10
7	Uneven Stitching											
8	Pleat	4	3	4	2	3	3	3	3	5	4	34
9	Gathering at Neck Area		1	1			1	2				5
10	Gathering at Armhole											
11	Gathering at Side Seam											
12	Improper Zipper Joint											
13	Gathering at Waist											
14	Bar tack missing											
15	Press Tuck Missing											
16	Improper Tuck											
17	Part Mistake											
18	Part Shading											
19	Pocket Shading											
20	Neck Rib											
21	Draw Cord Shading											
22	Sleeve Shading											
23	Placket Shading											
24	Improper Pocket Joint											
25	Pocket Up-Down											
26	Placket Box Uneven											
27	Up-Down Placket											
28	Uneven Placket											
29	Hole Displace											
30	Button Half Stitch											

31	Main/Care Label Reverse											
32	Center Out Label											
33	Label Attach at Wrong Side											
34	Label Missing	2	2	2	2	2	1	2	2	2		17
35	Open Seam at Label											
36	Label Mistake											
37	Size Mistake											
38	Waist Band Mistake											
39	Print Problem											
40	Embroidery Problem											
41	Collar Point Up-Down											
42	Shoulder Point Up											
43	Both Shoulder Up-Down											
44	Both Sleeve Up-Down											
45	Armhole Point Up-Down		3	2	2	2	2	2	2	1	3	19
46	Side Slid Uneven											
47	Cross Point Up-Down											
48	Draw Cord Up-Down											
49	Off Shape at Armhole											
50	Poor Neck Shape											
51	Neck Rib Width Uneven											
52	Improper Sleeve Joint											
53	Off Shade at Side Seam											
54	Uneven Hem											
55	Bottom High/Low											
56	Puckering at Hem											
57	Chelly Reverse											
58	Twisting											
59	Uncut Thread											
60	Raw edge Un-matching Strip											
61	Snap Button Improper Attaching											
62	Uneven Fly Shape											
63	Oil Stain											
64	Dirty Mark											
65	Needle Hole											
66	Needle Mark											
67	Fabric Fault											
68	Sewing Reject											
69	Fabric Reject			2						2		4
	Total Defect	12	14	12	8	9	10	11	19	12	15	144

Q.C Garments Inspection Report in sewing section



Chaity Composite Ltd.

Quality Control Department
100% End Line/Finishing Inspection Report

QC/SE-CCL-22
Version-2

Per: Red Label
 File No.: 202069
 No.: T-SHIRT
 m: T-SHIRT

Date: 6-2-19
 Color: GREY
 Line: 12

DESCRIPTION	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	TOTAL
SKIP STITCH	11	1111								111	15
BROKN STITCH											
DOWN STITCH											
OPEN SEAM	211	11	11	11	11			11		1111	19
TENSION PROBLEM											
JOINT UNMATCHING				11	111	1	1	1	1	11	11
UNEVEN STITCHING											
PLEAT E	11	11	11	11	1111	2111	1111	1111	1111	111	52
GATHERING AT NECK AREA										111	3
GATHERING AT ARMHOLE											
GATHERING AT SIDE SEAM											
GATHERING/IMPROPER ZIPPER JOINT											
GATHERING AT WAIST											
BAR TACK MISSING											
TUCK/PRESS TUCK MISSING											
IMPROPER TUCK/PRESS TUCK											
PART MISTAKE											
PART SHADING											
POCKET SHADING											
NECK RIB/PIPING SHADING											
DRAW CORD SHADING											
SLEEVE SHADING											
PLACKET SHADING											
IMPROPER/SLANTED POCKET JOINT											
POCKET UP DOWN											
PLACKET/PLACKET BOX UN-EVEN											
UP DOWN PLACKET											
UNEVEN/SLANTED PLACKET											
HOLE DISPLACE											
BUTTON HALF STITCH											
MAIN/CARE LABEL REVERSE											
CENTER OUT/SLANTED LABEL											
LABEL ATTACH AT WRONG SIDE											
LABEL MISSING		11	1				1				6
OPEN SEAM AT LABEL											
LABEL MISTAKE											
SIZE MISTAKE											
WAIST BAND MISTAKE											
PRINT PROBLEM											
EMBROIDERY PROBLEM											
COLLAR POINT UP DOWN											
SHOULDER/HALA POINT UP											
BOTH SHOULDER UP DOWN											
BOTH SLEEVE UP DOWN											
ARMHOLE POINT UP DOWN		11	11	11	11	11	1		11	111	16
SIDE SLIT UNEVEN/UP DOWN											
CROSS POINT UP DOWN											
DRAWCORD UP DOWN											
BOTH SIDE LEG UP DOWN											
OFF SHAPE AT ARMHOLE											
POOR NECK SHAPE											
NECK RIB WIDTH UN - EVEN											
IMPROPER SLEEVE JOINT											
OFF SHAPE AT SIDE SEAM											
UNEVEN HEM											
BOTTOM HIGH LOW											
PUCKERING AT HEM											
CHELLY REVERSE											
TWISTING											
UNCUT THREAD											
RAWEDGE											
UNMATCHING STRIPE											
SNAP BUTTON IMPROPER ATTACH ING											
UNEVEN FLY SHAPE											
OIL STAIN											
DIRTY MARK											
NEEDLE CUT/ HOLE											
NEEDLE MARK											
FABRIC FAULT											
SEWING REJECT											
FABRIC REJECT											
TOTAL DEFECT	9	13	20	2	12	11	7	10	9	2	9

Figure: 3.4-3 Q.C Garments Inspection Report

Table 3.4-3 Q.C Garments Inspection Report in Sewing Section

Chaity Composite Ltd.
 Quality Control Department
 100% End Line/Finishing Inspection Report

Buyer: Red Label
 Item: T-Shirt
 Color: Grey

Style No: 307069
 Date: 06. 03. 19

SL NO	Description	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	Total
1	Skip Stitch	2	4	2	2		1	1	1	2		15
2	Broken Stitch										3	3
3	Down Stitch											
4	Open Seam	5	2	2	2	2			2		4	19
5	Tension Problem											
6	Joint Un-matching				2	3	1	1	1	1	2	11
7	Uneven Stitching											
8	Pleat	2	2	2	2	2	4	6	6	4	4	32
9	Gathering at Neck Area		1	1							3	5
10	Gathering at Armhole											
11	Gathering at Side Seam											
12	Improper Zipper Joint											
13	Gathering at Waist											
14	Bar tack missing											
15	Press Tuck Missing											
16	Improper Tuck											
17	Part Mistake											
18	Part Shading											
19	Pocket Shading											
20	Neck Rib											
21	Draw Cord Shading											
22	Sleeve Shading											
23	Placket Shading											
24	Improper Pocket Joint											
25	Pocket Up-Down											
26	Placket Box Uneven											
27	Up-Down Placket											
28	Uneven Placket											
29	Hole Displace											
30	Button Half Stitch											

31	Main/Care Label Reverse											
32	Center Out Label											
33	Label Attach at Wrong Side											
34	Label Missing		2	1		1	1	1				6
35	Open Seam at Label											
36	Label Mistake											
37	Size Mistake											
38	Waist Band Mistake											
39	Print Problem											
40	Embroidery Problem											
41	Collar Point Up-Down											
42	Shoulder Point Up											
43	Both Shoulder Up-Down											
44	Both Sleeve Up-Down											
45	Armhole Point Up-Down		2	2	2	2	2	1		2	3	16
46	Side Slid Uneven											
47	Cross Point Up-Down											
48	Draw Cord Up-Down											
49	Off Shape at Armhole											
50	Poor Neck Shape											
51	Neck Rib Width Uneven											
52	Improper Sleeve Joint											
53	Off Shade at Side Seam											
54	Uneven Hem											
55	Bottom High/Low											
56	Puckering at Hem											
57	Chelly Reverse											
58	Twisting											
59	Uncut Thread											
60	Raw edge Un-matching Strip											
61	Snap Button Improper Attaching											
62	Uneven Fly Shape											
63	Oil Stain											
64	Dirty Mark											
65	Needle Hole											
66	Needle Mark											
67	Fabric Fault											
68	Sewing Reject											
69	Fabric Reject		1	2	1			1		2	2	9
	Total Defect	9	13	10	10	13	11	7	10	9	15	107

Q.C Garments Inspection Report in sewing section

Chaity Composite Ltd.
Quality Control Department
100% End Line/Finishing Inspection Report

Version-2
 Date : 04-09-19
 Color : Grey
 Line : 2

Red Label
 No. : 30160 (E)
 Description : T-SHIRT

DESCRIPTION	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	TOTAL
SKIP STITCH											1
BROKN STITCH											1
DOWN STITCH											1
OPEN SEAM											1
TENSION PROBLEM											9
JOINT UNMATCHING											1
UNEVEN STITCHING											1
PLEAT E											20
GATHERING AT NECK AREA											1
GATHERING AT ARMHOLE											1
GATHERING AT SIDE SEAM											1
GATHERING/IMPROPER ZIPPER JOINT											1
GATHERING AT WAIST											1
BAR TACK MISSING											1
TUCK/PRESS TUCK MISSING											1
IMPROPER TUCK/PRESS TUCK											1
PART MISTAKE											1
PART SHADING											1
POCKET SHADING											1
NECK RIB/PIPING SHADING											1
DRAW CORD SHADING											1
SLEEVE SHADING											1
PLACKET SHADING											1
IMPROPER/SLANTED POCKET JOINT											1
POCKET UP DOWN											1
PLACKET/PLACKET BOX UN-EVEN											1
UP DOWN PLACKET											1
U NEVEN/SLANTED PLACKET											1
HOLE DISPLACE											1
BUTTON HALF STITCH											1
MAIN/CARE LABEL REVERSE											1
CENTER OUT/SLANTED LABEL											1
LABEL ATTACH AT WRONG SIDE											1
LABEL MISSING											17
OPEN SEAM AT LABEL											1
LABEL MISTAKE											1
SIZE MISTAKE											1
WAIST BAND MISTAKE											1
PRINT PROBLEM											1
EMBROIDERY PROBLEM											1
COLLAR POINT UP DOWN											1
SHOULDER/HALA POINT UP											1
BOTH SHOULDER UP DOWN											1
BOTH SLEEVE UP DOWN											1
ARMHOLE POINT UP DOWN											2
SIDE SLIT UNEVEN/UP DOWN											1
CROSS POINT UP DOWN											1
DRAWCORD UP DOWN											1
BOTH SIDE LEG UP DOWN											1
OFF SHAPE AT ARMHOLE											1
POOR NECK SHAPE											1
NECK RIB WIDTH UN - EVEN											1
IMPROPER SLEEVE JOINT											1
OFF SHAPE AT SIDE SEAM											1
UNEVEN HEM											1
BOTTOM HIGH LOW											1
PUCKERING AT HEM											1
CHELLY REVERSE											1
TWISTING											1
UNCUT THREAD											1
RAWEDGE											1
UNMATCHING STRIPE											1
SNAP BUTTON IMPROPER ATTACH ING											1
UNEVEN FLY SHAPE											1
OIL STAIN											1
DIRTY MARK											1
NEEDLE CUT/ HOLE											1
NEEDLE MARK											1
FABRIC FAULT											1
SEWING REJECT											1
FABRIC REJECT											1
TOTAL DEFECT	5	4	2	4	5	6	9	9	10	10	12

Figure: 3.4-4 Q.C Garments Inspection Report

Table 3.4-4 Q.C Garments Inspection Report in sewing section

Chaity Composite Ltd.
 Quality Control Department
 100% End Line/Finishing Inspection Report


Buyer: Red Label
 Item: T-Shirt
 Color: Grey

Style No: 307069
 Date: 04. 03. 19

SL NO	Description	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	Total
1	Skip Stitch							1	1	1		3
2	Broken Stitch		1	1	1	1	1	1		1	1	8
3	Down Stitch											
4	Open Seam	2	1	1	1							5
5	Tension Problem											
6	Joint Un-matching								4	2	3	9
7	Uneven Stitching											
8	Pleat	3	2	2	2	1	2	3	2	3		20
9	Gathering at Neck Area				1		1	1				3
10	Gathering at Armhole											
11	Gathering at Side Seam											
12	Improper Zipper Joint											
13	Gathering at Waist											
14	Bar tack missing											
15	Press Tuck Missing										1	1
16	Improper Tuck											
17	Part Mistake											
18	Part Shading											
19	Pocket Shading											
20	Neck Rib											
21	Draw Cord Shading											
22	Sleeve Shading											
23	Placket Shading											
24	Improper Pocket Joint											
25	Pocket Up-Down											
26	Placket Box Uneven											
27	Up-Down Placket											
28	Uneven Placket											
29	Hole Displace											
30	Button Half Stitch											

31	Main/Care Label Reverse											
32	Center Out Label											
33	Label Attach at Wrong Side											
34	Label Missing			4	2	1	1	2	2	2	3	17
35	Open Seam at Label											
36	Label Mistake											
37	Size Mistake											
38	Waist Band Mistake											
39	Print Problem											
40	Embroidery Problem											
41	Collar Point Up-Down											
42	Shoulder Point Up											
43	Both Shoulder Up-Down											
44	Both Sleeve Up-Down											
45	Armhole Point Up-Down										2	2
46	Side Slid Uneven											
47	Cross Point Up-Down											
48	Draw Cord Up-Down											
49	Off Shape at Armhole											
50	Poor Neck Shape											
51	Neck Rib Width Uneven											
52	Improper Sleeve Joint											
53	Off Shade at Side Seam											
54	Uneven Hem											
55	Bottom High/Low											
56	Puckering at Hem											
57	Chelly Reverse											
58	Twisting											
59	Uncut Thread											
60	Raw edge Un-matching Strip											
61	Snap Button Improper Attaching											
62	Uneven Fly Shape											
63	Oil Stain											
64	Dirty Mark											
65	Needle Hole											
66	Needle Mark											
67	Fabric Fault											
68	Sewing Reject											
69	Fabric Reject	2	1	2	2	2	1					10
	Total Defect	5	4	8	7	5	6	9	9	10	10	73

Q.C Garments Inspection Report in sewing section



Chaity Composite Ltd.

Quality Control Department
100% End Line/Finishing Inspection Report

QC/SE-CCL-22
Version-2

Date: 03-03-19
Color: BLUE
Line: 12

Buyer: RED LABEL
Style No: 307031E
To No: T SHIRT
Item:

DESCRIPTION	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	TOTAL
1 SKIP STITCH	/										1
2 BROKN STITCH											1
3 DOWN STITCH		//									2
4 OPEN SEAM											1
5 TENSION PROBLEM						//					2
6 JOINT UNMATCHING											1
7 UNEVEN STITCHING		//									2
8 PLEAT E											1
9 GATERING AT NECK AREA											1
10 GATHERING AT ARMHOLE											1
11 GATHERING AT SIDE SEAM											1
12 GATHERING/IMPROPER ZIPPER JOINT											1
13 GATHERING AT WAIST											1
14 BAR TACK MISSING											1
15 TUCK/PRESS TUCK MISSING											1
16 IMPROPER TUCK/PRESS TUCK											1
17 PART MISTAKE											1
18 PART SHADING											1
19 POCKET SHADING											1
20 NECK RIB/PIPING SHADING											1
21 DRAW CORD SHADING											1
22 SLEEVE SHADING											1
23 PLACKET SHADING											1
24 IMPROPER/SLANTED POCKET JOINT											1
25 POCKET UP DOWN											1
26 PLACKET/PLACKET BOX UN-EVEN											1
27 UP DOWN PLACKET											1
28 U NEVEN/SLANTED PLACKET											1
29 HOLE DISPLACE											1
30 BUTTON HALF STITCH											1
31 MAIN/CARE LABEL REVERSE											1
32 CENTER OUT/SLANTED LABEL											1
33 LABEL ATTACH AT WRONG SIDE											1
34 LABEL MISSING											1
35 OPEN SEAM AT LABEL											1
36 LABEL MISTAKE		//		//							2
37 SIZE MISTAKE											1
38 WAIST BAND MISTAKE											1
39 PRINT PROBLEM											1
40 EMBROIDERY PROBLEM											1
41 COLLAR POINT UP DOWN											1
42 SHOULDER/HALA POINT UP											1
43 BOTH SHOULDER UP DOWN											1
44 BOTH SLEEVE UP DOWN											1
45 ARMHOLE POINT UP DOWN	/	//	//								3
46 SIDE SLIT UNEVEN/UP DOWN											1
47 CROSS POINT UP DOWN											1
48 DRAWCORD UP DOWN											1
49 BOTH SIDE LEG UP DOWN											1
50 OFF SHAPE AT ARMHOLE											1
51 POOR NECK SHAPE											1
52 NECK RIB WIDTH UN - EVEN											1
53 IMPROPER SLEEVE JOINT											1
54 OFF SHAPE AT SIDE SEAM											1
55 UNEVEN HEM											1
56 BOTTOM HIGH LOW											1
57 PUCKERING AT HEM											1
58 CHELLY REVERSE											1
59 TWISTING											1
60 UNCUT THREAD											1
61 RAWEDGE											1
62 UNMATCHING STRIPE											1
63 SNAP BUTTON IMPROPER ATTACHING											1
64 UNEVEN FLY SHAPE											1
65 OIL STAIN											1
66 DIRTY MARK											1
67 NEEDLE CUT/ HOLE											1
68 NEEDLE MARK											1
69 FABRIC FAULT											1
70 SEWING REJECT											1
71 FABRIC REJECT											1
TOTAL DEFECT	1	2	2	2	1	1	1	1	1	1	15

Figure: 3.4-5 Q.C garments Inspection Report

Table 3.4-5 Q.C Garments Inspection Report in sewing section

Chaity Composite Ltd.
 Quality Control Department
 100% End Line/Finishing Inspection Report

Buyer: Red Label
 Item: T-Shirt
 Color: Grey

Style No: 307069
 Date: 03. 03. 19

SL NO	Description	8-9	9-10	10-11	11-12	12-1	2-3	3-4	4-5	5-6	6-7	Total
1	Skip Stitch	1	1		1			1		2	2	8
2	Broken Stitch				2	1	2	1	2	1	2	11
3	Down Stitch		2	3		2						7
4	Open Seam	1										1
5	Tension Problem	1										1
6	Joint Un-matching	2			1		2	1	1	1	1	9
7	Uneven Stitching											
8	Pleat	1	2		1	1	1		1	2	2	11
9	Gathering at Neck Area											
10	Gathering at Armhole											
11	Gathering at Side Seam											
12	Improper Zipper Joint											
13	Gathering at Waist											
14	Bar tack missing											
15	Press Tuck Missing											
16	Improper Tuck											
17	Part Mistake											
18	Part Shading											
19	Pocket Shading											
20	Neck Rib											
21	Draw Cord Shading											
22	Sleeve Shading											
23	Placket Shading											
24	Improper Pocket Joint											
25	Pocket Up-Down											
26	Placket Box Uneven											
27	Up-Down Placket											
28	Uneven Placket											
29	Hole Displace											

30	Button Half Stitch											
31	Main/Care Label Reverse											
32	Center Out Label											
33	Label Attach at Wrong Side											
34	Label Missing											
35	Open Seam at Label											
36	Label Mistake	2	1	3	1	1	1	2	1	1	2	15
37	Size Mistake											
38	Waist Band Mistake											
39	Print Problem											
40	Embroidery Problem											
41	Collar Point Up-Down											
42	Shoulder Point Up											
43	Both Shoulder Up-Down											
44	Both Sleeve Up-Down											
45	Armhole Point Up-Down	1	2	3	1		1		1	1	1	11
46	Side Slid Uneven											
47	Cross Point Up-Down											
48	Draw Cord Up-Down											
49	Off Shape at Armhole											
50	Poor Neck Shape											
51	Neck Rib Width Uneven											
52	Improper Sleeve Joint											
53	Off Shade at Side Seam											
54	Uneven Hem											
55	Bottom High/Low											
56	Puckering at Hem											
57	Chelly Reverse											
58	Twisting											
59	Uncut Thread											
60	Raw edge Un-matching Strip											
61	Snap Button Improper Attaching											
62	Uneven Fly Shape											
63	Oil Stain											
64	Dirty Mark											
65	Needle Hole											
66	Needle Mark											
67	Fabric Fault											
68	Sewing Reject	1										1
69	Fabric Reject		2	2	3	1	1					9
	Total Defect	9	8	9	7	5	7	5	6	8	10	74

Table 3.4.1 Garments Inspection Report**Summery Table for
Chaity Composite Ltd.**

SL NO:	Description of Faults	Date wise Faults			
		03. 03. 19	04. 03. 19	05. 03. 19	06. 03. 19
1	Skip Stitch	8	5	6	15
2	Broken Stitch	11		4	3
3	Down Stitch	7		8	
4	Open Seam	1	20	15	19
5	Tension Problem	1			
6	Joint Un-matching	9	3	10	11
7	Pleat	11	30	34	32
8	Gathering at Neck Area		5	5	5
9	Label Mistake	15	1		
10	Label Missing		13	17	6
11	Armhole Point UP-Down	11	18	19	16
12	Fabric Reject	9	6	4	9
13	Sewing Reject	1			
	Total Faults:	76	101	122	116

3.4.2 Graphical Analysis

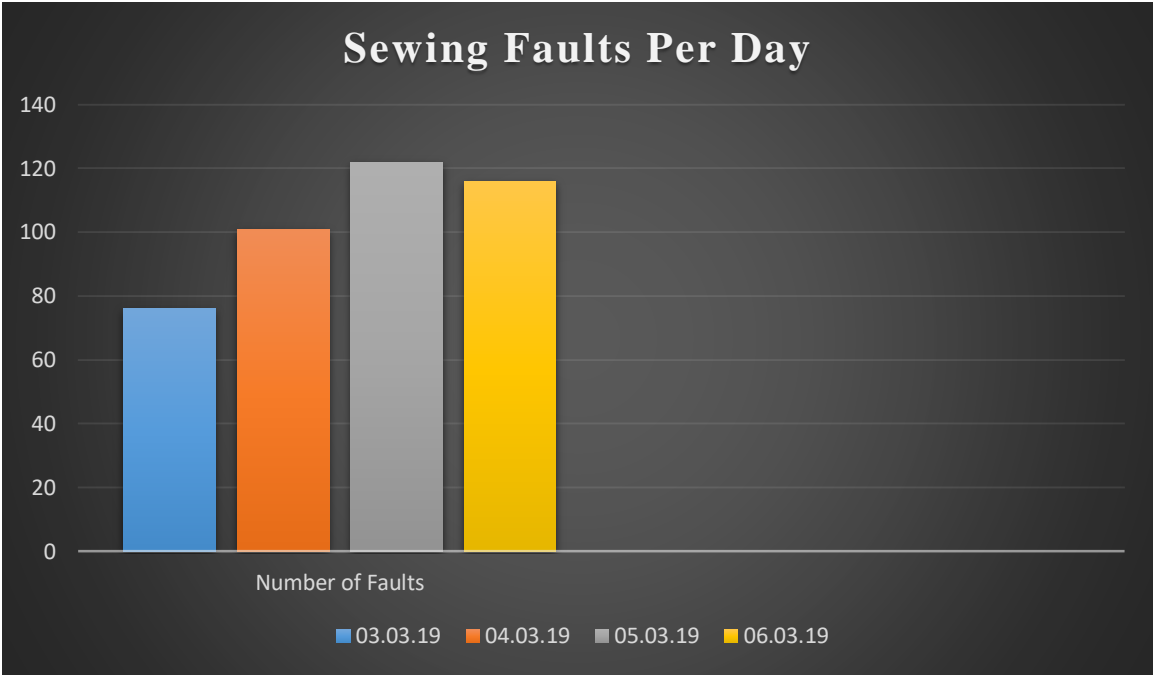


Figure: 3.4.2-1, Buyer: H&M, Style: SS T-shirt (figure 3.4.1)

Q.C Garments Inspection Report in Finishing Section

Date: 27/01/19

Fatullah apparels
Q.C. Inspection report

Buyer name: PEPE DENIM
Order No. STYNO-BE012
Reference No.
Type of Sample: 5-SLV T-SHIRT.
Fabrication: 100% ORGANIC COTTON
Colour: WHITE GSM:

Comments: * ACROSS FRONT & BACK I & PLUS
* CHEST I & PLUS
* TAKE CARE THE QCM - SIR.
* THIS IN LINE REPORT VERY VERY POBLAM. OF F-PKT SKIP STITCH
* SHOULDER JOINT UP DOWN - PKT. JOINT ROWING. OF BABEL TIB DOWN STITCH

Measurement Point	Size: XL 28-30-40		Size: L 24-26-36		Size: M 32-34-42		Size: XL		Size: M	
	RQR.	Found	RQR.	Found	RQR.	Found	RQR.	Found	RQR.	Found
A TOTAL-BODY LENGTH	130	126 ✓	110	106 ✓	100	96 ✓	110	106 ✓	120	116 ✓
B CHEST 1" BELOW	46	44 ✓	44	42 ✓	44	42 ✓	46	44 ✓	42	40 ✓
C BOTTOM-	46	44 ✓	44	42 ✓	44	42 ✓	46	44 ✓	42	40 ✓
D SLV-LENGTH E1B-	18	18 ✓	18	18 ✓	18	18 ✓	18	18 ✓	18	18 ✓
E SLV OPENING	5 1/4	5 1/4 ✓	5 1/4	5 1/4 ✓	5 1/4	5 1/4 ✓	5 1/4	5 1/4 ✓	5 1/4	5 1/4 ✓
F ARMHOLE STRAIGHT	9 1/4	9 1/4 ✓	9 1/4	9 1/4 ✓	9 1/4	9 1/4 ✓	9 1/4	9 1/4 ✓	9 1/4	9 1/4 ✓
G NECK WIDTH	7 1/4	7 1/4 ✓	7 1/4	7 1/4 ✓	7 1/4	7 1/4 ✓	7 1/4	7 1/4 ✓	7 1/4	7 1/4 ✓
H NECK DROP	4	4 ✓	4	4 ✓	4	4 ✓	4	4 ✓	4	4 ✓
I ACROSS SHOULDER STOS	19	18 ✓	18	18 ✓	18	18 ✓	19	18 ✓	17	17 ✓
J ACROSS FRONT AT 7" HPS	17 1/4	17 1/4 ✓	16 1/4	16 1/4 ✓	16 1/4	16 1/4 ✓	17 1/4	17 1/4 ✓	15 1/4	15 1/4 ✓
K ACROSS FRONT AT 7" HPS	17 1/4	17 1/4 ✓	16 1/4	16 1/4 ✓	16 1/4	16 1/4 ✓	17 1/4	17 1/4 ✓	15 1/4	15 1/4 ✓
L ACROSS BACK AT 7" HPS	17 1/4	17 1/4 ✓	16 1/4	16 1/4 ✓	16 1/4	16 1/4 ✓	17 1/4	17 1/4 ✓	15 1/4	15 1/4 ✓
M										
N										
O										
P										
Q										
R										
S										
T										

Q.C. Manager

Figure: 3.5-1 Q.C Garments Inspection report in finishing section

Table 3.5-1 Q.C Garments Inspection Report in Finishing Section

**Fatullah Apparels
Q.C Inspection Report**

Buyer Name: Peperdenim
 Order No: style no-BE KB12
 Type of Sample: S. SLV T- Shirt
 Fabrication: 100% cotton
 Color: White

S.L No:	Measurement Point	Size: XL			Size: L			Size: XXL			Size: M	
		RQR.	Found		RQ R.	Found		RQ R.	Found		RQR.	Fou nd
A	Front Body Length	30	-3/8	✓	29	+3/6	✓	30	-1/2	-1/2	28,1/4	✓
B	Chest 1" Below	46	-1/2	-1/4	44	-1/2	✓	46	-3/4	-1/2	42	+1/2
C	Bottom Length	46	-1/2	-1/2	44	+3/4	✓	46	-1/2	-1/2	42	+1/2
D	Sleeve Length	18	✓	✓	18	+1/2	✓	18, 3/4	-1/4	-1/4	17,1/4	✓
E	Sleeve Opening	33/4	+1/5	+1/4	13	✓	✓	13, 1/4	+1/4	+1/4	12,3/4	✓
F	Armhole Straight	93/4		+1/4	9,1/4	+3/4	+1/4	9,2/4	+1/4	✓	8,3/4	✓
G	Neck Width	73/4	-1/9	-1/4	7,1/2	-1/8	-1/8	7,3/4	✓	✓	7,1/3	✓
H	Near Drop	4	-1/8	✓	3,7/8	✓	✓	4	-1/8	✓	3,3/4	✓
I	Across Shoulder	19	✓	✓	18	+1/4	+1/8	19	✓	✓	17	✓
J	Across Front at HPS	17 1/4	+1/2	+1/4	16, 1/4	+1	+14	17, 1/4	+1/4	-1/4	15,1/4	✓
K	Across Back at HPS	173/4	+1/9	+1/4	16, 3/4	+3/4	+14	17, 3/4	+1/2	+1/2	15,3/4	✓

Q.C Garments Inspection Report in finishing section

Fatullah apparels
Q.C. Inspection report

Date: _____

Buyer name: 622BEE
 Order No. 362140
 Reference No. 717282
 Type of Sample: B-20T SHIRT/SW
 Fabrication: _____
 Colour: 7650T06A00 GSM: 140

Comments: _____

Measurement Point	Size: XXS		Size: XS		Size: S		Size: M		Size: L		Size: XL		XXL
	RQR.	Found	RQR.	Found	RQR.	Found	RQR.	Found	RQR.	Found	RQR.	Found	
A 1/2 CHEST ROUND	41		44		47		50 ✓		53 +5 +5		56 +5 +5	59	
B 1/2 BOTTOM ROUND	41		44		47		50 ✓		53 ✓ ✓		56 +5 +5	59	
C FRONT BREADTH	39		35.5		36.5		38 +5		39 +5 ✓		41 ✓ +5	42	
D BACK BREADTH	30.5		36		38.5		39 +5		40 ✓ ✓		42 +5 +5	43.5	
E OUTSIDE NECK WIDTH	17		17.5		18		18.5 x1		19 +5 1		19.5 +5 +5	20	
F NECK DROP FRONT	7.5		8		8.5		9 +5		9.5 +5 +5		10 +5 +5	10.5	
G NECK DROP BACK	1.5		1.5		1.8		1.5 ✓		1.5 ✓ ✓		1.5 ✓ ✓	1.5	
H SHOULDER LENGTH	12		12.5		13		13.5 ✓		14 ✓ ✓		14.5 ✓ ✓	15	
I SHORT SLV LENGTH	17		19		20		21 +5		22 +5 +5		23 +5 ✓	24	
J UPPER ARM WIDTH	15		16		17		18 +5		19 +5 +5		20 +5 ✓	21	
K SLV OPENING	13.5		14.25		15		15.5 ✓		16.25 ✓		17.5 ✓ +5	18	
L FRONT PRIT HOLE	17		18		19		20 +5		21 ✓ ✓		22 ✓ +5	23	
M BACK LENGTH FRIT HOLE	58		65		68		71 ✓		73 +5 +5		75 ✓ ✓	77	
N													
O													
P													
Q													
R													
S													
T													

Line Q.C. _____
Q.C. Manager _____

Figure: 3.5-2 Q.C Garments Inspection Report

Table 3.5-2 Q.C Garments Inspection Report in Finishing Section

**Fatullah Apparels
Q.C Inspection Report**

Buyer Name: BIZZBEE
 Order Number: 362140
 Type of Sample: B-20T.
 Shirt S. SLV
 Fabrication: 100% cotton
 Color: 7650 Tobacco

S.L No:	Measurement Point	Size: XXS		Size: XS		Size: S		Size: M	
		RQR.	Found	RQR.	Found	RQR.	Found	RQR.	Found
A	½ Chest Round	41		44	✓	47	✓	50	✓
B	½ Bottom Round	41	✓	44	✓	47	✓	50	✓
C	Front Breadth	33	✓	35.5	✓	36.5	✓	38	+ .5
D	Back Breadth	34.5	✓	36	✓	37	✓	39	+ .5
E	Out-side Neck width	17	✓	17.5	✓	18	✓	18.5	+1
F	Neck drop Front	7.5	✓	8	✓	8.5	✓	9	- .5
G	Neck drop Back	1.3	✓	1.5	✓	1.2	✓	1.5	✓
H	Shoulder Length	12	✓	12.5	✓	13	✓	13.5	✓
I	Shoulder SLV Length	17	✓	19	✓	20	✓	21	- .5
J	Upper arm width	15	✓	16	✓	17	✓	18	- .5
K	Sleeve opening	13.5	✓	14.25	✓	1.5	✓	15	✓
L	Front arm width	17	✓	18	✓	10	✓	20	+ .5
M	Back length from HPS	58	✓	65	✓	68	✓	71	✓
N									

Table 3.5.1 Inspection Report in Finishing Garments Section

**Summery Table for
Fatullah Apparels**

S.L No:	Measurement Point	Size: XL			Size: L		
		RQR.	Found		RQR.	Found	
A	Front Body Length	30	-3/8	✓	29	+3/6	✓
B	Chest 1" Below	46	-1/2	-1/4	44	-1/2	✓
C	Bottom Length	46	-1/2	-1/2	44	+3/4	✓
D	Sleeve Length	18	✓	✓	18	+1/2	✓
E	Sleeve Opening	3,3/4	+1/5	+1/4	13	✓	✓
F	Armhole Straight	9,3/4	✓	+1/4	9,1/4	+3/4	+1/4
G	Neck Width	7,3/4	-1/9	-1/4	7,1/2	-1/8	-1/8
H	Near Drop	4	-1/8	✓	3,7/8	✓	✓
I	Across Shoulder	19	✓	✓	18	+1/4	+1/8
J	Across Front at HPS	17, 1/4	+1/2	+1/4	16,1/4	+1	+14
K	Across Back at HPS	17,3/4	+1/9	+1/4	16,3/4	+3/4	+14

Chapter IV

Discussion of Result

4.1 Fabric Inspection Report Analysis for Chaity Composite Ltd.

In this report we can see that total 54 roll is inspected. The fabric composition is 100% cotton S/J & the color is Grey dusty light. The total weight 1193 kg & width 60 inch. Defects are Hole, Enzyme dust, Dirty spot, Needle mark, Pin hole and Oil spot. We can see that maximum Grade is (A).

4.2: Garments Finishing Report Analysis for Chaity Composite Ltd.

In this report we can see that there are generally occurs 69 types of faults in T-Shirt. We found 13 types of faults. Respectively faults: Skip stitch, Broken-stitch, Down-stitch, Open seam, joint un-missing, pleat, Arm hole point up-down etc. We observed more than 5-6 faults are seen daily. Such as skip stitch, Open seam, Pleat, Arm-hole point up-down, Joint un-missing. In a sewing line we have seen about 76 to 122 alteration per day.

4.3: Fabric Inspection Report Analysis for Fatullah Apparels.

In this report we can see 34 roll is inspected. The Fabric type is Fleece. Average weight 30 kg & width 180 cm. Defects are Oil spot, Fly yarn, Sinkers mark, Hole, Set off etc. We can see that maximum Grade (C).

4.4: Final Garments Finishing Inspection Report Analysis for Fatullah Apparels.

Accuracy in cutting is the main concern here because cutting with straight knife always not become accurate. We also observed that uneven measurement occurs for operator's miss concentration. We found some types of wrong measurements. Respectively: Neck width, across front at HPS, across back at HPS, Arm hole straight.

4.5 Compare between the Spinning Faults in Chaity Group & Fatullah Apparels.

There are no spinning faults seen in Chaity group but some faults are seen in Fatullah Apparels. The spinning faults of Fatullah Apparels are oil spot and fly yarn.

4.6 Compare between the Knitting Faults in Chaity Group & Fatullah Apparels.

Both factory have some knitting problems. The knitting faults of Chaity Group are hole and needle mark. The knitting faults of Fatullah Apparels are hole, set off and sinker mark.

4.7 Compare between the Dyeing Faults in Chaity Group & Fatullah Apparels.

There are both factory have some dyeing faults. The faults of Chaity Groups are pin hole, enzyme dust and dirty spot. The fault of Fatullah Apparels are hole, dirty spot and abrasion.

Chapter V

Conclusion

5.1 Conclusion

Garments industry is one of the major sector of Bangladesh, the scope of which is increasing day by day. Garments finishing is very important because buyer's satisfaction depends on it. At the same time competitors are also increasing day by day. In garment industry knit garments are mostly popular. Before shipment garment finishing process is very important. Finishing process is done in different method according to the buyer specification. Garments finishing means, mainly applies of processing, folding and packing of garments. In a garments industry finishing section involves with garment washing, checking, final inspection, pressing & packing etc. Proper finishing process can be improved quality of garments and make on time order shipment. Garments shipment is very much dependable on garments finishing section. Finishing section add value to the product which attracts customers by the presenting activities of the product according to the buyer's requirements. There are use different types of sewing machine for making the garments. Those are Lock Stitch sewing machine, Over Lock sewing machine, Flat Lock sewing machine, Button Hole sewing machine. During discussion on Inspection Report of T-shirt and Hoody Jacket the fabric composition is respectively 100% cotton and 95% cotton and 5% spandex. The color of T-shirt is light grey and the color of hoody jacket is orange and honey. There is three color of fabric inspected. The faults are slubs, hole, needle mark, enzyme dust, oil spot, pin hole, sinker mark and abrasion mark found during inspection. On which in report nine role is reject due to excessive defect points/100 square yds. As acceptable defects points/100 square yds. If up to 28 points will not be acceptable.

Reference:

- ❖ Garments Manufacturing Technology by Abu Saleh.
- ❖ <https://en.wikipedia.org/wiki/Inspection>
- ❖ <http://www.asprova.jp/mrp/glossary/en/cat252/post-831.html>
- ❖ <http://textilemerchandising.com/final-inspection-in-garment-industry>
- ❖ <http://textilelearner.blogspot.com/2012/04/garments-inspection-flow-chart-of.html>
- ❖ <http://www.garmentsmerchandising.com/final-inspection-in-readymade-garments-industry/>