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International
University

Faculty of Engineering
Department of Textile Engineering

REPORT ON

Study on the comments on samples of knit garment production

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

Advance in Apparel Manufacturing Technology



Letter of Approval

February 01, 2020

To

The Head

Department of Textile Engineering

102, Sukrabad, Mirpur Road. Dhaka – 1207

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

Dear Sir,

I am just waiting to let you know that this thesis ‘Study on the comments on samples of knit garment production’ has been prepared bearing ID’s (162-23-4664, 162-23-4741) is completed for final evaluation. The whole report is prepared based on proper assessment and investigation. We were directly involved with our work.

Therefore it will be highly appreciated if you kindly accept the Thesis report and considered for final evaluation

You Sincerely.

A handwritten signature in black ink, appearing to read 'Md. Abdullah Al Mamun', is written over a horizontal dashed line.

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Declaration

We hereby declare that the work which is presented in this thesis entitled “Study on the comments on samples of knit garment production” has been done under the supervision of Md. Abdullah Al Mamun, Assistant Professor TE, Daffodil International University. We also state that this project has not been presented in any other universities and all the resource of information are totally acknowledged.

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Finally, we express our sincere gratitude to our parents and friends for their continuous support, ideas and love during our studies.

Dedication

The study is whole heartedly dedicated to our parents, who have been our source of inspiration and gave us strength when we thought of giving up, who continuously provide their moral, spiritual, emotional and financial support.

And lastly, we dedicated this book to the almighty God, thank you for the guidance, strength, power of mind, protection and skills and for giving us a healthy life. All of these, we offer to you.

Abstract

Our Project (Thesis) is on “Study on the comments on samples of knit garment production.” The role of sample section in RMG sector is very important. Whatever the efficiency or profitability of the manufacturing floors may be, the factory merchandising department will not be able to build a good business relationship with the customer if they fail to deliver quality products to the customers on time. The samples produced in the sample section are vital parameters by which buyers evaluate the emphasizing performance of the factory. They become frustrated with the factory or the factory merchandising team when they do not receive samples in a timely and unqualified manner, resulting in the cancelation of orders or the decline to reward future orders to that factory. These can have an impact on the overall economy of the factory.

By analyzing the project there are many faults are found. In this study most of the fault found in measurement (22.73%), followed by workmanship fault (22.73%), fitting fault (22.73%), Accessories faults (15.15%), Sade faults (10.60%) & material fault (6.06%). Causes, effect and results of problems; potential problem-solving. The goal of this project is to define the Sample Section problem and develop possible solutions as well as practical solutions that will save the factory from losing future orders from well-known customers

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Chapter- 01

1. Introduction:

A large number of materials or objects represent the whole item in a small or small number of them, a small or small number of which will be known as the sample. In a simple word, a separate unit or a representative part of the whole unit. This is the engineering view of the definition of the sample. Generally, in the garments manufacturing industry, the terms "Sample" are known as the model or design that will be followed for bulk or mass production. In the RMG sector, before moving to the production order, prototypes are made according to the wishes of the buyer. In general, the purpose of the sample is to attract the buyer only, and then confirm the order. If the sample develops with the good quality then the buyer willing to put the order automatically to the garment industry. From the very beginning of the order to ship wherever the sample is needed.

Therefore, the creation or output of the sample is immediately becoming a very important task. Every RMG sample production field has its own Sampling or Sample Unit. Their only goal is to produce a sample according to the requirements of the purchaser. Once all the parameters have been met, it can easily be inferred that the sample plays the most important role in the manufacture of clothes.

1.1 Objectives of the study

The purpose of the study is to properly clarify the sample, sample faults, causes of sample failure and how the failures can be improved and overcome. If a full-time worker has the correct sample failure information, then the loss will be significantly reduced.

Also, if a worker has a small shortage on the sample the knowledge will fulfill his or her shortage. This research or expertise will boost experience and competencies.

The key aims are given below for the moment:

- To learn the sampling or sampling segment or department of the RMG Sector
- To know the form and value of the sample
- Understanding of working with both information, experience and skills
- To learn step by step about the right sample creation
- To learn the defects of the sample
- To know the reasons for the sample failure
- To detect defects in the sample
- To learn the remedies for fault
- Learn how to be mindful of errors
- To determine the sample failure problems and limitations
- To know about the buyer's requirements samples

1.2 Limitations of the Study

There are many challenges, drawbacks, fails, problems and obstacles in every kind of work and it's very natural. And as usual in our work we have also faced several problems. But they didn't face any major or critical issues. Though the problems or limitations are not too small or easy, either. Hardly any of them. During the research work I would like to note the problems, and they are given below:

- Workers have good skills, but they're not able to give us enough attention and work information.
- Staff and office materials are too tied, and they don't have enough time for us as well.
- Even if he is skilled in his work, he gives us time, but he doesn't have enough knowledge of the work.
- Also, hundred percent of sampling and failure problems cannot be learned within 60 days.

Chapter- 02

2. Literature Review

2.1 Previous Work

A study on investigation on the defects found in the different types of samples in a RMG industry was done by Md. Rayhan Uddin and Rezaul Karim in April, 2017 and they found measurement problem 28.34%, sewing problem 15%, print problem 15% and rest of the faults are fitting problem 13.33%, fabric construction problem 13.33% and rest of the faults are 15%. Another study on investigation on the comments on sample garments was conducted by Shah Mizanur Rahman and Sojol Podder in December, 2017 and they found measurement fault 43%, garment part shape fault 29% and rest of the faults are 28%.

Another study on investigation on the comments of sample garments was done by Jahed Hossain Jamy and Masrukh Ahmed in April, 2018 and they found workmanship fault 28%, fitting fault 26%, Color fault 14%, Material fault 12% and rest of the faults are 20%.

Also, another study on buyer comments on different sample was conducted by Md. Selim Reza and S.M. Hassan Al Mamun in April, 2019 and they found measurement fault 27%, high stretch/tension 12.5%, uneven join 12.5%, Puckering 10%, Pattern problem 10% and rest of the faults are 28%

2.2 Garments Sampling

Garment sampling is an extremely important process. It is a blueprint of what can be performed in bulk production. Sampling is very challenging but the industry should attract buyers. Since buyers usually place the order after the sample value pleases them. Garment sampling is a very important task in clothing manufacturing since it gives the customer satisfaction with the item being made. It is important partially because if the consumer is not happy with the goods it puts the following at risk:

- Order placement
- Acceptance of certain or all of the garments produced.

An industry may have a separate department for the sampling. However, since the merchandiser is the person who deals with the customers in terms of samples and other criteria, this sampling department must operate according to the guidance. Since the products are to be made according to the buyers' price ranges and quality standards, merchandiser must advise.

2.3 Purpose of Sampling

- ❖ To allow the buyer to assess the manufacturer's production capabilities.
- ❖ To provide a way to update the production process in bulk.
- ❖ To allow the thread and fabric usage to be calculated by the manufacturer and to create cost quotations.

2.4 The Details Attached to the Garment Sample

After the order confirmation, the following details are attached to each sample sent to the buyer with the help of a tag. It contains both the details of what the buyer has requested and what the fabric / trim supplier has used, etc.

- ❖ Ref no.
- ❖ Color
- ❖ Fabric
- ❖ Composition
- ❖ Description
- ❖ Quantity
- ❖ Style no/ Size
- ❖ Store

2.5 Sampling Process

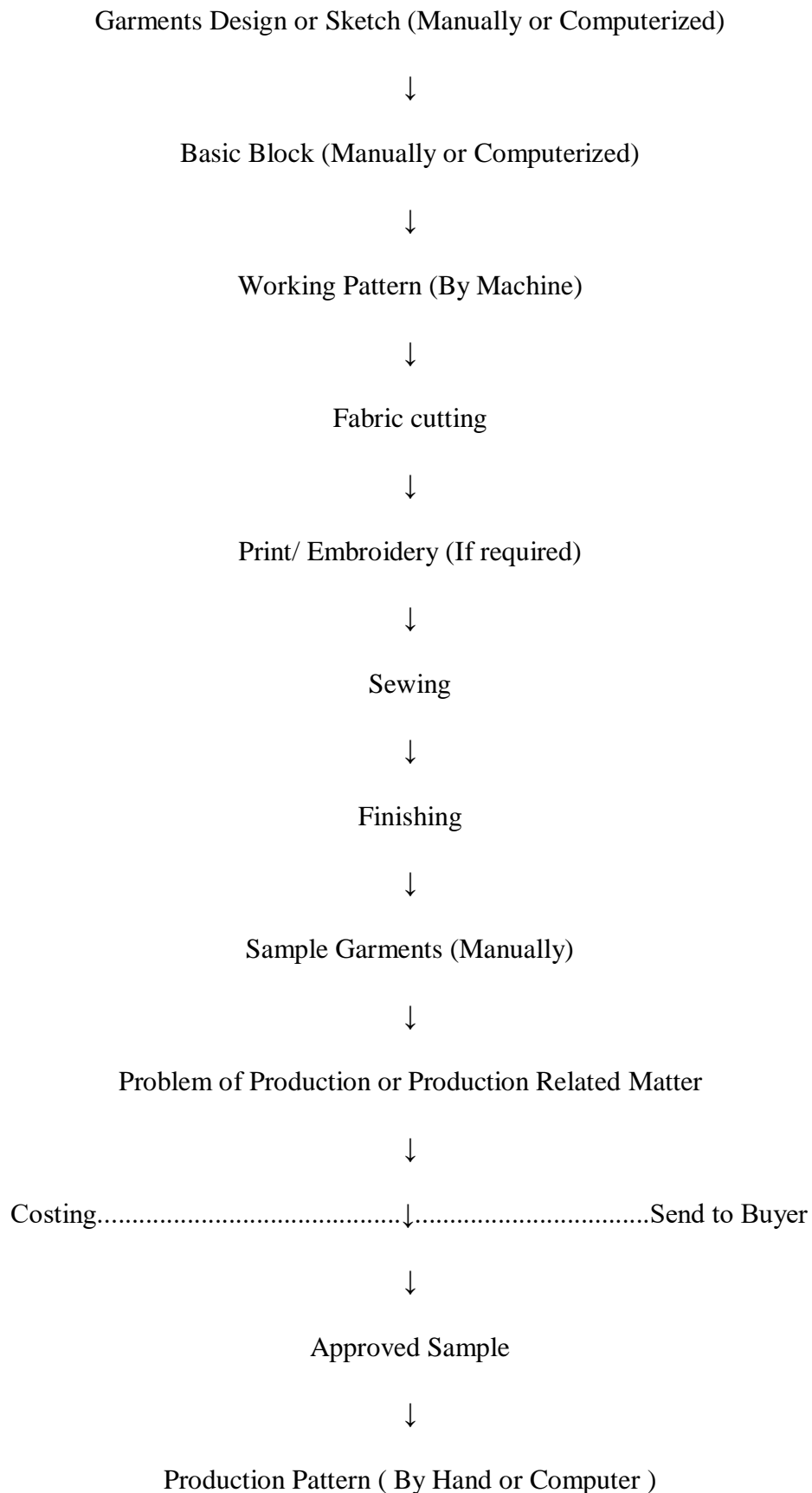
The sample department process will vary on an ongoing basis and the development process will cover a wide variety of unique products from natural fabrics, fiber blends, new yarns, textile structures, finishes and new technology surface effects, and all types of composite products such as woven, knit wear, hosiery, cut and sewn clothes, household products, industrial and medical products.

The sampling stages are different; the first step includes the creation of the initial concept or design idea and the approval of the client.

The second phase covers the process after approval of the first model sample and the functions of the manufacturing and ordering portion are performed, the item is checked and trials are carried out once the final sample requirements have been drawn up.

The third and final phase includes a range of activities that are performed outside the manufacturer/developer, if needed, before large-scale or bulk production capacity.

2.6 Flow chart of Garment Sample Making



2.7 Sampling Types

They are many types of sample like-

- ❖ Proto samples or fit samples
- ❖ Photo shoot samples
- ❖ Salesmen samples or promotional samples
- ❖ Size set samples
- ❖ Pre-production samples
- ❖ Online sample
- ❖ Shipment sample
- ❖ Counter samples or reference samples

2.7.1 Proto Samples or Fit Samples

The samples are made after the new order is put with the customer. Those samples are needed to test the measurements, style and fit. Therefore they can be made available in similar materials, except in the exact dimensions and requirements of the buyer. Some buyers may need these samples if they want to print the pictures of the garments on the packing box, hang mark, in showrooms, etc., after sending the proto samples, the buyers will discuss the samples and access the sample content and give us feedback and reviews.

2.7.2 Photo shoot Sample

In this category, which deals primarily with the actual fit of clothing. The buyers will do photo shoot sessions with the samples that we have sent out. This specifically helps us to get the correct criteria and measuring issues. By doing this the buyer will send us feedback on the picture attachments.

2.7.3 Salesman Sample

The buyer wants those samples to get the requests from their customers. If the buyer has seven sellers in his office, then the buyer will ask us to make seven samples of each design. The salesmen will book their customers' orders by displaying those examples. Buyer must place the order according to the customer's test appeal. Sales samples are made of textiles, trimmings and accessories. The buyer pays the dealer for the developer samples.

2.7.4 Size set Samples

The analysis is carried out after the seller has reviewed it. We will send out specimens in one SMS package. Therefore, comparisons of the package range are made to ensure that the scoring of all sizes is ok and the measurements are fairly good.

2.7.5 Counter Sample or Reference Sample

These are the samples which are made in the same way as the other samples. We must send customers samples and hold one of the same samples for our use. After receiving authorization from the customer, we will conduct the task according to the comparison study we have with us.

2.7.6 Pre-production Samples

Such samples were more like authorization samples. In actual manufacturing material, we have to be made from real bulk trims. This must reflect that the output will be the same as those samples.

2.7.7 Wash Sample

Wash sample is produced and sent to the buyer for assessment of the feeling and handle of the fabric during Denim washing or shirt washing method, then either at the size set point or PP level washing sample is sent to the buyer for authorization and the washing cycle is continued. If the sample is not approved with suggestions or accepted, then the factory must apply for approval the second sample. After feeling assessment, buyer may suggest changes in the washing process.

2.7.8 Online Sample

Some pieces were taken out in the middle of production while manufacturing is online. The output parts are sent as a TOP sample to the consumer. Every buyer demands some TOP sample. The goal is to cross-check whether the factory meets the specification of the PP sample or not.

2.7.9 Shipment Samples

These samples should be sent straight before shipment. This should be shipped in actual packaging with all the labels, logos, etc. (such specimens will not necessarily be tested by the buyer for anything). But even if we get some suggestions from consumers, such as price tag modifications or range enhancements, we'll follow the process changes, but that isn't the danger to the manufacturer.

2.8 Meeting with Buyers

The stage developer of a production house shows its inventions, the new models for customers. On the other hand, if the customer already had a set model of a fashion and needed some relevant adjustments to the layout, materials or trims, they would address this with the merchandiser of the production unit.

2.9 Development of Initial Samples for the Buyer

Samples are made with available fabrics and trims at this stage after receiving the buyer's concept or instructions on the new style.

2.10 Development of Fabric Sample, Bit Loom, Print and Embroidery Artwork

The fabric is designed according to the buyer's requirements. Creation of fabric means procurement of customer-specific fabric for solid colors with matching properties. Allowing for the solid color lap dip is very important process. Merchants re-send lap dips before they accept lap dip test. In the case of yarn dyed fabrics, merchants produce fabric samples with specified patterns, lines, or checks. Those fabric samples are called Bit Loom. Other

permissions are available, such as acceptance of print and embroidery artwork, and paint approval. In the pre-production process, this can be done later.

2.11 Costing of Garment (complete cost as well as manufacturing cost)

Merchants compile price sheets containing value break-up information such as cost of raw materials, cost of production, depreciation and profit. It's a very critical stage to price. Because it depends on their price whether a company gets order or not. If the price of fabric is very high, the supplier will lose the order because, on the other side, if the producer holds the cost low, they won't benefit from the order. Estimating the price of the clothes should be based on data.

Chapter- 03

3. METHODOLOGY

3.1 Data Collection

We have collected secondary data from a reputed knit composite factory.

3.1.1 Sample No: 01

	JERSEY		Sample size			Deviations allowed in production ±	SM size S	befree
	2,021,413,482	XS	S	M	L		11/11/2019	COMMENTS
A	FRONT LENGTH from fold to bottom	102.5	102.5	104.5	104.5	1.0	101.0	Pls prolong it by 1,5 cm. See pic.2.
B	BACK LENGTH by centre	100.5	100.5	102.5	102.5	1.0	99.0	Pls prolong it by 1,5 cm. See pic.2.
C	1/2 CHEST WIDTH under armpit	32.5	34.5	37.5	40.5	1.0	34.5	
W	1/2 WAIST WIDTH 36,0 cm from H.P.S.	28.6	30.6	33.6	36.6	1.0	33.0	Pls lessen it by 1,2 cm. See pic.2.
H	1/2 HIP WIDTH 60,0 cm from H.P.S	36.5	38.5	41.5	44.5	1.0	38.5	
D	1/2 BOTTOM WIDTH	37.0	39.0	42.0	45.0	1.0	39.0	
E	NECK WIDTH	17.0	17.5	18.0	18.5	0.5	15.5	Pls widen it by 2,0 cm. See pic.2.
F1	NECK DROP FRONT	9.3	9.5	9.7	9.9	0.5	10.0	
F2	NECK DROP BACK	2.0	2.0	2.0	2.0	0.5	1.7	
J	SHOULDER STRAP WIDTH	6.0	6.0	6.0	6.0	0.0	6.0	
K	ARMPIT DEPTH straight angle from L.P.S.	18.5	19.0	19.5	20.0	0.5	16.8	Pls make it 19,0 cm. See pic.2.
M1	BACK WIDTH 13 cm from H.P.S	19.5	20.5	22.0	23.5	0.5	18.5	Pls widen it by 2,0 cm. See pic.2.
M2	FRONT WIDTH 13 cm from H.P.S	22.0	23.0	24.5	26.0	0.5	23.0	
R1	RIB WIDTH	2.0	2.0	2.0	2.0	0.0	0.8	Pls make it 2,0 cm. See pic.1.
R2	1/2 NECK RIB LENGTH	23.0	23.5	24.0	24.5	0.5	22.5	Pls change E measure. See pic.2.
R3	1/2 ARMHOLE RIB LENGTH	22.1	22.8	23.8	24.8	0.5	22.0	Pls change K measure. See pic.2.

Table: 3. 1 Sample Measurements No: 1

COMMENTS:

1. Jersey quality is correct on sample.
2. Rib quality is correct on sample. See pic.1.

Rib is made from main jersey.

Rib width is not correct. It should be 2.0 cm like in style 2021 413 482.

Pls don't deform neck and armhole line.

Pls don't twist rib. Control rib stripes direction.

3. Pls change patterns according to the picture 2 and the table above.

Pls make measures of E, K, M1, M2, R1 like you make in style 2021 413 482.

4. Bottom line is stretched. Pls control bottom workmanship. See pic.3.

Bottom hem is correct on sample.

Cover lock stitches should hide bottom edge.

5. Main and care labels position and design are correct on sample. Pls follow our instructions on the pic.4.

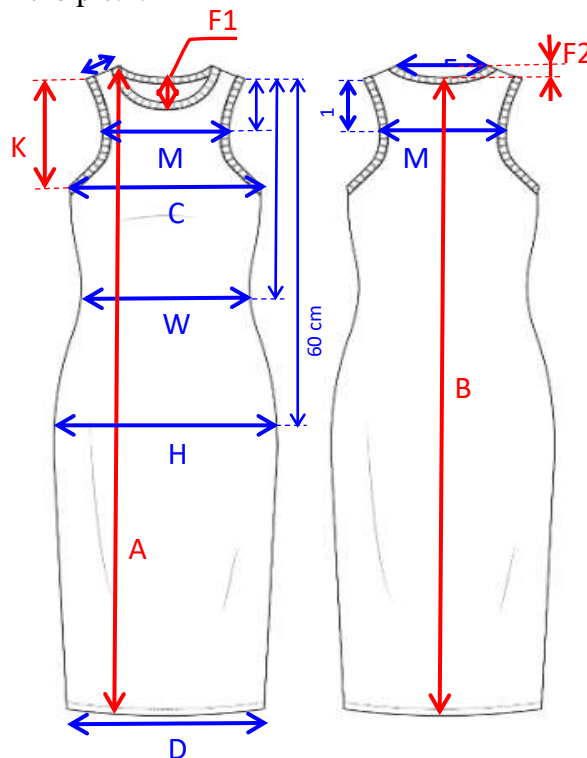


Figure: 3. 1 Sample Front Part and Back Part

Pic.1. Rib quality is correct on sample. Rib is made from main jersey. Pls don't deform neck and armhole line. Rib width is not correct on sample.



Figure: 3. 3 Rib width

Pls don't twist rib. Control rib stripes direction.



Correct rib direction

Figure: 3. 2 Rib direction

Rib width should be 2.0 cm like in style 2021 413 482.

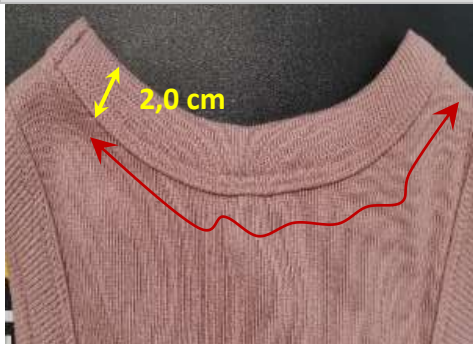


Figure: 3. 5 Neck and armhole lines



Incorrect rib direction

Figure: 3. 4 Incorrect rib

Pic.3. Bottom line is stretched. Pls control bottom workmanship. Bottom hem is correct on sample. Coevrlock stitches should hide bottom edge.

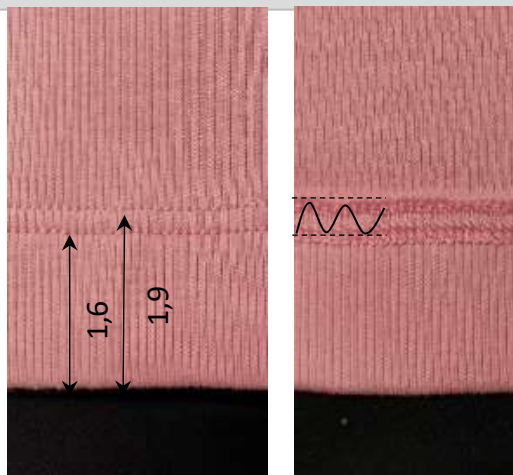


Figure: 3. 6 Bottom

Pic.2. Pls change patterns according to the picture 2 and the table above. Pls make measures of E, K, M1, M2, R1 like you made in style 2021 413 482.



Figure: 3. 7 Sample pattern

Pic.4. Main and care label position and design are correct on sample. Pls follow our instruction on the picture.

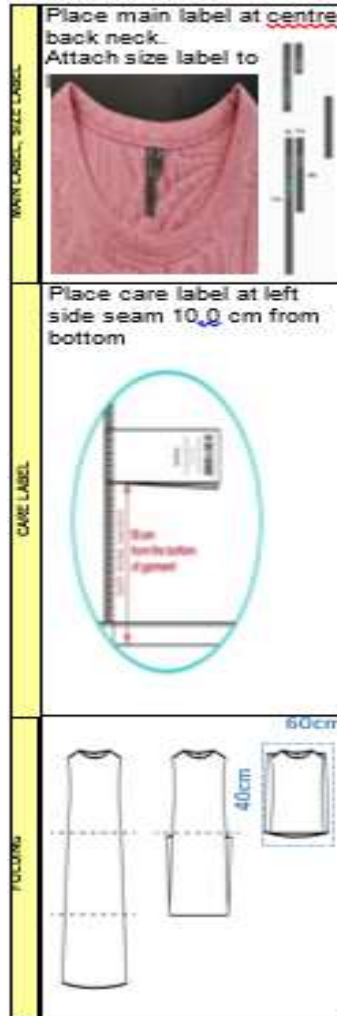


Figure: 3. 8 Position of Main and care label position and design

3.1.2 Sample No: 02

BLOUSE		Sample size			Deviations allowed in production \pm	SM Size S	before
2021 432 492						11/19/2019	COMMENTS
	XS	S	M	L			
FRONT LENGTH from H.P.S to bottom	46.5	47.0	49.5	52.0	1.0	44.5	Pls prolong it by 2,5 cm. See pic.4
BACK LENGTH by centre	43.5	43.5	45.5	47.5	1.0	42.5	Pls prolong it by 1,0 cm. See pic.4
1/2 CHEST WIDTH under armpit	51.5	53.5	56.5	59.5	1.0	53.5	
1/2 BOTTOM WIDTH	51.5	53.5	56.5	59.5	1.0	53.5	
BACK NECK WIDTH	20.3	20.7	21.1	21.5	0.5	19.7	Pls widen it by 1,0 cm. See pic.4
NECK DROP FRONT	9.3	9.5	9.7	9.9	0.0	10.5	Pls lift it by 1,0 cm. See pic.4
NECK DROP BACK	2.4	2.5	2.6	2.7	0.0	2.6	
SLEEVE LENGTH short sleeve	18.7	19.0	19.3	19.6	0.5	19.0	
1/2 BICEPS direct under arm pit	21.4	22.0	22.9	23.8	0.5	21.8	
1/2 SLEEVE WIDTH at bottom	18.4	19.0	19.9	20.8	0.5	18.8	
ARMPIT DEPTH straight from H.P.S.	27.5	28.0	28.5	29.0	0.5	28.0	
SHOULDER	16.2	16.5	17.0	17.5	0.5	16.7	
BACK WIDTH 15cm from H.P.S	44.5	45.5	47.0	48.5	0.5	45.7	
CHEST WIDTH 15cm from H.P.S.	45.0	46.0	47.5	49.0	0.5	46.0	
NECK RIB HEIGHT	1.8	1.8	1.8	1.8	0.0	1.8	
1/2 NECK RIB LENGTH	21.1	21.5	21.9	22.3	0.5	21.5	
SLEEVE BOTTOM FINISH	2.0	2.0	2.0	2.0	0.0	2.1	
NECK PIPING WIDTH	1.0	1.0	1.0	1.0	0.0	1.0	

Table: 3. 2 Sample Measurements No: 2

COMMENTS:

1. Pls use approved fabric quality. Warp direction is distorted. See pic.1.
2. Rib quality is correct on sample. Rib color should match to the main fabric color. See pic.2
3. Back neck piping is correct on sample. Its color should match to the main fabric color. See pic.2.
4. Shoulder technical tape is correct on sample. See pic.3.
5. Pls change patterns according to the pic.4 and the table above.
6. Fashion seams along armhole is correct on sample. See pic.5. Seam should be parallel to the armhole line.
7. Sleeve bottom hem is correct on sample. See pic.6.
8. Bottom should be raw and rolled. See pic.7. Sample bottom line isn't rolled enough. Pls control it.
9. Pls change care label position. See pic.8. Pls follow our instructions.

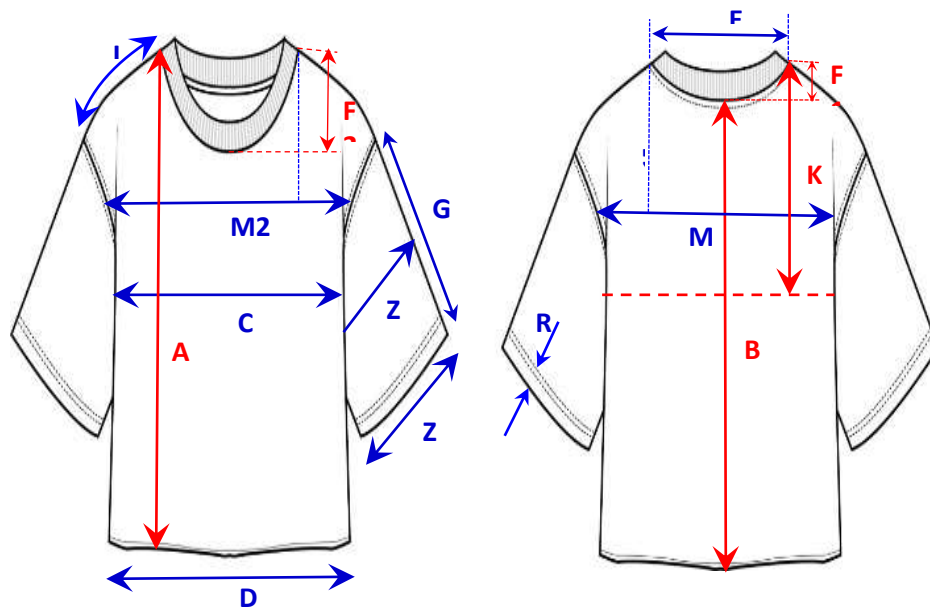


Figure: 3. 9 Front and Back part of sample

Pic.1. Pls use approved fabric quality.
Warp direction is distorted.



Figure: 3. 10 Fabric direction

Pic.2. Rib quality is correct on sample.
Back neck piping is correct on sample.
Rib and back neck piping color should match to the main fabric color.

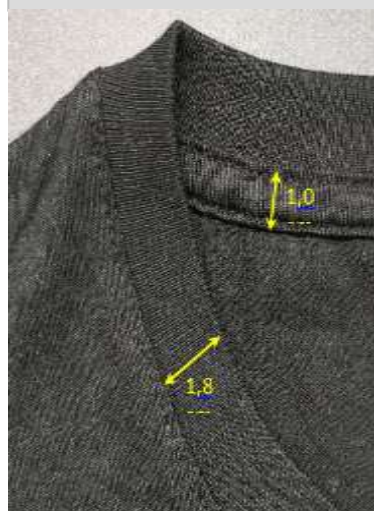


Figure: 3. 11 Rib and Back neck piping

Pic.3. Shoulder technical tape is correct
on sample.

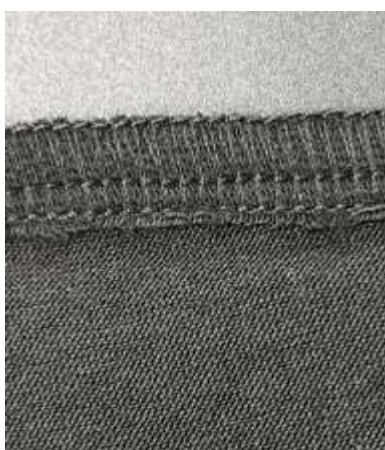


Figure : 3. 12 Technical tape

Pic.5. Fashion seams along armhole is correct
on sample.
Seam should be parallel to the armhole line.

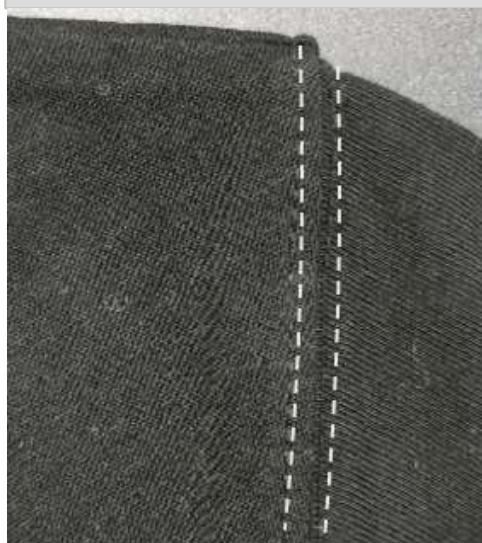


Figure: 3. 13 Armhole seam

Pic.4. Pls change patterns according to the pic.4 and the table above.



Figure: 3. 14 Sample Pattern

Pic. 6. Sleeve bottom hem is correct on sample.

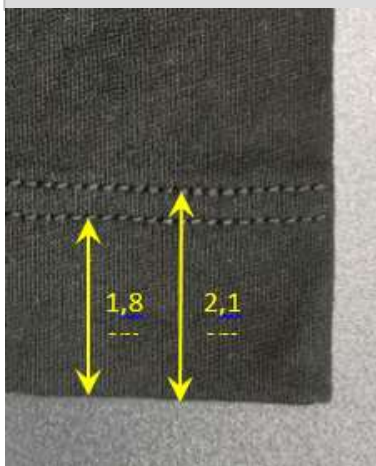


Figure: 3. 15 Bottom

Pic.7. Bottom line should be raw and rolled. Sample bottom line isn't rolled enough. Pls control it.



Figure: 3. 16 Bottom line

Pic.8


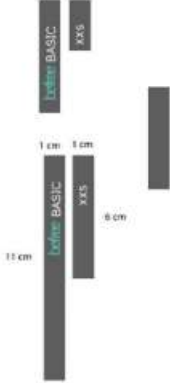
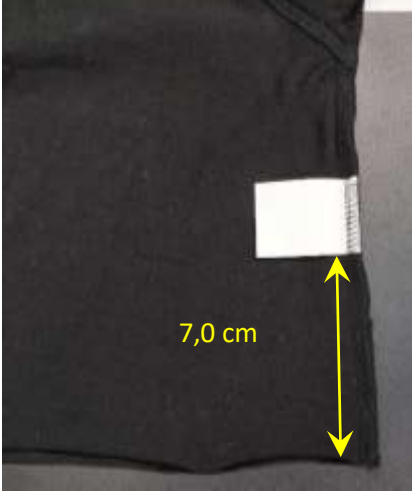
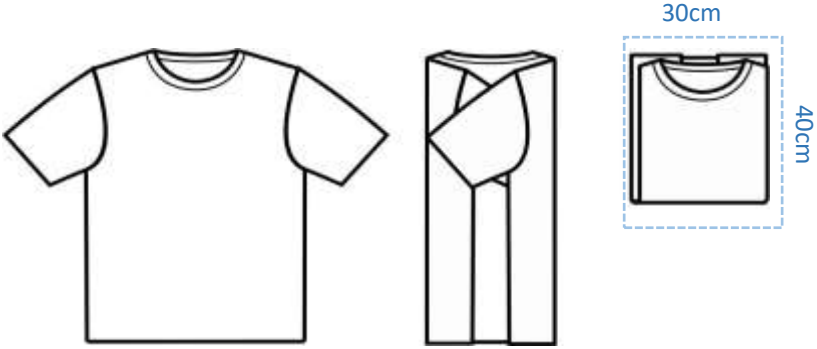
<p>MAIN LABEL, SIZE LABEL</p>	<p>Place main label at centre back neck. Attach size label to main label.</p>  
<p>CARE LABEL</p>	<p>Place care label at left side seam 7,0 cm from bottom</p> 
<p>FOLDING</p>	

Figure: 3. 17 Instruction of Main label, care label and Folding

3.1.3 Sample No: 03

	Jersey dress		Sample size			Deviations allowed in production ±	SM	befree
	2,021,555,528	XS	S	M	L		11/28/2019	COMMENTS
A	FRONT LENGTH from HPS to bottom	110.5	111.0	113.5	114.0	1.0	111.0	Pls prolong it by 1,0 cm.
A1	FRONT LENGTH from HPS to pocket	18.5	19.0	19.5	20.0	1.0	18.0	Pls lower it by 1,0 cm. See pic.4.
B	BACK LENGTH by centre	105.0	105.0	107.0	107.0	1.0	103.0	Pls lift F2 by 1,0 cm. Pls prolong it by 1,0 cm See pic.4.
C	1/2 CHEST WIDTH under armpit	44.5	46.5	49.5	52.5	1.0	48.5	Pls narrow it by 2,0 cm. See pic.4.
H	1/2 BOTTOM WIDTH	53.0	55.0	58.0	61.0	1.0	55.0	
E	BACK NECK WIDTH	21.6	22.0	22.5	23.0	0.5	19.6	Pls widen it by 2,4 cm. See pic.4.
F1	NECK DROP FRONT from HPS to bottom	16.9	17.0	17.1	17.2	0.5	15.0	Pls deepen it by 2,0 cm. See pic.4.
F2	NECK DROP BACK	8.0	8.0	8.0	8.0	0.2	9.0	Pls lift it by 1,0 cm. See pic.4.
J	SHOULDER without plackets	2.0	2.0	2.4	2.4	0.1	1.6	Pls widen it by 0,4 cm. See pic.4.
K	ARMPIT DEPTH straight angle from L.P.S.	20.5	21.0	21.5	22.0	0.5	21.0	
M1	BACK WIDTH 13cm from H.P.S	22.9	23.2	23.7	24.2	0.5	20.0	Pls widen it by 3,2 cm. See pic.4.
M2	FRONT WIDTH 13cm from H.P.S	24.5	25.5	27.0	28.5	0.5	21.5	Pls widen it by 4,0 cm. See pic.4.
N1	PIPING WIDTH	1.0	1.0	1.0	1.0	0.0	1.0	
N3	1/2 NECK LENGTH	37.1	37.8	38.5	39.2	0.5	34.5	See pic.4.
R1	POCKET HEIGHT	11.0	11.0	11.0	11.0	0.3	10.6	
R2	POCKET WIDTH	10.0	10.0	10.0	10.0	0.3	9.9	
R3	DISTANCE FROM POCKET TO ARMHOLE	2.0	2.0	2.5	2.5	0.3	2.5	Pls change pocket placement. See pic.4.
R4	DISTANCE FROM POCKET TO SIDE SEAM	9.0	9.0	9.5	9.5	0.5	13.5	Pls change pocket placement. See pic.4.
S	SLIT LENGTH	27.0	27.0	27.0	27.0		30,0+30,5	Pls shorten it by 3,0 cm. They should be symmetrical.

COMMENTS:

1. Jersey quality is correct on sample. Please pay attention to jersey print color 5, 8, 55 matching and symmetry. See pic.1
2. The piping quality is correct on sample. See pic.2 The piping width is correct on sample. Piping should be cutted from main jersey and be one colored. See pic. 1B.
3. Placket is correct on sample. See pic.3. Pls make plackets more rolled, so cut them shorter then armhole and neck length.
4. Pls change patterns according to the table above and the picture 4.
5. Pls control pocket placement. See pic.5. Pls improve pocket workmanship.
6. Fixing stitches at the placket near side seams and near left shoulder seam are correct on sample. See pic.6.
7. Main and care labels are correct on sample. See pic.7.

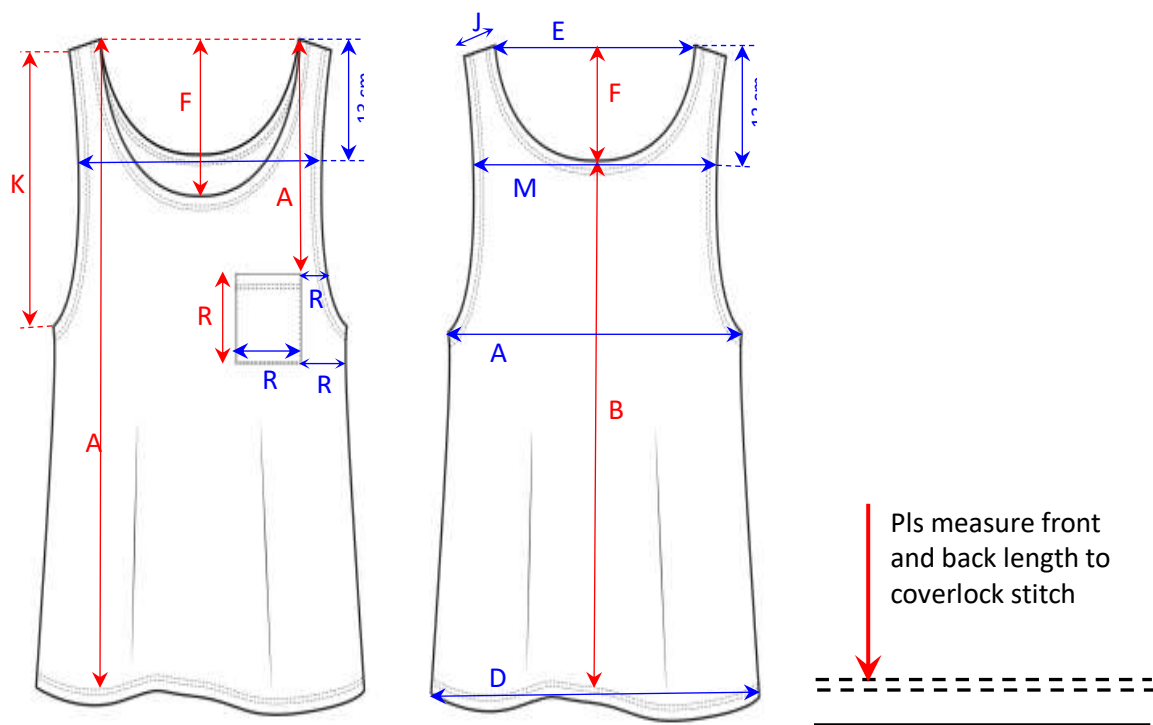


Figure: 3. 18 Sample Front and Back Part

Pic.1. Jersey quality is correct on sample. Please pay attention to jersey print color 5, 8, 55 matching and symmetry.

- Bottom line should be along wide print line. Rolled bottom should be in one color. See pic. A;
- Neck and shoulder plackets and back neck piping should be in one color. See pic. B;
- Pocket should match to front detail. See pic. C.

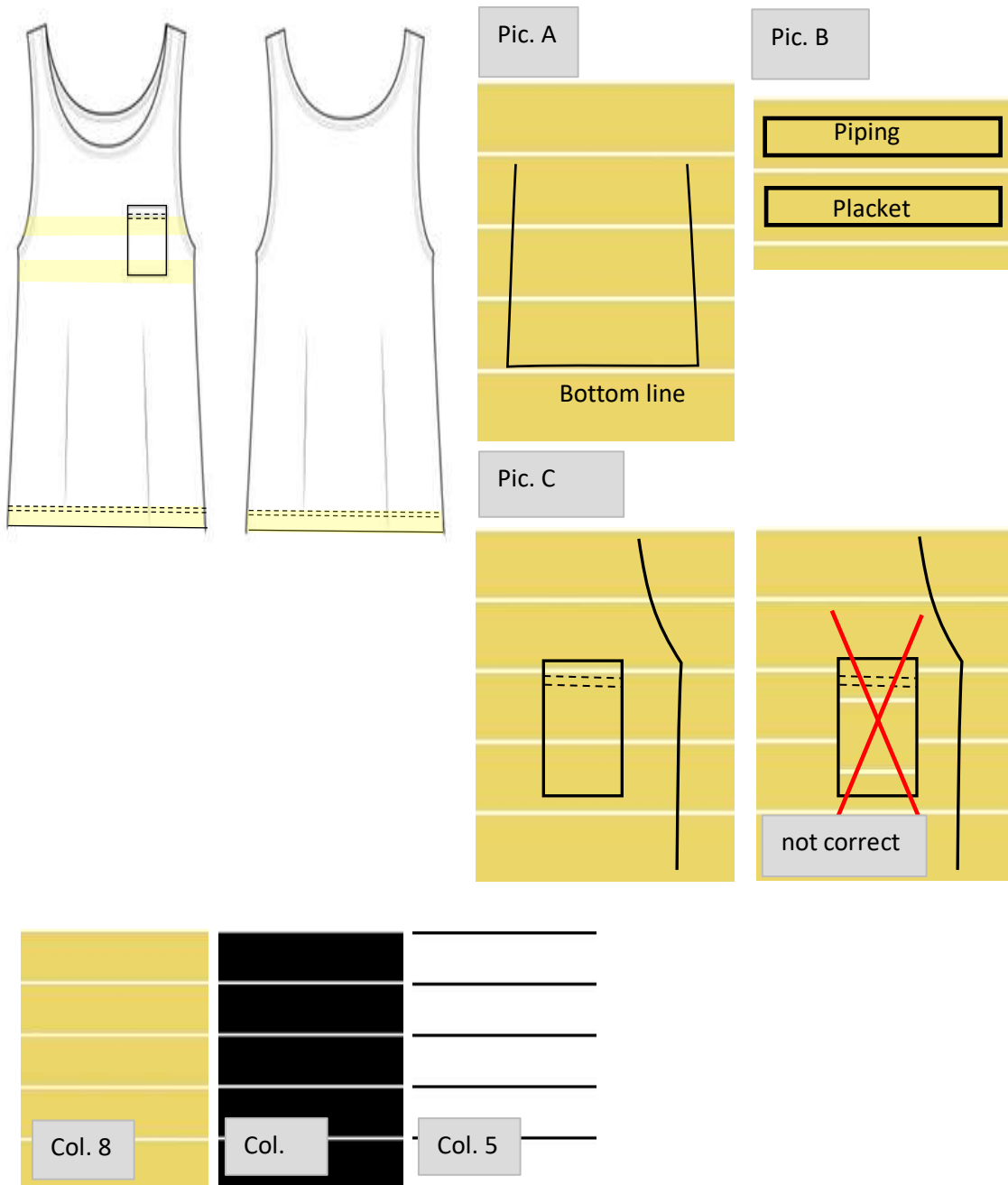


Figure: 3. 19 Pocket Position and color matching

Pic.3. Plackets and bottom workmanship are correct on sample.
 Pls make plackets more rolled, so cut them shorter than armhole and neck length.

Neck and armholes plackets.

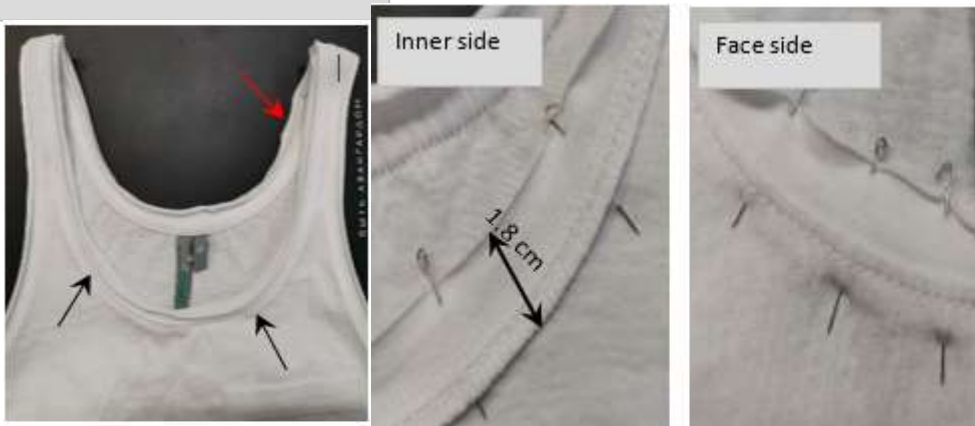


Figure: 3. 20 Neck and armhole placket

Bottom workmanship.

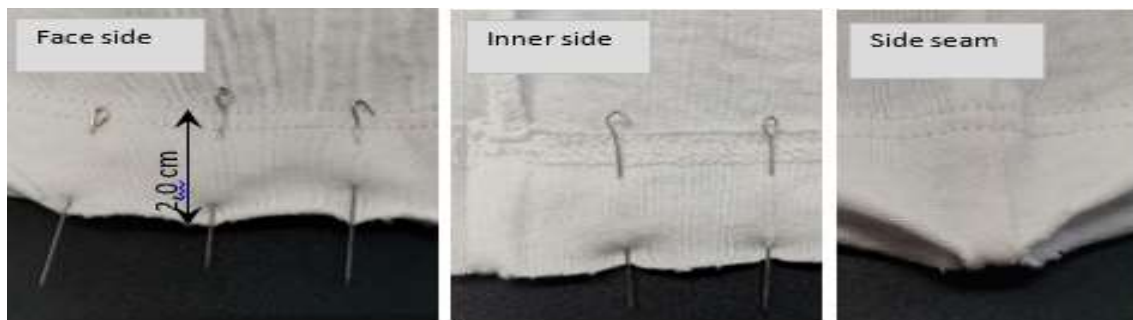


Figure: 3. 21 Bottom workmanship

Pic.6. Fixing stitches at the placket near side seams and near left shoulder seam are correct on sample.

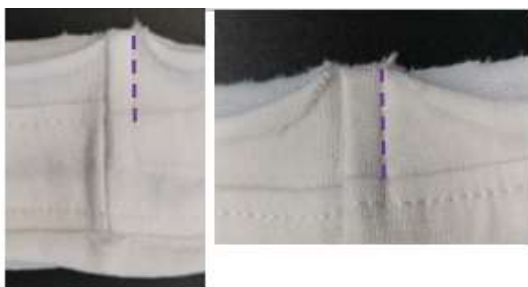


Figure: 3. 22 Stitches

Pic.2. the piping quality is correct on sample.
 The piping width is correct on sample.
 Piping should be cutted from main jersey and be one colored. See pic.



Figure: 3. 23 Piping

Pic.4. Pls change patterns according to the table above and the picture.

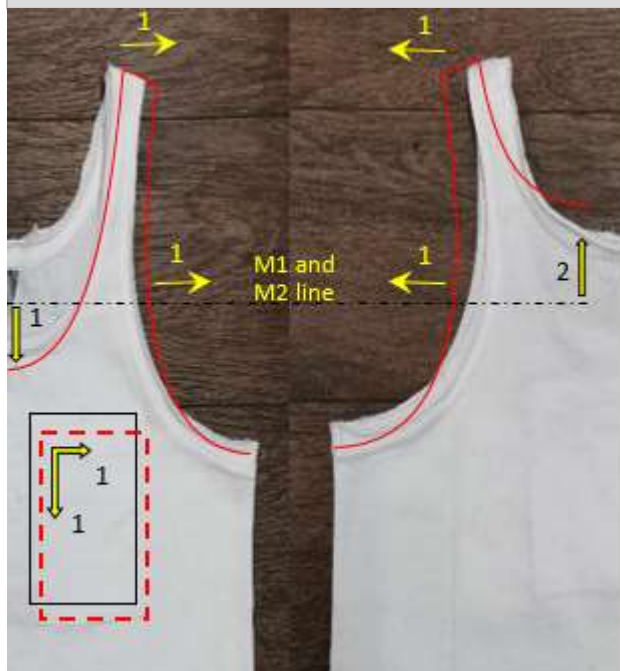


Figure: 3. 24 Pattern

Pic.5. Pls control pocket placement. Pls improve pocket workmanship. Pocket sides should be perpendicular to each other. Pls control distance between top pocket side and fashion seam.

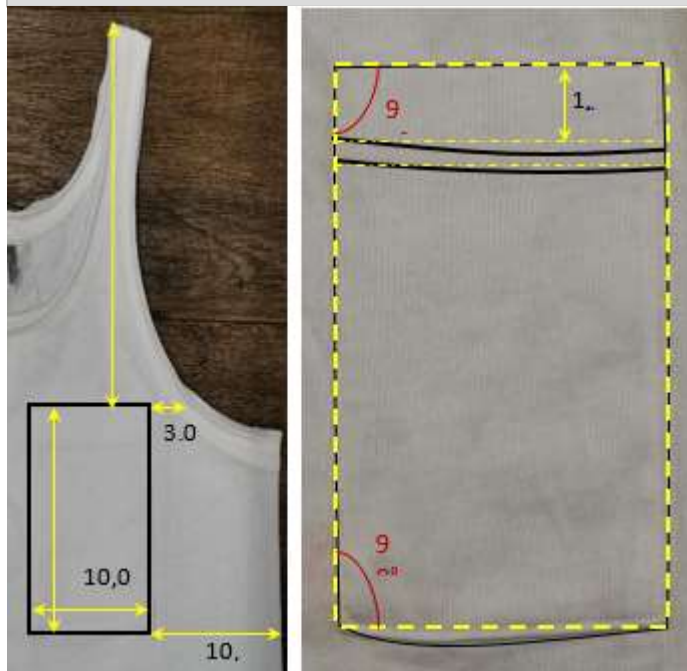


Figure: 3. 26 Pocket

Pic.7.

Place main label at centre back neck.
Attach size label to main label.



Place care label at left side seam 10 cm from bottom.



CARE LABEL

FOLDING

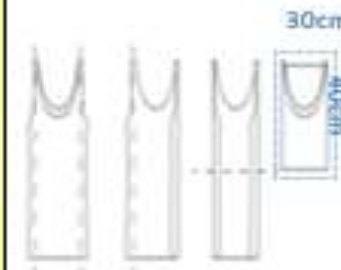


Figure: 3. 25 Instruction

3.1.4 Sample No: 04

	JERSEY	Sample size				Deviations allowed in production \pm	SM	bulk	before
	2,021,555,524	S	M	L	XL				COMMENTS
							12/5/2019	1/14/2020	
A	FRONT LENGTH from H.S.P. to bottom	90.5	91.0	94.5	95.0	1.5	88.0	88.5	Pls strictly keep 90,5
A1	DISTANCE to waist seam	43.0	43.5	44.0	44.5	0.0	43.0	43.0	
B	BACK LENGTH by centre	87.0	87.0	90.0	90.0	1.5	86.0	86.5	Pls follow the patterns
B1	DISTANCE to waist seam	40.5	40.5	40.5	40.5	1.0	39.5	40.3	
C	1/2 CHEST WIDTH under armpit	60.0	62.0	64.0	66.0	1.0	59.0	59.0	Pls follow the patterns
W	1/2 WAIST WIDTH, at seem relax	34.0	36.0	38.0	40.0	1.0	39.0	39.0	Pls lessen elastic tape by 5,0 cm
W	1/2 WAIST WIDTH, at seem stretched	56.0	58.0	60.0	62.0	1.0	56.0	55.0	Pls follow the patterns
D	1/2 BOTTOM WIDTH	57.0	59.0	61.0	63.0	1.0	56.0	56.0	Pls follow the pttens
E	BACK NECK WIDTH neck piping excl	22.0	22.5	23.0	23.5	0.5	24.5	22.0	
F1	NECK DROP FRONT neck piping excl	10.0	10.2	10.4	10.6	0.0	13.0	10.0	
F2	NECK DROP BACK neck piping excl	3.3	3.3	3.3	3.3	0.0	3.5	2.5	Pls control it.
G	SLEEVE LENGTH neck piping excl	23.5	24.5	25.5	26.5	1.0	22.0	23.5	
Z1	1/2 BICEPS direct under arm pit	21.0	21.9	22.8	23.7	0.5	20.0	20.5	Pls control it.
Z2	CUFF width	2.0	2.0	2.0	2.0		2.0	2.0	
K	ARMPIT DEPTH straight angle from HHPS	28.5	29.0	29.5	30.0	0.5	27.5	29.0	Pls control it.
U	POCKET LENGTH	16.5	16.5	16.5	14.0	0.0	16.5	16.5	
U1	The width of the pocket in an extended form	4.5	4.5	4.5	4.5	0.5	4.5	4.0	Pls control it
N	NECK PLACKET HEIGHT	1.5	1.5	1.5	1.5	0.0	2.0	1.5	
N1	1/2 NECK PLACKET LENGTH at top	26.5	27.0	27.5	28.0	0.5		26.5	
N2	1/2 NECK PLACKET LENGTH at seam	28.5	29.0	29.5	30.0	0.5	32.0	28.5	
R1	BOTTOM FINISH	2.0	2.0	2.0	2.0	0.0	2.0	1.9	

Table: 3. 4 Sample Measurements No: 4

Comment:

1. Jersey quality pls follow confirmed quality. Pls follow the scheme for print.PIC 1
2. The quality of elastic tape is correct on sample, the color of elastic tape should be dtm to shell. PIC 2. The workmanship of waist is correct. Pls lessen the length of elastic tape by 5.0 cm.
3. Workmanship of cuff is incorrect on sample. The cuff should be the same width. Please control it .PIC 3. Pls change fixing position as on sheme, pls cancel excess fixing
4. Workmanship of neckline is correct on sample. Pls do not sterched the placket of neckline of front when sew.PIC 4. pls control it on bulk. Main label should be sewed even.
5. PIC 5.The workmanship of pocket is correct .Top stitching should be even, pls control it in bulk.
6. PIC 6. The bottom hem should be carefully. The stitches from the edge should be 1.5 cm. The distance between the stitches should be 0.3 cm. Please improve. The stitch of bottom hem is crooked, no excess fabric should be visible .Pls control it in bulk.
7. The neckline of back should be without crinkles, pls control it in bulk.PIC 7.
8. All seams should be made accurately, seams should not be with fringe, all threads should be cut. Please control it.
9. Pls use main label No. 2. Reg main label attaching follow our instruction below. The folding way should be as per at our instructio below. PIC 7.

PIC 1. Pls follow the scheme for print

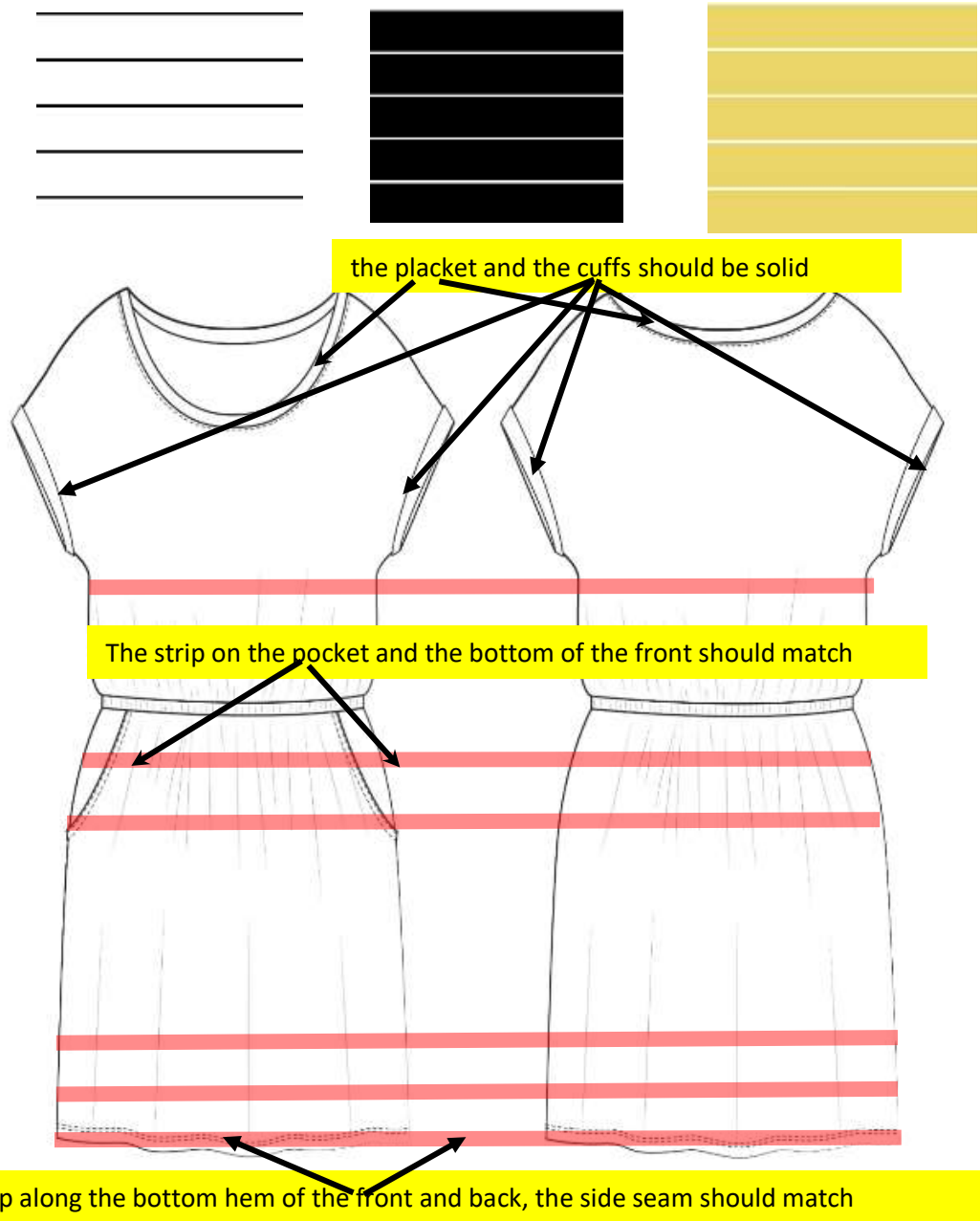


Figure: 3. 27 Scheme for print

PIC 2. The quality of elastic tape is correct on sample, the color of elastic tape should be dtm to shell.

The workmanship of waist is correct. **Pls lessen the length of elastic tape by 7,0 cm.**

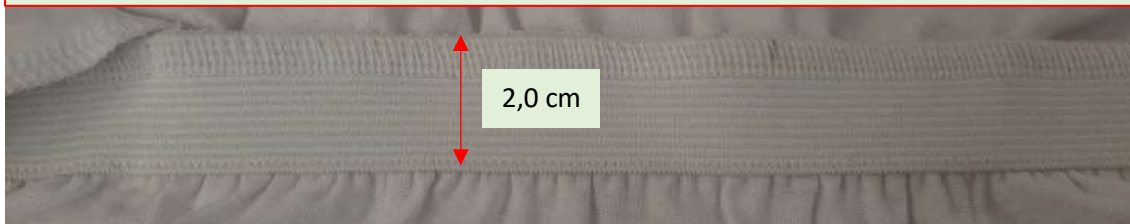


Figure: 3. 28 Elastic tape

PIC 3. Workmanship of cuff is incorrect on sample. The cuff should be the same width. Please control it. Pls change fixing position as on sheme, pls cancel excess fixing.



Figure: 3. 29 Cuff

PIC 4 . Workmanship of neckline is correct on sample. Pls do not sterched the placket of neckline of front when sew, pls control it on bulk. Main label should be sewed even.

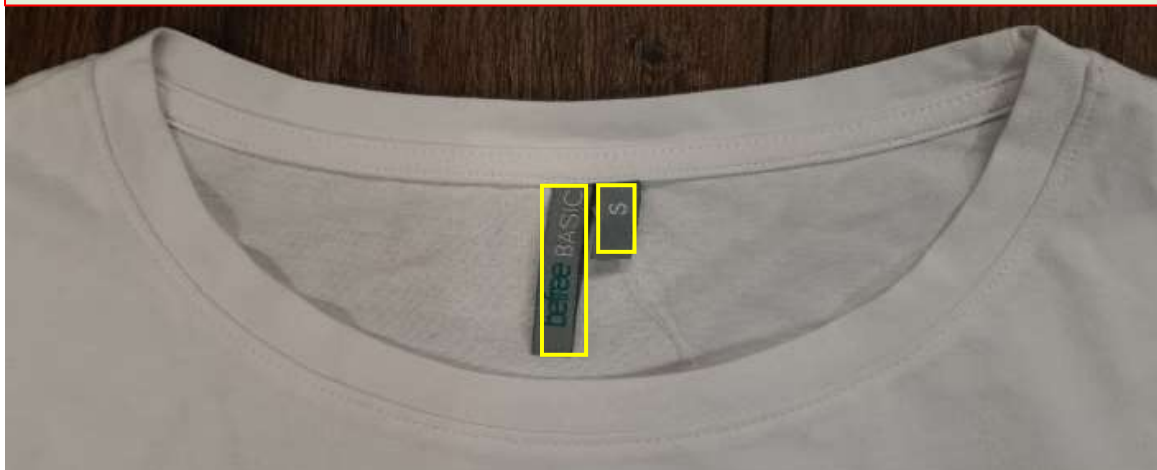


Figure: 3. 30 Neckline

PIC 5. The workmanship of pocket is correct. Top stitching should be even, pls control it in bulk.

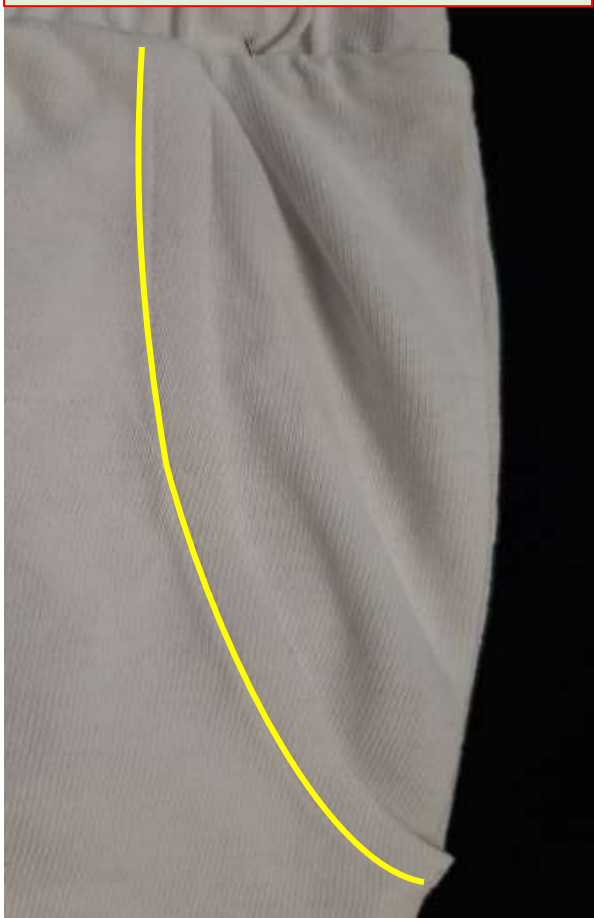


Figure: 3. 31 Stitch

PIC 6. The bottom hem should be carefully. The stitches from the edge should be 1.5 cm. The distance between the stitches should be 0,3 cm. Please improve . The stitch of bottom hem is crooked, no excess fabric should be visible .Pls control it in bulk.

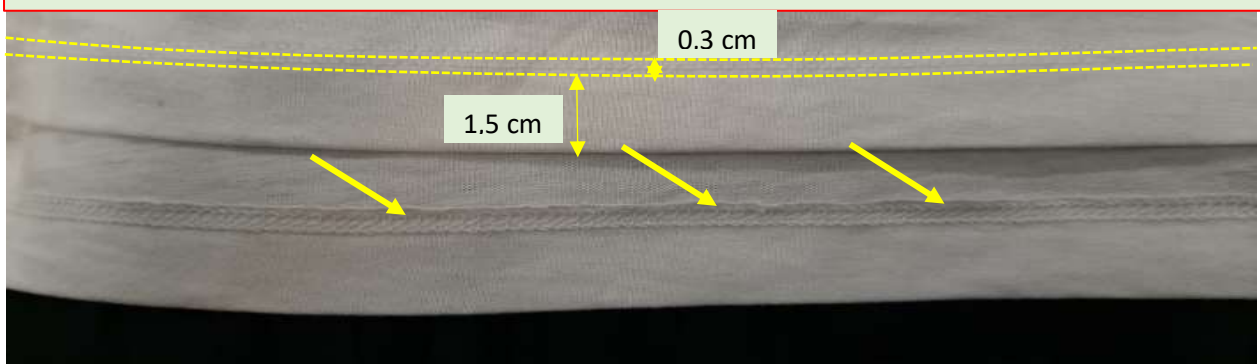


Figure: 3. 32 Sample Bottom

PIC 7. The neckline of back should be without crinkles, pls control it in bulk.



Figure: 3. 33 Neckline

PIC 8 Pls use main label No. 2.
Reg main label attaching follow our instruction below. The folding way should be as per at our instruction below.



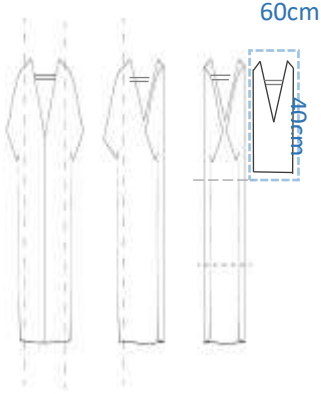
<p>MAIN LABEL, SIZE LABEL</p> <p>Place main label at center back neck. Attach size label to main label.</p> 	<p>CARE LABEL</p> <p>Place care label at left side seam 10 cm from bottom</p> 	<p>FOLDING</p> 
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Figure: 3. 34 Instruction of Accessories and Folding

3.1.5 Sample No: 05

	JERSEY	Sample size			Deviations allowed in production $n \pm$	SM	before
	2,021,555,526	S	M	L		12/4/2019	COMMENTS
A	FRONT LENGTH from H.S.P. to bottom	87.5	88.0	91.5	1.5	87.5	Pls keep 87,5
B	BACK LENGTH by centre	83.5	83.5	86.5	1.5	83.5	Pls keep 83,5
C	1/2 CHEST WIDTH under armpit	49.0	52.0	55.0	1.0	47.0	Pls keep 49,0
W	1/2 WAIST WIDTH, 40 cm from H.S.P.	54.0	57.0	60.0	1.0	53.7	
D	1/2 BOTTOM WIDTH	72.0	75.0	78.0	1.0	72.0	
E	BACK NECK WIDTH	19.5	20.0	20.5	0.8	18.5	Pls strictly 19,5 cm
F1	NECK DROP FRONT	9.5	9.7	9.9	0.5	9.3	Pls strictly 9,5 cm
F2	NECK DROP BACK	2.0	2.1	2.2	0.2	2.0	Pls strictly 2,0 cm
J	SHOULDER	5.0	5.3	5.6	0.3	5.5	
K	ARMPIT DEPTH straight angle from L.P.S.	18.0	18.5	19.0	0.5	18.0	
M1	BACK WIDTH 13cm from H.P.S	30.5	32.0	33.5	0.5	30.5	Pls keep 30,5 cm
M2	FRONT WIDTH 13cm from H.P.S	28.5	30.0	31.5	0.5	29.0	

Table: 3. 5 Sample Measurements No: 5

COMMENTS:

1. Fabric quality - pls follow the quality confirmed
2. The neckline and armhole workmanship are correct on the sample.PIC 1.
3. Pls control workmanship of main label, it should be even.PIC 2
4. The armhole is stretched, pls control it in bulk. In the first sample it was better.PIC 3.
5. The workmanship of the bottom edge is correct on the sample. PIC 4. Please control the inside, there should not be excess fabric.
6. The quality of the seams should be better, the seams should be whole, without breaking, please control it in bulk.PIC 5. Pls do not tighten the armhole and neckline when sewing.
7. All seams should be made accurately, seams should not be with fringe, all threads should be cut. Please control it.
8. PIC 4.Main label is correct, pls use main label No.2. Reg main label attaching follow our instruction below. The folding way should be as per at our instruction below.

PIC 1. The neckline and armhole workmanship are correct on the sample.



Figure: 3. 35 Neckline and armhole

PIC 2. Pls control workmanship of main



Figure: 3. 36 Main label

PIC 3. The armhole is stretched, pls control it in bulk. in the first sample it was better.



Figure: 3. 37 Armhole

PIC 4. The workmanship of the bottom edge is correct on the sample. Please control the inside, there should not be excess fabric.



Figure: 3. 38 Bottom edge

PIC 5. The quality of the seams should be better, the seams should be whole, without breaking, please control it in bulk.

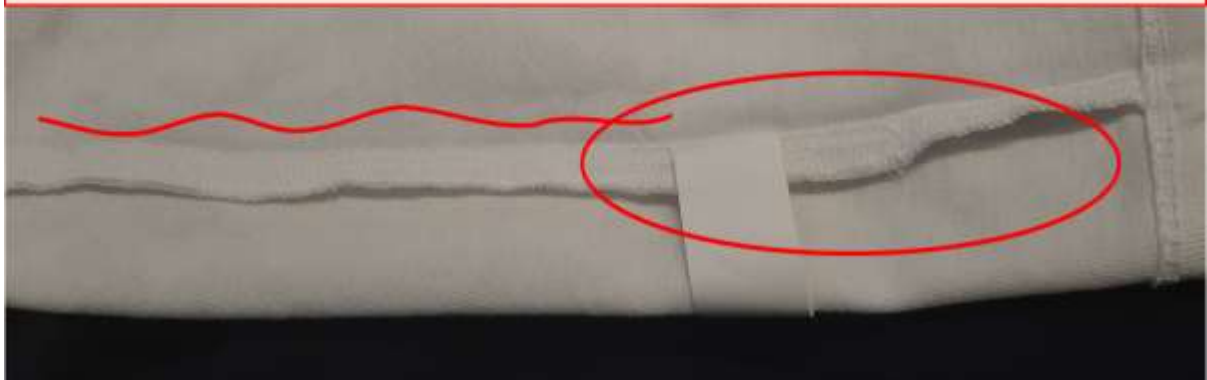


Figure: 3. 39 Seam

PIC 6. Main label is correct, pls use main label No.2. Reg main label attaching follow our instruction below.
 The folding way should be as per at our instructio below.



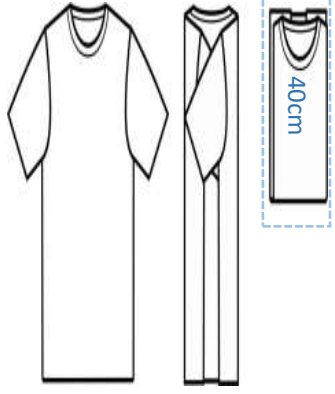
<p style="writing-mode: vertical-rl; transform: rotate(180deg);">MAIN LABEL, SIZE LABEL</p> <p>Place main label at centre back neck. Attach size label to main label.</p> 	<p style="writing-mode: vertical-rl; transform: rotate(180deg);">CARE LABEL</p> <p>Place care label at left side seam 10 cm from bottom</p> 	<p style="writing-mode: vertical-rl; transform: rotate(180deg);">FOLDING</p> 
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Figure: 3. 40 Instruction of Accessories and Folding

3.1.6 Sample No: 06

	Jersey dress	Sample size			Deviations allowed in production \pm	SM	befree
	2,021,555,528	S	M	L		11/28/2019	COMMENTS
A	FRONT LENGTH from HPS to bottom	11 1.0	11 3.5	11 4.0	1.0	111.0	Pls prolong it by 1,0 cm.
A1	FRONT LENGTH from HPS to pocket	19. 0	19. 5	20. 0	1.0	18.0	Pls lower it by 1,0 cm. See pic.4.
B	BACK LENGTH by centre	10 5.0	10 7.0	10 7.0	1.0	103.0	Pls lift F2 by 1,0 cm. Pls prolong it by 1,0 cm See pic.4.
C	1/2 CHEST WIDTH under armpit	46. 5	49. 5	52. 5	1.0	48.5	Pls narrow it by 2,0 cm. See pic.4.
H	1/2 BOTTOM WIDTH	55. 0	58. 0	61. 0	1.0	55.0	
E	BACK NECK WIDTH	22. 0	22. 5	23. 0	0.5	19.6	Pls widen it by 2,4 cm. See pic.4.
F1	NECK DROP FRONT from HPS to bottom	17. 0	17. 1	17. 2	0.5	15.0	Pls deepen it by 2,0 cm. See pic.4.
F2	NECK DROP BACK	8.0	8.0	8.0	0.2	9.0	Pls lift it by 1,0 cm. See pic.4.
J	SHOULDER without plackets	2.0	2.4	2.4	0.1	1.6	Pls widen it by 0,4 cm. See pic.4.
K	ARMPIT DEPTH straight angle from L.P.S.	21. 0	21. 5	22. 0	0.5	21.0	
M1	BACK WIDTH 13cm from H.P.S	23. 2	23. 7	24. 2	0.5	20.0	Pls widen it by 3,2 cm. See pic.4.
M2	FRONT WIDTH 13cm from H.P.S	25. 5	27. 0	28. 5	0.5	21.5	Pls widen it by 4,0 cm. See pic.4.
N1	PIPING WIDTH	1.0	1.0	1.0	0.0	1.0	
N3	1/2 NECK LENGTH	37. 8	38. 5	39. 2	0.5	34.5	See pic.4.
R1	POCKET HEIGHT	11. 0	11. 0	11. 0	0.3	10.6	
R2	POCKET WIDTH	10. 0	10. 0	10. 0	0.3	9.9	
R3	DISTANCE FROM POCKET TO ARMHOLE	2.0	2.5	2.5	0.3	2.5	Pls change pocket placement. See pic.4.
R4	DISTANCE FROM POCKET TO SIDE SEAM	9.0	9.5	9.5	0.5	13.5	Pls change pocket placement. See pic.4.
S	SLIT LENGTH	27. 0	27. 0	27. 0		30,0+30, 5	Pls shorten it by 3,0 cm. They should be symmetrical.

Table: 3. 6 Sample Measurements No: 6

Comments:

1. Jersey quality is correct on sample. Please pay attention to jersey print color 5, 8, 55 matching and symmetry. See pic.1
2. The piping quality is correct on sample. See pic.2. The piping width is correct on sample. Piping should be cut from main jersey and be one colored. See pic. 1B.
3. Placket is correct on sample. See pic.3. Pls make plackets more rolled, so cut them shorter than armhole and neck length.
4. Pls change patterns according to the table above and the picture 4.
5. Pls control pocket placement. See pic.5. Pls improve pocket workmanship.
6. Fixing stitches at the placket near side seams and near left shoulder seam are correct on sample. See pic.6.
7. Slit workmanship is correct. See pic.7. Pls control slit length. Slit sides should be symmetrical.
8. Main and care labels are correct on sample. See pic.8.

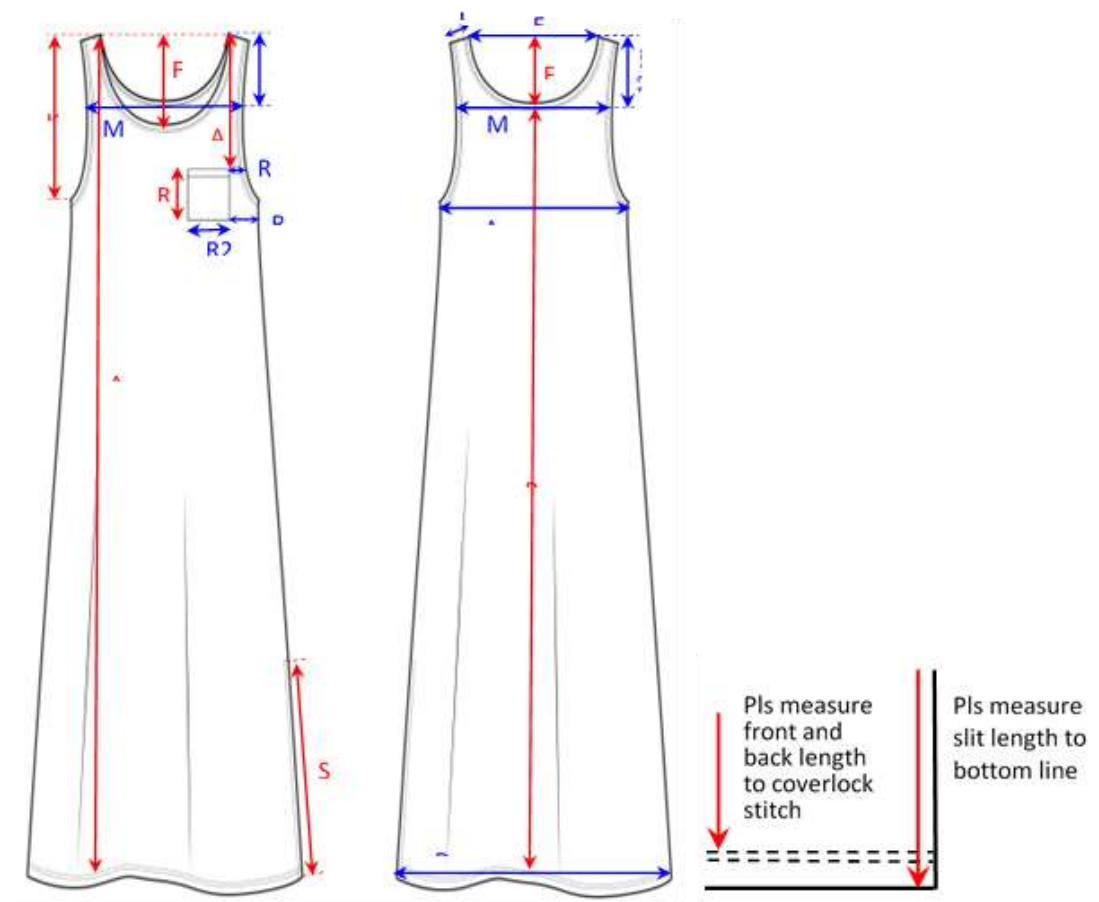


Figure: 3. 41 Sample Front and Back part

Pic.1. Jersey quality is correct on sample. Please pay attention to jersey print color 5, 8, 55 matching and symmetry.

- bottom line should be along wide print line. Rolled bottom should be in one color. See pic. A;
- neck and shoulder plackets and back neck piping should be in one color. See pic. B;
- pocket should match to front detail. See pic. C.

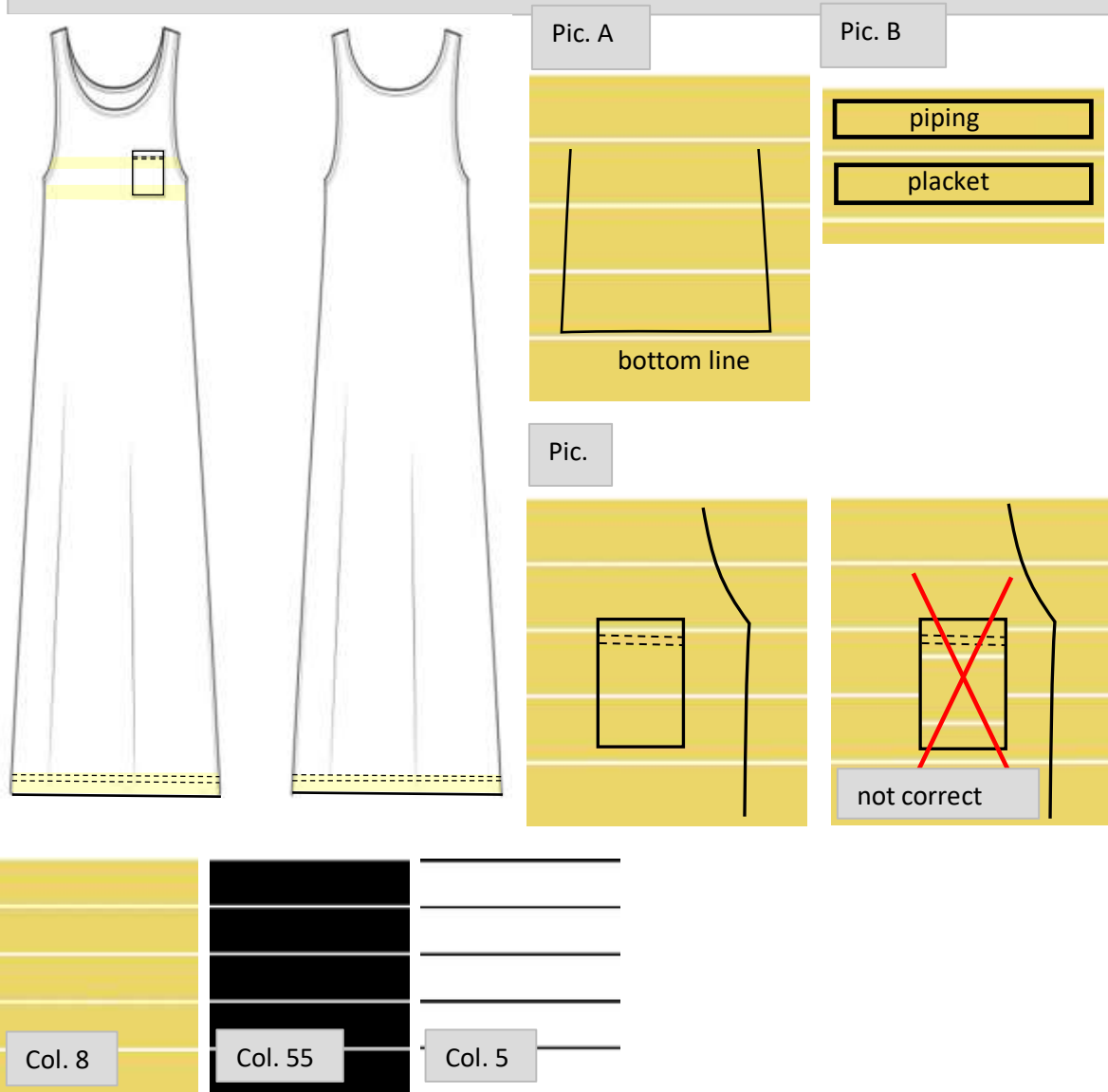


Figure: 3. 42 Position of Pocket, bottom and neck line

Pic.3. Plackets and bottom workmanship are correct on sample.
 Pls make plackets more rolled, so cut them shorter than armhole and neck length.

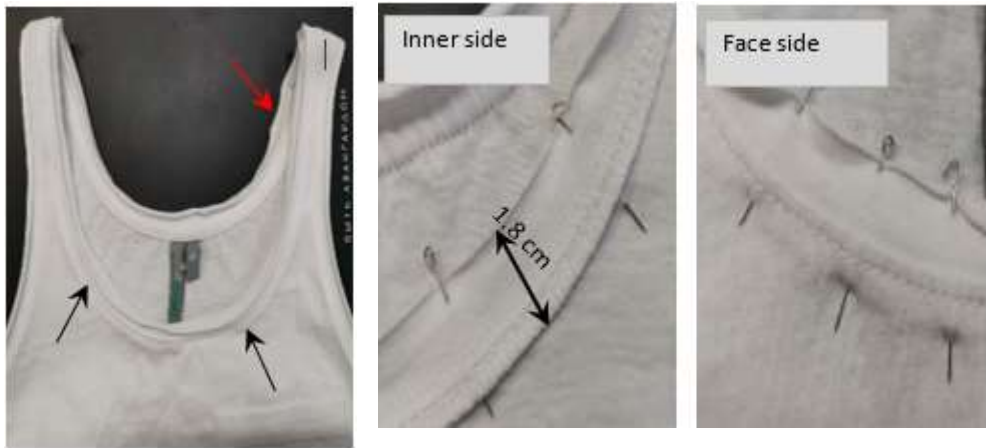


Figure: 3. 43 Placket and Bottom

Bottom workmanship.

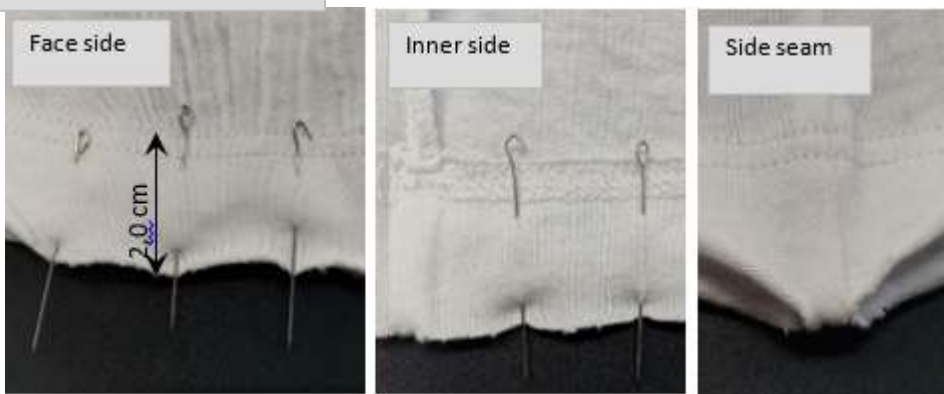


Figure: 3. 44 Bottom

Pic.6. Fixing stitches at the placket near side seams and near left shoulder seam are correct on sample.

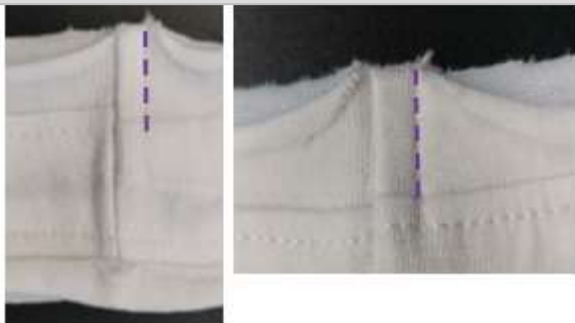


Figure: 3. 45 Stitch

Pic.2. The piping quality is correct on sample. The piping width is correct on sample. Piping should be cut from main jersey and be one colored. See pic. 1B.



Figure: 3. 46 Piping

Pic.4. Pls change patterns according to the table above and the picture.

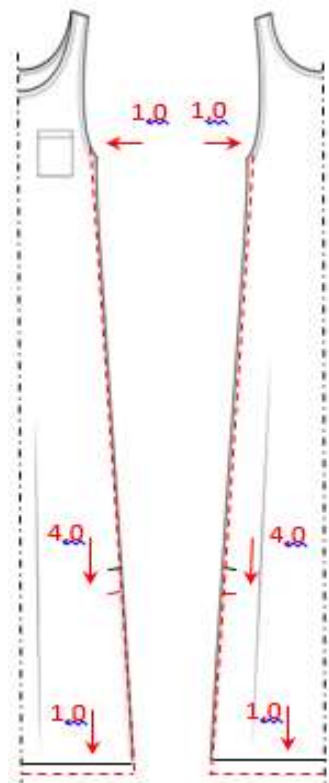
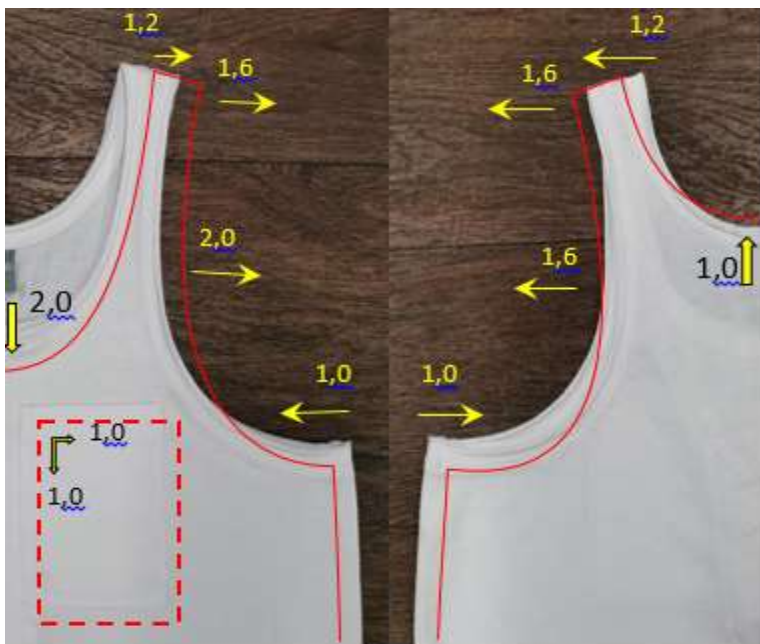


Figure: 3. 47 Pattern

Pic.5. Pls control pocket placement. Pls improve pocket workmanship. Pocket sides should be perpendicular to each other. Pls control distance between top pocket side and fashion seam.

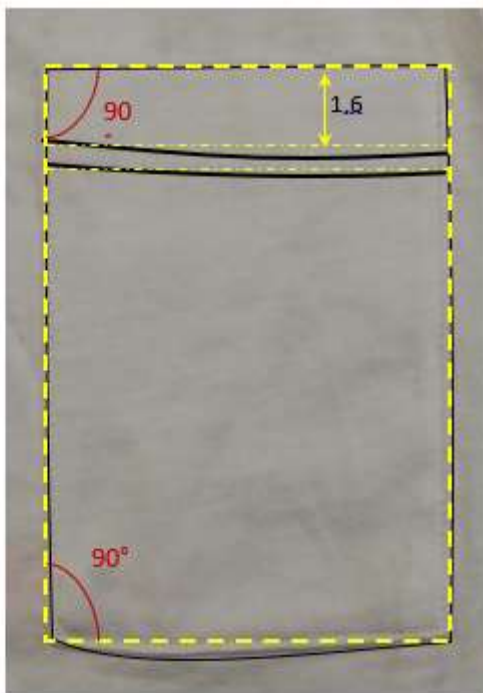
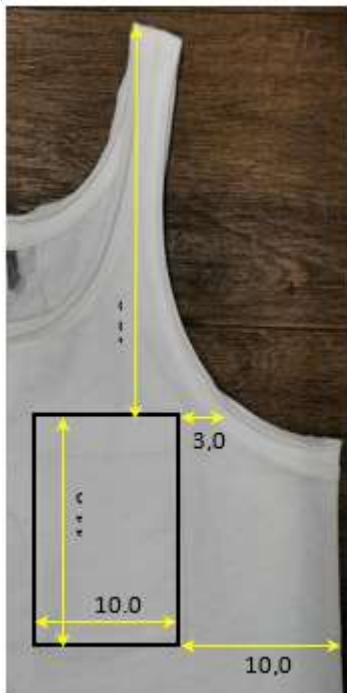


Figure: 3. 48 Pocket

Pic.7. Slit workmanship is correct.
Pls control slit length. Slit sides should be symmetrical.

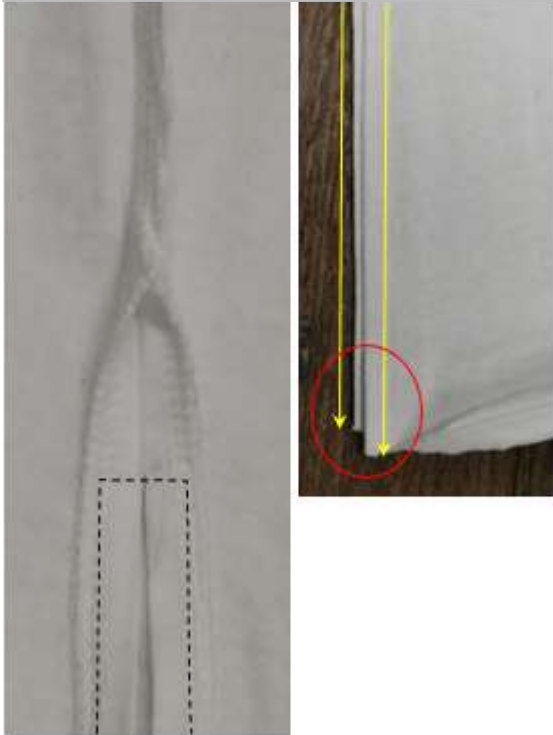


Figure: 3. 49 Slit

Pic.8.



Figure: 3. 50 Instruction of Accessories and Folding

3.1.7 Sample No: 07

	BLOUSE					Deviations allowed in production ±	SM size S	befree
	2031060410		38	40	42		12/5/2019	COMMENTS
			M	L	XL			
A	FRONT LENGTH from H.S.P. (from shoulder fold) to bottom	46.0	46.5	49.0	49.5	1.0	45.0	Pls follow PIC 5
A1	FRONT LENGTH from H.S.P. to pocket	18.5	18.8	19.1	19.4	0.5	18.0	Pls follow PIC 3
B	BACK LENGTH by centre	44.5	44.5	46.5	46.5	1.0	43.5	Pls follow PIC 4
C	1/2 CHEST WIDTH under armpit	47.0	49.0	51.0	53.0	1.0	47.0	
H	1/2 BOTTOM WIDTH	45.0	47.0	49.0	51.0	1.0	45.0	
E	BACK NECK WIDTH	16.5	16.9	17.3	17.7	0.5	16.5	
F1	NECK DROP FRONT	10.5	10.7	10.9	11.1	0.5	10.5	
F2	NECK DROP BACK	2.5	2.6	2.7	2.8	0.0	2.5	
G	SLEEVE LENGTH short with cuff	15.0	15.3	15.6	15.9	0.5	15.0	
Z1	1/2 BICEPS direct under arm pit	16.0	16.6	17.2	17.8	0.5	16.0	
Z2	1/2 SLEEVE WIDTH at bottom	14.5	15.1	15.7	16.3	0.5	14.5	
K	ARMPIT DEPTH straight angle from L.P.S.	17.5	18.0	18.5	19.0	0.5	17.5	
J	SHOULDER	8.5	8.7	8.9	9.1	0.5	8.5	
M1	BACK WIDTH 13cm from H.P.S	35.0	36.0	37.0	38.0	0.5	35.0	
M2	FRONT WIDTH 13cm from H.P.S	33.5	34.5	35.5	36.5	0.5	33.5	
S1	NECK PLACKET WIDTH	1.5	1.5	1.5	1.5	0.0	1.5	
S2	1/2 PLACKET LENGTH	22.5	23.5	24.5	25.5	0.5	22.5	
V	BOTTOM HEM	2.0	2.0	2.0	2.0	0.0	2.0	
P	POCKET WIDTH	10.0	10.0	10.5	10.5	0.0	10.0	
P1	POCKET LENGTH	10.0	10.0	10.5	10.5	0.0	10.0	
P2	POSITION OF POCKET from side seam	9.0	9.0	9.5	9.5	0.5	9.0	

Table: 3. 7 Sample Measurements No: 7

Comment:

1. Fabric quality is correct on sample.
 2. "The quality (2*2) of rib is Ok.
The color should be match to main jersey collar. Pic 1"
 - The collar should be:
 - col 15 - rib s/b khaki color
 - col 65 - rib s/b black color
 - col 75 - rib s/b red color
 - col 95- rib s/b pink color
 3. Shell tape inside is correct on sample.PIC 2.
 4. Pocket made crooked, please improve. PIC 3. The pocket must match the table and should be stitched evenly.
 5. Pls modify the top part of back and the sleeve.PIC 4.
 6. "The line of bottom hem is crooked, pls improve .Pls add 1,0 to bottom hem of front.PIC 5 ."
 7. Pls change the workmanship of neck according to the scheme.PIC 6.
 8. The line of armhole should be smooth, pls improve.PIC 7.
Pls do not iron the sleeve, there should be no bend on the sleeve.
 9. The stitches from the edge should be 1.5 cm. PIC 8. The distance between the stitches should be 0.3 cm. Please improve
 10. Pls change the workmanship of armhole. Pls sew side seam and after sew sleeve. PIC 9.
9. Please find labeling and folding instruction at the bottom of size specie 10.

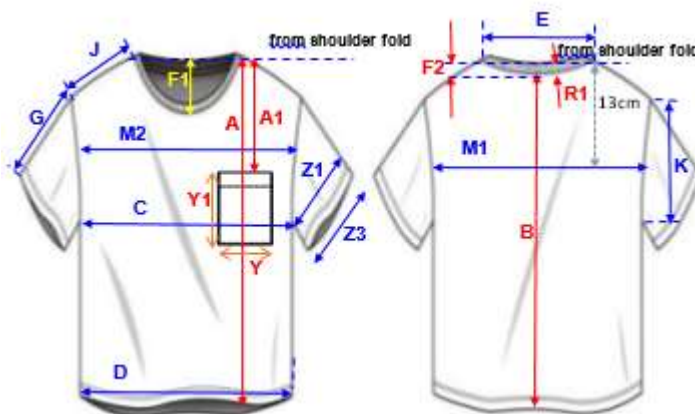


Figure: 3. 51 Sample Front and Back part

PIC 1.The quality (2*2) of rib is Ok.



Figure: 3. 52 Rib

PIC 2. Shell tape inside is correct on sample



Figure: 3. 53 Tape

PIC 3. Pocket made crooked, please improve. The pocket must match the table and should be stitched evenly.



Figure: 3. 54 Pocket

PIC 4. Pls modify the top part of back and the sleeve.

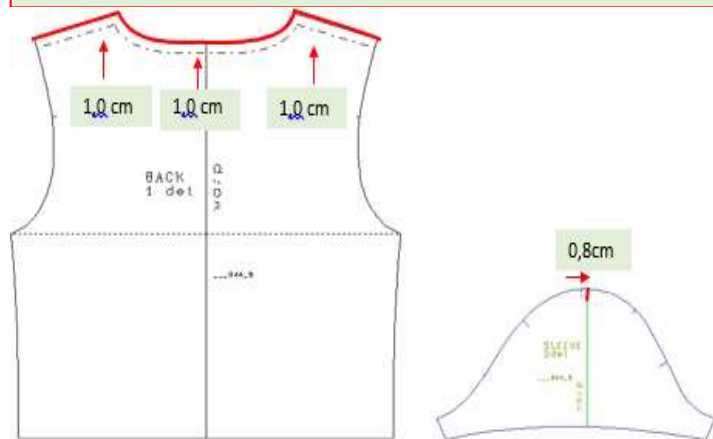


Figure: 3. 55 Pattern

PIC 5 . The line of bottom hem is crooked ,pls improve .Pls add 1,0 to bottom hem of front.



Figure: 3. 56 Bottom

PIC 6 . Pls change the workmanship of neck according to the scheme.

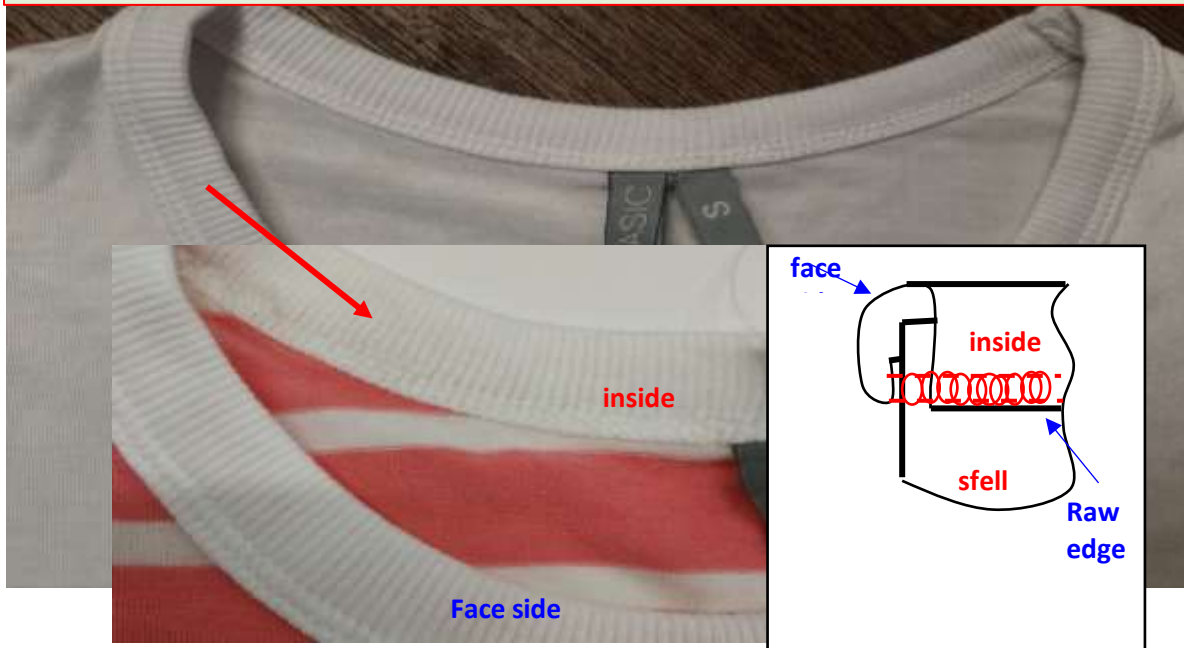


Figure: 3. 57 Neck

PIC 8. The stitches from the edge should be 1.5 cm.
The distance between the stitches should be 0,3 cm. Please improve .

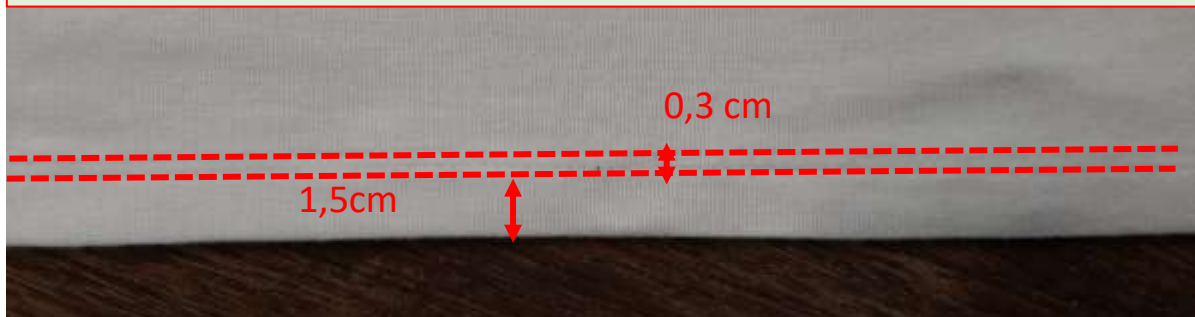


Figure: 3. 58 Stitch

PIC 7. The line of armhole should be smooth, pls improve. Pls do not iron the sleeve, there should be no bend on the sleeve.



Figure: 3. 59 Armhole line

PIC 9. Pls change the workmanship of armhole. Pls sew side seam and after sew sleeve.



Figure: 3. 60 Armhole seam

MAIN LABEL, SIZE LABEL

Place main label at center back neck. Attach size label to main label.

CARE LABEL

Place care label at left side seam 10 cm from bottom

FOLDING

PIC 10. Main label is correct, pls use main label No.2. Reg main label attaching follow our instruction below. The folding way should be as per at our instructio below.

Figure: 3. 61 Accessories and folding

3.1.8 Sample No: 08

JERSEY			Sample size				Deviations allowed in production \pm	AS size S	before
2,031,060,447	XX S	XS	S	M	L	XL		1/21/2020	COMMENTS
FRONT LENGTH from HPS (from fold) to bottom	54.0	54.0	54.0	54.0	56.0	56.0	1.0	54.0	
BACK LENGTH by centre	40.0	40.0	40.0	40.0	42.0	42.0	1.0	40.5	
1/2 CHEST WIDTH under armpit	33.0	35.0	37.0	40.0	43.0	46.0	1.0	36.0	Pls increase it by 1,0cm. See pic #2.
1/2 WAIST WIDTH, 38 cm from H.P.S.	30.0	32.0	34.0	37.0	40.0	43.0	1.0	33.0	Pls increase it by 1,0cm. See pic #2.
1/2 BOTTOM WIDTH	32.5	34.5	36.5	39.5	42.5	45.5	1.0	35.6	Pls increase it by 1,0cm. See pic #2.
NECK DROP FRONT from HPS (from fold)	18.1	18.3	18.5	18.7	18.9	19.1	0.5	18.5	
NECK DROP BACK from HPS (from fold)	14.0	14.0	14.0	14.0	14.0	14.0	0.5	13.5	
SHOULDER STRAP WIDTH	2.0	2.0	2.0	2.0	2.0	2.0	0.0	2.0	
ARMPIT DEPTH straight angle from L.P.S.	18.0	18.5	19.0	19.5	20.0	20.5	0.5	18.5	
BACK WIDTH 14cm from HPS	22.0	23.0	24.0	25.5	27.0	28.5	0.5	24.0	
FRONT WIDTH 14cm from HPS	23.5	24.5	25.5	27.0	28.5	30.0	0.5	24.0	Pls increase it by 1,5cm. See pic #4.
PLACKET WIDTH	1.7	1.7	1.7	1.7	1.7	1.7	0.0	1.7	
1/2 ARMHOLE PLACKET LENGTH	20.1	20.8	21.5	22.5	23.5	24.5	0.5	23.0	Pls reduce it by 1,5cm. See pic #5.

Table: 3. 8 Sample Measurements No: 8

COMMENTS:

1. Jersey quality is not correct on sample. It's very transparent!
2. Body bottom and string workmanship is correct on sample. See pic #1.
3. Pls make the fitting and measurement corrections according to pic #2. See the changes in the table above.
4. Pls control the symmetry of front neck. See pic #3.
5. Pls follow labeling and folding instruction below.
6. Pls change the shape of armhole. See pic #4.
7. Pls reduce the length of armhole plackets. Now they are too long and flabby. See pic #5 and size chart above.

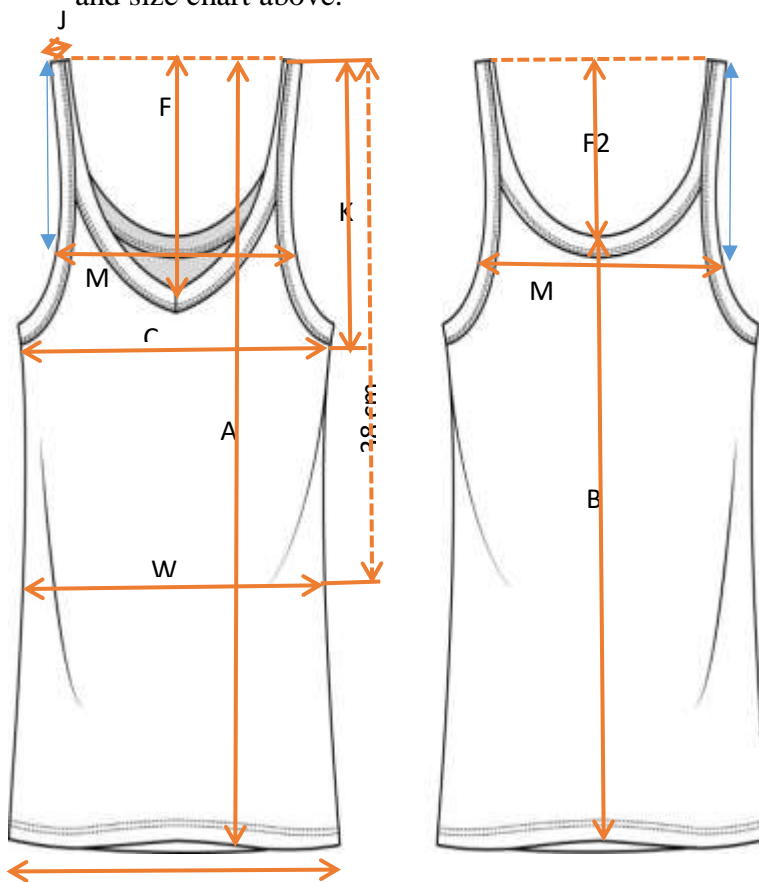


Figure: 3. 62 Sample front and back part

#1. Body bottom and string workmanship is correct on sample.

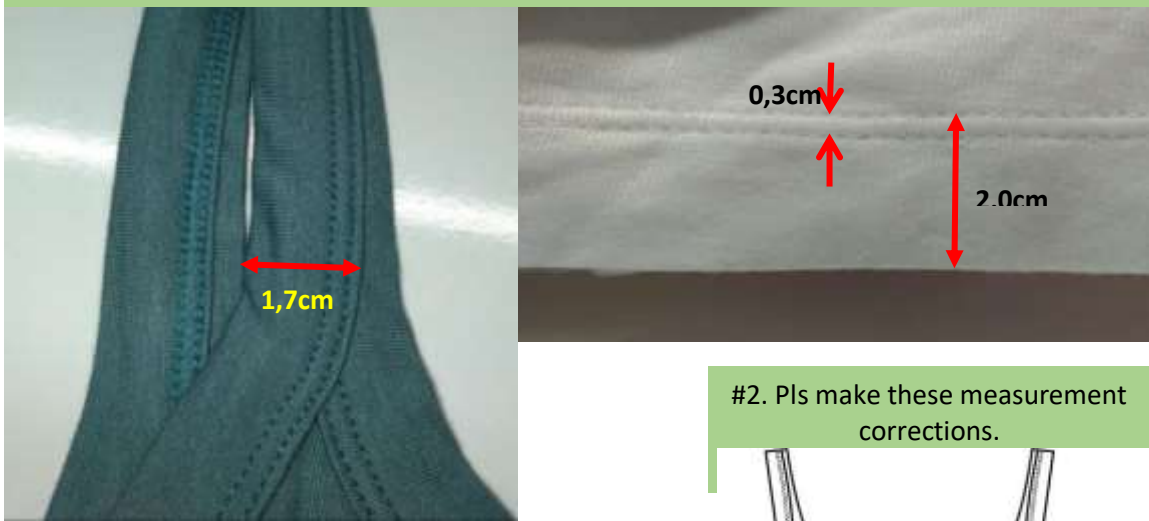


Figure: 3. 63 Bottom and String

#2. Pls make these measurement corrections.

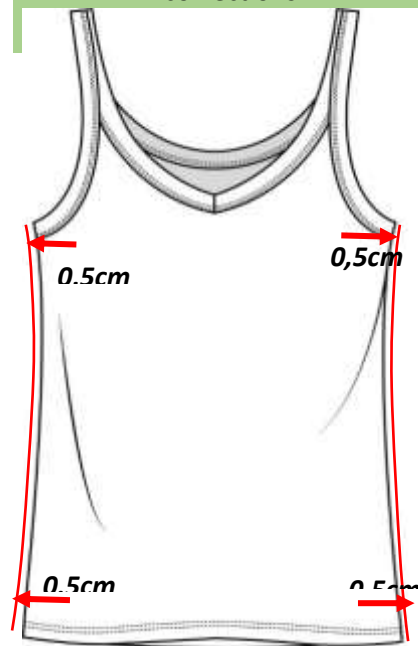


Figure: 3. 64 Pattern

#3. Pls control the symmetry of front low neck.



Figure: 3. 65 Neck

#4. Pls change the shape of armhole.



Figure: 3. 66 Armhole

#5. Pls reduce the length of armhole plackets. Now they are too long and flabby.



Figure: 3. 67 Armhole Placket


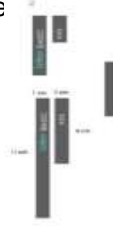

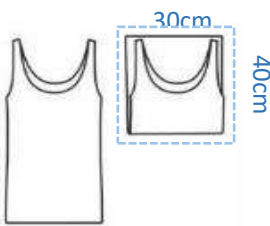
MAIN LABEL, SIZE LABEL	<p>Place main label at centre back neck. Attach size label.</p>  
CARE LABEL	<p>Place care label at left side seam 10 cm from bottom</p> 
FOLDING	

Figure: 3. 68 Accessories and Folding

3.1.9 Sample No: 09

	JERSEY			Sample size				Deviations allowed in production \pm	SM size S	S AS size S	befree
	2,031,061,448	XXS	XS	S	M	L	XL		12/16/2019	1/31/2020	COMMENTS
A	FRONT LENGTH from H.S.P. to bottom	48.0	48.5	49.0	49.5	53.0	53.5	1.0	49.0	47.8	Pls control length
B	BACK LENGTH by centre	39.5	39.5	39.5	39.5	42.5	42.5	1.0	39.5	39.0	
C	1/2 CHEST WIDTH under armpit	31.5	33.5	35.5	38.5	41.5	44.5	1.0	34.5	35.5	
W	1/2 WAIST WIDTH 26 cm from H.P.S.	26.0	28.0	30.0	33.0	36.0	39.0	1.0	30.5	29.7	
D	1/2 BOTTOM WIDTH	30.0	32.0	34.0	37.0	40.0	43.0	1.0	34.0	34.0	
F1	NECK DROP FRONT	8.1	8.3	8.5	8.7	8.9	9.1	0.2	8.5	8.2	
J2	SHOULDER STRAP LENGTH	23.5	24.0	24.5	25.0	25.5	26.0	0.5	23.5	25.0	
K	ARMPIT DEPTH straight angle from L.P.S.	8.0	8.5	9.0	9.5	10.0	10.5	0.5	8.8	8.5	
M1	BACK WIDTH from strap centre to strap centre	13.5	14.5	15.5	16.5	17.5	18.5	0.5	14.5	15.5	
M2	FRONT WIDTH between strap front	20.3	20.9	21.5	22.4	23.3	24.2	0.5	18.0	22.0	
R1	PIPING WIDTH	0.9	0.9	0.9	0.9	0.9	0.9	0.0	0.9	0.9	
R2	BOTTOM FINISH	2.0	2.0	2.0	2.0	2.0	2.0	0.0	2.0	2.0	
Q	weight			77.0							

Table: 3. 9 Sample Measurements No: 9

Comments:

1. Jersey quality is correct on sample. Please pay attention to jersey stripes for color 5 matching and symmetry. See pic.1.
2. The color of thread should be matched to color jersey.
3. Using main jersey for piping is correct on sample. See pic.2. Piping workmanship is correct. Using chain stitching for piping is correct on your sample. Pls control piping tightness. Armhole and neck lines should not be deformed. Neck and armhole measures should have the same length before and after fitting. Pls control it. Fixing stitches are correct on sample.
4. Pls control all measures. Pls correct armhole form. See pic.3.
5. Bottom hem is correct on sample. See pic.4. Pls control bottom line. It should be smooth. Pls don't stretch bottom line.
6. Main care design is correct on sample. Pls correct its placement. It should be vertical. See pic.5. Care label design and position are correct on sample.

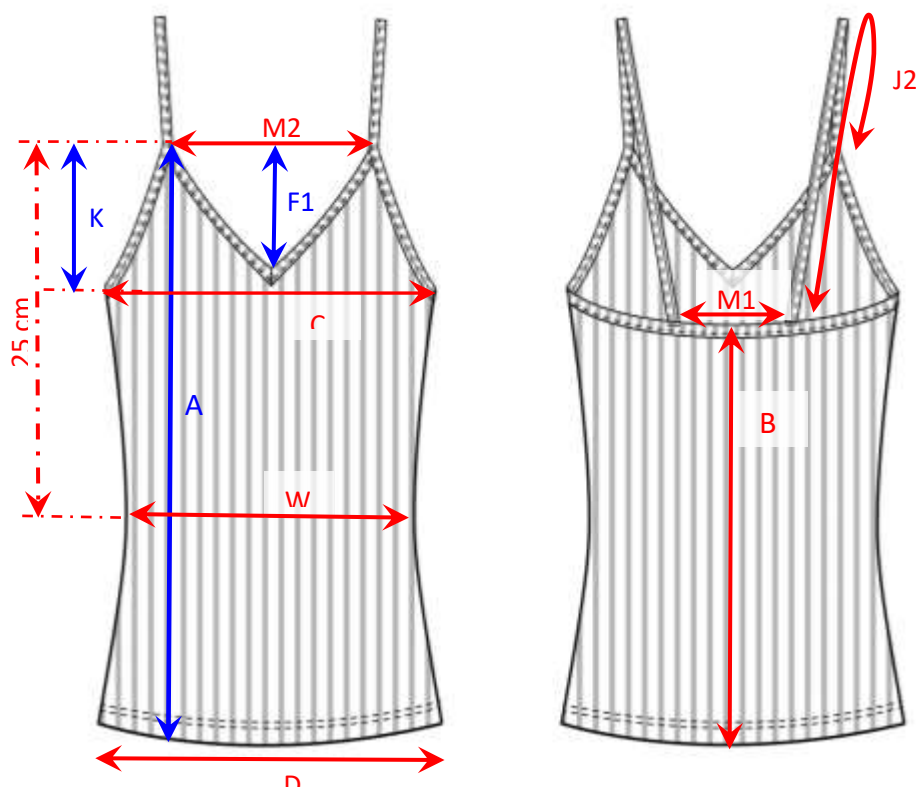
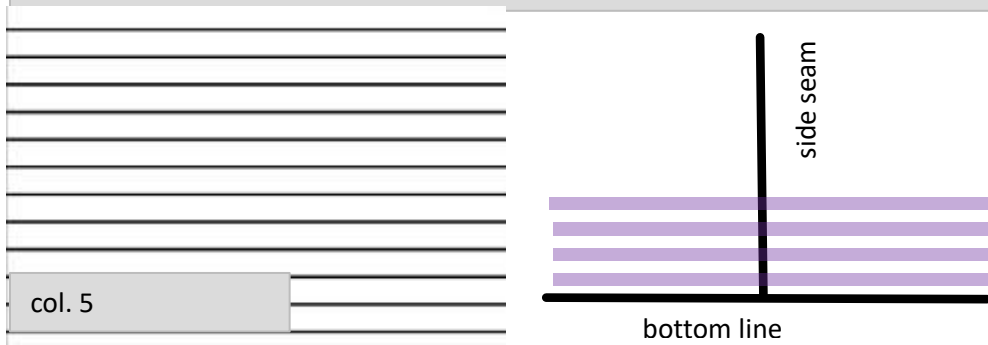


Figure: 3. 69 Sample Front and back part

Pic.1. Jersey quality is correct on sample. Please pay attention to jersey stripes for color 5 matching and symmetry.



Pls control horizontal matching.

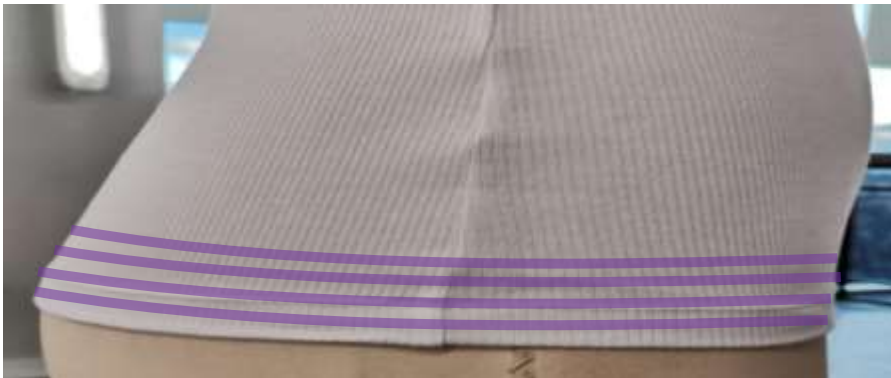


Figure: 3. 70 Bottom

Pic.3. Pls correct armhole

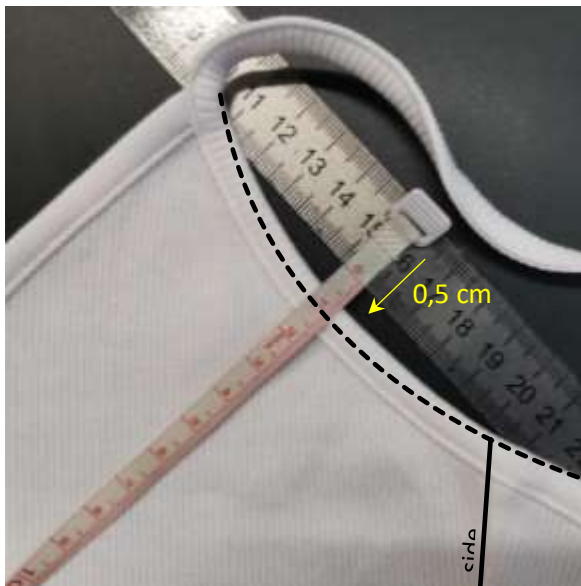


Figure: 3. 71 Armhole

Pic.4. Bottom hem is correct on sample. Pls control bottom line. It should be smooth. Pls don't stretch bottom line.

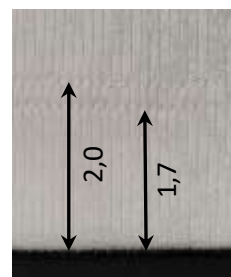
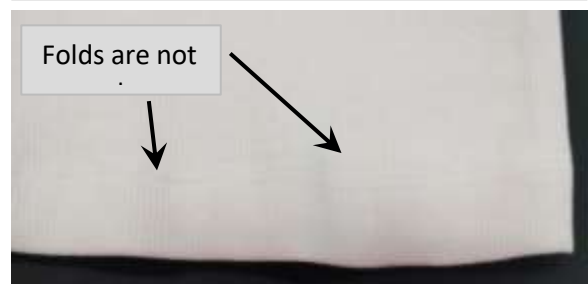


Figure: 3. 72 Bottom hem

Pic.2. Using main jersey for piping is correct on sample.

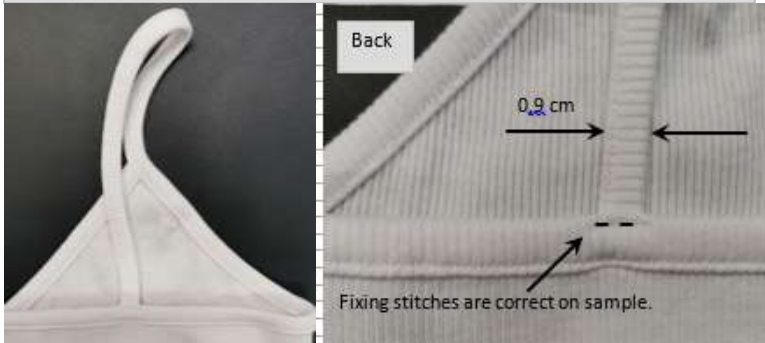


Figure: 3. 73 Piping



Figure: 3. 74 Inner and Face side Piping

Pls control piping tightness. Armhole and neck lines should not be deformed. Neck and armhole measures should have the same length before and after fitting. Pls control it.



Figure: 3. 75 Back part of Sample

Pic.5. Main care design is correct on sample. Pls correct its placement. It should be vertical. Care label design and position are correct on sample.

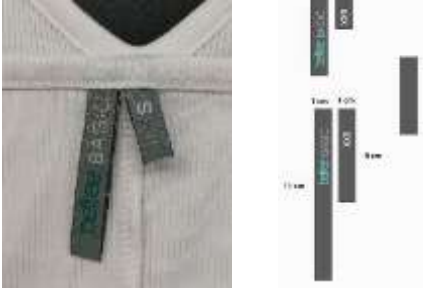
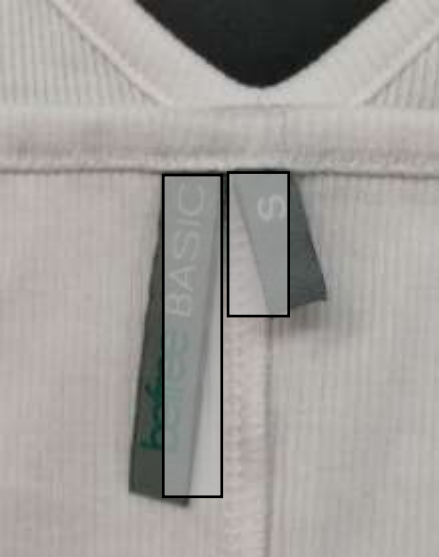

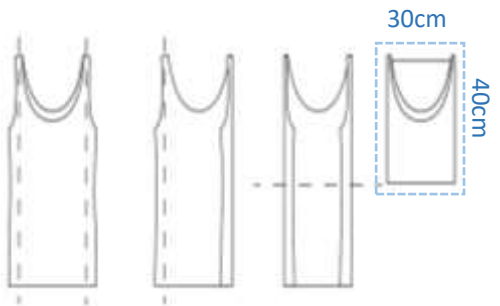
<p style="writing-mode: vertical-rl; transform: rotate(180deg);">MAIN LABEL, SIZE LABEL</p>	<p>Place main label at centre back neck. Attach size label to main label.</p> 	
<p style="writing-mode: vertical-rl; transform: rotate(180deg);">CARE LABEL</p>	<p>Place care label at left side seam 10 cm from bottom</p> 	
<p style="writing-mode: vertical-rl; transform: rotate(180deg);">FOLDING</p>		

Figure: 3. 76 Accessories and folding

3.1.10 sample No: 10

	JERSEY		Sample size				Deviations allowed in production ±	2AS size S	befree
	2,031,061,507								
		XS	S	M	L	XL		1/30/2020	COMMENTS
A	FRONT LENGTH from H.S.P. to bottom	95.5	96.0	96.5	100.0	100.5	1.5	94.5	Pls control measure.
B	BACK LENGTH by centre	87.0	87.0	87.0	90.0	90.0	1.5	86.5	Pls control measure.
C	1/2 CHEST WIDTH under armpit	33.5	35.5	38.5	41.5	44.5	1.0	36.0	
W	1/2 WAIST WIDTH 26 cm from H.P.S.	28.0	30.0	33.0	36.0	39.0	1.0	29.5	
H	1/2 HIP WIDTH, 50 cm from H.P.S.	35.0	37.0	40.0	43.0	46.0	1.0	36.5	Pls control measure.
D	1/2 BOTTOM WIDTH	36.5	38.5	41.5	44.5	47.5	1.0	38.0	
F1	NECK DROP FRONT	7.8	8.0	8.2	8.4	8.6	0.2	7.5	
J2	SHOULDER STRAP LENGTH	23.5	24.0	24.5	25.0	25.5	0.5	24.0	
K	ARMPIT DEPTH straight angle from L.P.S.	7.5	8.0	8.5	9.0	9.5	0.5	7.8	
M1	BACK WIDTH from strap centre to strap centre	14.9	15.5	16.5	17.5	18.5	0.5	15.2	
M2	FRONT WIDTH between strap front	20.9	21.5	22.5	23.5	24.5	0.5	21.5	
R1	PIPING WIDTH	0.9	0.9	0.9	0.9	0.9	0.0	0.9	
R2	BOTTOM FINISH	2.0	2.0	2.0	2.0	2.0	0.0	2.0	
S	SLIT LENGTH	21.5	21.5	21.5	21.5	21.5	0.0	21.7	Pls control slit sides measures.

Table: 3. 10 Sample Measurements No: 10

COMMENTS:

1. Jersey quality is correct on sample. Please pay attention to jersey stripes for color 5 matching and symmetry. See pic.1.
2. The color of thread should be matched to color jersey.
3. Using main jersey for piping is correct on sample. See pic.2. Piping workmanship is correct. Using chain stitching for piping is correct on your sample. Pls control piping tightness. Armhole and neck lines should not be deformed. Neck and armhole measures should have the same length before and after fitting. Pls control it. Fixing stitches are correct on sample.
4. Pls control all measures. Slit sides should be symmetrical and have the same length
5. Pls correct armhole form. See pic.3.
6. Pls correct slit workmanship. See pic.4.
7. Bottom hem is correct on sample. See pic.5.
Pls control bottom line. It should be smooth.
Pls don't stretch bottom line.
8. Main care design is correct on sample. Pls correct its placement. It should be vertical.
See pic.6. Care label design and position are correct on sample.

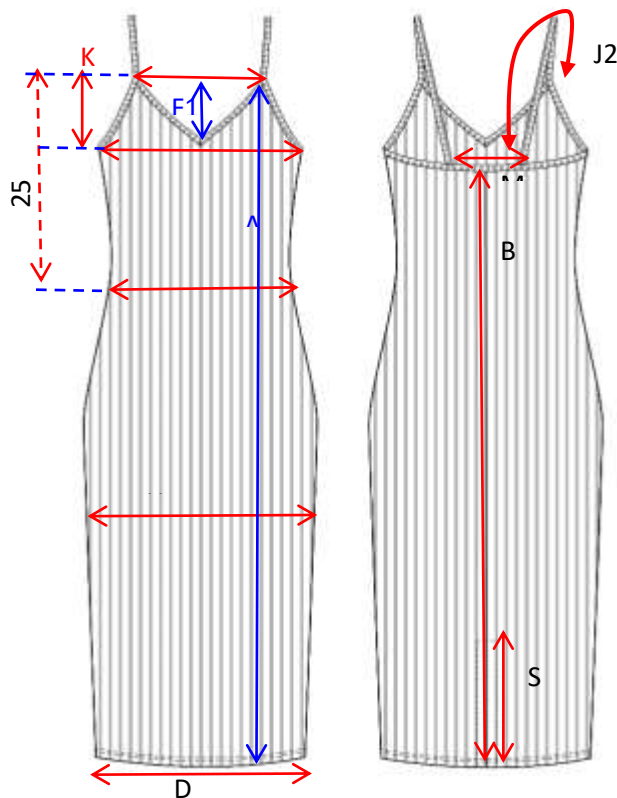


Figure: 3. 77 Sample Front and back part

Pic.1. Jersey quality is correct on sample. Please pay attention to jersey stripes for color 5 matching

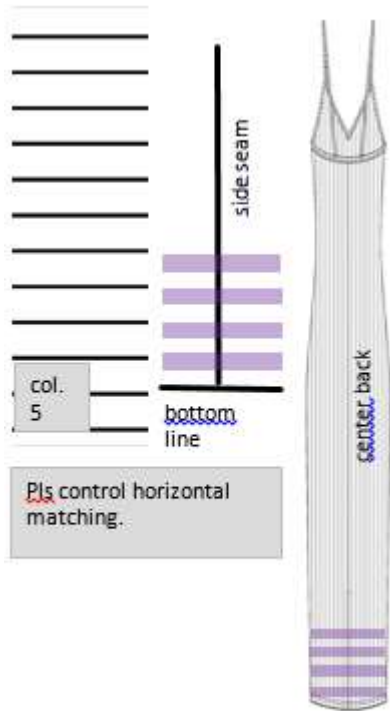


Figure: 3. 78 Bottom design

Pic.2. Using main jersey for piping is correct on sample.



Pls control piping tightness. Armhole and neck lines should not be deformed. Neck and armhole measures should have the same length before and after fitting. Pls control it.



Figure: 3. 79 Piping

Pic.4. Pls correct slit

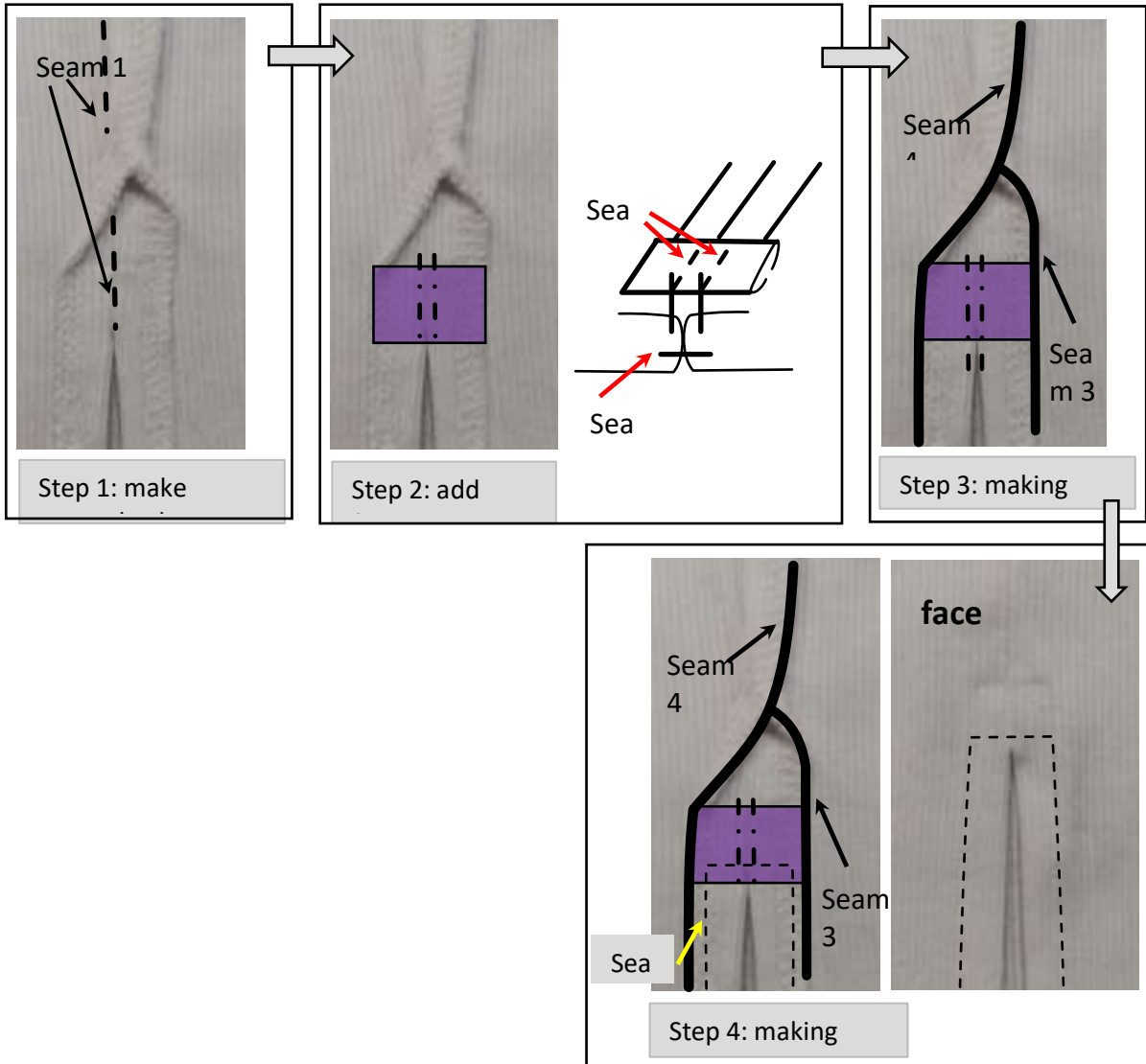


Figure: 3. 80 Seam

Pic.3. Pls correct armhole form.

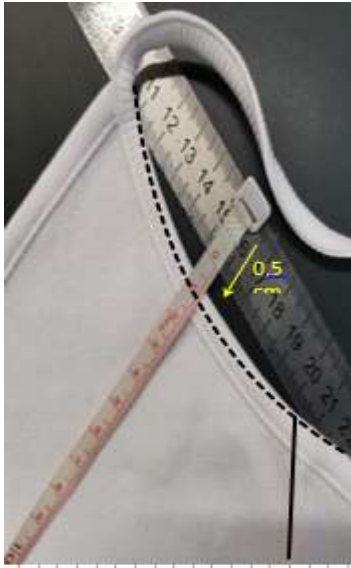


Figure: 3. 81 Armhole

Pic.5. Bottom hem is correct on sample. Pls control bottom line. It should be smooth. Pls don't stretch bottom line.

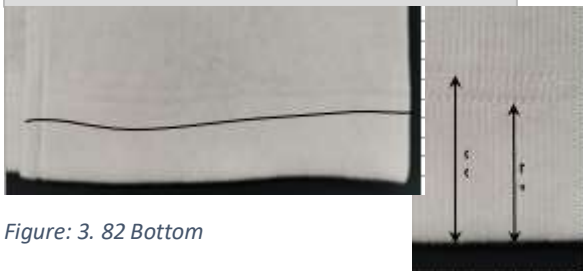


Figure: 3. 82 Bottom

Pic.6. Main label design is correct on sample. Pls correct its placement. It should be vertical. Care label design and position are correct on sample.

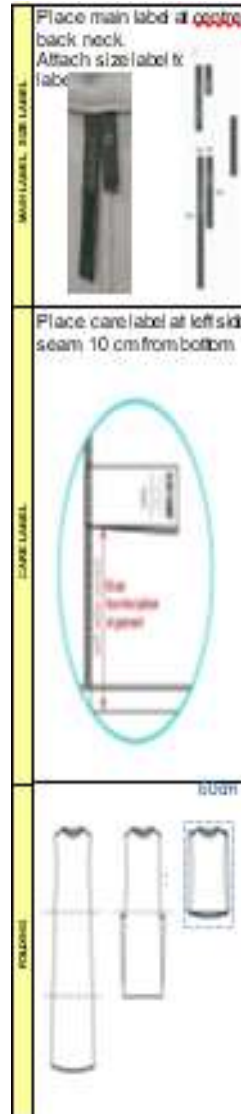


Figure: 3. 83 Instruction of Accessories and Folding

3.1.11 Sample No: 11

DESCRIPTION	POM Comments	TOL-	TOL+	Requested	Agent	Internal	Variance	Revise To	Comments
BL - Front length from HPS to bottom		3/8	3/8	28	0.0	28		28	
AB - Shoulder slope		1/4	1/4	2 1/4	0.0	2 1/4		2 1/4	
Shoulder seam forward		1/8	1/8	3/4	0.0	3/4		3/4	
AB - Across shoulder		1/4	1/4	17	0.0	16 3/4	-1/4	17 1/4	increase
AB - Across front 7" from HPS		1/4	1/4	15	0.0	14 3/4	-1/4	15	bts
AB - Across back 7" from HPS		1/4	1/4	15 1/2	0.0	15 1/4	-1/4	15 3/4	increase
AB - Chest width- 1" below armhole		1/2	1/2	20 1/2	0.0	20 1/4	-1/4	20 1/2	bts
Bottom opening width		1/2	1/2	20	0.0	20		20	
Bottom hem height		1/8	1/8	7/8	0.0	7/8		7/8	
NK - Neck width- HPS to HPS		1/8	1/8	6 3/4	0.0	6 3/4		6 3/4	
NK - Front neck drop from HPS		1/8	1/8	3 3/4	0.0	3 3/4		3 3/4	
NK - Back neck drop from HPS		1/8	1/8	1/2	0.0	3/8	-1/8	1/2	bts
NK - Neck trim binding height inside		1/8	1/8	3/8	0.0	3/8		3/8	
CL - Collar height @ CB	rib	1/8	1/8	2 3/4	0.0	2 1/4	-1/2	2 3/4	increase to our standard
CL - Collar spread		1/8	1/8	4	0.0	3 1/2	-1/2	4	bts
CL - Collar point		1/8	1/8	2 3/8	0.0	2	-3/8	2 3/8	increase to our standard
CL - Tie space		0.0	0.0	1/4	0.0	1/4		1/4	
Placket Length, including 3/8" box stitch at bottom		1/4	1/4	5 3/4	0.0	5 3/4		5 3/4	
PK - Placket width		1/8	1/8	1	0.0	1		1	
SL - Sleeve length from CB neck- 3 points-short		1/4	1/4	17 1/2	0.0	17 1/2		17 1/2	
AH - Armhole straight		1/4	1/4	8 3/4	0.0	8 7/8	1/8	8 3/4	bts
SL - Cap height		1/4	1/4	6 1/4	0.0	6 1/4		6 1/4	
SL - Muscle width 1" below armhole		1/4	1/4	7	0.0	7 1/4	1/4	7	bts
Sleeve opening width -short		1/4	1/4	6 3/4	0.0	6 3/4		6 3/4	
Sleeve rib height		1/8	1/8	3/4	0.0	3/4		3/4	
TR - Button spacing- 1st button from neck seam	to button center	1/8	1/8	1 3/4	0.0	1 3/4		1 3/4	
TR - Button spacing- remaining buttons	button center to center	1/8	1/8	2	0.0	2		2	
Pocket placement from HPS		1/4	1/4	7 1/2	0.0	7 3/4	1/4	7 1/2	bts
Pocket placement from CF		1/8	1/8	1 7/8	0.0	2	1/8	1 7/8	bts
Chest pocket width		1/4	1/4	3 3/4	0.0	3 3/4		3 3/4	
Chest pocket height @center		1/4	1/4	4 1/2	0.0	4 1/2		4 1/2	
Chest pocket height at sides		1/4	1/4	4	0.0	4		4	
Pocket stitch height	to bottom stitch	1/8	1/8	5/8	0.0	5/8		5/8	
Logo placement at inner pocket corner for ALL SIZES!!!	right above pocket opening topstitching	0.0	0.0	0.0	0.0	0.0	0.0	0.0	

Table: 3. 11 Sample Measurements No: 11

Comments:

1. Increase across shoulder +1/2" to finish at 16 1/4".
2. Increase across back +1/2" to finish at 15 3/4".
3. Collar height at center back should finish at 2 3/4" to follow as our polos with no collar band.
4. Collar point is missing -3/8". Increase to finish at 2 3/8".
5. Collar spread is missing -1/2". ". Increase to finish at 4".
6. Garment was twirking very badly. Must improve.
7. Shoulder seams were pulling a little. Must improve.
8. Improve sewing around neckline. Looks pulled in a bit. Adjust sewing tension.
9. Improve sewing around placket. Thread looks uneven. Placket edges can be straighter.
10. Bring all other measurements back to requested specs.

Construction Comments:

1. Garment was twirking very badly. Must improve.
2. Shoulder seams were pulling a little. Must improve.
3. Improve sewing around neckline. Looks pulled in a bit. Adjust sewing tension.

Improve sewing around placket. Thread looks uneven. Placket edges can be straighter



Figure: 3. 84 Sample front, side back and shoulder part

3.1.12 Sample No: 12

DESCRIPTION	POM Comments	TOL-	TOL+	Requested	Agent	Internal	Variance	Revise To	Comments
BL - Front length from HPS to bottom		3/8	3/8	28 1/2	0.0	28	-1/2	28 1/2	bts
AB - Shoulder slope		1/4	1/4	2 1/4	0.0	2 3/8	1/8	2 1/4	bts
Shoulder Seam forward evenly		1/8	1/8	3/4	0.0	1/2	-1/4	3/4	was uneven
AB - Across shoulder		3/8	3/8	17 1/2	0.0	17 1/4	-1/4	17 1/2	bts
AB - Across front 7" from HPS		3/8	3/8	15 1/4	0.0	15 1/2	1/4	15 1/4	bts
AB - Across back 7" from HPS		3/8	3/8	15 3/4	0.0	15 7/8	1/8	16 1/4	revise
AB - Chest width- 1" below armhole		1/2	1/2	21	0.0	21		21	
Bottom opening width-relaxed/straight		1/2	1/2	20 1/2	0.0	20 1/2		20 1/2	
Bottom hem height		1/8	1/8	7/8	0.0	7/8		7/8	
Sleeve length from CB - 3 points - short		3/8	3/8	17 3/4	0.0	17 3/4		17 3/4	
AH - Armhole straight		1/4	1/4	9	0.0	9		9	
SL - Cap height		1/4	1/4	6 1/2	0.0	6	-1/2	6 1/2	bts
SL - Muscle width 1" below armhole		1/4	1/4	7 1/4	0.0	6 7/8	-3/8	7 1/4	bts
SL - Sleeve opening width- short		1/4	1/4	6 3/4	0.0	6 3/4		6 3/4	
Sleeve rib height		0.0	0.0	3/4	0.0	3/4		3/4	
NK - Neck width- HPS to HPS		1/8	1/8	6 3/4	0.0	6 1/2	-1/4	6 3/4	bts
NK - Front neck drop from HPS		1/8	1/8	3 3/4	0.0	3 1/2	-1/4	3 3/4	bts
NK - Back neck drop from HPS		1/8	1/8	1/2	0.0	1/4	-1/4	1/2	bts
Inside neck binding		0.0	0.0	3/8	0.0	3/8		3/8	
CL - Collar height @ CB	collar is rib	1/8	1/8	2 3/4	0.0	2 5/8	-1/8	2 3/4	bts
CL - Collar point		1/8	1/8	2 1/4	0.0	2 3/16	-1/16	2 1/4	bts
CL - Collar spread		1/8	1/8	4 1/4	0.0	4	-1/4	4 1/4	revise
CL - I/E space		1/8	1/8	1/4	0.0	1/4		1/4	
Placket Length with 3/8" Box stitch height		1/4	1/4	5	0.0	4 3/4	-1/4	5	bts
PK - Placket width		1/8	1/8	1	0.0	1		1	
1st button placement from neck seam		1/8	1/8	1/2	0.0	1/2		1/2	
Last button from placket seam		1/8	1/8	2 1/8	0.0	2	-1/8	2 1/4	update
Logo placement from HPS		1/4	1/4	8 1/2	0.0	8 1/2		8 1/2	
Logo placement from CF		1/8	1/8	3 1/2	0.0	3 5/8	1/8	3 1/2	bts

Table: 3. 12 Sample Measurements No: 12

FIT COMMENTS:

1. Neckline came in small.
 - a. Neck width missing $-1/4''$, increase back to requested spec of $6\ 3/4''$.
 - b. Front neck drop came in higher by $1/4''$, drop back to requested spec of $3\ 3/4''$.
 - c. Back neck drop came in higher by $1/4''$, drop back to requested spec of $1/2''$.
2. Armhole shaping looks reversed from front to back. Front looks like it needs to be scooped closer to body and back looks like it needs to be filled. See photos.
3. Back cap width had excess at top. Needs to be cleaned.
4. Sleeve cap height missing $-1/2''$. Bring back to requested spec of $6\ 1/2''$.
5. Muscle width $-3/8''$. Bring back to requested spec of $7\ 1/4''$.
6. Reduce across front $-1/4''$ back to requested spec of $15\ 1/4''$.
7. Revise across back to finish at $16\ 1/4''$.
8. Body length missing $-1/2''$. Bring back to requested spec of $28\ 1/2''$.
9. Bring all other measurements back to requested specs.

Construction Comments:

1. Shoulder seam forward was uneven from neck to armhole ranging from $1/2''$ - $3/4''$. Please improve to finish evenly.



Figure: 3. 85 Sample Front, Side and Back Part



Figure: 3. 86 Armhole

3.1.13 Sample No: 13

DESCRIPTION	POM Comments	TOL-	TOL+	Requested	Agent	Internal	Variance	Revise To	Comments
BL - Front length from HPS to bottom		1/2	1/2	27 1/2	0.0	27 1/4	-1/4	27 1/2	bts
AB - Shoulder slope		1/4	1/4	2 1/4	0.0	2 1/4		2 1/4	
Shoulder seam forward		1/8	1/8	3/4	0.0	3/4		3/4	
AB - Across shoulder		3/8	3/8	17 1/2	0.0	18 1/4	3/4	17 1/2	too wide - bts
AB - Across front 7" from HPS		3/8	3/8	15 1/4	0.0	15	-1/4	15 1/4	bts
Across back 7" from HPS		3/8	3/8	15 3/4	0.0	15 1/2	-1/4	16	increase
AB - Chest width- 1" below armhole		1/2	1/2	21	0.0	20 3/4	-1/4	20 1/2	reduce
Bottom Opening Width - above rib seam join		1/2	1/2	19	0.0	18 1/2	-1/2	18 1/2	keep
Bottom Opening Width		1/2	1/2	18	0.0	18		18	
Hem Height	1x1 rib	1/8	1/8	3	0.0	3		2 1/2	reduce
NK - Neck width- HPS to HPS	seam to seam	1/8	1/8	7	0.0	7		7	
NK - Front neck drop from HPS	to seam	1/8	1/8	4 1/4	0.0	4 3/8	1/8	4 1/4	bts
NK - Back neck drop from HPS	to seam	1/8	1/8	1/2	0.0	3/4	1/4	1/2	bts
Neck trim Height	1x1 rib	1/8	1/8	3/4	0.0	5/8	-1/8	3/4	bts
Inside neck binding		1/8	1/8	3/8	0.0	3/8		3/8	
SL - Sleeve length from CB neck- 3 points-long		3/8	3/8	35 1/2	0.0	35 3/4	1/4	35 1/4	reduce
AH - Armhole straight		1/4	1/4	9	0.0	9 1/4	1/4	9	bts
SL - Cap height		1/8	1/8	6 1/4	0.0	6 1/2	1/4	6 1/4	too long - bts
SL - Muscle width 1" below armhole		1/4	1/4	7 1/2	0.0	7 1/2		7 1/4	reduce
SL - Forearm width 8" from sleeve opening		1/4	1/4	5 1/2	0.0	5 1/2		5 1/2	
SL - Sleeve opening width - stretched at above cuff		1/4	1/4	4 1/2	0.0	4 1/4	-1/4	4 1/4	keep
SL - Sleeve opening width - relaxed at rib edge		1/4	1/4	4	0.0	4		4	
CU - Cuff height	1x1 rib	1/8	1/8	3	0.0	3		2 1/2	reduce
Logo placement from HPS		1/4	1/4	8 1/2	0.0	8 1/2		8 1/2	
Logo placement from CF		1/4	1/4	3 1/2	0.0	3 5/8	1/8	3 1/2	bts

Table: 3. 13 Sample Measurements No: 13

FIT COMMENTS:

1. across shoulder was over spec, reduce $-3/4$ ", finish at $17 \frac{1}{2}$ ".
2. Increase across back $+1/2$ ", finish at 16 ". This should also help improve armhole shaping at back.
3. Sleeve length was long, reduce $-1/2$ ", finish at $35 \frac{1}{4}$ ".
4. Sleeve lift was not that good:
 - a. Reduce cap height $-1/4$ ", finish at requested spec of $6 \frac{1}{4}$ ".
 - b. Armhole was low and far from body. Raise armhole $-1/4$ " and bring closer to body at bottom. See photos.
5. Cap width looks wide at front. Shave down. See photo.
6. Muscle wide, reduce $-1/4$ ", finish at requested spec of $7 \frac{1}{4}$ ".
7. Reduce chest to finish at $20 \frac{1}{2}$ ". Keep bottom opening as sample now, $18 \frac{1}{2}$ " at seam and 18 " at edge.
8. Keep sleeve opening at seam as sample at $4 \frac{1}{4}$ ".
9. Bring all other measurements back to requested specs.

Construction Comments:

1. Reduce rib trim heights at sleeve cuff and bottom hem $-1/2$ ", finish at $2 \frac{1}{2}$ ".
2. Neck binding color is wrong. Follow bom.
3. Neck binding length was too short. It should go all the way to shoulder seams. See photos.
4. Do not hard press. It is leaving pointed shapes at shoulders and tops of armhole.
5. Improve sewing around armholes and shoulders, looks rippled. Needs to be smoother.



Figure: 3. 87 Sample Front, Back and Side Part



Figure: 3. 88 Armhole



Figure: 3. 89 Neck

3.1.14 Sample No: 14

DESCRIPTION	POM Comments	TOL-	TOL+	Requested	Agent	Internal	Variance	Revise To	Comments
BL - Front length from HPS to bottom		1/2	1/2	27 1/2	0.0	26 7/8	-5/8	27 1/2	bts
AB - Shoulder slope		1/4	1/4	2 1/4	0.0	2 1/4		2 1/4	
Shoulder seam forward		1/8	1/8	3/4	0.0	7/8	1/8	3/4	keep even
AB - Across shoulder		3/8	3/8	17 1/2	0.0	17 7/8	3/8	17 1/2	bts
AB - Across front 7" from HPS		3/8	3/8	15 1/4	0.0	15 3/8	1/8	15 1/4	bts
Across back 7" from HPS		3/8	3/8	16	0.0	16		16	
AB - Chest width- 1" below armhole		1/2	1/2	20 1/2	0.0	21	1/2	20 1/2	bts
Bottom Opening Width - above rib seam join		1/2	1/2	18 1/2	0.0	18 3/4	1/4	18 1/2	bts
Bottom Opening Width		1/2	1/2	18	0.0	18 3/8	3/8	18	bts
Hem Height	1x1 rib	1/8	1/8	2 1/2	0.0	2 7/16	-1/16	2 1/2	
NK - Neck width- HPS to HPS	seam to seam	1/8	1/8	7	0.0	6 7/8	-1/8	7	bts
NK - Front neck drop from HPS	to seam	1/8	1/8	4 1/4	0.0	4 1/8	-1/8	4 1/4	bts
NK - Back neck drop from HPS	to seam	1/8	1/8	1/2	0.0	5/8	1/8	1/2	bts
Neck trim Height	1x1 rib	1/8	1/8	3/4	0.0	3/4		3/4	
Inside neck binding		1/8	1/8	3/8	0.0	1/2	1/8	3/8	bts
SL - Sleeve length from CB neck- 3 points-long		3/8	3/8	35 1/4	0.0	35 1/4		35 1/4	
AH - Armhole straight		1/4	1/4	9	0.0	9		9	
SL - Cap height		1/8	1/8	6 1/4	0.0	6	-1/4	6 1/4	bts
SL - Muscle width 1" below armhole		1/4	1/4	7 1/4	0.0	7 1/8	-1/8	7 1/4	bts
SL - Forearm width 8" from sleeve opening		1/4	1/4	5 1/2	0.0	5 1/2		5 1/2	
SL - Sleeve opening width - stretched at above cuff		1/4	1/4	4 1/4	0.0	4 3/8	1/8	4 1/4	bts
SL - Sleeve opening width - relaxed at rib edge		1/4	1/4	4	0.0	4 3/8	3/8	4	bts
CU - Cuff height	1x1 rib	1/8	1/8	2 1/2	0.0	2 7/16	-1/16	2 1/2	bts
Logo placement from HPS		1/4	1/4	8 1/2	0.0	8 1/2		8 1/2	
Logo placement from CF		1/4	1/4	3 1/2	0.0	3 5/8	1/8	3 1/2	bts

Table: 3. 14 Sample Measurements No: 14

Comment

1. Body length came in short, was missing $-5/8$ ". Increase back to spec of $27\ 1/2$ ".
2. Across shoulders still came in wider than requested. Reduce back to requested spec of $17\ 1/2$ ".
3. Increase across back $+14$ " to $16\ 1/4$ ".
4. Reduce front width at $8\ 1/2$ " below hps $1/4 - 3/8$ " to improve shaping at front further. Currently sample measures 16 ", Reduce to $15\ 3/4$ " to $15\ 5/8$ ".
5. Chest came in over spec again. Reduce chest $-1/2$ " back to requested spec of $20\ 1/2$ ".
6. Sleeve opening was over spec. Reduce $-3/8$ " back to requested spec of 4 ".
7. All other fit was okay, bring all measurements back to sp



Figure: 3. 90 Sample Front, Back and Side Part

3.1.15 Sample No: 15

DESCRIPTION	POM Comments	TOL-	TOL+	Requested	Agent	Internal	Variance	Revise To	Comments
BL - Front length from HPS to bottom		1/2	1/2	27 1/2	0.0	27	-1/2	28 1/2	revise
AB - Shoulder slope		1/4	1/4	2 1/4	0.0	2 1/8	-1/8	2 1/4	bts
Shoulder seam forward		1/8	1/8	3/4	0.0	1	1/4	3/4	was uneven
AB - Across shoulder		3/8	3/8	17 1/2	0.0	17 1/8	-3/8	17 1/2	bts
AB - Across front 7" from HPS		3/8	3/8	15 1/4	0.0	15	-1/4	15 1/4	bts
Across back 7" from HPS		3/8	3/8	15 3/4	0.0	15 5/8	-1/8	16 1/4	revise
AB - Chest width- 1" below armhole		1/2	1/2	21	0.0	20 3/4	-1/4	21	bts
Bottom Opening Width		1/2	1/2	20 1/2	0.0	20 3/8	-1/8	20 1/2	bts
Bottom Hem Stitch Height		1/8	1/8	1/2	0.0	1/2		1/2	
NK - Neck width- HPS to HPS		1/8	1/8	7	0.0	6 1/2	-1/2	7	bts
NK - Front neck drop from HPS		1/8	1/8	4 1/4	0.0	4 1/8	-1/8	4 1/2	revise
NK - Back neck drop from HPS		1/8	1/8	1/2	0.0	3/4	1/4	1/2	bts
Neck trim Height		1/8	1/8	5/8	0.0	1/2	-1/8	5/8	bts
Inside neck binding		1/8	1/8	3/8	0.0	3/8		3/8	
SL - Sleeve length from CB neck- 3 points- long		3/8	3/8	35 1/2	0.0	35	-1/2	35 1/2	bts
AH - Armhole straight		1/4	1/4	9	0.0	9		9	
SL - Cap height		1/8	1/8	6 1/4	0.0	6 1/2	1/4	6 1/4	reduce bts
SL - Muscle width 1" below armhole		1/4	1/4	7 1/2	0.0	7 1/4	-1/4	7 1/4	reduce
SL - Forearm width 8" from sleeve opening		1/4	1/4	5 1/2	0.0	5 1/2		5 1/2	
SL - Sleeve opening width - relaxed at rib edge		1/4	1/4	4	0.0	4 1/4	1/4	4 1/2	revise (pom should read no rib)
Sleeve Hem Stitch Height		1/8	1/8	1/2	0.0	1/2		1/2	
Logo Placement from HPS		1/8	1/8	8 1/2	0.0	8 1/2		8 1/2	
Logo placement from CF		1/8	1/8	3 1/2	0.0	3 5/8	1/8	3 1/2	bts

Table: 3. 15 Sample Measurements No: 15

FIT COMMENTS:

1. Armhole/sleeve:

- a. Shift front armhole a little closer to body. See photo.
- b. Fill in back armhole curve slightly. See photo.
- c. Increase across shoulders back to spec and this will help with back armhole shaping to fill in better. See photos.
- d. Improve sleeve lift. Cap height was too long and was pinned out. Reduce cap height back to requested spec of 6 ¼”.
- e. Cap width shape looks wide at front. Shave down shaping. See photo.
- f. Armhole is collapsing at back. See photo. Improve shaping.

2. Increase across back +5/8” to finish at 16 ¼”.

3. Increase body length to finish at 28”.

4. Neckline:

- a. Neck width came in too narrow, missing -1/2”. Increase back to requested spec of 7”.
- b. Front neck drop too high. Drop +3/8”, finish at 4 ½”.
- c. Raise back neck drop ¼” to ½” as requested.

5. Sleeve length came in under spec. Increase +½” back to requested spec of 35 ½”.

6. Reduce muscle -1/4”, finish at 7 ¼”.

7. Increase sleeve opening +1/4”, finish at 4 ½”.

8. Bring all other measurements back to requested specs.

Construction Comments:

1. Shoulder seam forward was uneven from neck to armhole. Please improve to finish evenly.
2. Neck binding length was too short. It should go all the way to shoulder seams. See photos.



Figure : 3. 91 Sample Front, Back and Side Part



Figure: 3. 92 Armhole



Figure: 3. 93 Neck

Chapter- 04

4. Result & Discussion

4.1 Fault Analysis

Serial	Sample type	A Fitting	B Workmanship	C Material	D Shade	E Accessories	F Measurement
1	PP	*	*			*	*
2	PP	*	*	*	*	*	*
3	PP	*	*	*	*	*	*
4	PP	*	*		*	*	*
5	PP	*	*			*	*
6	PP	*	*		*	*	*
7	PP	*	*	*	*	*	*
8	PP	*	*	*		*	*
9	PP	*	*		*	*	*
10	PP	*	*		*	*	*
11	Fit	*	*				*
12	Fit	*	*				*
13	Fit	*	*				*
14	Fit	*	*				*
15	Fit	*	*				*
Total		15	15	4	7	10	15

Table: 4. 1 Fault Analysis

A= Fitting

B=Workmanship

C= Material

D= Shade

E= Accessories

F= Measurement

4.2 Fault Calculation in Percentage:

Formula:

Fault Percentage = (No. of Particular Fault \times 100) \div Total Fault

Example:

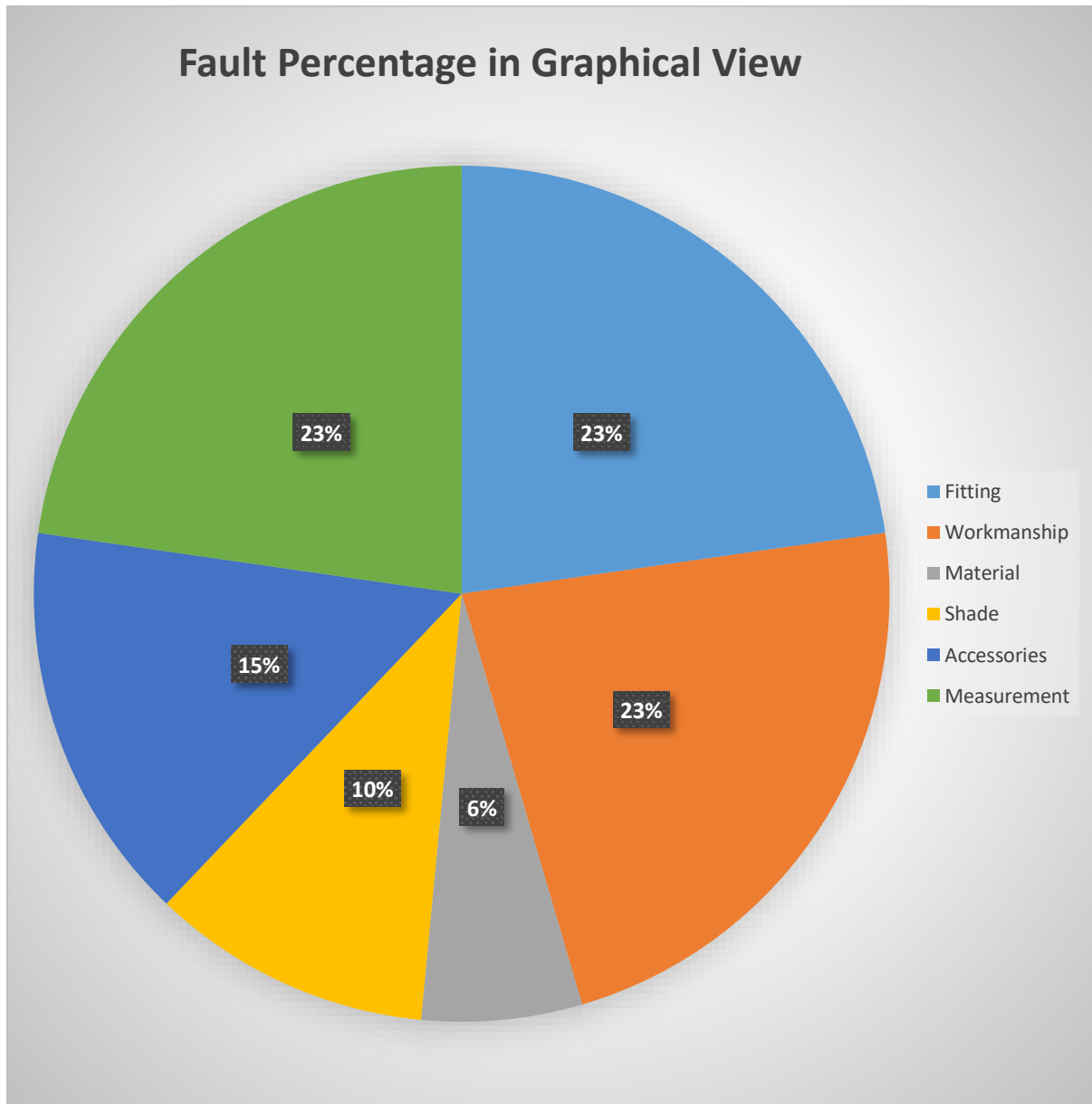
$$\begin{aligned} \text{A) Fitting Fault Percentage} &= (15 \times 100) \div 66 \\ &= 1500 \div 66 \\ &= 22.73 \end{aligned}$$

4.3 Fault Percentage

Name of Fault	No of Fault	Percentage of Fault
Fitting	15	22.73%
Workmanship	15	22.73%
Material	4	6.06%
Shade	7	10.60%
Accessories	10	15.15%
Measurement	15	22.73%

Table: 4. 2 Fault Percentage

4.4 Fault Percentage in Graphical View



4.5 Major Fault and Remedies

4.5.1 Measurement Fault:

Measurement means any object's numerical value, which expresses the amount, length, width, height, depth, etc. of the object. A measurement is a vital and very important unit for understanding any object. Thus, the measurement of garments is also very important for making perfect and buyer requirement garments. But in our industry, the maximum measurement fault is made, which is why our maximum sample is rejected even by the buyer.

Reasons of measurement fault:

1. Making the wrong pattern or CAD
2. Failure to understand the measurement sheet
3. Mistake of cutting the fabric
4. Inappropriate sewing

Remedies of measurement fault:

1. Improving the pattern
2. Carefully inspect the measurement sheet
3. Improving the cutting
4. Improving the sewing
5. Increase to measurement knowledge
6. Careful when fabric numbering

4.5.2 Workmanship Faults:

The quality of execution of a design refers to workmanship. The closer to the design the final product is in terms of look quality of material and quality of construction. Under the workmanship, all problems occur in garments can be considered. Although sewing can be regarded as the primary work fault

Reason:

- » Less sample sewing person skills
- » Bad type of sewing thread should be used.
- » Miss handling Machine sewing correctly

Remedies:

- » Must develop sample sewing person skills
- » Using good kind of sewing thread.
- » Machine stitching should be done correctly

4.5.3 Fitting Fault:

Fitting refers that when any garments used, the person who use it on his body it should be suitable and appropriately adjust. When the garments don't adjust with the user body then it called the fitting fault. It may be big or small from the body.

Reasons

- » Poor skill of the sample pattern maker
- » Poor skill of the sample cutting man
- » Less sample sewing person skills
- » Sample man's less skill in understanding the measurement sheet

Remedies

- » Should boost pattern builder skills
- » Have to increase the skill of sample cutting man
- » Must develop sample sewing individual skills
- » Have to enhance the skill of the sample man to understand the Measurement Sheet.

4.5.4 Material Fault

Reason:

- » Poor skill of the sample Knitting, Dyeing person
- » Bad type of Yarn & Chemical should be used.
- » Knitting, Compactor machine miss handling rightly

Remedies:

- » Must improve the Knitting Operators skills
- » You should use a good type of yarn & chemical.
- » Machine compactors should be handled correctly

4.5.5 Shade Variation Faults

Reason:

- Poor workmanship.
- This is due to incorrect cutting, bundling and counting.
- An uneven batch of missing shade.
- Different batch mixing for the same clothes.

Remedy:

- The parts of the garment must be kept in the correct bundle with number after cutting.
- Every part of a batch of fabric shade is used for the same garment.
- Shade marks each component because of cutting of the cloth.

4.5.6 Accessories Fault

Reason:

- Poor skill of the sample sewing person
- Bad type of sewing thread should be used.
- Sewing machine miss handling properly

Remedies:

- Label Availability should be ensured
- Have to enhance the skill of sample sewing person
- Good type of sewing thread should be used
- Sewing machine should be handled correctly

Chapter- 05

5. Conclusion

Sampling is the core of every processing of export orders. The future of any style depends purely on buyer and factory which adds value to the samples. But it is very important to understand the process of sample production in the initial stage or in the production of sampling to monitor quality and costs. Merchandiser plays an important role in the sampling process as the only person between the buyer and the plant who knows the buyer's requirements, technical information and sampling time. The process of sampling is about eventual meeting of specific needs. It's about the products the company can make or outsource profitably for which market demand exists. The most appropriate way to place an order is by sampling. Sampling purpose is not only to get a bulk order but also to give some extra benefits to the exporters. The use of technology, computer driven design, as well as innovation and imagination are essential tools in driving apparel sampling.

We collect 15 reports and found 66 defects in a sample of different buyers. We note the fault and try to find the percentage. From the percentage value, we can see most of the problems occurred in measurement and workmanship. In measurement we find more than 22.73% faults also in workmanship we find almost 22.73% faults and the rest of the faults are 54.54%.

Chapter- 06

6. Reference

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1. Merchandising section of Falcon Group
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Online literature:

1. [https://en.wikipedia.org/wiki/Sample_\(statistics\)](https://en.wikipedia.org/wiki/Sample_(statistics))
2. <https://textilestudycenter.com/fabric-inspection>
3. <http://www.textileschool.com/articles/175/garment-sampling>
4. <http://textilemerchandising.com/tag/different-stages-of-sampling-in-garmentsindustry>

Comments on Sample

ORIGINALITY REPORT

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